Additives and Heat Stabilizers for PVC Plastisol
A Sustainable Approach to Modern Coating Technology

Patcham FZC is a well-established manufacturer of specialty additives headquartered in the United Arab Emirates. Since its inception, Patcham has steadily grown into a leading supplier of specialty additives for Paint & Coatings, Ink, PVC and Composite industries.

The company’s Pat-Add range of coating additives includes wetting & dispersing agents, defoamers, slip & leveling agents, rheology modifiers. Whilst keeping focus on environmental sustainability, the company produces products using green raw materials that are APEO free and have low or no VOC.

These products are multi functional and multi compatible, which simplifies the production process, reduces the chance of errors and minimizes inventory thus improving cost effectiveness.

Patcham has built a strong manufacturing and R&D infrastructure that enables the rapid transition from concept to products. The company has strategically located technical service laboratories, offices and representatives around the world to provide the most efficient customer service. In addition, a well-developed robust supply chain network enables it to deliver its products and services to customers around the globe with minimal lead-time.
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## PVC Heat Stabilizers
- Issues
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Introduction

What is a Plastisol?

PVC Plastisol are liquid dispersion systems of polyvinyl chloride and PVC copolymer resin in compatible plasticizers. The liquids may vary in viscosity from thin milk-like fluids to heavy pastes that have the consistency of molasses.

<table>
<thead>
<tr>
<th>Main Ingredients</th>
<th>Fillers</th>
<th>Solvents</th>
</tr>
</thead>
<tbody>
<tr>
<td>PVC Resin</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Plasticizers</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Additive</td>
<td>Heat Stabilizers &amp; Kickers</td>
<td></td>
</tr>
</tbody>
</table>

Application

The range of plastisol applications is extremely wide, and so are the variety of production methods.

Plastisol products include the following:

- Artificial leather (e.g. gloves, boots)
- Automotive artificial leather
- Dipped goods and dip coatings (e.g. tool handholds, bar ends)
- Toys (e.g. dolls, balls, toy, animals, anatomic models for education)
- Floorings
- Wall coverings
- Roofing membranes
- Carpet backing and heavy weight coatings
- Conveyor belts
Introduction

Issues

Raw Materials - Issues
- Long dispersion time
- Pigment streaks/Incomplete wetting
- Flooding and floating of colorants
- Storage stability

Rheology Factors - Issues
- High viscosity
- Poor air release due to pseudoplastic rheology

Application - Issues
- Pinholes
- Air entrapment
- Shade variations
- Low production yield

Figure 3. Longer dispersion time

Figure 4. Air entrapment

Figure 5. Incomplete wetting/High viscosity
Dispersion of particles in plasticizer, there are deficiencies that need to be corrected through the use of additives. High viscosity, long dispersion time, flooding and unstable pigment concentrates are some of the issues related to wetting and dispersion (Figure 3 and 4).

Introduction of energy by the use of machines through high shear will break down agglomerated particles into its individual particles. If these individual particles are not fully stabilized, the finely distributed particles reaggregate and form flocculates (Figure 6).

Pat-Add wetting and dispersing additives stabilize the dispersed particles by adsorbing onto the surface of pigments or filler particles. Electrostatic repulsion or steric hindrance (Figure 7) will govern on the stabilization of individual particles of pigments/fillers.

For the specific application, it is recommended that compatibility with the plasticizer should be considered for selecting the best additive that will be utilized.

**Advantages of Pat-Add Wetting and Dispersing Additives:**

- Higher pigment loading with constant viscosity
- Shorter dispersion time
- Excellent wetting of pigments and fillers
- Improved flow behavior
- Increase product yield
- Improved color homogeneity
- Longer storage stability of dispersions
Pat-Add DA 3225

Pat-Add DA 3225 is a HMV ultra-charge polymer technology based wetting and dispersing additive for solvent borne and solvent free applications. Designed with ultra-dense adhesion charges, providing the strongest attachment onto pigment surface.

Benefits:
- Higher pigment loading with lower and flowable viscosity
- High color strength development
- No adverse effect in end use application
- Efficient in pigment dispersion of organic, inorganic and basic black pigment
- Improves storage stability

<table>
<thead>
<tr>
<th>Raw materials</th>
<th>PY 83</th>
<th>PR 112</th>
<th>PB 15:4</th>
<th>PG 7</th>
<th>Raven 450</th>
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<tbody>
<tr>
<td>DIDP</td>
<td>76.00</td>
<td>64.00</td>
<td>62.00</td>
<td>54.00</td>
<td>67.00</td>
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<tr>
<td>Pat-Add DA 3225</td>
<td>4.00</td>
<td>6.00</td>
<td>7.50</td>
<td>10.50</td>
<td>3.00</td>
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<tr>
<td>Synergist</td>
<td>-</td>
<td>-</td>
<td>-</td>
<td>0.50</td>
<td>-</td>
</tr>
<tr>
<td>Pigment</td>
<td>20.00</td>
<td>30.00</td>
<td>30.00</td>
<td>35.00</td>
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<td><strong>Total</strong></td>
<td>100.00</td>
<td>100.00</td>
<td>100.00</td>
<td>100.00</td>
<td>100.00</td>
</tr>
</tbody>
</table>

Grinding: Transfer materials to a Horizontal Bead mill, maintain temperature 77-86°C

Table 2. Plastisol Colorants Formulation with Pat-Add DA 3225

Figure 9. Colorants in Plastisol Application

Figure 10. Colorants in Plasticizer with Pat-Add DA 3225
Patcham Additives

Pat-Add DA 895

A multi-purpose solvent-free wetting and dispersing additive for PVC plastisol and thermoplastics. Its electroneutral composition enables it to stabilize organic and inorganic pigments, particularly carbon blacks.

Particularly suitable for the production of PVC Colorants/ Color Master paste for PVC. Pat-Add DA 895 creates a Newtonian behavior of the material by reducing viscosity.

<table>
<thead>
<tr>
<th>Raw Materials</th>
<th>TiO₂ - rutile PW 6</th>
<th>Phthalocyanine blue PB 15:3</th>
<th>Yellow iron oxide PY - 42</th>
<th>Special black 4 - PBlk - 7</th>
<th>Bayferrox Red Iron Oxide 130² PR 101</th>
</tr>
</thead>
<tbody>
<tr>
<td>% SOP</td>
<td>2.5</td>
<td>18.2</td>
<td>15.00</td>
<td>38.00</td>
<td>12.00</td>
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<tr>
<td>Liquid epoxy resin</td>
<td>30.50</td>
<td>59.00</td>
<td>30.00</td>
<td>63.20</td>
<td>25.30</td>
</tr>
<tr>
<td>Reactive diluents (C12-C14 type)</td>
<td>7.50</td>
<td>14.90</td>
<td>12.30</td>
<td>16.00</td>
<td>18.50</td>
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<tr>
<td>Pat-Add DA 895</td>
<td>1.50</td>
<td>4.00</td>
<td>7.50</td>
<td>5.70</td>
<td>6.00</td>
</tr>
<tr>
<td>Aerosil 972</td>
<td>0.30</td>
<td>-</td>
<td>-</td>
<td>-</td>
<td>-</td>
</tr>
<tr>
<td>Pat-Add AF 35</td>
<td>0.20</td>
<td>0.10</td>
<td>0.20</td>
<td>0.10</td>
<td>0.20</td>
</tr>
<tr>
<td>Pigment</td>
<td>60.00</td>
<td>22.00</td>
<td>50.00</td>
<td>15.00</td>
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<td>100.00</td>
<td>100.00</td>
<td>100.00</td>
<td>100.00</td>
</tr>
</tbody>
</table>

Table 1. Guide formulation with Pat-Add DA 895

Flow behavior RMPC in Styrene free UPR

Tinting of UPR Colorants to White Gel Coats

2% RMPC Phthalocyanine blue PB 15:3

Initial After 24 hrs

2% RMPC PBlk 7

Initial After 24 hrs
Patcham Additives

Pat-Add DA 2025

Pat-Add DA 2025 is a wetting and dispersing agent for use in PVC plastisol.

Pat-Add DA 2025 is most effective for wetting of inorganic pigments, including titanium dioxide, extenders and blowing agents such as ADC and zinc oxide.

![Figure 11. Pigment wetting of Pat-Add DA 2025](image)

**Figure 11. Pigment wetting of Pat-Add DA 2025**

**Table 3. Guide formulation with Pat-Add DA 2025**

<table>
<thead>
<tr>
<th>Raw Materials</th>
<th>Parts by weight</th>
</tr>
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<tbody>
<tr>
<td>DOP</td>
<td>50.00</td>
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<tr>
<td>ADC Powder</td>
<td>50.00</td>
</tr>
<tr>
<td>Pat-Add DA 2025</td>
<td>0.25</td>
</tr>
<tr>
<td><strong>Total</strong></td>
<td><strong>100.25</strong></td>
</tr>
</tbody>
</table>

Reference Pat-Add DA 2025

![Figure 12. Pat-Add DA 2025 in three-roll mill](image)

**Figure 12. Pat-Add DA 2025 in three-roll mill**

![Figure 13 shows Pat-Add DA 2025 will allow higher filler loading without high viscosity build up. This will enable the formulator to make highly filled plastisol without compromising workability of the paste.](image)

**Figure 13 shows Pat-Add DA 2025 will allow higher filler loading without high viscosity build up. This will enable the formulator to make highly filled plastisol without compromising workability of the paste.**
Patcham Additives

Deaerators

Pat-Add AF 5106

Pat-Add AF 5106 is a green bio based additive used as air release and de-airing agent. Pat-Add AF 5106 removes entrapped air in plastisol preparations and eliminates surface defects of cured plastisol articles.

Key benefits of Pat-Add AF 5106:

• Remove entrapped air during plastisol preparations
• Avoid surface defects like pin holes
• Attain smooth finish
• Work with higher volumes more easily
• No adverse effect in foam applications

Pat-Add DA 7006 / 7006 N

Pat-Add DA 7006/7006 N is a medium volatile viscosity depressant for PVC plastisols. It keeps the plastisol mass workable over long period of storage and prevents viscosity build up. It also allows incorporating more filler by keeping same viscosity of the PVC plastisols.

Main benefits are:

• High filler loading with constant viscosity
• Extremely effective for filler wetting
• Provides excellent stability of PVC plastisols without any sedimentation
PVC Heat Stabilizer

Issues

- PVC resin needs relatively high processing temperatures
- Resin suffers heat degradation at the lower temperatures than processing temperatures
- Results in loss of properties
  - Mechanical
  - Colour

Heat Stabilizers

<table>
<thead>
<tr>
<th>Type</th>
<th>Grade</th>
</tr>
</thead>
<tbody>
<tr>
<td>Barium / Zinc</td>
<td>Patstab 301 Low phenol, Nonylphenyl free</td>
</tr>
<tr>
<td></td>
<td>Patstab 303</td>
</tr>
<tr>
<td></td>
<td>Patstab 307</td>
</tr>
<tr>
<td></td>
<td>Patstab 306</td>
</tr>
<tr>
<td></td>
<td>Patstab 308</td>
</tr>
<tr>
<td></td>
<td>Patstab 324</td>
</tr>
<tr>
<td></td>
<td>Patstab 336</td>
</tr>
<tr>
<td></td>
<td>Patstab 355 SF PTBBA, 2-EHA free</td>
</tr>
<tr>
<td></td>
<td>Patstab 301 Patstab 303 Patstab 307 Patstab 306 Patstab 308 Patstab 324 Patstab 336 Patstab 355 SF PTBBA, 2-EHA free</td>
</tr>
<tr>
<td>Calcium / Zinc</td>
<td>Patstab 405 PTBBA, 2-EHA free</td>
</tr>
<tr>
<td></td>
<td>Patstab 411</td>
</tr>
<tr>
<td></td>
<td>Patstab 410 PTBBA, 2-EHA free  Phenol free Nonylphenyl free</td>
</tr>
<tr>
<td></td>
<td>Patstab 401 Patstab 409 Patstab 415 Patstab CZL65</td>
</tr>
</tbody>
</table>

Kickers (PVC Foam Stabilizers)

<table>
<thead>
<tr>
<th>Kicker Potassium / Zinc</th>
<th>Patstab 701 (Fast) Phenol free</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Patstab 702 (Medium)</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Kicker Barium / Zinc</th>
<th>Patstab 305 (Medium/ Fast) ---</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Patstab 321K (Medium/ Fast) Phenol free</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Kicker Calcium/ Zinc</th>
<th>Patstab 419K (Medium) Phenol free</th>
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</thead>
</table>