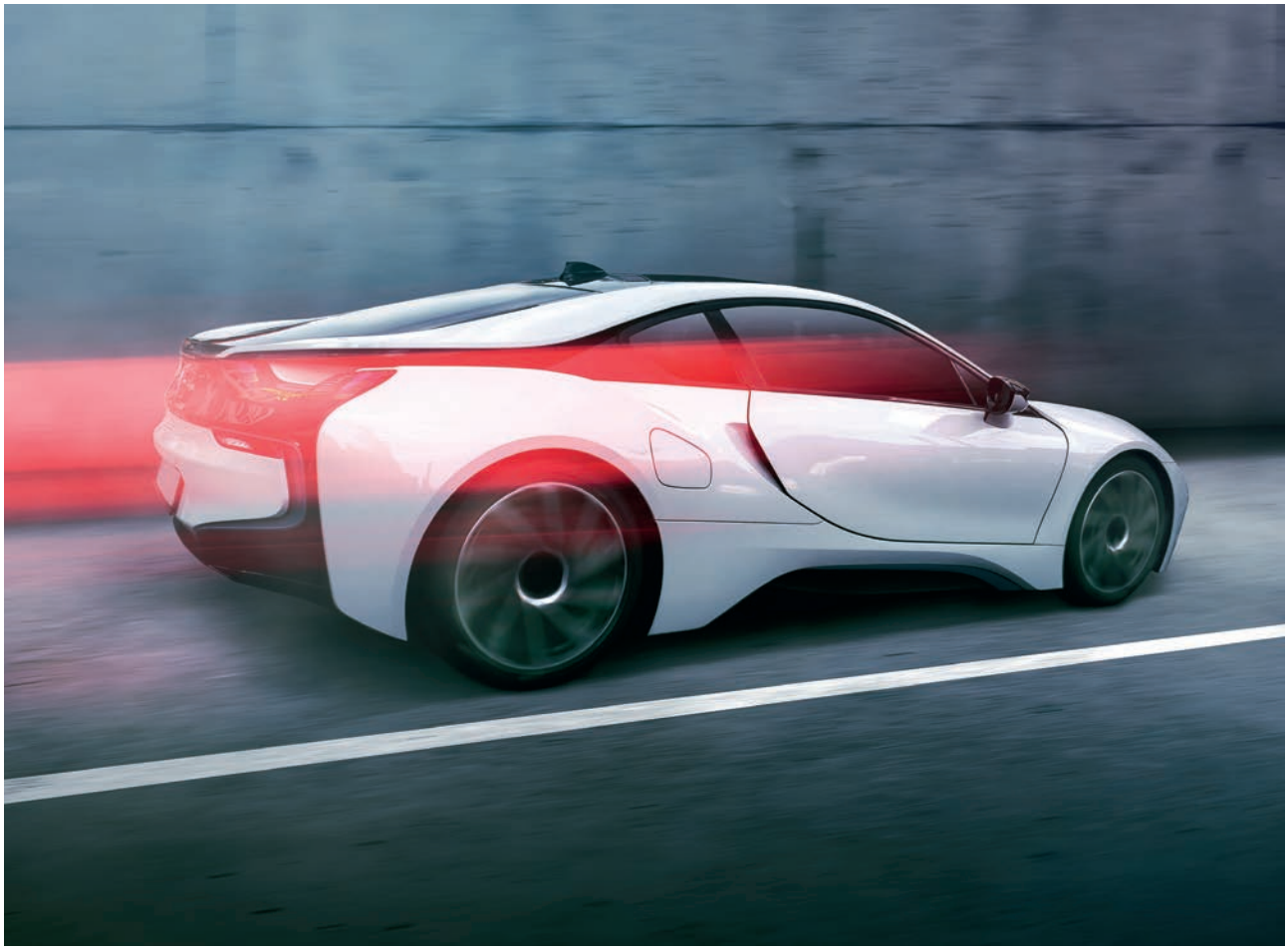
POLYURETHANE ADDITIVES FOR AUTOMOTIVE INTERIORS

SEATING
INSTRUMENT PANELS
NVH
STEERING WHEELS

ASIA



EVONIK
Leading Beyond Chemistry

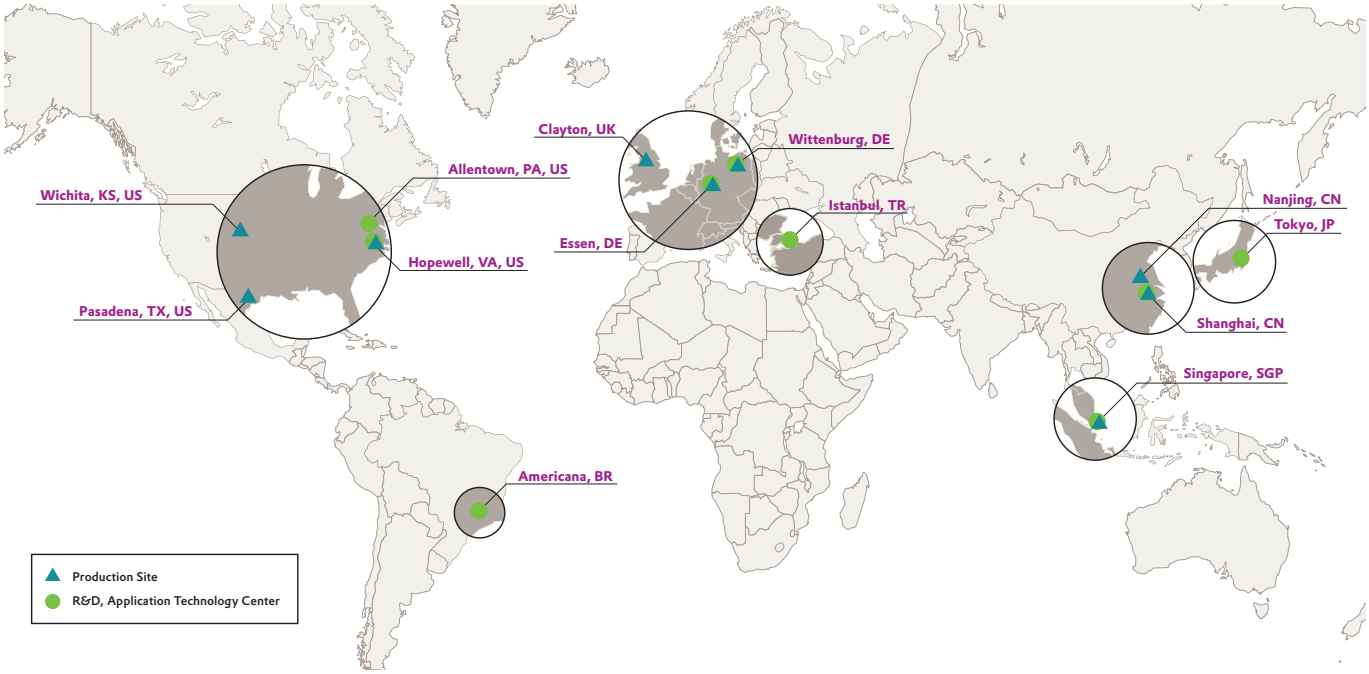
EVONIK – Driving the Polyurethane Industry

Evonik is the global leader in polyurethane additives, offering the broadest range of catalysts, surfactants, release agents and performance additives to the automotive industry.

By working closely with our customers, we continually stay ahead of the latest trends and issues impacting the automotive market, enabling us to proactively develop breakthrough products and innovative solutions to answer changing market demands.

With manufacturing and laboratories spanning the globe, we are well positioned to serve your needs, now, and in the future.

WE ARE WHERE YOU ARE



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Our vision is to be the leading additives *partner* to the automotive industry by providing sustainable products that offer optimal processing, whilst targeting the lowest VOC and odor possible to optimize *value* for our customers.

CATALYSTS

Our latest Negligible Emission grades offer reduced emissions compared to conventional amines, resulting in lower exposure to VOC's for both worker and consumers.

Catalyst Selection Chart

	Blow	Balanced	Gel	MDI	TDI / MDI	TDI	Delayed Action	Seating	NVH	Steering Wheels	Instrument Panels	VDA 278	Chamber Test	Improved Surface Appearance
DABCO® 33 LV			✓	✓	✓	✓		✓	✓	✓	✓			
DABCO® 33 LX			✓	✓	✓	✓		✓	✓	✓	✓			
DABCO® 8154			✓	✓	✓	✓	✓	✓	✓					
DABCO® CRYSTALLINE			✓	✓	✓	✓		✓	✓	✓	✓			
DABCO® DC 5 LE			✓	✓	✓			✓	✓	✓			✓	
DABCO® 3040 A		✓		✓	✓	✓		✓	✓	✓	✓			
DABCO® MP 608		✓		✓	✓	✓	✓	✓	✓	✓	✓			
DABCO® BL 11	✓			✓	✓	✓		✓	✓					
DABCO® BL 17	✓			✓	✓	✓	✓	✓	✓					
DABCO® MP 615		✓		✓	✓			✓	✓	✓	✓	✓	✓	✓
DABCO® NE 300	✓			✓	✓	✓		✓	✓	✓	✓	✓	✓	
DABCO® NE 310	✓			✓	✓	✓		✓	✓	✓	✓	✓	✓	
DABCO® NE 317	✓			✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	
DABCO® NE 1050			✓	✓	✓	✓		✓	✓	✓	✓	✓	✓	
DABCO® NE 1065 A		✓		✓	✓			✓	✓	✓	✓	✓	✓	✓
DABCO® NE 1065 BF NEW		✓		✓	✓	✓		✓	✓	✓	✓	✓	✓	✓
DABCO® NE 1066		✓		✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓
DABCO® NE 1070			✓	✓	✓	✓		✓	✓				✓	
DABCO® NE 1075 NEW		✓		✓	✓	✓		✓	✓	✓	✓		✓	
DABCO® NE 1082			✓	✓	✓	✓		✓	✓				✓	
DABCO® NE 1091			✓	✓	✓	✓		✓		✓		✓	✓	
DABCO® NE 1550			✓	✓	✓	✓		✓	✓	✓	✓	✓	✓	
DABCO® NE 1600 NEW			✓	✓	✓	✓		✓		✓	✓	✓	✓	✓
DABCO® RE 533 NEW			✓	✓	✓	✓		✓	✓	✓	✓			
DABCO® RE 540 NEW			✓	✓	✓	✓		✓	✓	✓	✓			✓
POLYCAT® 58		✓		✓	✓			✓	✓	✓	✓	✓	✓	✓
POLYCAT® 92		✓		✓	✓	✓		✓	✓	✓	✓			
POLYCAT® 203			✓	✓					✓	✓		✓	✓	

CATALYSTS
Traditional Catalysts

Evonik has been the global leader in polyurethane additives for several decades, offering the broadest range of catalysts to the automotive industry.

	Flash Point, °C (PMCC)	Viscosity @ 25 °C cPs	Water Solubility	Calculated OH Number, mgKOH/g	Product Description
DABCO® 33 LV	>110	125	Soluble	560	Strong urethane reaction catalyst for multipurpose use, liquid (Also known as TEGOAMIN® 33.)
DABCO® 33 LX	>110	223	Soluble	841	Tertiary amine gel catalyst with strong influence on the urethane (polyol-isocyanate) reaction.
DABCO® 8154	110	160	Soluble	548	Delayed action gel catalyst; DABCO® Crystalline based, less corrosive than other delayed-action catalysts.
DABCO® CRYSTALLINE	62	N/A	P. Soluble	N/A	Strong urethane reaction catalyst for multi-purpose use; high-purity triethylenediamine (TEDA).
DABCO® DC 5 LE	178	4,300	Insoluble	138	Low emission, delayed action co-catalyst that strongly promotes the urethane reaction.
DABCO® 3040 A	120	5.6	Soluble	19	A low thermo-sensitive catalyst, excellent surface curing for low mold temperature, improve system processing window.
DABCO® MP 608	65	227	Soluble	569	A delayed balance amine catalyst with optimum flow ability for complex and large parts, especially for MDI rich system.
DABCO® BL 11	71	4	Soluble	251	Strong urea reaction blow catalyst, liquid (Also known as TEGOAMIN® BDE.)
DABCO® BL 17	65	61	Soluble	476	Delayed-action urea reaction catalyst; acid-blocked DABCO® BL 11 catalyst.
POLYCAT® 77	92	3	Soluble	N/A	Balanced gel and blow catalyst that can promote open cells in some applications.

DABCO® NE 1600 IN COMBINATION WITH DABCO® BA 316

Utilising DABCO® NE 1600 in combination with DABCO® BA 316 provides for a unique Negligible Emission catalyst package for TDI and MDI moulded foams.

- Excellent physical properties after humid ageing
- Meets VDA278 specification
- Meets Chamber Test requirements
- Tool for lightweight seating systems

Watch our new DABCO® NE 1600 video on Explore PU

CATALYSTS

Emission-Optimized Amine Catalysts

	Flash Point, °C (PMCC)	Viscosity @ 25 °C cPs	Water Solubility	Calculated OH Number, mgKOH/g	Product Description
DABCO® NE 300	124	9	Soluble	276	Negligible Emission urea reaction blow catalyst for MDI and TDI flexible molded foams. Meets thermodesorption method VDA 278 for VOC and FOG.
DABCO® NE 310	118	12	Soluble	269	Reactive blow catalyst.
DABCO® NE 317	126	40.7	Soluble	585	Reactive delayed blow catalyst.
DABCO® NE 1050	N/A	195	Soluble	514	Reactive gel catalyst for MDI and TDI flexible molded foams.
DABCO® NE 1065 A	88	5	Soluble	282	Negligible Emission reactive gel catalyst with slight blow. Promotes surface cure.
DABCO® NE 1065 BF NEW	88	5	Soluble	282	Negligible Emission reactive gel catalyst with slight blow. Promotes surface cure. Free of 5 major benzenes, when tested in accordance with the Chinese chamber test.
DABCO® NE 1066	94	8	Soluble	271	Emission Optimized reactive delayed gel catalyst, providing for improved surface cure.
DABCO® NE 1070	168	1,200	Soluble	730	Negligible Emission urethane reaction gel catalyst for MDI and TDI flexible molded foam.
DABCO® NE 1075 NEW	99	10	Soluble	230	Low emission reactive balanced-gel catalyst. Provides for a good foam cure.
DABCO® NE 1082	105	280	Soluble	495	Negligible Emission urethane reaction gel catalyst for MDI and TDI flexible molded foam.
DABCO® NE 1091	>93	425	Insoluble	117	Novel non fugitive gel catalyst designed to maintain the TDI based molded foam physical properties after humid aging.
DABCO® NE 1550	>93	579	Soluble	313	Negligible Emission amine that promotes the urethane (polyol-isocyanate) reaction. It reacts into the polyurethane matrix, thereby not contributing to emissions.
DABCO® NE 1600 NEW	>100	423	Soluble	187	Our latest Negligible Emission gel catalyst. Enables formulators to meet stringent OEM targets (VOC and heat-humidity aging) and produce foams that will pass polycarbonate staining tests.
DABCO® RE 533 NEW	80	70	Soluble	742	Emission-optimized gel catalyst based on TEDA. Significantly reduces foam odor in final foam, and amine emissions in the foam manufacturing/production environment.
DABCO® RE 540 NEW	100	85*	Soluble	414	Emission-optimized gel catalyst based on TEDA. Can achieve significant amine emission reduction compared to conventional TEDA-based catalysts, can reduce foam odor in final foam.
POLYCAT® 203	120	725	Soluble	1,109	POLYCAT® 203 is a low water containing, amine-based catalyst for integral skin applications, optimized for use with Liquid Blowing Agents.

* = Viscosity at 23°C

SILICONE SURFACTANTS

Automotive interiors utilize flexible foam technology due to its wide range of density, cushioning ability and versatility of use.

Silicone Surfactant Selection Chart

	MDI	TDI / MDI	TDI	Relative Potency	Seating	NVH	Instrument Panels	VDA 278	Chamber Test
CELL REGULATING SURFACTANTS									
TEGOSTAB® B 8745 LF 2	+++			Very low	*	*	*	✓✓✓	✓✓
TEGOSTAB® B 8715 LF 2	+++	••	•	Low	*	*	*	✓	✓
TEGOSTAB® B 8734 LF 2	+++	•••	••	Medium	*	*	*	✓✓	✓✓✓
TEGOSTAB® B 8734 BF	+++	•••	••	Medium	*	*	*	✓✓	✓✓✓
TEGOSTAB® B 8747 LF 2	+++	•••	••	Medium	*	*	*	✓✓✓	✓✓✓
TEGOSTAB® B 8629	+++	•••	••	Medium	*				
TEGOSTAB® B 8726 LF 2	+++	•••	•••	Medium-high	*	*		✓	✓
TEGOSTAB® B 8724 LF 2 *(mainly serves as a cell regulator in MDI systems and as a stabilizer in TDI systems)*		++	•••	High	*				✓✓✓
TEGOSTAB® B 8751 LCF NEW	+++	•••	••	High	*	*	*	✓✓	✓✓✓
STABILIZING SURFACTANTS									
TEGOSTAB® B 8761 LF 2	••	++	+++	Low-medium	*	*	*	✓✓	✓✓✓
TEGOSTAB® B 8738 LF 2	••	+++	++	Low-medium	*	*	*		✓✓✓
TEGOSTAB® B 8736 LF 2	••	+	+++	Medium-high	*	*		✓✓	✓
TEGOSTAB® B 8742 LF 2		+++	+++	High	*	*		✓✓	✓
TEGOSTAB® B 8737 LF 2			+++	Very high	*				
TEGOSTAB® B 8763 LCF NEW		+	+++	High	*	*		✓✓	✓
LOW ODOR SURFACTANTS									
DABCO® SI 1107 LO NEW	+++	•••	••	Medium	*	*	*	✓✓	✓✓✓
TEGOSTAB® B 8734 LO NEW	+++	•••	••	Medium	*	*	*	✓✓	✓✓✓
TEGOSTAB® B 8734 BF 2	+++	•••	••	Medium	*	*	*	✓✓	✓✓✓
TEGOSTAB® B 8742 LO NEW	+++	•••	••	High	*	*	*	✓✓	✓✓✓
TEGOSTAB® B 8761 LO NEW	••	++	+++	Low-medium	*	*	*	✓✓	✓✓✓

\+ = applicable as single surfactant
++ = recommended as single surfactant
+++ = strongly recommended as single surfactant

• = applicable as co-surfactant
•• = recommended as co-surfactant
••• = strongly recommended as co-surfactant

✓ = Low VOC at lower usage levels
✓✓ = Very low VOC
✓✓✓ = Ultra-low VOC

* = suitable

Silicone surfactants for integral skin foam applications like steering wheels, headrests or armrests

	Density (kg/m³)	Special performance
TEGOSTAB® B 8993	150 – 1,000	A finer, more uniform cell structure is obtained. It improves the compatibility of the raw materials and enhances the mechanical properties.
TEGOSTAB® B 8905	150 – 1,000	Provides a finer and more uniform cell structure. This improves the tensile strength.
TEGOSTAB® B 8930	150 – 400	Is specially designed for ether systems containing water as a blowing agent. It reduces the formation of pinholes, gives a finer cell structure beneath the skin and improves the optical appearance of the surface.

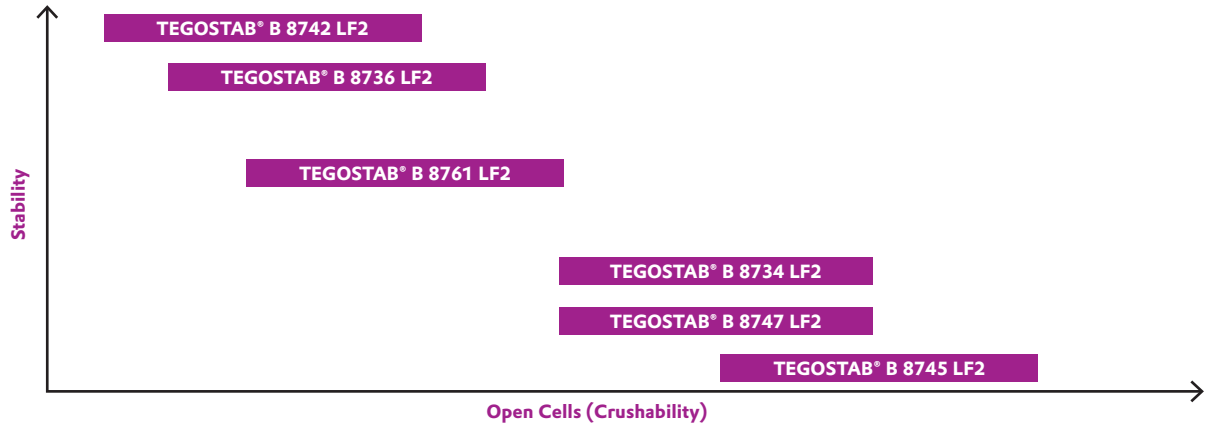
PERFORMANCE

	Calculated OH Number, mgKOH/g	Water Solubility	Flash Point, °C (PMCC)	Viscosity @ 25 °C cPs	Product Description
CELL REGULATING SURFACTANTS					
TEGOSTAB® B 8745 LF 2	52	Soluble	71	75-125	For enhanced MDI/system miscibility and ultra-low VOC.
TEGOSTAB® B 8715 LF 2	82	Insoluble	>180	30-50	Low potency MDI surfactant with low-medium VOC and broad latitude for open foams.
TEGOSTAB® B 8734 LF 2	83	Insoluble	>180	35-55	Very low VOC, medium potency MDI surfactant.
TEGOSTAB® B 8734 BF	83	Insoluble	>180	35-55	Very low VOC, medium potency MDI surfactant, 5 benzene-free and included in sales specification
TEGOSTAB® B 8747 LF 2	51	Soluble	112	75-125	Ultra-low VOC medium potency surfactant with excellent emulsification support.
TEGOSTAB® B 8629	128	Insoluble	115	10-16	Higher potency regulator. Often used in TDI/MDI based molded foam for furniture.
TEGOSTAB® B 8726 LF 2	72	Insoluble	>100	30-50	Regulator with low-medium stabilizing effect. Often recommended for less stable MDI systems (e.g. high monomeric MDI), or MDI/TDI systems.
TEGOSTAB® B 8724 LF 2	79	Insoluble	184	20-40	Strongest cell regulator (for sub-surface void reduction) with moderate stabilizing effect.
TEGOSTAB® B 8751 LCF NEW	84*	Miscible	>100	300	High potency, concentrated emulsion-based silicone surfactant, which offers significantly reduced LCA values.
STABILIZING SURFACTANTS					
TEGOSTAB® B 8761 LF 2	41	P. Soluble	149	120-170	Low-medium potency TDI or TM 20 silicone surfactant providing enhanced emulsification and very low VOC.
TEGOSTAB® B 8738 LF 2	76	Insoluble	166	25-55	Low-medium potency TDI or TM 20 silicone surfactant. Also can be used at lower usage levels as a co-surfactant in mostly MDI based foams.
TEGOSTAB® B 8736 LF 2	72	Insoluble	68	25-45	Very low VOC TDI silicone surfactant with broad processing latitude.
TEGOSTAB® B 8742 LF 2	67	Insoluble	64	20-40	High potency TDI or TM 20 silicone surfactant designed for optimized vibration dampening (reduced transmissivity) foam leading to improved passenger dynamic comfort.
TEGOSTAB® B 8737 LF 2	69	Insoluble	64	20-40	Strongest TDI foam stabilizing silicone surfactant. For most standard formulations too potent as a sole surfactant. Combinations with a cell regulator (e.g. TEGOSTAB® B 8724 LF 2) are recommended.
TEGOSTAB® B 8763 LCF	40*	Soluble	61	170-390	Low Carbon Footprint, high potency surfactant, predominantly for TDI molded foams. Contains ~53% water.
LOW ODOR SURFACTANTS					
DABCO® SI 1107 LO NEW	55	Insoluble	131	490	Ultra-low odor, medium potency MDI surfactant
TEGOSTAB® B 8734 LO NEW	55	Insoluble	171	323	Ultra-low odor & ultra-low aldehyde, very low VOC, medium potency MDI surfactant.
TEGOSTAB® B 8734 BF 2 NEW	55	Insoluble	171	323	Ultra-low odor & ultra-low aldehyde, medium potency MDI surfactant, 5 benzenes free and included in sales specification
TEGOSTAB® B 8742 LO NEW	44	Insoluble	>200	180-185	Ultra-low odor & ultra-low aldehyde, high potency TDI or TM 20 silicone surfactant designed for optimized vibration dampening (reduced transmissivity) foam leading to improved passenger dynamic comfort.
TEGOSTAB® B 8761 LO NEW	54	Insoluble	153	301	Low odor & very low VOC, low-medium potency TDI or TM 20 surfactants that provides enhanced emulsification.

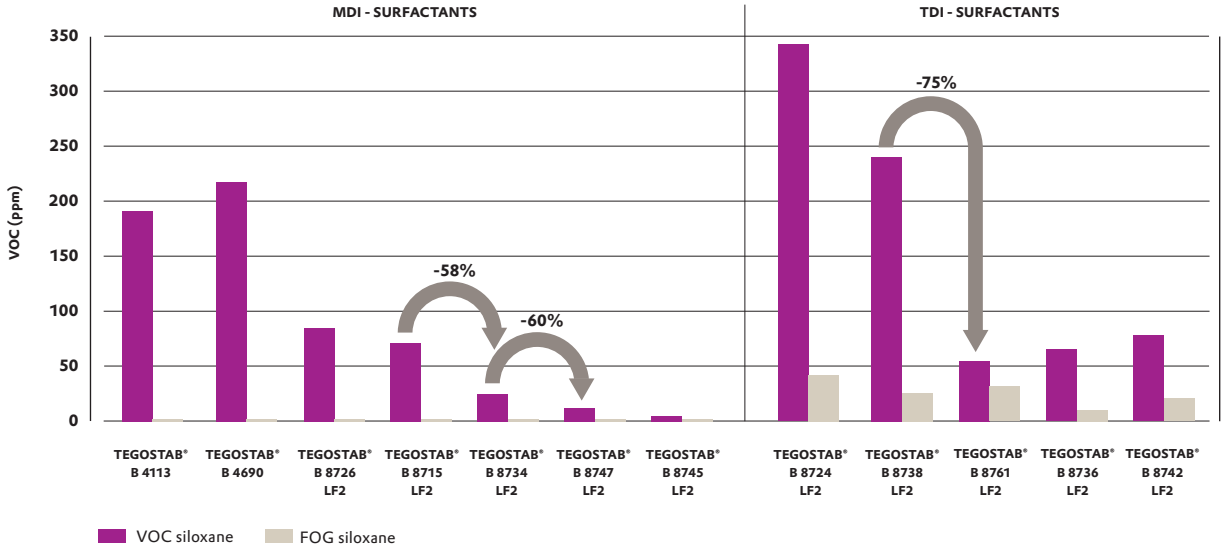
* = without water

SILICONE SURFACTANTS
Low VOC Surfactants

Our latest low VOC surfactants enable formulators to meet stringent VDA278 emission targets, whilst producing high quality foam.



REDUCING SILOXANE EMISSIONS IN VDA 278



All TEGOSTAB® LF 2 products are phthalate-free!

Typical emissions at 1 pphp use level, Index 95, samples taken from the foam core.

REDUCING CARBON FOOTPRINT

With a heightening focus on sustainability, Evonik has introduced its first Low Carbon Footprint (LCF) surfactant with TEGOSTAB® B 8763 LCF.

This grade boasts a Global Warming Potential (GWP) value of just 1.5 kg CO_2 eq. and is ideal for TDI HR (high resilience) applications, with its excellent balance of foam flow, stabilization and cell regulation.

SILICONE SURFACTANTS
Low Odor Surfactants

Consumers are becoming increasingly aware of odors emanating from the interior of their vehicles. To assist in formulating low odor foams, Evonik is introducing a new range of Low Odor Surfactants, starting with TEGOSTAB® B 8734 LO.
These grades offer the same level of performance you have come to expect from Evonik surfactants, whilst being virtually odorless.

TEGOSTAB® B 8734 LO

Ultra-low liquid odor high performance MDI silicone surfactant

- Ultra-low liquid odor, ultra-low aldehydes
- Very low emissions according to all relevant VOC tests (e.g. VDA 278, VDA 276, etc.)
- Open, easy to crush foam
- Excellent surface/subsurface regulation

TEGOSTAB® B 8742 LO

Ultra-low liquid odor high performance TDI silicone surfactant

- Ultra-low liquid odor, ultra-low aldehydes
- Low emissions according to all relevant VOC tests (e.g. VDA 278, VDA 276, etc.)
- High vibration dampening
- Wide processing latitude

Learn more about Evonik's Low Odor Surfactants in our introductory video

ODOR PANEL

Evonik has established their own certified odor panel in Shanghai, China to facilitate it's in-house odor testing during new product development and to better support customers.

PERFORMANCE ADDITIVES

Evonik's range of Performance Additives can help formulators to delay reactions, improve physical properties or reduce aldehyde levels.

INTRODUCING ORTEGOL® LA 3

ORTEGOL® LA 3 is a second generation scavenger that can drastically reduce formaldehyde and acetaldehyde levels in automotive molded foams.

- Scavenges formaldehyde and acetaldehyde
- Improves physical properties
- Good processability
- Negligible Emission

TEGOCOLOR®

Evonik markets a range of color pastes for polyester and polyether foams. They are dispersions of pigments and are available in red, yellow, green, blue and black.

TEGOCOLOR® pastes offer improved compatibility and typically require lower use levels, due to the efficiency of these state of the art pigments.

Performance Additives Selection Chart

	MDI	TDI / MDI	TDI	Delayed Action	Seating	NVH	Steering Wheels	Instru-ment Panels	VDA 278	Chamber Test
DABCO® BA 150	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓
DABCO® BA 316 NEW	✓	✓	✓		✓	✓	✓	✓	✓	✓
DABCO® DEOA 85	✓	✓	✓		✓	✓			✓	✓
ORTEGOL® LA 2	✓	✓	✓		✓	✓	✓	✓	✓	✓
ORTEGOL® LA 3	✓	✓	✓		✓	✓	✓		✓	✓
ORTEGOL® 501	✓					✓		✓	✓	✓
ORTEGOL® 720 NEW		✓	✓	✓	✓				✓	✓

	Flash Point, °C (PMCC)	Viscosity @ 25 °C cPs	Specific Gravity @ 21 °C (g/cm³)	Water Solubility	Calculated OH Number, mgKOH/g	Product Description
DABCO® BA 150	>200	390	1.15	Soluble	390	Negligible Emission, hydrolytically stable product used to delay the catalyst reaction and to improve flow while maintaining back-end cure.
DABCO® BA 316 NEW	112	<2,000	1.16	Insoluble	35	DABCO® BA 316 is a Negligible Emission performance additive which, when used in conjunction with DABCO® NE 1550 or DABCO® NE 1600, helps to maintain physical properties after humid aging.
DABCO® DEOA 85	168	782	1.09	Soluble	1363	Standard crosslinking additive for HR-molded foam.
ORTEGOL® LA 2	>93	98	0.96	Soluble	1290	ORTEGOL® LA 2 can assist formulators in lowering formaldehyde levels in automotive molded foams.
ORTEGOL® LA 3	n/a	n/a	1.08	Soluble	645	ORTEGOL® LA 3 has proven to notably reduce all aldehyde levels in automotive molded foams.
ORTEGOL® 501	>200	275	0.95	Insoluble	>5	Strong silicone-free cell opener.
ORTEGOL® 720 NEW	>100	200	1.28	Soluble	1274	ORTEGOL® 720 is an alternative crosslinker to DABCO® DEOA 85, that can provide a significant Improvement to both dry and wet compression sets

RELEASE AGENTS
GORAPUR® Release Agents

In order to meet the increasing requirements of the automotive industry and evermore stringent environmental protection regulations, Evonik is constantly developing improved release agents. With our extensive know-how of Polyurethane chemistry, we offer innovative and bespoke products that help our customers to improve surface finish, reduce waste and increase efficiency.

GORAPUR® Release Agents are specially formulated to give very efficient demolding, excellent surface finish and low build-up rates. All of our release agents are designed to be applied by spray-gun. For the optimum atomization, especially of water-based products, air-assisted spray-guns are recommended. However for large moldings and high transfer efficiency "air-less" spray-guns can be used.

All Evonik products have excellent release properties ensuring that only very thin films need to be applied. This guarantees very high levels of cost effectiveness and a low build-up of wax in the molds. The solvents used in our high-solids 'A3' and 'A4' products are fully synthetic, guaranteeing high flash points and very high purity. This makes them highly suitable for use with electro static spray guns.

PROCESS ADDITIVES

Evonik also offers a range of Anti-Squeak agents which help to minimise friction on foam parts; thereby, optimizing seat covering (with fabric or leather) while ensuring the foam does not squeak during use. Our products are environmentally friendly, do not disturb foam structure and do not contribute to fogging or VOC emissions.

For mold preparation after cleaning we recommend the use of our GORAPUR® LK 104 mold primer. For very quick and efficient application, GORAPUR® LK 104 is a pasty mold priming wax which is specially formulated to provide an exceptionally stable base layer reducing blistering and flaking of the wax film.

Evonik offers a comprehensive range of GORAPUR® release agents for all automotive applications. To learn more about how we can help you, please contact your local Sales Manager or visit www.explorepu.evonik.com.

	Flash Point, °C	Mold Temperature, °C	Product Description
STANDARD RELEASE GRADES			
GORAPUR LK 8901-11-3-B	56 – 60	45 – 70	High flashpoint release agent with easy demolding that gives excellent surface finish and low build-up.
GORAPUR® LK 149-60 E	25 – 30	40 – 70	Standard automotive release agent for high production volumes.
GORAPUR® LK 8000-21 H	61 – 65	N/A	Low flammability release agent concentrate for local dilution.
PROCESS ADDITIVES			
GORAPUR® LH 526-series	N/A	N/A	Water-based anti-squeak agents, available in clear, blue or UV pigmented versions. Easily processed.
GORAPUR® LH 5260-series	N/A	N/A	Ultra-low VOC, water-based anti-squeak agent. Available in clear, blue or UV pigmented versions.
GORAPUR® LK 104	25 – 30	>70	Mold priming and touch-up paste, easy application.

OUR COMMITMENT

Evonik is committed to producing new additives that improve productivity, enhance performance and have a reduced impact on the environment. We have strict quality management processes in place as well as many diversity initiatives.

Our products are backed by a global network of support services:

- Local sales & technical service personnel, with in-depth industry knowledge and understanding of your needs.
- Dedicated R&D centers of excellence.
- Analytical labs, with the capability to conduct automotive specific tests, such as VDA 278.
- Worldwide manufacturing and warehouse capabilities.

SAFETY IS PARAMOUNT AT EVONIK

- We are consistently among the leaders in safety in the chemical industry.
- Among the industry leaders in environmental, health and safety (EH&S) performance.
- Every employee is required to understand and adhere to our global EH&S policy. It is a condition of employment.

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To further discuss your requirements for polyurethane additives for the automotive industry, or to learn more about regional product availability.
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