

## Technical tip

# Eastman non-phthalate plasticizer choices for waterborne adhesives

## Introduction

Creating much-needed elasticity, plasticizers improve the performance of adhesives. In waterborne adhesives, DIBP has been an industry standard, however DIBP has been classified as an SVHC (substance of very high concern) according to REACH. Changing regulations and consumer preferences now demand that more non-phthalate plasticizers be used in consumer products. Eastman Chemical Company has a broad portfolio of non-phthalate plasticizers.

Presented here are Benzoflex™ 2088 plasticizer, Eastman TXIB™ formulation additive, and Eastman Effusion™ plasticizer, which have the following advantages:

- Suitable for most adhesive systems, providing improved wet tack, set times, and open times
- Compatible with PVAc and VAE emulsions
- Reliability of supply with no adverse labeling required
- Eastman TXIB is highly compatible with Benzoflex™ plasticizers and Eastman Effusion.

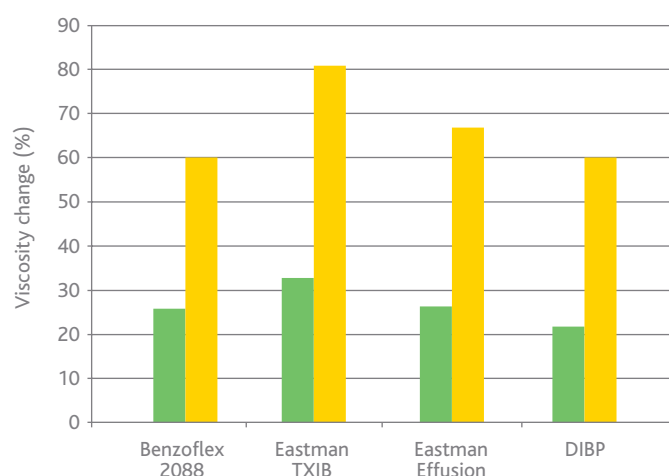
## In vinyl acetate homopolymer formulations (PVAc)

The following graphs demonstrate that our non-phthalate plasticizers have a comparable or better performance than DIBP.

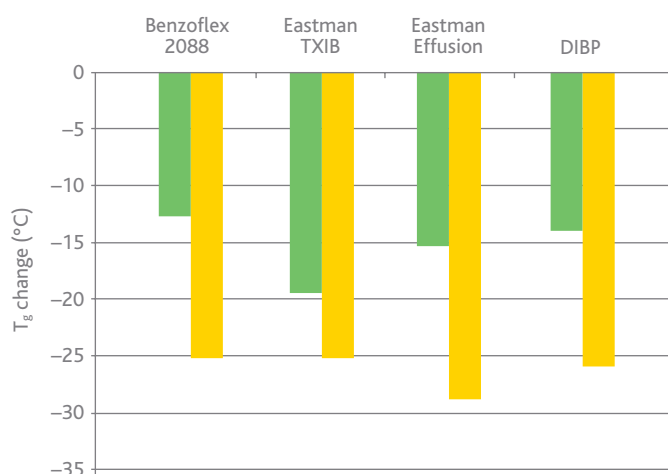
- Benzoflex 2088 provides an efficient  $T_g$  suppression, particularly at higher addition levels for better low-temperature properties.
- Eastman TXIB provides an efficient  $T_g$  suppression at lower addition levels for better low-temperature properties combined with a large viscosity increase. The use of this product is recommended only at lower addition levels.
- Eastman Effusion provides an efficient  $T_g$  suppression for better low-temperature properties at both high and low addition levels.

It is possible to use the plasticizers alone or in combination to optimize the desired  $T_g$  suppression and viscosity increase. You should determine the correct Eastman plasticizer level for your specific formulation.

## Effect of plasticizer on PVAc



- 5% plasticizer content in plasticized PVAc emulsion mixture
- 10% plasticizer content in plasticized PVAc emulsion mixture



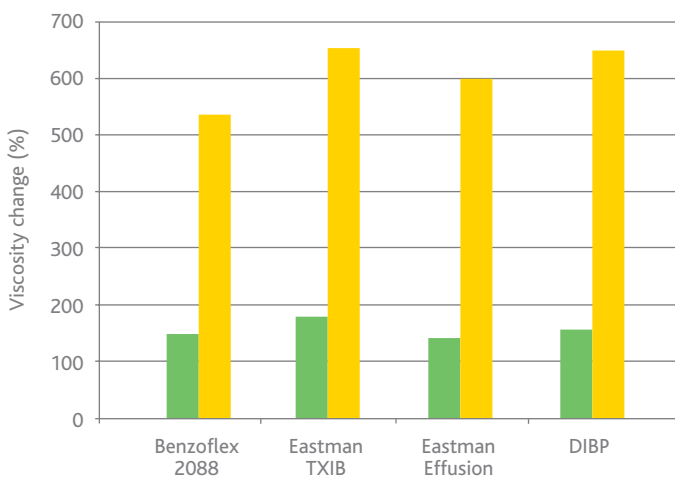
## In vinyl acetate ethylene copolymer formulations (VAE)

The following graphs demonstrate that our non-phthalate plasticizers have a comparable or better performance than DIBP.

- Benzoflex™ 2088 plasticizer provides an efficient  $T_g$  suppression, particularly at lower addition levels for better low-temperature properties.
- Eastman TXIB™ formulation additive and Eastman Effusion™ plasticizer provide an extremely efficient  $T_g$  suppression for better low-temperature properties.

As in PVAc adhesives, it is possible to optimize your formulation blends of Benzoflex 2088 with Eastman TXIB and Eastman Effusion to achieve the desired balance of viscosity and  $T_g$  suppression.

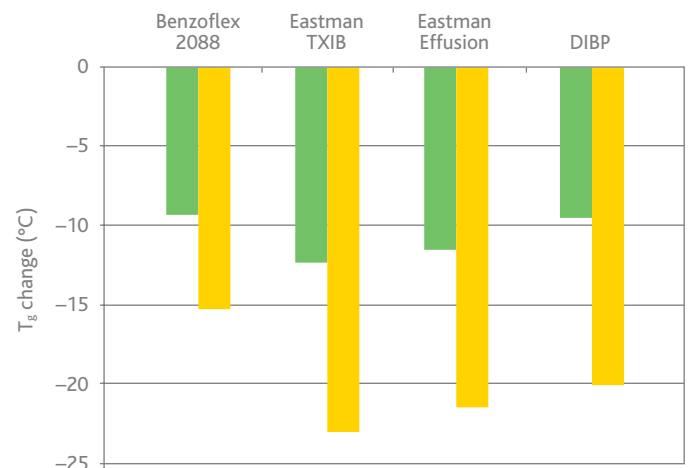
### Effect of plasticizer on VAE



- 5% plasticizer content in plasticized VAE emulsion mixture
- 10% plasticizer content in plasticized VAE emulsion mixture

## Other applications

Benzoflex 2088 improves adhesion in acrylic latex caulks. It may also be used in pressure sensitive acrylics and the A side of 2K polysulfide sealants and polyurethane sealants. In PVC, it serves as a fast fuser, delivering low-processing temperatures and low volatility, which makes it a good plasticizer for interior applications, such as flooring. Eastman TXIB is completely compatible with PVC in all proportions and is usually blended with general-purpose plasticizers such as Eastman 168™ non-phthalate plasticizer. Eastman TXIB also serves as a plasticizer in nail polish and industrial coatings. Eastman Effusion is also a high-solvating plasticizer, which imparts lower plastisol viscosity for PVC plastisols.



To find out more about the secure supply and efficiency for Benzoflex 2088, Eastman TXIB, and Eastman Effusion, contact your Eastman representative today.

## Regulatory status in food contact application

Product regulatory information sheets for Benzoflex 2088, Eastman Effusion, and Eastman TXIB are available on request. Contact Eastman at 800-EASTMAN or visit [www.EastmanPlasticizers.com](http://www.EastmanPlasticizers.com) for more information.

	North America Region	European Union – (EU) No. 10/2011*
Benzoflex™ 2088 plasticizer	Lawful for use in certain food contact applications	Not listed
Eastman Effusion™ plasticizer	Lawful as a plasticizer in polymers for use: (1) in adhesives, (2) in pressure sensitive adhesives, and (3) as a coating or component of paper or paperboard intended for use in contact with dry foods with no free surface fat or oil	Not listed
Eastman TXIB™ formulation additive	Lawful for use in certain food contact applications	Lawful for use in certain food contact applications

\*Regulation 10/2011 refers to food contact applications in plastics.

## Typical properties

	Benzoflex 2088	Eastman Effusion	Eastman TXIB	DIBP
Specific gravity @ 20°C	1.16	1.045	0.945	1.038
Surface tension @ 25°C, dynes/cm	44	34	27.5	33
Boiling point @ 760 mm Hg, °C	356	337	281	320
Freezing point, °C	<16*	16	-70	-37
Viscosity, Brookfield @ 25°C, mPa•s	71	16	5	36

\*Benzoflex 2088 has the possibility to solidify at 16°C in certain conditions, however the product supercools, so is capable of remaining a liquid below 16°C. The melting point is 16°C. The pour point is <-21°C.

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