



### Overview

- 100% active coconut oil-based diisopropanolamide surfactant
- Non-DEA containing alternative to cocamide DEA
- Mild, naturally derived and readily biodegradable
- Exceptional foam stabilizing, viscosity building and solubilizing properties
- Use in HI&I water-based detergents, and in personal care cleansing formulations along with anionic surfactants for enhanced foam control and viscosity response

### Regulatory

The substances in Surfamide DIPA are listed on and in compliance with the following Inventories: US (TSCA), Canada (DSL), China (IECSC), Korea (ECL: KE-14301)

CAS#149497-02-9

INCI Name: Cocamide DIPA

### Technical Information

Surfamide DIPA is a 1:1 coconut oil based diisopropanolamide surfactant containing glycerin for emolliency and lubrication. Effective as a foam booster and stabilizer, fragrance and essential oil solubilizer, and viscosity builder, foam booster and stabilizer in wide range of liquid detergent and cleaning product formulations. Surfamide DIPA is a versatile ingredient that offers the best properties of cocamide MEA and cocamide DEA without the handling issues of cocamide MEA or the diethanolamine regulation issues of cocamide DEA.

Surfamide DIPA is a 100% active, naturally plant derived surfactant with high biodegradability and low aquatic toxicity. The exceptional quality and low color profile of Surfamide DIPA allows for use in a wide range of markets and applications.

### Formulary

Surfamide DIPA promotes and stabilizes foam, and builds viscosity in liquid cosmetic formulations typically in the range of 1-5%.

### Typical Properties

PROPERTY	VALUE
Appearance	Viscous amber liquid
Odor	Mild
Ionic character	Nonionic
Water solubility	Dispersible
Activity, %	100
Free amine, %	8 Maximum
pH (1% aq.)	9.5±1.0
Density@25°C	0.99±0.04 g/ml
Flash point, °F	>200
RVOC, EPA, %	0
Storage	Freeze/thaw stable
Shelf life	2 years

### Packaging and Handling

Surfamide DIPA is available in:  
Totes (Net Wt. 2200 lbs)  
Drums (Net Wt. 450 lbs)

Refer to Safety Data Sheet (SDS) for information on the safe use, handling, and disposal of this product.

DOT Classification: Non-Regulated

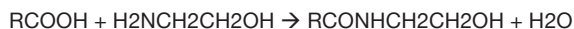
# Surfamide DIPA

## Cocamide DIPA

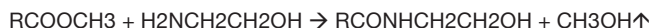
Alkanolamides are versatile ingredients that find application as foam boosters and stabilizers, and as viscosity builders in liquid detergent formulations ranging from liquid dishwashing liquids to liquid laundry. Alkanolamides are economical ingredients in HI&I cleaning formulations, textile scouring, dye-leveling and sizing ingredients, and in lubricants as corrosion inhibitors.

Commercial alkanolamides are produced through a condensation reaction between fatty acids or fatty esters with an alkanolamine as characterized by monoethanolamine (MEA), diethanolamine (DEA) and diisopropanolamine (DIPA).

The generalized amide formation reaction from primary alkanolamines is illustrated below between 1 mole of fatty acid and 1 mole of MEA, resulting in a 1:1 monoethanolamide and water:

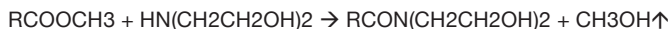
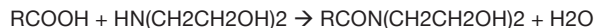


To minimize competing reactions resulting in by-products such as amine soap, amino esters and ester amides, monoethanolamides are more typically made from fatty esters, either fatty acid methyl esters or fatty triglycerides. The methyl ester reaction is illustrated below resulting in a 1:1 monoethanolamide and methanol:



The related reaction substituting the methyl ester with a fatty triglyceride, reacting with 3 moles of MEA results in 3 moles of 1:1 monoethanolamide with 1 mole of glycerin. In this example, glycerin typically remains in the product, where methanol is typically removed via vacuum stripping when made from the methyl ester. Residual glycerin from the fatty triglyceride reaction may yield beneficial properties such as humectancy and lubricity, where the methyl ester reaction yields higher amide actives after vacuum stripping methanol, but at the possible expense of unwanted odor. Monoethanolamides are characterized by limited water solubility and likely to be a solid at room temperature.

Secondary amine dialkanolamides are produced through a condensation reaction similar to that of monoalkanolamides characterized by limited water solubility but likely to be a liquid at room temperature. The generalized amide formation reaction from secondary alkanolamines is illustrated below between 1 mole of fatty acid and 1 mole of DEA, resulting in a 1:1 diethanolamide and water, and similar to monoalkanolamides, can be prepared from the either fatty acid methyl esters or fatty triglycerides. Diethanolamides produced from methyl esters are typically referred to as "super amides" due to their high amide content:



Original work involving dialkanolamides is generally credited to Wolf Kritchevsky (US Patent 2089212 issued 1937), where fatty dialkanolamides were produced in both a 1:1 ratio of fatty acid, either through fatty acid or ester, and 2:1 ratio indicating a 2:1 molar excess of amine to fatty acid. The 2:1 fatty alkanolamides, or Kritchevsky amides, are characterized as liquid, water soluble products made up of a mixture of amide, amino ester, free amine, amine soap, amide ester and water, differing in performance and physical properties from a simple blend of a 1:1 amide with added alkanolamine. The 2:1 alkanolamides when back titrated with fatty acids of same or varied composition to the amide are referred to as "modified" 2:1 amides, and can be tailored to a very wide range of applications.

General Surfactants produces and has the ability to produce 1:1, 2:1 and modified 2:1 amides for nearly any application, utilizing a range of alkanolamines, fatty acids, fatty triglycerides and fatty acid methyl ester blends that include:

Surfamide M1	1:1 Cocamide DEA
Surfamide 8	2:1 Cocamide DEA
Surfamide 81	2:1 Modified Coco Diethanolamide
Surfonate 100	2:1 Modified Detergent Alkanolamide
Surfamide MIPA	1:1 Cocamide MIPA Superamide
Surfamide DIPA	1:1 Cocamide DIPA
Surfamide 8 DIPA	2:1 Cocamide DIPA
Surfamide 81 DIPA	2:1 Modified Cocamide DIPA
Surfamide 91 DIPA	2:1 Modified Fatty Acid DIPA
Surfonate 100 DIPA	2:1 Modified Detergent Alkanolamide

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