ADDITIVE FINDER

allnex ADDITIVES



ADDITOL®

- Surface and Appearance
- Dispersants
- Grinding Medium
- Defoamers
- Oxidative Driers

EBECRYL®

CYCAT®

- Catalyst and Hardeners
- Rheology Modifiers
- Adhesion Promoters
- Cure Boosters for UV/LED/EB
- Special Effects

MODAFLOW®



1K and 2K
DECO

Electron Beam
UV Curable

Powder Coating

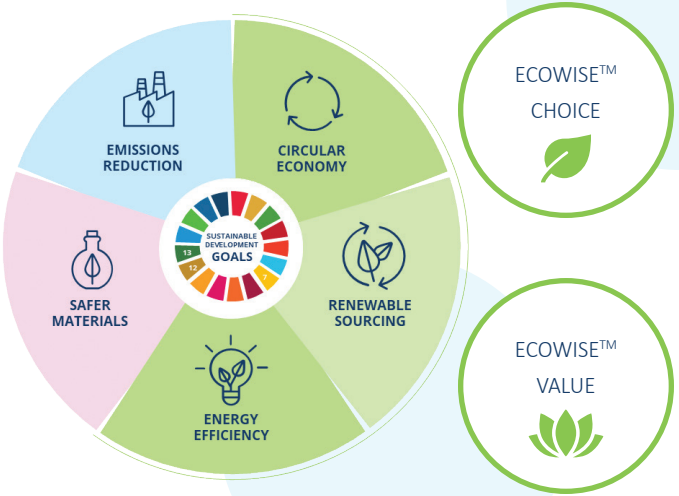
Adhesives
Automotive

Direct to Metal
Architectural

allnex ADDITIVES

A fivefold focus for a new tomorrow – the pillars of our sustainability program.

Sustainability Pillars



Circular Economy

We diligently explore options to limit the consumption of resources, keep them in use as long as possible, and eventually, recover and recycle them at the end of service life.

Renewable Sourcing

We aim at minimal use of finite resources and strive to reduce climate impacts by looking at renewable alternatives for raw materials and the energy we use.

Energy Efficiency

We design our product and manufacturing process in a way that enables maximum efficiency in energy utilization across the product life-cycle.

Safer Materials

We are committed to making the substitution of potentially harmful chemicals by safer options one of our guiding considerations.

Emissions Reduction

We work to reduce the emissions of volatile organic solvents across the product life-cycle to protect people and the environment.

be ECOWISE™

ECOWISE™ Products

Brings significant sustainability proposition along one or more of allnex's sustainability pillars.

ECOWISE™ VALUE

Assessed and passed against the most stringent global industry standards and ecolabels for specific markets.

ECOWISE™ CHOICE

Product	Product Group
ADDITOL® dry CF200	Drier
ADDITOL® VXW 395	Surface and Appearance
ADDITOL® VXW 6208	Dispersant
ADDITOL® VXW 6208/60	Dispersant
EBECRYL® LEO 10103	Cure Booster for UV/EB

*Applicable products will be marked with these symbols:

Product	Product Group
ADDITOL® dry CF103	Drier
ADDITOL® dry CF100	Drier
ADDITOL® P 896	Surface and Appearance
ADDITOL® VXL 4930N	Surface and Appearance
ADDITOL® XL 6521	Dispersant
ADDITOL® XL 6592	Dispersant
ADDITOL® XW 1680	Rheology Modifier
ADDITOL® XW 6565	Grinding Mediums
ADDITOL® XW 6588	Dispersant
CYCAT® 4040	Catalyst
CYCAT® 6020	Catalyst
CYCAT® 6030	Catalyst
CYCAT® VXK 6395	Catalyst
EBECRYL® 1360	Surface and Appearance
EBECRYL® 168/170/171	Adhesion Promoter
EBECRYL® 898	Special Effect
EBECRYL® LEO 10101/10103	Cure Booster for UV/EB/LED
MODAFLOW® 2100	Surface and Appearance
MODAFLOW® 9200	Surface and Appearance
MODAFLOW® AQ 3025	Surface and Appearance
MODAFLOW® Lambda	Surface and Appearance
MODAFLOW® Powder	6000 Surface and Appearance
MODAFLOW® Resin	Surface and Appearance

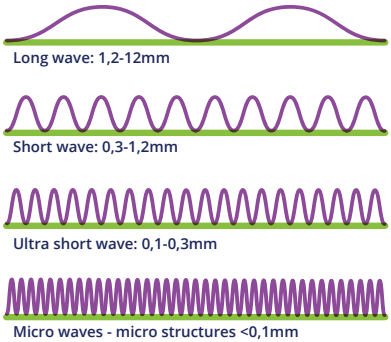
allnex ADDITIVES

Surface and Appearance Overview

To obtain good leveling (for physically drying coatings), sufficient substrate wetting, uniform solvent(s) evaporation, and well-balanced surface tension throughout the drying phase are essential.

- The surface topography of physically drying coatings is established during the solvent evaporation.
- In the locations where the volatile components have evaporated, the surface tension increases, and the coating migrates toward the higher surface tension areas, **creating waves** impacting appearance, coating uniformity, and application complexity *(higher surface tension, harder to spray)*.

Surface Topography



(Meth)-acrylics

+ Reduce microstructure
+ No impact on surface tension
+ No impact on interlayer adhesion

Silicones

+ Reduce long wave
+ Increase slip performance
+ Reduce surface tension
– Decrease interlayer adhesion

Flow and leveling additives are used to prevent surface waviness from materializing in coating defects, including orange peel, brush marks, peaks, craters, fisheyes, and pinholes (depending on the application and application technique).

Surface and Appearance Overview

Scan to learn more



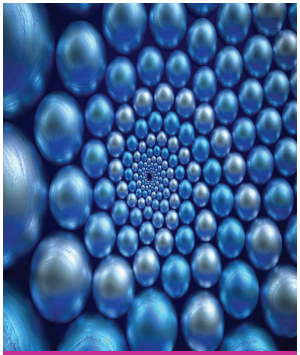
ADDITOL® XL 6537
– NEW –

- Improves substrate-wetting and aids in degassing
- Diminishes pinholes, craters, orange peel, and fisheyes
- Excellent resin compatibility
- Low dosage requirements
- 100% active



MODAFLOW® AQ 3025
– Highest Brilliance –

- Ultimate brilliancy, sharpness, and DOI control
- FDA-compliant polymeric flow promoter
- Reduces micro-foam
- Controls orange peel & coating micro-structure



ADDITOL® XW 6586
– Ultimate Beauty –

- FDA-compliant multipurpose silicone for improved appearance, gloss and surface slip
- 100% active for aqueous, solvent and 100% systems



ADDITOL® XW 6580
– Universal –

- Outstanding substrate-wetting
- Dynamic reduction in surface tension without impacting coating slip
- Can be used in solventborne and waterborne systems
- 100% active recoatable silicone Surface and Appearance Highlights

Surface and Appearance Highlights

Scan to learn more



EBECRYL® 1365
– New Scratch Eliminator –

- Improves scratch & mar resistance in UV/EB applications
- Exceptional transparency and compatibility
- Dynamic reduction in surface tension
- No silicone migration



MODAFLOW® LAMBDA
– Highest Brilliance –

- Polymeric flow promoter imparting ultimate brilliancy, sharpness, and DOI control
- Outstanding compatibility with conventional and UV/EB chemistries
- Controls orange peel & coating micro-structure



ADDITOL® XL 123N
– Silicone Flow Enhancer –

- Improves slip, scratch, and mar resistance for aqueous and solventborne solutions
- Dynamic reduction in surface tension, improves leveling and aids in degassing
- Thermally stable up to 400ºC



ADDITOL® XL 481
– Balanced –

- Micro-structure control
- Improves orange peel control
- Excellent compatibility with acrylic & polyester resin systems
- Low dosage requirements

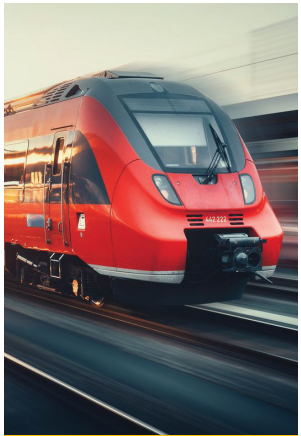
Surface and Appearance Highlights - Powder

Scan to learn more



MODAFLOW® Powder 6000
– High Performance –

- Micro-structure control
- Improves orange peel control
- Excellent cross compatibility
- FDA Possible
- Best recoatability



MODAFLOW® Powder 3000
– Balanced –

- Good brilliancy, sharpness and DOI control
- FDA Possible
- Good cross compatibility
- Good recoatability



ADDITOL® P 896
– Masterbatch Pigment –

- Improves wetting in pigmented systems
- Carrier is a high-performance hydroxylated polyester
- Silica free additive



ADDITOL® P 891
– Masterbatch Clear –

- Excellent scratch & Mar
- Both interior & outdoor applications
- Excellent clarity
- Silica free!

Surface and Appearance

	Active (%)	Viscosity (cps)	Chemistry	MW	Attributes
ADDITOL® XW 395	58	1200	Polyacrylate	L	FDA compliant, silicone-free, flow and leveling agent that improves wetting on difficult to "wet out" substrates. Eliminates craters without stabilizing foam. Ideal for RESYDROL® paint systems and can be used in **conventional waterborne, water reducible, or solventborne coatings**.
ADDITOL® XW 6586	100	1500	Polysiloxane	L	Versatile, FDA compliant flow and leveling silicone that offers excellent performance at low dosage. Reduces surface friction and improves hardness and slip without affecting re-coatability. Can be used in **UV/EB and conventional 100% solids, waterborne and solvent coatings** making it ideal for **SKU consolidation**.
EBECRYL® 341	80	50	Acrylate	L	Improves leveling and slip. Imparts release properties in **UV/EB applications** without silicones
EBECRYL® 350	100	350	Silicone diacrylate	L	Improves substrate wetting, flow, and leveling. Imparts slip and release flow properties with minimum impact on coating surface tension in **UV/EB applications**.
EBECRYL® 1360	100	2100	Silicone hexaacrylate	L	Films exhibit a smooth, tack-free surface with good anti-blocking resistance and increased hardness due to higher cross-link density in **UV/EB applications**.
EBECRYL® 1365	100	2500	Silicone hexaacrylate	L	Fast migration to the surface for dynamic reduction to surface energy with outstanding resin compatibility. Improves scratch, mar, and stain resistance in UV/EB applications, **high water contact angle 105º**.
MODAFLOW® 2100	100	8500	Acrylate	M	Improves surface wetting, flow, and leveling in clear and pigmented systems. Reduces pinholes, craters, and orange peel. Aids in pigment dispersion and de-airing in **UV/EB and conventional chemistries**.
MODAFLOW® AQ 3025	25	150	Acrylate	H	Opportunities to **reduce SKUs**, offers excellent compatibility and performance in both **conventional and UV/EB aqueous chemistries**. Gives robust substrate wetting without silicone, including not-so-perfect surfaces.

Surface and Appearance

	Active (%)	Viscosity (cps)	Chemistry	MW	Attributes
ADDITOL® XL 121N	14	–	Silicone	L	Improves substrate wetting and coating slip. Has excellent compatibility with **conventional solventborne chemistries**.
ADDITOL® XL 122	45	–	Silicone	L	Imparts slip and scratch resistance. Gives excellent substrate wetting, but will have some impact on surface tension for **conventional solventborne coatings**.
ADDITOL® XL 123N	60	–	Silicone	M	Outstanding performance: reduces microstructures, excellent flow and leveling, offers dynamic surface tension reduction in both **UV/EB and conventional solvent- and water-borne coatings**. Ideal for **SKU reduction**, plus a **unique scratch resistance synergy when used in conjunction with Modaflow® NSR 100**.
ADDITOL® VXL 4930N	40	75	Silicone	M	Polyether-modified silicone, offers balanced performance such as suitable substrate wet out, leveling, orange peel correction, and anti-catering without stabilizing foam. Compatible with **solvent- and water-borne conventional and UV/EB coatings**.
ADDITOL® XW 6537	100	10000	Polyester	M	Cost-effective flow and leveling agent that reduces orange peel and pinholes. Improves substrate wetting w/o silicone. Can be used in 100% solids and high solids **conventional and UV/EB coatings**.
ADDITOL® XW 6580	100	60	Silicone	L	**VOC-free**. Improves substrate wetting agents and reduces craters for **waterborne and solventborne** systems. Ideal product for **SKU consolidation**.
MODAFLOW® Resin	100	100000	Acrylate	H	Robust substrate wetting for 100% solids and high solids **conventional and UV/EB coatings**, Reduces orange peel, craters, and pinholes. Aids in formulation degassing and pigment dispersion. Ideal candidate to minimize **flow and leveling SKUs**.

Surface and Appearance

	Active (%)	Viscosity (cps)	Chemistry	MW	Attributes
ADDITOL® VXW 4971	50	4500	Acrylate	L	Amine-neutralized systems designed to improve surface appearance and reduce surface imperfections' impact on coating quality, designed primarily for RESYDROL® stoving systems.
ADDITOL® XL 480/481	70	200/100	Acrylate	M	Excellent for not-so-clean substrates such as coil. Creates a robust surface quality, reducing surface imperfections such as craters without silicones. Can be used in **conventional and UV/EB chemistries, but ideal for 100% solid, high solids, and solventborne applications**.
ADDITOL® XL 482	100	20000	Acrylate	M	**Cost-effective** flow modifier that reduces pinholes, fisheyes, craters, and orange peel. Aids in air release and pigment dispersions; works well in sensitive cure mechanism and can be used in **UV/EB applications, ideal for 100% solid, high solids, and solventborne applications**.
MULTIFLOW® Resin	50	100	Acrylate	H	A versatile additive, diluent in Xylene, that enhances flow and leveling, minimizes pinholes, fisheyes, and craters. Supports pigment dispersion in both **UV/EB and conventional non-aqueous coatings**, while promoting smooth surface deformation.
MODAFLOW® 9200	100	3000	Acrylate	L	Robust surface wetting performance for **100% solids, high solids, and solventborne conventional and UV/EB** applications, additional benefit as a co-dispersant for pigments.
MODAFLOW® Epsilon	80	1000	Acrylate	H	Effective in eliminating pinholes and craters in epoxy, polyester, urethane, and acrylic coatings. Also suitable for UV/EB applications.
MODAFLOW® Lambda	100	15000	Acrylate Hybrid	L	**Cross-linkable**, flow promoter that improves surface characteristics such as gloss, DOI, and brilliancy. Reduces orange peel. A non-migrating silicone **for conventional and UV/EB chemistries**.

Surface and Appearance – Powder

	Active %	Chemistry	Delivery type	OH #	Acid #	Attributes
ADDITOL® P824	15	Hydroxylated Polyester	Master Batch	45	–	Compatible with nearly all powder coating systems
ADDITOL® P890	10	Hydroxylated Polyester	Master Batch	50	–	Used in indoor and outdoor clear powder coatings
ADDITOL® P891	5	Carboxylated Polyester	Master Batch	–	35	Used in clear powder coatings, suggested for the manufacture of haze-free clear coatings
ADDITOL® P896	15	Hydroxylated Polyester	Master Batch	45	–	Used in pigmented powder coat, improves flow while maintaining good compatibility
MODAFLOW® Powder 3000	65	Polyacrylate	Silica carrier	–	–	Improves flow and leveling that broadens cross-compatibility between powder formulations
MODAFLOW® Powder 6000	65	Polyacrylate	Silica carrier	–	–	Developed to control surface defects in powder coating systems. Performs well in all thermoset powder coatings
MODAFLOW® Powder III	65	Polyacrylate	Silica carrier	–	–	Efficient flow aid for industrial powder coatings

Surface and Appearance Comparison

Attributes	MODAFLOW® Resin	MODAFLOW® 9200	MODAFLOW® Lambda	ADDITOL® XL 123N	ADDITOL® XL 480/481/482	ADDITOL® XW 6580	EBECRYL® 1365	ADDITOL® XL 6537
Gloss	✓	✓	✓	✓	✓	✓	✓	✓
DOI	✓	✓	✓	✓	✓	✓	✓	✓
Leveling	✓	✓	✓	✓	✓	✓	✓	✓
Crater Control	✓	✓	✓	✓	✓	✓	✓	✓
Pinhole Elimination	✓	✓	✓	✓	✓	✓	✓	✓
Defoaming	✓	✓	✓	✓	✓	✓	✓	✓
Surface Wetting	✓	✓	✓	✓	✓	✓	✓	✓
Slip & Mar Resistance	✓	✓	✓	✓	✓	✓	✓	✓
Adhesion Substrate	✓	✓	✓	✓	✓	✓	✓	✓
Re-coatability	✓	✓	✓	✓	✓	✓	✓	✓
Cross Compatibility	✓	✓	✓	✓	✓	✓	✓	✓
Special Textures	✓	✓	✓	✓	✓	✓	✓	✓
Clarity	✓	✓	✓	✓	✓	✓	✓	✓
Orange Peel	✓	✓	✓	✓	✓	✓	✓	✓
Facilitates Pigment Dispersion	✓	✓	✓	✓	✓	✓	✓	✓
Air Release	✓	✓	✓	✓	✓	✓	✓	✓

✓ Highly Recommended ✓ Recommended ✓ Not Recommended

Surface and Appearance – Powder

Attributes	MODAFLOW® Powder III	MODAFLOW® Powder 6000	MODAFLOW® Powder 3000
Gloss	✓	✓	✓
DOI	✓	✓	✓
Leveling	✓	✓	✓
Crater Control	✓	✓	✓
Pinhole Elimination	✓	✓	✓
Defoaming	✓	✓	✓
Surface Wetting	✓	✓	✓
Slip & Mar Resistance	✓	✓	✓
Adhesion Substrate	✓	✓	✓
Re-coatability	✓	✓	✓
Cross Compatibility	✓	✓	✓
Special Textures	✓	✓	✓
Clarity	✓	✓	✓

✓ **Highly Recommended**

✓ **Recommended**



Product	175.105	175.300	177.1010
• MODOFLOW® Powder III	Yes	Yes	Yes
• MODOFLOW® Powder 6000	Yes	Yes	Yes
• ADDITOL®P 896	Not determined	Yes	Not determined

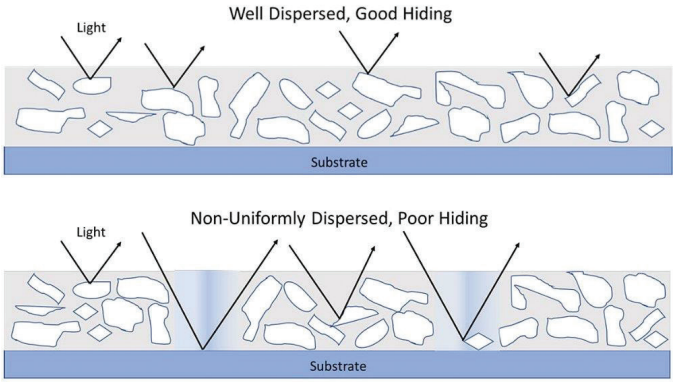
allnex Powder Coating Additives that Qualify For CFR Title 21

MODAFLOW® and ADDITOL® powder products may be used in certain indirect food applications. These applications are regulated by the U.S. Food and Drug Administration (FDA), under Title 21 of the Code of Regulations, CFR sections listed here:

allnex ADDITIVES

Dispersant Overview

Pigments **are insoluble particles specifically created to add color to various materials. They can be categorized into four types: *organic, inorganic, effect, and functional pigments*. A suitable *dispersion process* and the appropriate selection of pigments and additives are fundamental in determining the performance of the finished coating.**



A good dispersion of pigments will result in optimal characteristics:

- Color strength
- Minimum viscosity
- Maximum dispersion stability
- Hiding power
- Gloss

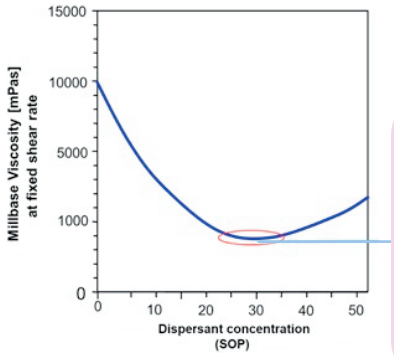
Possible effects and defects of a poor dispersion:

- Very time-consuming and costly process
- Low gloss
- Flocculation and flotation
- Low light and weather resistance
- Poor paint stability

Dispersant Concentration Selection and Optimization

Dispersant Demand Curve Experiment:

Consists of varying dispersant concentrations with fixed amounts of pigment, resin, and solvent.



This represents the lowest viscosity, the maximum amount of dispersion absorption, the highest gloss, and the BEST performance.

Other possible ways to assess the optimal amount of dispersant:

- Accelerated aging stability test
- Analysis of the formulation, application, and visual characteristics of the sample

As a rule, 2mg of polymeric dispersant per square meter of pigment surface area will be close to the optimum amount required. To determine the amount of dispersant needed, a straightforward calculation expressed as a percentage of Agent On Weight of Pigment (% AOWP) may be used.

$$\text{Active dispersant amount on pigment (\%)} = \frac{\text{Pigment Surface Area (BET)}}{\text{4 or 5}}$$

Dispersant Highlights

Scan to learn more



ADDITOL® XL 6590
– Excellent Stability –

- High MW cationic dispersant for UV/EB chemistries
- Broad compatibility with (in)organic pigments compatibilities
- Diluted in 35% in OTA-480



ADDITOL® XW 6588
– Controlled Migration –

- "Low ion migration" technology improves paint corrosion resistance
- Low viscosity direct grinds & concentrates
- High pigment loading for all pigments & fillers



ADDITOL® XL 6592
– Plethora of Uses –

- 100% active dispersant that is highly effective in 100% solids, high solids, water-borne, and solventborne coatings
- Compatible with most pigments
- Perfect for SKU consolidation



ADDITOL® XL 6577
– Highly Efficient –

- Best-in-class TiO2 pigment loading & stability (up to 70% loading)
- Effective with all inorganic pigments & fillers
- Lowers paint VOC levels

Dispersants

	Active %	Viscosity (cps)	Chemistry	Acid #	Amine #	Attributes
ADDITOL® VXW 6208	50	3000	Polymeric	20	–	Robust dispersant for aqueous solutions in **conventional and UV/EB chemistries**, **making it picture-perfect for SKU simplification**, excellent compatibility with organic and inorganic pigment, and improves anti-floating performance ***(ADDITOL® VXW 6208/60 works in solvent and water mediums)***.
ADDITOL® VXW 6394	40	1000	Polymeric	10	–	High MW blocked copolymer for an aqueous solution that can be used as a dispersant or a resin-free grinding medium for color concentrates. This makes it a **prototypical fit for SKU simplification**, and improves hiding power.
ADDITOL® XL 270	45	175	Fatty Acid (Electro Neutral)	–	–	**Universal**, ideal for water-reducible alkyds and UV/EB chemistries, **perfect for SKU simplifications**, improves pigment stabilization.
ADDITOL® XL 6521	60	500	Cationic	–	30	Workhouse for carbon black pigments offering high loading, low grind viscosities, and prevents re-flocculation in **UV/EB and conventional chemistries**. Best in high solids and solventborne applications.
ADDITOL® XL 6577	52	50	Phosphoric	60	–	High TiO2 loading (70%) for **solventborne and high solids** applications, low grind viscosity, and excellent pigment stability *(EBECRYL® 331, for UV/EB chemistries)*.
ADDITOL® XW 6582	38	700	Thermoset Acrylic	–	–	Allows for higher pigment loading without increasing viscosity or grinding time, excellent compatibility with (in)organic pigments for **conventional waterborne**.
ADDITOL® XW 6588	47	2500	Polymeric	17	–	Low ion migration dispersant for direct-to-metal applications imparting high pigment loading and improved corrosion resistance in **conventional waterborne**.

Dispersants

	Active %	Viscosity (cps)	Chemistry	Acid #	Amine #	Attributes
ADDITOL® VXL 4992	50	–	Polyester	6	20	All around excellent dispersant that offers strong wetting of inorganic pigments. Provides improvements in flow and leveling, deairing, gloss, and color strength. Reduces dispersing time in high viscosity application such as putties and primers for automotive refinish.
ADDITOL® VXL 6212	30	200	Cationic	TBD	TBD	High MW urethane designed for difficult to disperse pigments in **UV/EB and conventional, solventborne chemistries**. The high mw makes it possible to use as a direct grind resin.
ADDITOL® XL 204	55	175	Fatty Acid	57	57	Used as a dispersant or co-dispersant to reduce floating of inorganic and organic pigments. Reduces dispersing time for **high solids, waterborne, and solventborne UV/EB and conventional chemistries**.
ADDITOL® XL 6590	100	7000	Cationic	–	33	Outstanding performance in **UV/EB chemistries** offering excellent compatibility with (in)organic pigments, especially carbon black, and sensitive curing mechanisms, diluted with 35% OTA-480.
ADDITOL® XL 6592	100	25000	Polymeric	28	–	**Universal** dispersant that can **simplify dispersants SKU** with robust compatibility with (in)organic pigments. Used in solvent or aqueous mediums, plus outstanding performance and excellent compatibility with 1K, 2K, and UV/EB chemistries.
ADDITOL® XL 6593	45	300	Cationic	–	23	Ideal for difficult-to-disperse pigments, targeting VR and industrial applications.
ADDITOL® XW 440	30	175	Acrylate	–	–	Sodium neutralized **cost-effective** dispersant for the architectural market.

Grinding Medium Highlights

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ADDITOL® XL 6574
– Problem Solver –

- Wide range of resin compatibilities
- Strong pigment coloristic enhancement
- Ready to use – no additional preparation steps
- Durable backbone



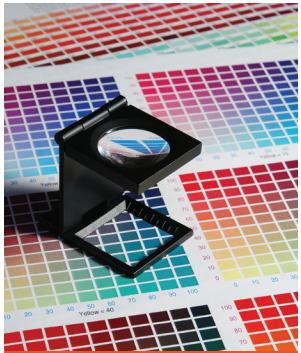
ADDITOL® XW 6591
– Process Friendly –

- Cross-linkable grinding medium plus co-dispersant for waterborne OEM/Refinish basecoats
- Compatible with 1K, 2K, and UV/EB chemistries
- Low VOC & Overbake stable
- Universal pigment compatibility



ADDITOL® XW 6565
– United Pigments –

- Universal grinding medium for POS colorants for high performance exterior paints (glycol-free)
- Excellent color development
- Improves humidity and water resistance performance
- Ideal for decorative pigments



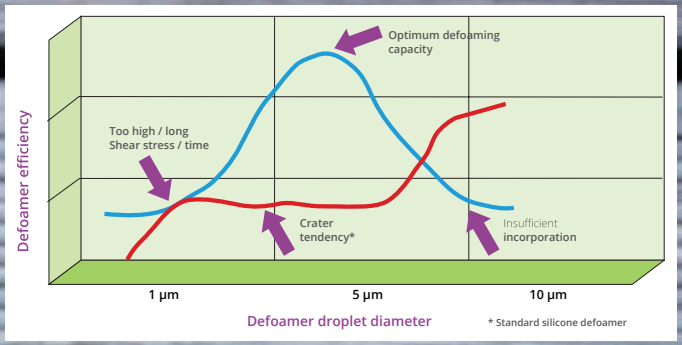
ADDITOL® XL 6557
– Colors matched –

- Cross-linkable grinding medium
- Imparts hardness and UV resistance, improves drying, mechanical, and water-resistant properties
- For stoving, 2K PUR and air-dry resin systems
- Universal pigment compatibility

Grinding Medium

	Active %	Viscosity (cps)	Chemistry	Acid #	Amine #	Attributes
ADDITOL® XL 204	55	<60	Modified fatty acid	57	57	Prevents the floating of titanium dioxide in conjunction with colored pigments.
ADDITOL® XL 250	55	<40	Modified fatty acid	65	65	**Reduced SKUs** as they can be used as a grinding medium, dispersant, or codispersant (pigment stabilization) for metallic pigments, works well with RALWAX 1010 to improve pigment orientation for automotive.
ADDITOL® XL 6557	70	2000	Modified Alkyd	< 7	–	**Cross-linkable** polymeric grinding medium that offers low paste viscosity and good pigment stabilization while offering good outdoor durability.
ADDITOL® XL 6574	70	3500	Acrylic	16	–	**Cross-linkable** grinding medium with excellent compatibility in refinish & industrial paints.
ADDITOL® XL 6589	65	Industrial	Thermo-plastic	7	–	Thermoplastic grinding medium with excellent compatibility with resinsused in VR and industrial paints offering high pigment loading, low grind viscosity, and anti-settling without impacting paint film hardness.
ADDITOL® XW 6535	45	2500	Alkyd modified co-polymer	–	18	Auto-emulsifying **universal** grinding medium for **solventborne and waterborne** paint tinting systems used in architectural and light industrial applications.
ADDITOL® XW 6565	38	5000	Comb Polymer	–	32	Auto-emulsifying multi-functional **universal** grinding medium, designed for **solventborne, waterborne, and all low VOC** decorative paints, offering excellent outdoor durability.
ADDITOL® XW 6581	50	170	Low MW polymer	–	–	Ionic and nonionic surfactants, grinding aide to support grinding mediums to improve grinding viscosities and helps prevent pigment deflocculation, and is **nonylphenol ethoxylate and VOC-free**.

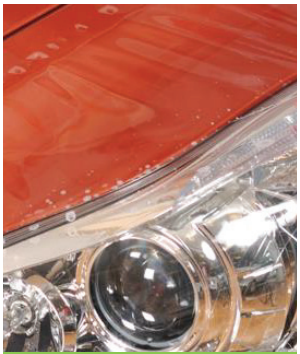
Defoamer



During production and handling, the increased volume by foam and the incorporated air will cause handling and filling problems. After application of coatings, air inside the system should leave the film while the viscosity is low enough to allow bubble marks to reflow. These larger bubbles are macro foam, which is eliminated by Defoamers. The dispersed air in the system which remains is called micro foam. Deaerators or air release agents carry these very small bubbles to the surface of the liquid phase. Highly viscous and intense pseudoplastic paints applied at high wet film thicknesses, e.g., by an airless spray gun, are susceptible to entrapped foam. The foam within the coating may lead to pinhole formation and can weaken the anti-corrosion performance of paints.

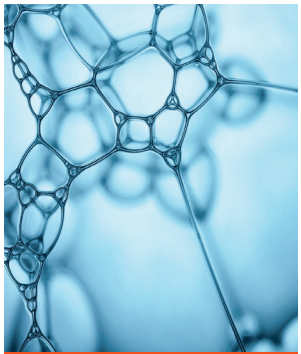
Defoamer Highlights

Scan to learn more



ADDITOL® XL 6507
– Airless –

- Polymer defoamer and deaerator for high solids systems
- Highly efficient
- Silicone-free, reflow effect avoids crater formation
- Excellent compatibility. It avoids haze and optical defects in many transparent systems



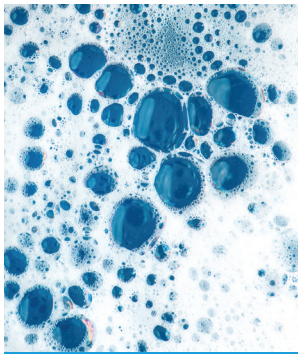
ADDITOL® XW 6567
– FDA Compliant –

- 100% active silicone-free defoamer for waterborne applications
- Shear stable under high shear (high shear needed for incorporation)
- High efficiency in foam destruction
- Can be added at any stage



ADDITOL® XW 6585
– Grind or Let Down –

- Silicone emulsion defoamer
- Highly effective
- Emulsifier-free technology
- Low dosage
- VOC free
- 25% silicone content



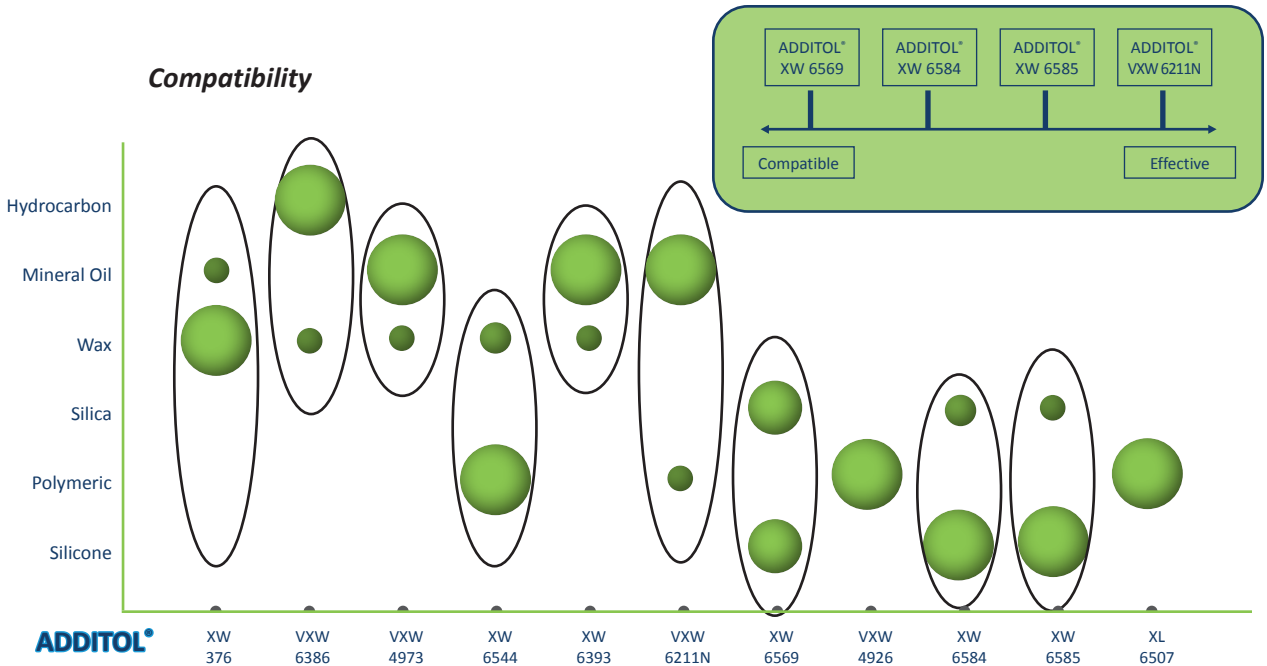
ADDITOL® XL 6531
– Knock Out –

- Solution of foam-destroying polymers for 100%, high solids, or solventborne systems.
- Highly effective
- Pigmented or transparent systems

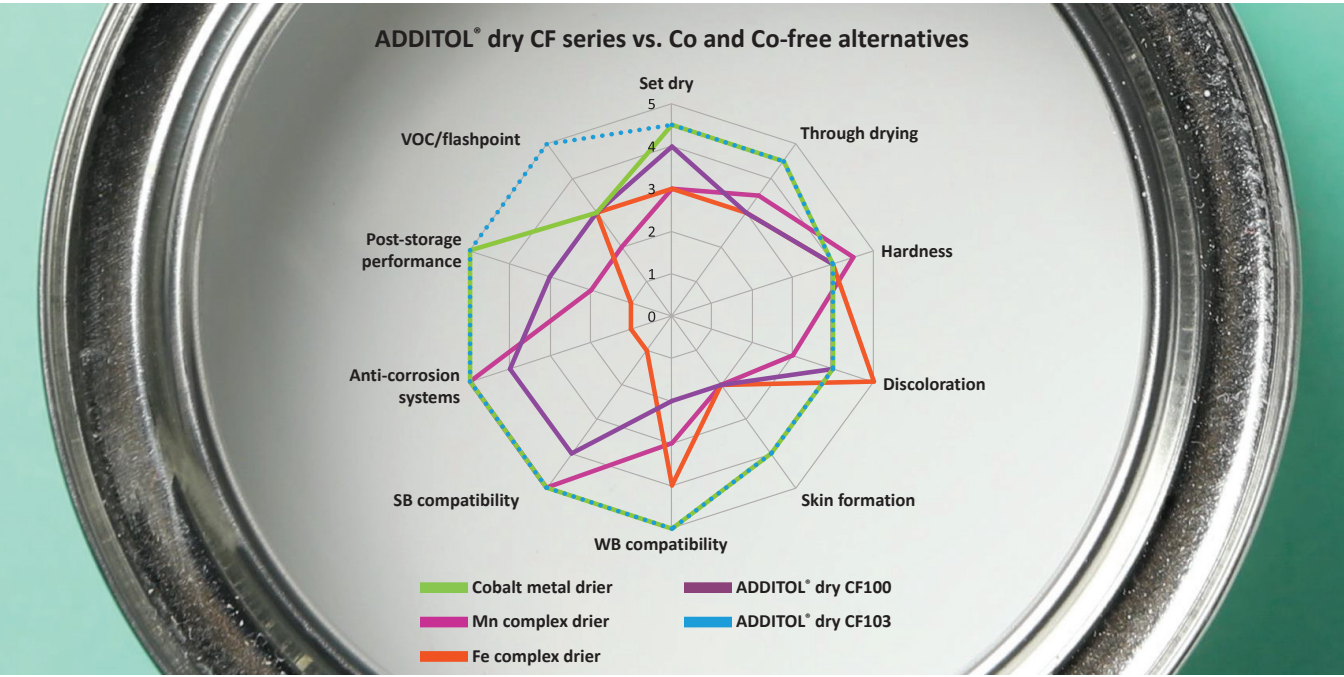
Defoamer

	Active %	Chemistry	Dosage %	Attributes / Uses
ADDITOL® VXW 4926	100	Fatty acid	2.0 - 15.0 % (binder)	Balance of defoaming and deairing performance for **aqueous** solutions that is **cross-linkable**, an excellent option for high film build applications.
ADDITOL® VXW 4973	100	Mineral oil and wax	0.1 - 0.6 %	Highly efficient mineral oil and wax defoamer for **waterborne coatings** offering robust performance in a variety of markets and applications.
ADDITOL® VXW 6211	100	Hydrocarbon and silicone	0.05 - 0.5 %	For pigmented paints or pigment pastes, one of the most effective defoamers for **conventional waterborne systems**.
ADDITOL® XL 6507	10	Polymeric	0.1 - 1.5 %	Polymer defoamer that offers efficiencies like silicone or hybrid silicone perfluorinated polymers, ideal for **UV/EB and conventional high solids and solventborne coatings**.
ADDITOL® XW 376	50	Mineral oil	0.05 - 0.5 % (paint)	Cost-effective, highly efficient, easy to incorporate defoamer for **UV/EB and conventional water-based** coatings, shear stable, alkali resistant (up to pH of 13), and excellent product for **consolidation of SKU for aqueous applications**.
ADDITOL® XW 6393	100	Mineral oil	0.1 - 0.5 %	Highly efficient low-odor defoamer for **aqueous** industrial and architectural paints.
ADDITOL® XW 6544	100	Polymeric	0.05 - 0.5 %	Highly efficient defoamer with excellent re-flow effect improves surface quality for **conventional and UV/EB waterborne systems**, **perfect product for SKU simplification**.
ADDITOL® XW 6569	20	Hydrophobic	0.05 - 0.5 %	Well-balanced, emulsifier-free defoamer/deaerator for transparent and high gloss systems, species no impact on rheology modifiers or re-coatability.
ADDITOL® XW 6585	25	Silicone	0.2 - 1.0 % (paint)	Emulsifier-free silicone defoamer modified with hydrophobic polymers to produce a **highly effective** defoamer for clear and pigmented **conventional and UV/EB water-based coatings**, XW 6585 does not interfere with rheology modifiers such as associative thickeners, and **VOC-, mineral oil-, and APEO- free**.

Defoaming Comparison

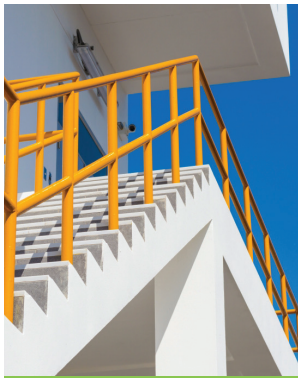


Oxidative Driers



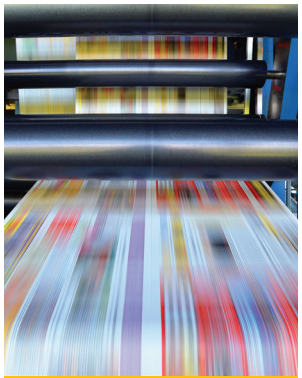
Oxidative Driers Highlights New Cobalt Free (CF) Driers!

Scan to learn more



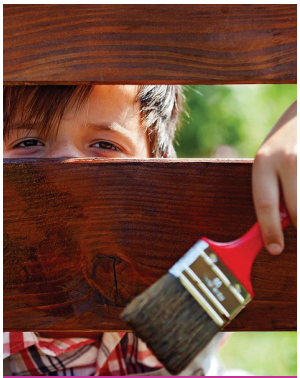
ADDITOL® dry CF 100
– Air dry reinvented –

- High performance manganese ligand for cobalt drier without increasing drying time and loss of performance for solventborne & waterborne alkyds
- Faster tack-free than cobalt
- Less surface skin



ADDITOL® dry CF 103
– Safe and strong –

- Cobalt free / solvent free drier for quick dry printing inks
- Waterborne & Solventborne systems
- Outstanding drying performance in natural oils and stain systems



ADDITOL® dry CF 200
– Surface focus –

- Combination of Li/Zr emulsified for easy stir in
- Excellent paint compatibility
- Waterborne & Solventborne systems
- Super-fast surface dry



ADDITOL® dry CF 300
– Through & Through –

- Combination of Zr/Ba emulsified for easy stir in
- Waterborne & Solventborne systems
- Crosslinks paint bulk giving excellent chemical resistance
- Good surface dry characteristics

Oxidative Driers – Usage



Dosing and other aspects

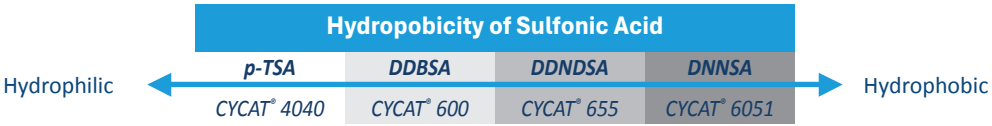
- Can be added directly to the paint system **at any stage** of production
- Dosages of **0.3 to 0.9%** (calculated on solid binder) recommended for medium-solids and water-borne alkyds
- Ultra high-solids alkyds require **up to 1.3%**
- When directly replacing cobalt in existing formulations, **ADDITOL® dry CF 100/103** can be used at the same add levels as a **cobalt 10% solution**
- The new products can be **combined** with all common secondary and **auxiliary driers**, e.g., aluminum, barium, calcium, lithium, potassium, strontium, zinc, or zirconium
- On occasion, the auxiliary driers have to be adjusted when switching from cobalt to our new products – experience shows **higher requirements of zirconium**

ADDITOL® dry CF 100	ADDITOL® dry CF 200	ADDITOL® dry CF 300
Cobalt-free Primary Drier	Cobalt-free Auxiliary Driers	
• Best dry time and storage stability • Best solvent-based performance	• Barium/Zirconium • High gloss systems • Good pigment wetting	• Lithium/Zirconium • Can be used in system where cure at lower temperatures is needed

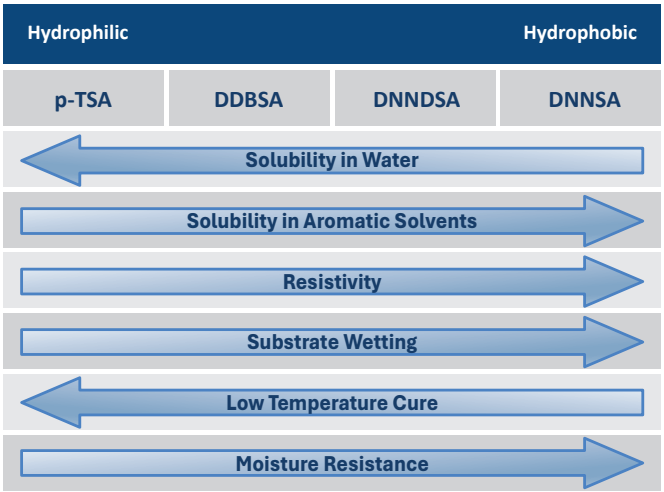
Oxidative Driers and Anti-Skinning

	Viscosity (cps)	Primary Metal	Secondary Metal	Secondary Metal	Attributes
ADDITOL® dry CF100	100	1% Mn	–	–	Excellent compatibility and fast incorporation in **all solventborne and waterborne** alkyd paints offering good hardness, less discoloration versus cobalt.
ADDITOL® dry CF103	100	1% Mn	–	–	Allows leveling and substrate wetting without strong wrinkling tendency.
ADDITOL® dry CF200	300	–	10% Zr	3% Li	Optimizes oxidative drying in **waterborne and solventborne** alkyd formulations.
ADDITOL® dry CF300	300	–	8.1% Zr	4.6% Ba	**Recommended to be used together with ADDITOL dry CF 100** for oxidative drying waterborne and solventborne alkyd resin paints.
ADDITOL® VXW 4940N	4000	3% Co	5% Zr	3% Ba	Pre-emulsion for easy incorporation Quick set-drying with an even trough-drying for **water dilutable** alkyds.
ADDITOL® VXW 6206	700	5% Co	7.5% Zr	0.22% Li	Especially suitable for externally emulsified alkyd resin emulsions.
ADDITOL® XW 6533	350	1.2% Mn	12% Zr	–	May be added as siccative to all **waterborne** oxidatively drying alkyd resin paints.
ADDITOL® XL 297	–	–	–	–	100% active oxime resin type that prevents in-can skinning for oxidative drying systems for **aqueous and solvent solutions**.
ADDITOL® XL 109/50LG	–	–	–	–	50% active phenol resin type that prevents in-can skinning for oxidative drying systems for **aqueous and solvent solutions**.

CYCAT® Sulfonic Acid Catalysts Technology Overview



- p-TSA
  - Strongest acidity
  - Lowest equivalent weight
  - Fastest cure response
  - Most economic
  - General industrial, industrial wood, and coil
- DDBSA
  - Higher electric resistance – electrostatic spray
  - FDA compliant
  - OEM automotive, packaging, and coil
- DNNSA and DNNDSA
  - Highest hydrophobicity and color
  - Best corrosive and hydrolysis resistance
  - Mainly coil



Catalyst Highlights

Scan to learn more



CYCAT® 6419
– Corrosion Resistance –

- Epoxy bonded DNNSA catalyst mainly for colored coil coating.
- Provides the best flow, wrinkle resistance, flexibility, and superior corrosion resistance
- PMN under review, check with local sales rep regarding region availability



CYCAT® 6020/CYCAT® 6325
– Automotive Clear Coat –

- CYCAT® 6020 amine blocked DDBSA catalyst designed for high gloss, DOI appearance.
- CYCAT® 6325 amine blocked DDBSA designed for faster cure response clear coat
- PMN filed and SNUR drafted, expected TSCA listing 2025



CYCAT® 6925
– Packaging Coating –

- Amine-neutralized DDBSA
- FDA 21 CFR Section 175.300 compliant catalyst for interior packaging coating
- PMN under review, check with local sales rep regarding region availability



CYCAT® 6838
– Improved Performance –

- CYCAT® 6838 polymer bonded DDBSA catalyst for OEM clear coats with very low color.

allnex ADDITIVES

Acid Catalysts - Unblocked

	Chemistry	Active %	Acid #	Gardner Color	Minimum Cure	Attributes / Uses
CYCAT® 296-9	DMAP Isobutanol	50	155-165	1	110°C	A derivative of pyrophosphoric acid catalyzes the reaction of partially alkylated and high imino amino resins.
CYCAT® 4040	p-TSA Isopropanol	40	130-140	1	RT	The most versatile and popular catalyst that can be used in **waterborne and solventborne** thermoset applications.
CYCAT® 600A	DDBSA Isopropanol	70	130-140	4	RT	Preferred over p-TSA for low alcohol containing systems; provides improved resistivity for electrostatic spray. Complies with FDA 21 CFR, Sec. 175.300 (b) (3) xiii (a&b).
CYCAT® 6051	DNNSA Butanol	50	60-65	>18	125°C	Best water and corrosion resistance for high-temperature applications on metal, ideal for coil.
CYCAT® XK 406N	Phosphate Xylene/ Butanol	17	100-112	2	80°C	A derivative of phosphoric acid designed for use in interior can coatings. **FDA 21 CFR 175.300 approved**, complies with FDA 21 CFR, Sec. 175.300 (b) (3) xiii (a&b).

Acid Catalysts - Blocked

	Chemistry	Active %	Density g / ml	Gardner Color	Minimum Cure	Attributes / Uses
CYCAT® 4045	p-TSA Ethylene glycol	20	1.16	1	100°C	Providing excellent formulated package stability and flow properties.
CYCAT® 4107	p-TSA Ethylene glycol	25	0.98	1	80°C	Designed to help build a wrinkle finish.
CYCAT® 6020	DDBSA Isopropanol	40	0.90	2	120°C	It is neutralized to improve flow properties, resulting in an excellent appearance and color that makes it ideal for automotive clearcoat.
CYCAT® 6025	DDBSA Isopropanol	25	0.85	2	120°C	Widely used in the automotive market but has applicability in general industrial and metal applications, offers improved cure speed over CYCAT® 6020.
CYCAT® 6030	DDBSA Isopropanol	30	0.90	2	120°C	Partially neutralized to improve cure response, excellent for applications using solventborne topcoat over a waterborne basecoat.
CYCAT® 6323	DNNSA n-Butanol	21	0.87	–	150°C	A new amine-blocked DNNSA catalyst offers **excellent humidity, detergent, and thermal resistance and excellent solubility** in aromatic and aliphatic solvents, ideal for coil applications.
CYCAT® VXK 6395	p-TSA Isopropanol	25	0.95	1	80°C	It has the **lowest onset cure temperature** compared to CYCAT® 4045, making it an excellent course for low-temperature applications. It also has outstanding stability.

Catalyst Highlights - Powder

Scan to learn more



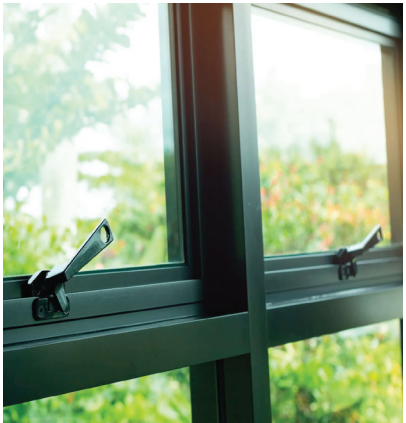
ADDITOL® P 963

- Use for Indoor/Outdoor:
  - Hybrid
  - TGIC
  - PT-910 systems
- 5% active in carboxylated polyester



ADDITOL® P 964

- Use in Indoor/Outdoor
  - Hybrid
  - TGIC
  - PT-910
- 5% active in carboxylated polyester



ADDITOL® P 966

- Super durable
- Use in outdoor
  - TGIC
  - PT-910
- 5% active in carboxylated polyester

ADDITOL® P963 is like ADDITOL® P964, with regional preference determining the choice of product.

Hardener Highlights – Powder

Scan to learn more



ADDITOL® P 932

- Aliphatic Urethane Hardener
- Blocked NCO
- Outdoor applications

ADDITOL® P 965

- Aromatic Urethane Hardener
- Blocked NCO
- Indoor applications



ADDITOL® P 791

- Aliphatic Polyanhydride
- Use with Acrylic systems
- Automotive clear coats
- Excellent flow & chemical resistance

BECKOPOX® EH 694

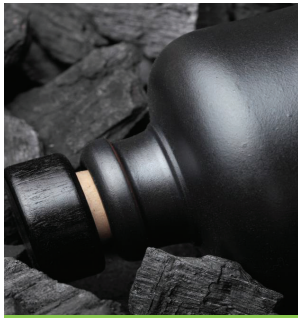
- Anhydride hardener for
- Hydroxyl polyester, acrylic, or epoxy resins
- Outstanding chemical & Overbake resistance



SYNTHACRYL® 700

– Dull matte –

- Acrylic hardener for use with polyester resin systems
- Indoor & outdoor applications
- Tg ~ 80
- EEW, G/eq - 770



SYNTHACRYL® 710

- Flexible dull matte -

- Acrylic hardener for use with polyester resin systems
- High flexibility
- Indoor & outdoor applications
- Tg ~ 54
- EEW, G/eq - 610

Rheology Highlights

Scan to learn more



ADDITOL® VXW 6387
– Body Builder –

- Supports in-can stability
- Builds baseline paint rheology
- Helps prevent inorganic pigment settling
- Sag prevention



ADDITOL® VXW 6360 & VXW 6388
– Clear Associations –

- Blend to achieve best low and mid shear viscosity profile
- Excellent weatherability
- Flat through gloss applications



SETALUX® 10-1302
– Orientation Focus –

- Excellent application properties, and sag performance
- Superior outdoor durability
- Excellent flexibility and yellowing resistance



SETALUX® 10-6266
– Covers Edges –

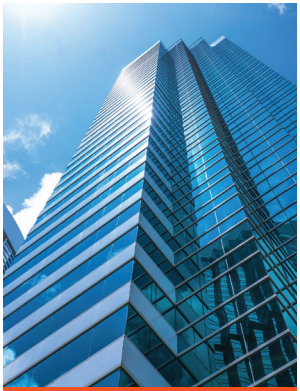
- Balances sag improvement with good leveling yields
- High DOI performance
- High shear durability gives manufacturing flexibility
- No negative impact on hardness and scratch resistance

Rheology Modifiers

	Active %	Markets	Chemistry	Solvents	Attributes / Uses
ADDITOL® AQ 1680	30	Decorative	ASE	Water	Alkali swellable rheology modifier.
ADDITOL® VXW 4934	35	Decorative	Modified wax	Water	Improves edge crawl and sagging limits for dip and spray applications respectively while plus prevents pigment settling (waterborne only).
ADDITOL® VXW 6360	30	Decorative	Polyurethane	Water/BDG	Associative thickener that can be added to grind or letdown, ideal for high shear application i.e., roller or paint brush.
ADDITOL® VXW 6387	60	Decorative	mod. fatty acid	MP	Co-dispersant that imparts anti-settling performance, added during the grinding process can act as a thickener.
ADDITOL® VXW 6380/6388	30/35	Decorative	Polyurethane	Water/BDG	Associative thickeners, VXW 6388 low shear incorporation ideal for spray, VXW 6360 med to high shear incorporation for brush or roller applications.
ADDITOL® XL 280	36	Decorative	Pre-activated montmorillonite clay	SNA	Strong anti-sagging and pigment anti-settling agent for **conventional solventborne coating**.
ADDITOL® XW 6536	50	Decorative	Pre-activated organic clay	Water	Improves viscosity recovery, making it **ideal for high film build** applications, and imparts anti-sagging and anti-settling properties.
SETALUX® 10-1302	50	Automotive	Microgel	Mix	Low-viscosity microgel that improves metal flake orientation. Acid Number ~ 5. Solvent mix: methyl n-amyl ketone / VM&P naphtha / heptane.
SETALUX® 10-6266	50	Automotive	Acrylic - RCA	Mix	Low viscosity rheology control agent that imparts sag resistance properties and provides improvements in appearance, DOI, and clarity. Acid Number ~ 6. Solvent mix: methyl n-amyl ketone / aromatic 100

Adhesion Promoters Highlights

Scan to learn more



ADDITOL® XW 6598
– Surface Synergy –

- Waterborne polyolefin dispersion
- Halogen-free
- PP adhesion promoter
- Whitish/opaque in appearance



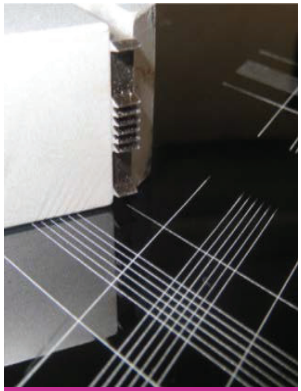
ADDITOL® XW 6599
– Grip Assurance –

- Waterborne chlorinated polyolefin dispersion
- PP adhesion promoter
- Light brown/opaque in appearance



DAOTAN® 6476
– Enduring Hold –

- Waterborne PUD-modified polyolefin dispersion
- Halogen-free
- Emulsifier free
- Unique viscosity behavior with rheology modifiers
- Pseudoplasticity



EBECRYL® 171
– Superior Adhesion –

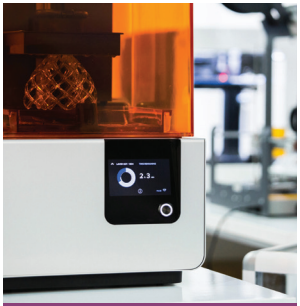
- Acidic methacrylate adhesion promoter for wood, plastics, and metal substrates for UV/EB coatings
- Excellent compatibility with UV/EB chemistries

Adhesion Promoters

	Active %	Viscosity (cps)	Chemistry	Functionality	Acid Value	Attributes / Uses
EBECRYL® 303	100	600	Acrylic Acrylate	2	–	Improves adhesion to plastic and metal through reduced volumetric shrinkage upon cure without any impact on outdoor durability for **UV/EB applications**.
ADDITOL® XW 6598	30	10-200	Polyolefin dispersion	–	–	**Halogen-free** polyolefin improves adhesion to low surface energy substrates such as polypropylene in **aqueous** solutions.
ADDITOL® XW 6599	30	10-2000	Polyolefin dispersion	–	–	Chlorinated polyolefin is designed to improve adhesion to low surface energy substrates such as polypropylene in **aqueous** solutions.
DAOTAN® 6476	30	10-200	Polyolefin dispersion	–	–	PUD is designed to improve the adhesion of **aqueous** solutions to low surface energy plastic such as polypropylene.
EBECRYL® 168/170/171	100	1350, 3000, 1200	Acidic (Meth)acrylate	1.5 - 2.0	~300	Phosphoric acid adhesion promoter for **UV/EB application** for improving adhesion to plastic, wood, or metal substrates, EBECRYL® 171 offers the best compatibility.
EBECRYL® 367	100	1500	Polyester Acrylate	3.0	–	Ink & varnish adhesion promoter. Low color & acid value. Excellent adhesion on corona-treated polyolefin substrates.
EBECRYL® B-CEA	100	3000	Carboxylic acid	1.0	350	UV/EB reactive monomer that has carboxylic and acrylic functionality in the same backbone. Excellent adhesion promoter for plastic, wood, glass, or metal substrates.

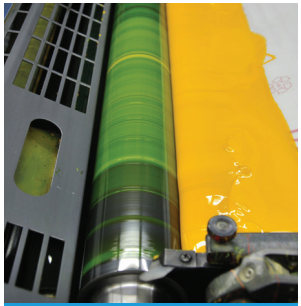
Cure Boosters for UV/LED/EB Applications Highlights

Scan to learn more



EBECRYL® LED Cure 02

- Thiol acrylate
- Minimum Odor
- Thermally stable
- Significantly improve cure response in LED, UVA, and low intensity applications
- Maximizes photoinitiator efficiencies by reducing the effect of oxygen inhibition



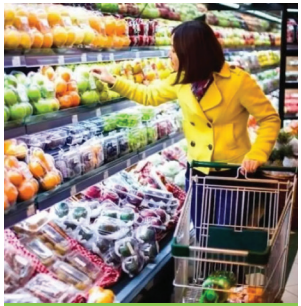
EBECRYL® LED 04

- Amino Polyether Hexa-acrylate
- Low migration profile, making LED 04 an ideal building block for low extractable applications such as food packaging applications
- Excellent compatibility over a wide range of UV/EB chemistries
- Excellent storage stability and ink flow performance



EBECRYL® LED 05

- Amino Polyether Hexa-acrylate
- Low migration profile, making LED 05 an ideal building block for low extractable applications such as food packaging applications
- Robust formulating latitude and excellent compatibility with a wide range of UV/EB chemistries
- Excellent formulation and ink storage stability and performance



EBECRYL® LEO 10103

- Self-Curing resin
- Excellent compatibility over a wide range of UV/EB chemistries
- Polymeric photoinitiator reducing migration concerns, making LEO 10103 ideal for pigmented and clear systems used in food packaging applications

Cure Boosters for UV/EB

	Active %	Viscosity (cps)	Chemistry	Functionality	Amine Value	Attributes / Uses
EBECRYL ® 7110	100	1200	Amine Co-initiator	1.5	–	Low color (Gardner <0.5) amine acrylate improves the cure response of clear and pigmented coatings, improves adhesion, and reduces water sensitivity.
EBECRYL ® LED 02	100	275	Thiol acrylate	3.0	–	Excellent compatibility and stability with a wide range of UV/EB chemistries, dramatic improvement in cure response in clear and pigmented coatings, low yellowing upon cure, and increased surface cure.
EBECRYL ® LED 03	450	450	Polyether amine acrylate	2.0	165	Suitable for food contact applications due to its low migration profile, low viscosity makes it ideal for inkjet applications.
EBECRYL® LED 04	100	17500	Polyether amine acrylate	6.0	110	Suitable for food contact applications due to low migration profile, improves surface cure, robust pigment, and letdown paste storage and stability.
EBECRYL® LED 05	100	7500	Polyether amine acrylate	6.0	95	Suitable for contact applications due to its low migration profile, outstanding pigment compatibility, stability, and storage of pigment paste and letdown vehicle while offering an excellent boost in surface cure reactivity.
EBECRYL ® LEO 10101/10103	100	3500/6000	Self-curing acrylate	1.5	–	Polymeric PI has low extractable making it ideal for food contact applications, reduces the need for photoinitiators, improves reactivity, and offers excellent compatibility and storage stability.
EBECRYL ® P - 115	100	30	Tertiary amine co-initiator	1.0	238	Co-initiator that works as a hydrogen donor or photo-activator to improve cure response in the presence of a photosensitizer such as benzophenone, reduces the impact of oxygen inhibition at ink surface to maximize photoinitiator effect(s).

Special Effect Highlights

Scan to learn more



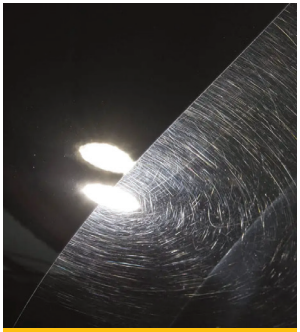
ADDITOL® P 950
– Tribo spray gun –

- Excellent powder stability
- Indoor and Outdoor applications
- Designed for use in Hybrid, HAA, TGIC, Polyurethane, and PT-910 systems
- 5% active on Hydroxylated Polyester



ADDITOL® P 920
– It's in the Wrinkle –

- Additive partner for CRYLCOAT® 2920-0
- Use in Glycoluril systems
- Easily tune in the level of wrinkle
- Transparent or pigmented paints
- Friendly formulations
- 5% active on Hydroxylated Polyester



MODAFLOW® NSR 100
– Scratch Resistance –

- Concentrated dispersion of nano silica
- Use in automotive OEM, vehicle refinish, plastic and wood clearcoats as well as pigmented topcoats
- Excellent compatibility with a broad range of acrylics and polyester

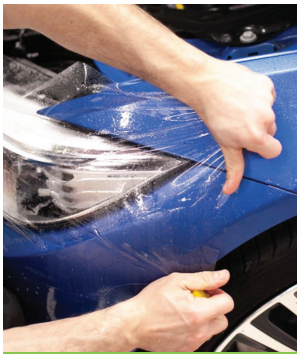


EBECRYL® 898
– Extends Matting Effect –

- 100% solids polyester acrylate resins that enables matte finishes in UV energy curable coatings
- Provides an outstanding toughness and adhesion
- High surface hardness

Special Effect Highlights

Scan to learn more



RESAMIN® HF 480
– Flexible –

- 100% active special plasticizing additive to improve flexibility in physical, force drying, 2K, and stoving solventborne paints
- Excellent for improving metallic flip/flop effects
- Also improves adhesion and gloss
- Heat and hydrolytically stable



TUNGOPHEN® B NV
– Oxidative Drier Control –

- Accelerates the through drying of oxidative solventborne coatings to improve gloss
- Reduces surface defects even in thick films
- Especially recommended for pigment (non-white) medium length oil alkyd resins



ADDITOL® XW 6536
– Hold Please –

- Organic activated clay that imparts extremely fast viscosity recovery
- Excellent options for high film build application
- Prevents sagging and settling



SETAL® 10-1803
– Wet on Wet –

- Sag control agent for 1K and 2K clear coats
- Does not impact coating durability, DOI or non-yellowing properties while maintaining excellent color retention
- Targeting metallic automotive systems

We trust this overview has given you a clearer understanding of the wide range of additives offered by allnex. For more details or any questions, please don't hesitate to contact us.

allnex ADDITIVES

*All values listed in tables are typical values and not specifications.

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