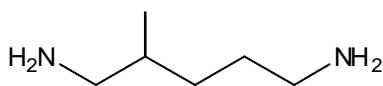
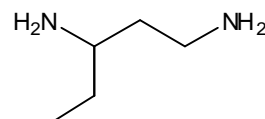


Epoxy Curing with INVISTA Specialty Amines: FAST FACTS



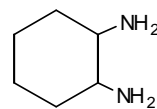
DYTEK® A amine
2-Methylpentamethylenediamine



DYTEK® EP diamine
1,3-Pentanediamine



DYTEK® BHMT-HP amine
Bis(hexamethylene)triamine



DYTEK® DCH-99 amine
1,2-Diaminocyclohexane

INVISTA specialty amines provide excellent properties when used as formulated adducts in the curing of epoxy systems for coatings, civil engineering, adhesives, laminates, composites, electrical and electronic applications. FAST FACTS provides a handy guide to selecting the best amine-adduct curing agent for your needs. Note that the relative order of properties shown below is dependent on the particular formulation used and is only intended as a general guide. Isophoronediamine (IPDA) has been included for comparative purposes. For additional details on formulating with INVISTA specialty amines, please see the Technical Information Sheet, Epoxy Curing with INVISTA Diamines, available from INVISTA Intermediates.

Advantages of INVISTA Specialty Amines

- **DYTEK® A amine:** Fast curing, provides high toughness and flexibility. Good for low temperature curing.
- **DYTEK® EP diamine:** Low color products, provides longer pot life than DYTEK® A amine.
- **DYTEK® DCH-99 amine:** Gives coatings with excellent chemical resistance. Imparts high Tg for composite applications.
- **DYTEK® BHMT-HP amine:** Unique product for softer, flexible coatings.

Property Selection Guide

- **Viscosity:** IPDA >> DYTEK[®] A amine > DYTEK[®] DCH-99 amine > DYTEK[®] EP diamine (for ease of mixing, handling, application)
- **Adduction Ratio:** DYTEK[®] DCH-99 amine >> IPDA (This means you can pack more curing agent power into a pound of DYTEK[®] DCH-99 amine adduct than into a pound of IPDA adduct.)
- **Pot Life:** DYTEK[®] BHMT-HP amine >> IPDA > DYTEK[®] DCH-99 amine > DYTEK[®] EP diamine > DYTEK[®] A amine
- **Gel Time:** DYTEK[®] DCH-99 amine > IPDA > DYTEK[®] EP diamine > DYTEK[®] A amine
- **Coating Hardness (Shore D):** IPDA ~ DYTEK[®] DCH-99 amine > DYTEK[®] A amine > DYTEK[®] EP diamine
- **Coating Gloss:** DYTEK[®] DCH-99 amine > DYTEK[®] A amine > DYTEK[®] EP diamine

• Chemical Resistance:

- **Water:** DYTEK[®] DCH-99 amine > IPDA > DYTEK[®] A amine > DYTEK[®] EP diamine
- **Hydrocarbon Solvents:** All are comparably good.
- **Dilute Aqueous Mineral Acids:** DYTEK[®] DCH-99 amine > IPDA > DYTEK[®] EP diamine >> DYTEK[®] A amine
- **Dilute Aqueous Acetic Acid:** IPDA > DYTEK[®] DCH-99 amine > DYTEK[®] EP diamine >> DYTEK[®] A amine
- **Dilute Aqueous Caustic:** DYTEK[®] DCH amine ~ IPDA > DYTEK[®] A amine > DYTEK[®] EP diamine

For Samples and Information:

INVISTA[™] Specialty Intermediates • (800) 231-0998

www.DYTEK.INVISTA.com

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