



## Overview

- 100% active 1:1 soybean oil based diethanolamide surfactant
- Mild, naturally derived and readily biodegradable
- Excellent aqueous viscosity building, foam stabilizing and boosting, and fragrance solubilizing
- Water dispersible lubricant and antistat for use in textile fiber spinning, cutting fluids and conveyor belt lubricants
- Use in water-based cleaning formulations along with anionic surfactants for enhanced foam control and viscosity response

## Regulatory

The substances in Surfamide S are listed on and in compliance with the following Inventories: US (TSCA; FIFRA Inert Ingredient), Canada (DSL), Mexico (INSQ), Europe (EINECS: 270-355-6), Australia (AICS), China (IECSC), Japan (ENCS: 8-311), Korea (ECL: KE-01088), New Zealand (NZIoC), Philippines (PICCS)

CAS#68425-47-8

INCI Name: Soyamide DEA

## Technical Information

Surfamide S is a 1:1 soybean oil based diethanolamide surfactant containing glycerin for emolliency and lubrication. Effective as a foam booster and stabilizer, fragrance and essential oil solubilizer, and viscosity builder in liquid detergent formulations, Surfamide S is a versatile ingredient.

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

## Formulary

Surfamide S is a versatile ingredient that find application that promotes and stabilizes foam, and builds viscosity in liquid detergent formulations.

Surfamide S is an effective degreasing emulsifier and corrosion preventing lubricant used in metal cleaning and finishing processes. Use Surfamide S in textile applications as an ingredient for scouring, dye-leveling and sizing applications.

Surfamide S is used as an antistatic agent in plastics, e.g. in polyethylene film for food packaging and rigid poly(vinyl) chloride, and used in combination with metallic salts as an antistatic for polystyrene and in impact-resistant rubber polystyrene blends.

## Typical Properties

PROPERTY	VALUE
Appearance	Clear to opaque amber liquid
Odor	Mild
Ionic character	Nonionic
Water solubility	Dispersible
Activity, %	100
Free amine, %	7 Maximum
pH (1% aq.)	10.0±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 S is available in:  
Totes (Net Wt. 2250 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:  
Drum (<100lbs Diethanolamine RQ):  
Non-hazardous

Tote (>100lbs Diethanolamine RQ):  
UN number: UN3082  
UN proper shipping name:  
Environmentally Hazardous Substance,  
Liquid, N.O.S. (Contains Diethanolamine)  
Transport hazard class: 9  
Packing group: III

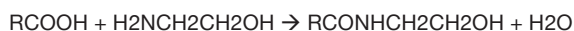
# Surfamide S

## Soyamide DEA

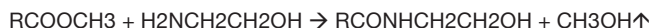
Alkanolamides are versatile ingredients that find application as foam boosters and stabilizers, and as viscosity builders in liquid detergent formulations ranging from liquid dishwashing liquids to liquid laundry. Alkanolamides are economical ingredients in HI&I cleaning formulations, textile scouring,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

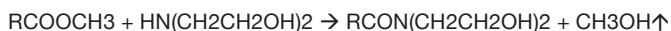
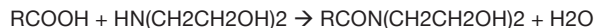


To minimize competing reactions resulting in by-products such as amine soap, amino esters and ester amides, monoethanolamides are more typically made from fatty esters, either fatty acid methyl esters or fatty triglycerides. The methyl ester reaction is illustrated below resulting in a 1:1 monoethanolamide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

Surfamide S is an outstanding foam stabilizer in high foam cleaning formulations, as the starting point formulation below illustrates:

### Grease Cutting High Foaming Hand Carwash

INGREDIENTS	WT. %
Water	to 100.0
Nonionic surfactant, eg. Tomodol 91-8	12.0
Ammonium lauryl ether sulfate, 60%	5.0
Surfamide S	1.5
Rhochem AO-12	4.0
Citric acid	to pH 6-7
Dye/fragrance	q.s.

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