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(54) Title: ACCELERATOR FOR CURING EPOXY RESINS COMPRISING ALKYLATED AMINES

(54) Bezeichnung: BESCHLEUNIGER FÜR DIE AUSHÄRTUNG VON EPOXIDHARZEN MIT ALKYLIIERTEN AMINEN

(57) Abstract: The present invention relates to a composition containing calcium nitrate, at least one epoxy resin and at least one amine of formula (I). The inventive composition allows the manufacture of low-emission epoxy-resin coatings that have good workability and that cure particularly rapidly in cold and damp conditions, without blushing-induced surface defects, thus achieving coatings of in particular high mechanical quality, with a minimal tendency to yellowing.

(57) Zusammenfassung: Gegenstand der vorliegenden Erfindung ist eine Zusammensetzung enthaltend Calciumnitrat, mindestens ein Epoxidharz und mindestens ein Amin der Formel (I). Die erfindungsgemässe Zusammensetzung ermöglicht emissionsarme Epoxidharz-Beschichtungen mit guter Verarbeitbarkeit, die bei feuchtkalten Bedingungen besonders schnell und ohne Blushing-bedingte Oberflächenstörungen aushärten und dabei mechanisch hochwertige Beschichtungen mit geringer Vergilbungsneigung ergeben.



WO 2020/070082 A1

ACCELERATOR FOR CURING EPOXY RESINS COMPRISING ALKYLATED AMINES

Technical field

- 5 The invention relates to the field of accelerators for epoxy resin compositions and to the use thereof, especially as coating.

State of the art

10 Coatings based on epoxy resins are widely used in the building trade. They consist of liquid resin and curing agent components, which are mixed before application and then cure at ambient temperatures in the range from about 5 to 35°C to form a material of high strength and stability. Such epoxy resin compositions have a tendency to surface defects such as haze, spots, roughness or tack, which is also referred to as "blushing". Blushing is caused by the amines
15 present in the curing agent component forming a salt with carbon dioxide (CO₂) from the air and occurs particularly at high humidity and low temperatures.

Especially in esthetically demanding coating applications such as floor coatings, the occurrence of blushing-related surface defects is extremely disadvantageous and usually necessitates laborious reworking or overcoating of the faulty areas or
20 often even of the entire coating.

The viscosity of an epoxy resin composition is reduced using thinners so that it is easy to apply and gives good wetting of the substrate surfaces. At the same time, thinners also reduce the susceptibility to blushing. The customary thinners, such as benzyl alcohol, are volatile compounds (VOC or SVOC) that are not
25 incorporated into the polymer matrix during curing and thus result in emissions.

For low-emission products, for which there is a growing demand from consumers, this means that thinners may be used only in small amounts or not at all.

For reduction of blushing and as reactive diluent, it is possible to use alkylated amines in the curing agent component, as described in EP 2,151,461, EP
30 2,943,464, WO 2016/023839, EP 3,138,863 or EP 3,144,335. But alkylated amines lead to slowed curing. For acceleration, it is possible to use the accelerators known for cold-curing epoxy resin compositions, such as 2,4,6-tris(dimethylaminomethyl)phenol or acids such as salicylic acid. With these,

however, the curing rate is still unsatisfactory within the first 24 hours, particularly at cold temperatures.

EP 0,471,988, EP 0,697,426 and EP 1,319,677 describe calcium nitrate as accelerator for the curing of epoxy resins with amines. However, neither cold
5 temperatures nor alkylated amines are used.

The preceding discussion of the background to the invention is intended only to facilitate an understanding of the present invention. It should be appreciated that the discussion is not an acknowledgment or admission that any of the material
10 referred to was part of the common general knowledge as at the priority date of the application. Similarly, it should be appreciated that throughout this specification, any reference to any prior publication, including prior patent publications and non-patent publications, is not an acknowledgment or admission that any of the material contained within the prior publication referred to was part
15 of the common general knowledge as at the priority date of the application.

Summary of the invention

It is an object of the present invention to provide low-emission epoxy resin coatings having good processibility, which, even under moist and cold conditions,
20 cure rapidly and without blushing-related surface defects, and at the same time result in coatings of high mechanical quality that have a low tendency to yellowing.

This object is achieved by the composition comprising calcium nitrate, at least one epoxy resin and at least one amine of the formula (I) as described in claim 1.

25 There has been no description to date of the use of calcium nitrate as accelerator for alkylated amines such as N-benzylethane-1,2-diamine. Surprisingly, calcium nitrate enables particularly rapid curing under moist and cold conditions within the first 24 hours, which is particularly demanding for amines of the formula (I) having alkylated amino groups. In this way, a coating can be walked upon after only a
30 short time, for example within the first 24 hours after application, and can be processed further, for example overcoated or sealed. Moreover, even under moist and cold conditions, esthetically pleasing surfaces having high gloss are achieved.

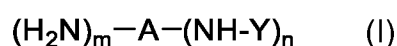
The composition described enables low-emission epoxy resin products having good processibility and longer pot life, which cure rapidly and can soon be walked upon, especially also under the moist and cold conditions, and at the same time give rise to materials of high mechanical quality that have high surface quality and a low tendency to yellowing. Such epoxy resin products are particularly suitable as coatings, especially for floors.

In one embodiment, the disclosure herein provides a composition comprising: calcium nitrate,
at least one epoxy resin, and
N-benzyl ethylene diamine,
wherein 0.5 to 2.5 parts by weight of calcium nitrate is present per 100 parts by weight of all amines having primary and/or secondary amino groups present.

Further aspects of the invention are the subject of further independent claims. Particularly preferred embodiments of the invention are the subject of the dependent claims.

Ways of executing the invention

The invention provides a composition comprising calcium nitrate, at least one epoxy resin and at least one amine of the formula (I),



where

m is 0 or 1, n is 1 or 2 and (m+n) is 2,

A is an alkylene radical that optionally contains nitrogen atoms or cyclic or aromatic components and has 2 to 10 carbon atoms, and

Y is an alkyl, cycloalkyl or aralkyl radical having 1 to 20 carbon atoms.

Throughout this specification, unless the context requires otherwise, the word "comprise" or variations such as "comprises" or "comprising", will be understood to imply the inclusion of a stated integer or group of integers but not the exclusion of any other integer or group of integers.

A "primary amino group" refers to an amino group which is bonded to a single organic radical and bears two hydrogen atoms; a "secondary amino group" refers to an amino group which is bonded to two organic radicals which may also together be part of a ring and bears one hydrogen atom; and a "tertiary amino group" refers to an amino group which is bonded to three organic radicals, two or three of which may also be part of one or more rings, and does not bear any hydrogen atom.

"Amine hydrogen" refers to the hydrogen atoms of primary and secondary amino groups.

"Amine hydrogen equivalent weight" refers to the mass of an amine or an amine-containing composition that contains one molar equivalent of amine hydrogen. Substance names beginning with "poly", such as polyamine or polyepoxide, refer to substances containing, in a formal sense, two or more of the functional groups that occur in their name per molecule.

A "thinner" refers to a substance that is soluble in an epoxy resin and lowers its viscosity, and that is not chemically incorporated into the epoxy resin polymer during the curing process.

"Molecular weight" refers to the molar mass (in g/mol) of a molecule. "Average molecular weight" refers to the number average M_n of a polydisperse mixture of oligomeric or polymeric molecules, which is typically determined by means of gel permeation chromatography (GPC) against polystyrene as standard.

"Pot life" refers to the duration of processibility of an epoxy resin composition, i.e. the maximum possible time span between the mixing of the components and the application of mixed composition in which it is in a sufficiently free-flowing state and is able to wet the substrate surfaces.

"Open time" of an adhesive refers to the maximum time span possible for a cohesive bond between the application of the adhesive and the joining of the parts to be bonded.

"Room temperature" refers to a temperature of 23°C.

Calcium nitrate $\text{Ca}(\text{NO}_3)_2$ may be present or used in the composition in anhydrous form or as the tetrahydrate. Calcium nitrate is also referred to as the calcium salt

of nitric acid or as nitrate of lime. It acts as an accelerator in the composition in the curing of the epoxy resin with the amine of the formula (I).

5 Preference is given to using calcium nitrate in the form of a solution that is liquid at room temperature.

10 More particularly, calcium nitrate is used in the form of a solution in water or an alcohol. Suitable alcohols are especially methanol, ethanol, the isomeric propanols or butanols, benzyl alcohol, 2-phenoxyethanol, 2-benzyloxyethanol, ethylene glycol, diethylene glycol, diethylene glycol monomethyl ether, diethylene glycol monoethyl ether, propylene glycol, propylene glycol monomethyl ether, propylene glycol monobutyl ether, propylene glycol monophenyl ether, dipropylene glycol, dipropylene glycol monomethyl ether.

Particular preference is given to using calcium nitrate in the form of a solution in water or ethanol.

15 Most preferably, calcium nitrate is in the form of an aqueous solution or is used as an aqueous solution.

The solution of calcium nitrate preferably has a concentration in the range from 10% to 80% by weight, according to the solubility in the solvent used.

20 An aqueous solution of calcium nitrate preferably has a concentration in the range from 30% to 70% by weight, especially 40% to 70% by weight.

25 The composition preferably contains such an amount of calcium nitrate that 0.1 to 20, preferably 0.2 to 10, more preferably 0.3 to 7, especially 0.5 to 5, parts by weight of calcium is present per 100 parts by weight of all amines having primary and/or secondary amino groups present.

Calcium nitrate may be present as the sole accelerator, or may be used in combination with further accelerators typically used in epoxy resin compositions.

30

A suitable epoxy resin is especially a liquid epoxy resin or a mixture containing two or more liquid epoxy resins.

“Liquid epoxy resin” refers to an industrial polyepoxide having a glass transition temperature below 25°C.

A suitable liquid epoxy resin is obtained in a known manner, in particular from the oxidation of the corresponding olefins or from the reaction of epichlorohydrin with the corresponding polyols, polyphenols or amines.

Suitable liquid epoxy resins are in particular aromatic epoxy resins, especially the glycidyl ethers of:

- 10 – bisphenol A, bisphenol F or bisphenol A/F, where A stands for acetone and F for formaldehyde, which served as reactants for the preparation of these bisphenols. In the case of bisphenol F, positional isomers may also be present, especially derived from 2,4'- or 2,2'-hydroxyphenylmethane.
- dihydroxybenzene derivatives such as resorcinol, hydroquinone or catechol;
- 15 – further bisphenols or polyphenols such as bis(4-hydroxy-3-methylphenyl)methane, 2,2-bis(4-hydroxy-3-methylphenyl)propane (bisphenol C), bis(3,5-dimethyl-4-hydroxyphenyl)methane, 2,2-bis(3,5-dimethyl-4-hydroxyphenyl)propane, 2,2-bis(3,5-dibromo-4-hydroxyphenyl)propane, 2,2-bis(4-hydroxy-3-tert-butylphenyl)propane, 2,2-bis(4-hydroxyphenyl)butane
- 20 (bisphenol B), 3,3-bis(4-hydroxyphenyl)pentane, 3,4-bis(4-hydroxyphenyl)hexane, 4,4-bis(4-hydroxyphenyl)heptane, 2,4-bis(4-hydroxyphenyl)-2-methylbutane, 2,4-bis(3,5-dimethyl-4-hydroxyphenyl)-2-methylbutane, 1,1-bis(4-hydroxyphenyl)cyclohexane (bisphenol Z), 1,1-bis(4-hydroxyphenyl)-3,3,5-trimethylcyclohexane (bisphenol TMC), 1,1-bis(4-
- 25 hydroxyphenyl)-1-phenylethane, 1,4-bis[2-(4-hydroxyphenyl)-2-propyl]benzene (bisphenol P), 1,3-bis[2-(4-hydroxyphenyl)-2-propyl]benzene (bisphenol M), 4,4'-dihydroxydiphenyl (DOD), 4,4'-dihydroxybenzophenone, bis(2-hydroxynaphth-1-yl)methane, bis(4-hydroxynaphth-1-yl)methane, 1,5-dihydroxynaphthalene, tris(4-hydroxyphenyl)methane, 1,1,2,2-tetrakis(4-
- 30 hydroxyphenyl)ethane, bis(4-hydroxyphenyl) ether or bis(4-hydroxyphenyl) sulfone;

- novolaks, which are especially condensation products of phenol or cresols with formaldehyde or paraformaldehyde or acetaldehyde or crotonaldehyde or isobutyraldehyde or 2-ethylhexanal or benzaldehyde or furfural;
- aromatic amines such as aniline, toluidine, 4-aminophenol, 4,4'-methylenediphenyldiamine, 4,4'-methylenediphenyldi(N-methyl)amine, 4,4'-[1,4-phenylenebis(1-methylethylidene)]bis(aniline (bis(aniline P) or 4,4'-[1,3-phenylenebis(1-methylethylidene)]bis(aniline (bis(aniline M)).

Further suitable liquid epoxy resins are aliphatic or cycloaliphatic polyepoxides, especially

- glycidyl ethers of saturated or unsaturated, branched or unbranched, cyclic or open-chain di-, tri- or tetrafunctional C₂ to C₃₀ alcohols, especially ethylene glycol, propylene glycol, butylene glycol, hexanediol, octanediol, polypropylene glycols, dimethylolcyclohexane, neopentyl glycol, dibromoneopentyl glycol, castor oil, trimethylolpropane, trimethylolethane, pentaerythritol, sorbitol or glycerol, or alkoxyated glycerol or alkoxyated trimethylolpropane;
- a hydrogenated bisphenol A, F or A/F liquid resin, or the glycidylation products of hydrogenated bisphenol A, F or A/F;
- an N-glycidyl derivative of amides or heterocyclic nitrogen bases, such as triglycidyl cyanurate or triglycidyl isocyanurate, or reaction products of epichlorohydrin with hydantoin.
- epoxy resins from the oxidation of olefins such as, in particular, vinylcyclohexene, dicyclopentadiene, cyclohexadiene, cyclododecadiene, cyclododecatriene, isoprene, 1,5-hexadiene, butadiene, polybutadiene or divinylbenzene.

A preferred epoxy resin is a liquid resin based on a bisphenol, in particular a bisphenol A diglycidyl ether and/or bisphenol F diglycidyl ether, as are commercially available, for example, from Olin, Huntsman or Momentive. These liquid resins have a viscosity that is low for epoxy resins and good properties as a coating when cured. They may contain proportions of solid bisphenol A resin or novolak glycidyl ethers.

The composition further comprises at least one amine of the formula (I).

A is preferably a divalent radical selected from the group consisting of 1,2-ethylene, 1,2-propylene, 1,3-propylene, 1,4-butylene, 1,3-butylene, 2-methyl-1,2-
 5 propylene, 1,3-pentylene, 1,5-pentylene, 2,2-dimethyl-1,3-propylene, 1,6-hexylene, 2-methyl-1,5-pentylene, 1,7-heptylene, 1,8-octylene, 2,5-dimethyl-1,6-hexylene, 1,9-nonylene, 2,2(4),4-trimethyl-1,6-hexylene, 1,10-decylene, 1,11-undecylene, 2-butyl-2-ethyl-1,5-pentylene, 1,12-dodecylene, 1,2-cyclohexylene, 1,3-cyclohexylene, 1,4-cyclohexylene, (1,5,5-trimethylcyclohexan-1-yl)methane-
 10 1,3, 4(2)-methyl-1,3-cyclohexylene, 1,3-cyclohexylenebis(methylene), 1,4-cyclohexylenebis(methylene), 1,3-phenylenebis(methylene), 1,4-phenylenebis(methylene), 3-aza-1,5-pentylene, 3,6-diaza-1,8-octylene, 3,6,9-triaza-1,11-undecylene, 3-aza-1,6-hexylene and 3,7-diaza-1,9-nonylene. These amines of the formula (I) are particularly readily available industrially.

15

Among these, preference is given to 1,2-ethylene, 1,2-propylene, 2-methyl-1,5-pentylene, 1,2-cyclohexylene, 1,3-cyclohexylene, 1,4-cyclohexylene, (1,5,5-trimethylcyclohexan-1-yl)methane-1,3, 4(2)-methyl-1,3-cyclohexylene, 1,3-cyclohexylenebis(methylene), 1,4-cyclohexylenebis(methylene), 1,3-
 20 phenylenebis(methylene), 1,4-phenylenebis(methylene), 3-aza-1,5-pentylene, 3,6-diaza-1,8-octylene, 3,6,9-triaza-1,11-undecylene, 3-aza-1,6-hexylene or 3,7-diaza-1,9-nonylene.

25

More preferably, the A radical is free of nitrogen atoms. Such a composition has particularly low sensitivity to blushing effects.

More particularly, A is thus a divalent radical selected from the group consisting of 1,2-ethylene, 1,2-propylene, 1,3-propylene, 1,4-butylene, 1,3-butylene, 2-methyl-1,2-propylene, 1,3-pentylene, 1,5-pentylene, 2,2-dimethyl-1,3-propylene, 1,6-hexylene, 2-methyl-1,5-pentylene, 1,7-heptylene, 1,8-octylene, 2,5-dimethyl-1,6-
 30 hexylene, 1,9-nonylene, 2,2(4),4-trimethyl-1,6-hexylene, 1,10-decylene, 1,11-undecylene, 2-butyl-2-ethyl-1,5-pentylene, 1,12-dodecylene, 1,2-cyclohexylene, 1,3-cyclohexylene, 1,4-cyclohexylene, (1,5,5-trimethylcyclohexan-1-yl)methane-1,3, 4(2)-methyl-1,3-cyclohexylene, 1,3-cyclohexylenebis(methylene), 1,4-

cyclohexylenebis(methylene), 1,3-phenylenebis(methylene) and 1,4-phenylenebis(methylene).

Most preferably, A is 1,2-ethylene, 1,2-propylene, 1,3-cyclohexylenebis(methylene) or 1,3-phenylenebis(methylene). These amines of the formula (I) are of comparatively low viscosity and enable coatings having particularly nice surfaces.

Especially preferred is 1,2-ethylene. These amines of the formula (I) are of particularly low viscosity and particularly readily available, and enable particularly rapid curing.

Also especially preferred is 1,2-propylene. These amines of the formula (I) are of particularly low viscosity and enable particularly nice surfaces.

Y is preferably hexyl, 2-ethylhexyl, octyl, nonyl, decyl, undecyl, dodecyl or an optionally substituted 1-phenylethyl, 2-phenylethyl, benzyl, naphthylmethyl, cyclohexylmethyl or 2-cyclohexylethyl radical.

More preferably, Y is a radical selected from 2-ethylhexyl, 2-phenylethyl, benzyl, 1-naphthylmethyl and cyclohexylmethyl. These amines of the formula (I) are of comparatively low viscosity and enable particularly nice surfaces.

Most preferably, Y is benzyl. These amines of the formula (I) enable particularly rapid curing and very particularly nice surfaces.

The amine of the formula (I) is preferably selected from the group consisting of N-benzylethane-1,2-diamine, N,N'-dibenzylethane-1,2-diamine, N-(1-naphthylmethyl)ethane-1,2-diamine, N-cyclohexylmethylethane-1,2-diamine, N-benzylpropane-1,2-diamine, N,N'-dibenzylpropane-1,2-diamine, N-benzyl-1,3-bis(aminomethyl)benzene, N,N'-dibenzyl-1,3-bis(aminomethyl)benzene, N-(2-ethylhexyl)-1,3-bis(aminomethyl)benzene, N,N'-bis(2-ethylhexyl)-1,3-bis(aminomethyl)benzene, N-(2-phenylethyl)-1,3-bis(aminomethyl)benzene

(constituent of styrenized 1,3-bis(aminomethyl)benzene, obtainable as Gaskamine[®] 240 from Mitsubishi Gas Chemical), N-benzyl-diethylenetriamine, N-benzyltriethylenetetramine, N¹,N⁴-dibenzyltriethylenetetramine, N-benzyltetraethylenepentamine, N¹,N⁵-dibenzyltetraethylenepentamine, N'-benzyl-
5 N-(3-aminopropyl)ethylenediamine, N''-benzyl-N,N'-bis(3-aminopropyl)ethylenediamine and N''',N'''-dibenzyl-N,N'-bis(3-aminopropyl)ethylenediamine.

Preference is given to amines of the formula (I) in which m and n are each 1.
10 These amines of the formula (I) enable particularly rapid curing. Such an amine of the formula (I) optionally additionally contains a certain proportion of dialkylated amine, i.e. amine of the formula (I) in which m is 0 and n is 2. The weight ratio here between monoalkylated amine (n and m are each 1) and dialkylated amine (n is 2) is preferably at least 50/50, especially at least
15 65/35.

A particularly preferred amine of the formula (I) is N-benzylethane-1,2-diamine or N-benzylpropane-1,2-diamine.
N-Benzylethane-1,2-diamine optionally contains proportions of N,N'-
20 dibenzylethane-1,2-diamine. N-Benzylpropane-1,2-diamine optionally contains proportions of N,N'-dibenzylpropane-1,2-diamine.

The most preferred amine of the formula (I) is N-benzylethane-1,2-diamine. This optionally contains up to 35% by weight of N,N'-dibenzylethane-1,2-diamine
25 based on the sum total of the two amines. This enables particularly rapid curing.

Preference is given to using the amine of the formula (I) as constituents of the reaction mixture from the partial alkylation of at least one amine of the formula A(NH₂)₂ with at least one alkylating agent.
30 Preferably, the alkylation is a reductive alkylation, where the alkylating agent used is an aldehyde or ketone and hydrogen.
Preference is given to conducting the reductive alkylation in the presence of a suitable catalyst. Preferred catalysts are palladium on charcoal (Pd/C), platinum

on charcoal (Pt/C), Adams' catalyst or Raney nickel, especially palladium on charcoal or Raney nickel.

When molecular hydrogen is used, the reductive alkylation is preferably worked in a pressure apparatus at a hydrogen pressure of 5 to 150 bar, especially 10 to 100
5 bar. This can be effected in a batchwise process or preferably in a continuous process.

The reductive alkylation is preferably conducted at a temperature in the range from 40 to 120°C, especially 60 to 100°C.

In the case of small volatile diamines such as ethane-1,2-diamine or propane-1,2-
10 diamine in particular, this is preferably used in a stoichiometric excess relative to the aldehyde or ketone and, after the alkylation, unconverted diamine is at least partly removed from the reaction mixture, especially by means of stripping. If desired, the reaction mixture may then be purified further, especially by freeing the monoalkylated amine at least partly of the dialkylated amine by means of
15 distillation.

The amine of the formula (I) is preferably present in such an amount that there are 0.1 to 1.2, preferably 0.2 to 1, especially 0.2 to 0.8, mol of amine hydrogens from amines of the formula (I) per mole of epoxy groups. If there is less than 1 mol of
20 amine hydrogens from amines of the formula (I) per mole of epoxy groups, further amines reactive with epoxy groups are preferably included.

Preferably, neither the epoxy resin nor the amine of the formula (I), the curing of which is accelerated by the calcium nitrate, is in the form of an emulsion in water.
25 More particularly, the reaction mixture comprising at least one epoxy resin, at least one amine of the formula (I) and calcium nitrate is not water-based. The reaction mixture preferably contains less than 5% by weight, more preferably less than 1% by weight, of water. Such a reaction mixture enables very hydrophobic and stable materials.

30

As well as calcium nitrate, at least one epoxy resin and at least one amine of the formula (I), the composition preferably additionally comprises at least one further

constituent selected from further accelerators, reactive diluents, further amines, thinners and fillers.

The epoxy resin composition preferably comprises

- 5 – a resin component comprising the epoxy resin and optionally at least one reactive diluent and
- a curing agent component comprising the amine of the formula (I) and optionally further amines,

10 where calcium nitrate, further accelerators and/or thinners may be present as a constituent of the resin component and/or of the curing agent component or as a constituent of a further component.

Preferred further accelerators are acids or compounds hydrolyzable to acids, especially organic carboxylic acids such as acetic acid, benzoic acid, salicylic acid, 2-nitrobenzoic acid, lactic acid, organic sulfonic acids such as

15 methanesulfonic acid, p-toluenesulfonic acid or 4-dodecylbenzenesulfonic acid, sulfonic esters, other organic or inorganic acids such as, in particular, phosphoric acid, or mixtures of the aforementioned acids and acid esters; tertiary amines such as, in particular, 1,4-diazabicyclo[2.2.2]octane, benzyldimethylamine, α -

20 methylbenzyldimethylamine, triethanolamine, dimethylaminopropylamine, imidazoles such as, in particular, N-methylimidazole, N-vinylimidazole or 1,2-dimethylimidazole, salts of such tertiary amines, quaternary ammonium salts, especially benzyltrimethylammonium chloride, amidines such as, in particular, 1,8-diazabicyclo[5.4.0]undec-7-ene, guanidines such as, in particular, 1,1,3,3-

25 tetramethylguanidine, phenols, especially bisphenols, phenolic resins or Mannich bases having tertiary amino groups, such as, in particular, 2-(dimethylaminomethyl)phenol, 2,4,6-tris(dimethylaminomethyl)phenol or polymers of phenol, formaldehyde and N,N-dimethylpropane-1,3-diamine, phosphites such as, in particular, di- or triphenyl phosphites, or compounds having mercapto

30 groups.

Preferred accelerators are acids, tertiary amines, or Mannich bases having tertiary amino groups. Particular preference is given to salicylic acid or 2,4,6-tris(dimethylaminomethyl)phenol.

The composition preferably comprises 2,4,6-tris(dimethylaminomethyl)phenol, preferably in a weight ratio of calcium nitrate to 2,4,6-tris(dimethylaminomethyl)phenol of 0.1/1 to 5/1, especially 0.2/1 to 2/1. Such a
5 combination enables epoxy resin compositions that cure rapidly to give a particularly high final hardness under warm and cold ambient conditions.

Preferred reactive diluents are reactive diluents containing epoxy groups, especially butanediol diglycidyl ether, hexanediol diglycidyl ether,
10 trimethylolpropane di- or triglycidyl ether, phenyl glycidyl ether, cresyl glycidyl ether, guaiacol glycidyl ether, 4-methoxyphenyl glycidyl ether, p-n-butylphenyl glycidyl ether, p-tert-butylphenyl glycidyl ether, 4-nonylphenyl glycidyl ether, 4-dodecylphenyl glycidyl ether, cardanol glycidyl ether, benzyl glycidyl ether, allyl glycidyl ether, butyl glycidyl ether, hexyl glycidyl ether, 2-ethylhexyl glycidyl ether,
15 or glycidyl ethers of natural alcohols, such as, in particular, C₈- to C₁₀- or C₁₂- to C₁₄- or C₁₃- to C₁₅-alkyl glycidyl ethers.

Preferred further amines are aliphatic, cycloaliphatic or araliphatic polyamines having at least 2, especially at least 3, amine hydrogens, such as, in particular,
20 2,2-dimethylpropane-1,3-diamine, pentane-1,3-diamine (DAMP), pentane-1,5-diamine, 1,5-diamino-2-methylpentane (MPMD), 2-butyl-2-ethylpentane-1,5-diamine (C₁₁ neodiamine), hexane-1,6-diamine, 2,5-dimethylhexane-1,6-diamine, 2,2(4),4-trimethylhexane-1,6-diamine (TMD), heptane-1,7-diamine, octane-1,8-diamine, nonane-1,9-diamine, decane-1,10-diamine, undecane-1,11-diamine,
25 dodecane-1,12-diamine, 1,2-, 1,3- or 1,4-diaminocyclohexane, 1,3-bis(aminomethyl)cyclohexane, 1,4-bis(aminomethyl)cyclohexane, bis(4-aminocyclohexyl)methane, bis(4-amino-3-methylcyclohexyl)methane, bis(4-amino-3-ethylcyclohexyl)methane, bis(4-amino-3,5-dimethylcyclohexyl)methane, bis(4-amino-3-ethyl-5-methylcyclohexyl)methane, 1-amino-3-aminomethyl-3,5,5-
30 trimethylcyclohexane (isophoronediamine or IPDA), 2(4)-methyl-1,3-diaminocyclohexane, 2,5(2,6)-bis(aminomethyl)bicyclo[2.2.1]heptane (NBDA), 3(4),8(9)-bis(aminomethyl)tricyclo[5.2.1.0^{2,6}]decane, 1,4-diamino-2,2,6-trimethylcyclohexane (TMCD), menthane-1,8-diamine, 3,9-bis(3-aminopropyl)-

2,4,8,10-tetraoxaspiro[5.5]undecane, 1,3-bis(aminomethyl)benzene (MXDA), 1,4-bis(aminomethyl)benzene, bis(2-aminoethyl) ether, 3,6-dioxaoctane-1,8-diamine, 4,7-dioxadecane-1,10-diamine, 4,7-dioxadecane-2,9-diamine, 4,9-dioxadodecane-1,12-diamine, 5,8-dioxadodecane-3,10-diamine, 4,7,10-trioxatridecane-1,13-diamine or higher oligomers of these diamines, bis(3-aminopropyl)polytetrahydrofurans or other polytetrahydrofurandiamines, cycloaliphatic diamines containing ether groups from the propoxylation and subsequent amination of 1,4-dimethylolcyclohexane, especially obtainable as Jeffamine[®] RFD-270 (from Huntsman), or polyoxyalkylenedi- or -triamines, especially Jeffamine[®] D-230, Jeffamine[®] D-400, Jeffamine[®] D-2000, Jeffamine[®] EDR-104, Jeffamine[®] EDR-148, Jeffamine[®] EDR-176, Jeffamine[®] T-403, Jeffamine[®] T-3000, Jeffamine[®] T-5000 (all from Huntsman), or corresponding amines from BASF or Nitroil, 2-aminoethylpiperazine, 3-dimethylaminopropylamine (DMAPA), 3-(3-(dimethylamino)propylamino)propylamine (DMAPAPA), bis(6-aminohexyl)amine (BHMT), diethylenetriamine (DETA), triethylenetetramine (TETA), tetraethylenepentamine (TEPA), pentaethylenehexamine (PEHA) or higher homologs of linear polyethyleneamines, dipropylenetriamine (DPTA), N-(2-aminoethyl)propane-1,3-diamine (N3 amine), N,N'-bis(3-aminopropyl)ethylenediamine (N4 amine), N,N'-bis(3-aminopropyl)-1,4-diaminobutane, N5-(3-aminopropyl)-2-methylpentane-1,5-diamine, N3-(3-aminopentyl)pentane-1,3-diamine, N5-(3-amino-1-ethylpropyl)-2-methylpentane-1,5-diamine, N,N'-bis(3-amino-1-ethylpropyl)-2-methylpentane-1,5-diamine, adducts of the abovementioned or further polyamines with epoxides or epoxy resins, especially adducts with diepoxides or monoepoxides, or polyamido amines, especially reaction products of a mono- or polybasic carboxylic acid or ester or anhydride thereof, especially a dimer fatty acid, with an aliphatic, cycloaliphatic or aromatic polyamine used in stoichiometric excess, especially a polyalkyleneamine, for example DETA or TETA, or Mannich bases, especially phenalkamines, i.e. reaction products of phenols, especially cardanol, with aldehydes, especially formaldehyde, and polyamines.

The composition preferably comprises at least one further amine selected from the group consisting of TMD, 1,2-, 1,3- or 1,4-diaminocyclohexane, 1,3-bis(aminomethyl)cyclohexane, 1,4-bis(aminomethyl)cyclohexane, bis(4-aminocyclohexyl)methane, IPDA, 2(4)-methyl-1,3-diaminocyclohexane, MXDA, 5 polyoxypropylenediamines having an average molecular weight M_n in the range from 200 to 500 g/mol, DMAPAPA, BHMT, DETA, TETA, TEPA, PEHA, DPTA, N3 amine, N4 amine, adducts of these or further polyamines with mono- or diepoxides and Mannich bases.

Among these, preference is given to TMD, 1,3-bis(aminomethyl)cyclohexane, 10 IPDA, MXDA, BHMT, DETA, TETA, TEPA, PEHA, DPTA, N3 amine, N4 amine or adducts thereof with mono- or diepoxides, especially adducts thereof with bisphenol A or bisphenol F diglycidyl ether. The additional use of such an amine can enable particularly high hardness or a particularly high glass transition temperature.

15 Among these, preference is further given to DMAPAPA, especially for use in epoxy resin adhesives. This gives particularly high strengths and bonding forces. Among these, preference is further given to an adduct of MPMD or propane-1,2-diamine with cresyl glycidyl ether, especially ortho-cresyl glycidyl ether. The adduct formation is preferably performed with an excess of MPMD or propane- 20 1,2-diamine over cresyl glycidyl ether, and the amine that has not formed an adduct is preferably removed after the reaction by means of distillation.

The composition may preferably comprise a combination of two or more of the further amines mentioned.

25 A particularly preferred further amine is IPDA. This amine is widely available and enable epoxy resin products having high hardness and high glass transition temperature.

In addition, the further amine is more preferably TETA or TEPA or N4 amine. These amines are widely available and inexpensive, and enable epoxy resin 30 compositions having particularly rapid curing, high hardness and high glass transition temperature.

The composition may preferably also comprise a combination of two or more such further amines.

Such further amines are preferably used in such an amount that there is 0.1 to 10, preferably 0.2 to 5, mol of amine hydrogens from further amines per mole of amine hydrogen from amines of the formula (I).

A suitable thinner is especially xylene, 2-methoxyethanol, dimethoxyethanol, 2-ethoxyethanol, 2-propoxyethanol, 2-isopropoxyethanol, 2-butoxyethanol, 2-phenoxyethanol, 2-benzyloxyethanol, benzyl alcohol, ethylene glycol, ethylene glycol dimethyl ether, ethylene glycol diethyl ether, ethylene glycol dibutyl ether, ethylene glycol diphenyl ether, diethylene glycol, diethylene glycol monomethyl ether, diethylene glycol monoethyl ether, diethylene glycol mono-n-butyl ether, diethylene glycol dimethyl ether, diethylene glycol diethyl ether, diethylene glycol di-n-butyl ether, propylene glycol butyl ether, propylene glycol phenyl ether, dipropylene glycol, dipropylene glycol monomethyl ether, dipropylene glycol dimethyl ether, dipropylene glycol di-n-butyl ether, diphenylmethane, diisopropylnaphthalene, mineral oil fractions, for example Solvesso[®] grades (from Exxon), alkylphenols such as tert-butylphenol, nonylphenol, dodecylphenol, cardanol (from cashewnutshell oil, containing 3-(8,11,14-pentadecatrienyl)phenol as its main constituent), styrenized phenol, bisphenols, aromatic hydrocarbon resins, especially types containing phenol groups, alkoxyated phenol, especially ethoxyated or propoxyated phenol, especially 2-phenoxyethanol, adipates, sebacates, phthalates, benzoates, organic phosphoric or sulfonic esters or sulfonamides.

Preferred thinners have a boiling point of more than 200°C.

The thinner is preferably selected from the group consisting of benzyl alcohol, styrenized phenol, ethoxyated phenol, aromatic hydrocarbon resins containing phenol groups, especially the Novares[®] LS 500, LX 200, LA 300 or LA 700 grades (from Rütgers), diisopropylnaphthalene and cardanol.

Particular preference is given to benzyl alcohol.

Thinners containing phenol groups are also effective as accelerator.

The composition preferably contains only a small content of thinners. It preferably contains less than 25% by weight, more preferably less than 15% by weight, especially less than 10% by weight, of thinners. This enables low-emissions or emissions-free epoxy resin products.

5

Suitable fillers are, in particular, ground or precipitated calcium carbonate, which is optionally coated with fatty acid, in particular stearates, baryte (heavy spar), talc, quartz powder, quartz sand, silicon carbide, iron mica, dolomite, wollastonite, kaolin, mica (potassium aluminum silicate), molecular sieve, aluminum oxide, aluminum hydroxide, magnesium hydroxide, silica, cement, gypsum, fly ash, carbon black, graphite, metal powders such as aluminum, copper, iron, zinc, silver or steel, PVC powder or hollow beads.

10

Preference is given to calcium carbonate, quartz powder, and quartz sand.

15 The composition optionally comprises further auxiliaries and additives, especially the following:

– reactive diluents, in particular those already mentioned, or epoxidized soybean oil or linseed oil, compounds containing acetoacetate groups, in particular acetoacetylated polyols, butyrolactone, carbonates, aldehydes, isocyanates or
20 silicones having reactive groups;

– solvents;

– further amines, especially monoamines such as, in particular, benzylamine or furfurylamine or aromatic polyamines such as, in particular, 4,4'-, 2,4' and/or 2,2'-diaminodiphenylmethane, 2,4- and/or 2,6-tolylenediamine, 3,5-

25

dimethylthio-2,4-tolylenediamine and/or 3,5-dimethylthio-2,6-tolylenediamine, 3,5-diethyl-2,4-tolylenediamine and/or 3,5-diethyl-2,6-tolylenediamine;

– compounds having mercapto groups, in particular liquid mercaptan-terminated polysulfide polymers, mercaptan-terminated polyoxyalkylene ethers, mercaptan-terminated polyoxyalkylene derivatives, polyesters of thiocarboxylic
30 acids, 2,4,6-trimercapto-1,3,5-triazine, triethylene glycol dimercaptan or ethanedithiol;

– polymers, in particular polyamides, polysulfides, polyvinyl formal (PVF), polyvinyl butyral (PVB), polyurethanes (PUR), polymers having carboxyl

- groups, polyamides, butadiene-acrylonitrile copolymers, styrene-acrylonitrile copolymers, butadiene-styrene copolymers, homo- or copolymers of unsaturated monomers, in particular from the group comprising ethylene, propylene, butylene, isobutylene, isoprene, vinyl acetate or alkyl
- 5 (meth)acrylates, in particular chlorosulfonated polyethylenes or fluorine-containing polymers or sulfonamide-modified melamines;
- fibers, in particular glass fibers, carbon fibers, metal fibers, ceramic fibers or polymer fibers such as polyamide fibers or polyethylene fibers;
 - pigments, in particular titanium dioxide, iron oxides or chromium(III) oxide;
 - 10 – rheology modifiers, in particular thickeners or antissettling agents;
 - adhesion improvers, in particular organoalkoxysilanes;
 - flame-retardant substances, in particular the aluminum hydroxide or magnesium hydroxide fillers already mentioned, antimony trioxide, antimony pentoxide, boric acid ($B(OH)_3$), zinc borate, zinc phosphate, melamine borate,
 - 15 melamine cyanurate, ammonium polyphosphate, melamine phosphate, melamine pyrophosphate, polybrominated diphenyl oxides or diphenyl ethers, phosphates such as, in particular, diphenyl cresyl phosphate, resorcinol bis(diphenylphosphate), resorcinol diphosphate oligomer, tetraphenylresorcinol diphosphite, ethylenediamine diphosphate, bisphenol A
 - 20 bis(diphenylphosphate), tris(chloroethyl) phosphate, tris(chloropropyl) phosphate, tris(dichloroisopropyl) phosphate, tris[3-bromo-2,2-bis(bromomethyl)propyl] phosphate, tetrabromobisphenol A, bis(2,3-dibromopropyl ether) of bisphenol A, brominated epoxy resins, ethylenebis(tetrabromophthalimide),
 - 25 ethylenebis(dibromonorbornanedicarboximide), 1,2-bis(tribromophenoxy)ethane, tris(2,3-dibromopropyl) isocyanurate, tribromophenol, hexabromocyclododecane, bis(hexachlorocyclopentadieno)cyclooctane or chloroparaffins; or
 - additives, especially dispersed paraffin wax, film-forming auxiliaries, wetting
 - 30 agents, leveling agents, defoamers, deaerators, stabilizers against oxidation, heat, light or UV radiation, or biocides.

The composition preferably comprises further auxiliaries and additives, especially pigments, wetting agents, leveling agents and/or defoamers.

5 In the composition, the ratio of the number of groups reactive toward epoxy groups relative to the number of epoxy groups is preferably in the range from 0.5 to 1.5, especially 0.7 to 1.2.

10 The primary and secondary amino groups present in the composition, and any other groups present that are reactive toward epoxy groups, react with the epoxy groups, resulting in ring opening (addition reaction) thereof. As a result primarily of this reaction, the composition polymerizes and thereby cures.

The resin component and the curing agent component of the composition are stored in separate containers. Further constituents of the composition may be present as a constituent of the resin component or of the curing agent component;
15 further constituents reactive toward epoxy groups are preferably a constituent of the curing agent component. It is likewise possible for further constituents to be present as a dedicated, separate component.

A suitable container for storage of the resin component or the curing agent component is especially a vat, a hobcock, a bag, a bucket, a can, a cartridge or a
20 tube. The components are storable, meaning that they can be stored prior to use for several months up to one year or longer without any change in their respective properties to a degree relevant to their use. For the use of the epoxy resin composition, the components are mixed with one another shortly before or during application. The mixing ratio between the resin component and the curing agent
25 component is preferably chosen such that the groups of the curing agent component that are reactive toward epoxy groups are in a suitable ratio to the epoxy groups of the resin component, as described above. In parts by weight, the mixing ratio between the resin component and the curing agent component is typically in the range from 1:10 to 10:1.

30 The components are mixed by means of a suitable method; this mixing may be done continuously or batchwise. If the mixing does not immediately precede the application, it has to be ensured that not too much time passes between the mixing of the components and the application and that the application is effected

within the pot life. The mixing is especially effected at ambient temperature, which is typically within the range from about 5 to 40°C, preferably about 10 to 35°C.

Curing by chemical reaction begins with the mixing of the two components, as described above. The curing typically proceeds at a temperature in the range from 5 0 to 150°C. It preferably proceeds at ambient temperature and typically extends over a few days to weeks. The duration depends upon factors including the temperature, the reactivity of the constituents, and the stoichiometry thereof, and on the presence of accelerators.

10 The composition is applied to at least one substrate, the following substrates being particularly suitable:

- glass, glass ceramic, concrete, mortar, cement screed, fiber cement, brick, tile, gypsum and natural rocks such as granite or marble;
- repair or leveling compounds based on PCC (polymer-modified cement mortar) 15 or ECC (epoxy resin-modified cement mortar);
- metals or alloys such as aluminum, iron, steel, copper, other nonferrous metals, including surface-upgraded metals or alloys such as galvanized or chrome-plated metals;
- asphalt or bitumen;
- 20 – leather, textiles, paper, wood, woodbase materials bonded with resins, e.g. phenolic, melamine or epoxy resins, resin-textile composites or further so-called polymer composites;
- plastics, such as rigid and flexible PVC, polycarbonate, polystyrene, polyester, polyamide, PMMA, ABS, SAN, epoxy resins, phenolic resins, PUR, POM, TPO, 25 PE, PP, EPM or EPDM, in each case untreated or surface-treated, for example by means of plasma, corona or flames;
- fiber-reinforced plastics, such as carbon fiber-reinforced plastics (CFP), glass fiber-reinforced plastics (GFP) and sheet molding compounds (SMC);
- insulation foams, especially made of EPS, XPS, PUR, PIR, rock wool, glass 30 wool or foamed glass;
- coated or painted substrates, especially painted tiles, coated concrete, powder-coated metals or alloys or painted metal sheets;

- coatings, paints or varnishes, especially coated floors that have been overcoated with a further floor covering layer.

If required, the substrates can be pretreated prior to application, especially by physical and/or chemical cleaning methods or the application of an activator or a primer.

The curing of the composition described affords a cured composition.

The composition described is advantageously usable as coating, primer, adhesive, sealant, encapsulating compound, casting resin, or as matrix for fiber composites such as, in particular, CFRP or GFRP. The term "coating" also covers primers, paints, varnishes and sealants.

The composition is preferably used as coating or adhesive.

The composition described is more preferably used as coating. Coatings are understood here to mean coverings of all kinds that are applied over an area, especially floor coverings, paints, varnishes, sealants, primers or protective coatings, especially also those for heavy-duty corrosion protection.

The composition is particularly suitable as a floor covering or floor coating for interiors such as offices, industrial halls, gym halls or cooling spaces, or outdoors for balconies, terraces, parking decks, bridges or roofs, as a protective coating for concrete, cement, metals, plastics or wood, for example for surface sealing of wood constructions, vehicles, loading areas, tanks, silos, shafts, pipelines, machines or steel constructions, for example of ships, piers, offshore platforms, lock gates, hydroelectric power plants, river constructions, swimming pools, wind turbines, bridges, chimneys, cranes or sheet-pile walls, or as an undercoat, primer coat or anticorrosion primer or for hydrophobization of surfaces.

Particularly advantageously, the composition described is used in low-emission coatings with environmental quality seals, for example according to Emission Code (EC1 Plus), AgBB, DIBt, Der Blaue Engel, AFSSET, RTS (M1) and US Green Building Council (LEED).

For use as a coating, the composition advantageously has a fluid consistency with low viscosity and good leveling properties. The mixed composition is, within the pot life, typically applied to the surface of a substrate as a thin film having a layer

5 thickness of about 50 μm to about 5 mm, typically at ambient temperature.

Application is effected especially by pouring onto the substrate to be coated and subsequent homogeneous distribution with the aid, for example, of a coating bar or a notched trowel. Application can also be effected with a brush or roller or in the form of a spray application, for example as an anticorrosion coating on steel.

10 Curing typically gives rise to substantially homogeneous, glossy and nontacky films of high hardness which have good adhesion to a wide variety of different substrates.

The invention further provides a method of coating, comprising the steps of

- 15 (i) mixing the components of the composition described,
(ii) applying the mixed composition to a substrate within the pot life,
followed by the curing of the mixed composition.

It is possible to apply a further coating to the fully or partly cured composition, in

20 which case said further layer may likewise be an epoxy resin composition, or else another material, especially a polyurethane or polyurea coating.

Particular preference is also given to using the composition described as an adhesive. When used as adhesive, after the components have been mixed, it

25 typically has a pasty consistency with structurally viscous properties. On application, the mixed adhesive is applied within the pot life to at least one of the substrates to be bonded and the two substrates are joined to form an adhesive bond within the open time of the adhesive.

The mixed adhesive is applied especially by means of a brush, roll, spatula, doctor

30 blade or trowel, or from a tube, cartridge or metering device.

The adhesive is particularly suitable for uses in the construction industry, especially for the reinforcement of built structures by means of steel elements or elements made of carbon fiber-reinforced composite plastics (CFRP), for

constructions containing bonded precast concrete components, especially bridges or concrete towers, for example for wind turbines, shafts, pipelines or tunnels, or for constructions containing bonded natural rocks, ceramic elements or parts made of fiber cement, steel, cast iron, aluminum, wood or polyester, for the

5 anchoring of anchors or steel bars in boreholes, the fixing of, for example, handrails, railings or doorframes, for repairs such as, in particular, the filling of edges, holes or joins in concrete maintenance, or for the bonding of films of polyvinylchloride (PVC), flexibilized polyolefin (Combiflex[®]) or adhesion-modified chlorosulfonated polyethylene (Hypalon[®]) to concrete or steel.

10 Further fields of use relate to structural bonding in the construction or manufacturing industry, especially as adhesive mortar, assembly adhesive, reinforcement adhesive such as, in particular, for the bonding of CRP or steel elements to concrete, brickwork or wood, as element adhesive, for example for bridge elements, sandwich element adhesive, facade element adhesive,

15 reinforcing adhesive, bodywork adhesive or half-shell adhesive for rotor blades of wind turbines.

Such an epoxy resin adhesive is likewise suitable for the filling of cavities such as fissures, cracks or drillholes, wherein the adhesive is filled or injected into the cavity and fills it after curing, and bonds or sticks the flanks of the cavity to one

20 another in a force-fitting manner.

The invention further provides a method of bonding, comprising the steps of

- (i) mixing the components of the composition described,
 - (ii) applying the mixed composition within the pot life,
 - 25 – either to at least one of the substrates to be bonded and joining the substrates to form a bond within the open time,
 - or into a cavity or gap between two or more substrates and optionally inserting an anchor into the cavity or gap within the open time,
- followed by the curing of the mixed composition.

30

An "anchor" refers here more particularly to a rebar, a threaded rod or a bolt. An anchor is especially adhesive-bonded or anchored in a wall, ceiling or foundation

in such a way that a portion thereof is bonded in a force-fitting manner and a portion thereof protrudes and can be subjected to a construction load.

Identical or different substrates may be bonded.

5

The application and curing of the composition described, or the method of coating or the method of bonding, affords an article coated or bonded with the composition. This article may be a built structure or part thereof, especially a built structure above or below the ground, an office, an industrial hall, a sports hall, a chill room, a silo, a bridge, a roof, a staircase, a balcony, a terrace or a parking deck, or it may be an industrial good or a consumer good, especially a pier, an offshore platform, a lock gate, a crane, a bulkhead, a pipeline or a rotor blade of a wind turbine, or a mode of transport such as, in particular, an automobile, a truck, a rail vehicle, a ship, an aircraft or helicopter, or an installable component thereof.

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The invention thus further provides an article obtained from the described method of coating or from the described method of bonding.

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The composition described is notable for advantageous properties. It has easy and good processibility, especially as a coating, cures rapidly and can soon be walked upon and/or is soon processible, especially also under moist and cold conditions. What are achieved are especially coatings of high mechanical quality with a nice surface and a low tendency to yellowing.

25 **Examples**

Working examples are adduced hereinafter, which are intended to elucidate the invention described. The invention is of course not limited to these described working examples.

"AHEW" stands for amine hydrogen equivalent weight.

30 "EEW" stands for epoxy equivalent weight.

"Standard climatic conditions" refer to a temperature of $23 \pm 1^\circ\text{C}$ and a relative air humidity of $50 \pm 5\%$.

Description of the measurement methods:

Viscosity was measured on a thermostated Rheotec RC30 cone-plate viscometer (cone diameter 50 mm, cone angle 1°, cone tip-plate distance 0.05 mm, shear rate 10 s⁻¹).

- 5 **Amine value** was determined by means of titration (with 0.1N HClO₄ in acetic acid versus crystal violet).

Substances and abbreviations used:

Sikafloor®-264N (A)	Sikafloor®-264N component A (RAL 5005), filled pigmented resin component of an epoxy resin floor coating, EEW 450 g/eq (from Sika)
B-EDA	N-benzylethane-1,2-diamine, prepared as described below, AHEW 50.1 g/eq
B-PDA	N-benzylpropane-1,2-diamine, prepared as described below, AHEW 54.8 g/eq
TETA	triethylenetetramine, AHEW about 28 g/eq (technical grade, from Huntsman)
Adduct-1	adduct of propylene-1,2-diamine and technical grade o-cresyl glycidyl ether, prepared as described below, AHEW 90 g/eq
Jeffamine® D-230	polyoxypropylenediamine with average molecular weight about 240 g/mol, AHEW 60 g/eq (from Huntsman)
Ca nitrate solution	50% by weight of calcium nitrate tetrahydrate in water
Ancamine® K54	2,4,6-tris(dimethylaminomethyl)phenol (from Air Products)

- 10 **N-Benzylethane-1,2-diamine (B-EDA):**

A round-bottom flask was initially charged with 180.3 g (3 mol) of ethylene-1,2-diamine under a nitrogen atmosphere at room temperature. With good stirring, a solution of 106.0 g (1 mol) of benzaldehyde in 1200 ml of isopropanol was slowly added dropwise, and the mixture was stirred for 2 hours. The reaction mixture was

15 then hydrogenated in a continuous hydrogenation apparatus with a Pd/C fixed bed catalyst at a hydrogen pressure of 80 bar, a temperature of 80°C and a flow rate of 5 ml/min. To monitor the reaction, IR spectroscopy was used to check whether the imine band at about 1665 cm⁻¹ had disappeared. Thereafter, the hydrogenated

solution was concentrated on a rotary evaporator at 65°C, removing unreacted ethylene-1,2-diamine, water and isopropanol. The reaction mixture thus obtained was a clear, pale yellowish liquid having an amine value of 678 mg KOH/g. 50 g of this were distilled at 80°C under reduced pressure, with collection of 31.3 g of
5 distillate at a vapor temperature of 60 to 65°C and 0.06 mbar. What was obtained was a colorless liquid having a viscosity of 8.3 mPa·s at 20°C, an amine value of 750 mg KOH/g and a purity, determined by GC, of > 97%.

N-Benzylpropane-1,2-diamine (B-PDA):

10 A round-bottom flask was initially charged with 444.8 g (6 mol) of propane-1,2-diamine under a nitrogen atmosphere at room temperature. With good stirring, a solution of 212.2 g (2 mol) of benzaldehyde in 1'500 ml of isopropanol was slowly added dropwise, and the mixture was stirred for 2 hours. The reaction mixture was then hydrogenated in a continuous hydrogenation apparatus with a Pd/C fixed bed
15 catalyst at a hydrogen pressure of 90 bar, a temperature of 85°C and a flow rate of 5 ml/min. To monitor the reaction, IR spectroscopy was used to check whether the imine band at about 1665 cm⁻¹ had disappeared. Thereafter, the hydrogenated solution was concentrated on a rotary evaporator at 65°C, removing unreacted propane-1,2-diamine, isopropanol and water. A clear, pale yellowish liquid was
20 obtained. 300 g of this were distilled at 80°C under reduced pressure, with collection of 237.5 g of distillate at a vapor temperature of 60 to 65°C and 0.08 mbar. A colorless liquid having an amine value of 682 mg KOH/g was obtained, which, by ¹H NMR, was a mixture of N¹-benzylpropane-1,2-diamine and N²-benzylpropane-1,2-diamine in a ratio of about 2/1 and had a GC purity of
25 > 97%.

Adduct-1:

An initial charge of 4.15 kg of propane-1,2-diamine under a nitrogen atmosphere was heated to 70°C and then, with good stirring, 2.93 kg of Araldite® DY-K (o-cresyl glycidyl ether, technical grade, from Huntsman) was added gradually, with
30 the temperature of the reaction mixture from 70 to 80°C. After 1 hour at 80°C, the reaction mixture was cooled down and the volatile constituents were removed by

distillation by means of a thin-film evaporator (0.5-1 mbar, jacket temperature 115°C).

Production of epoxy resin compositions:

5 **Examples 1 to 17:**

For each example, the ingredients of the curing agent component indicated in tables 1 to 3 were mixed in the indicated amounts (in parts by weight) by means of a centrifugal mixer (SpeedMixer™ DAC 150, FlackTek Inc.) and stored with the exclusion of moisture.

10 The resin component used was Sikafloor®-264N comp. A (blue) (from Sika) in the amount specified in tables 1 to 3 (in parts by weight).

The two components of each composition were then processed by means of the centrifugal mixer to give a homogeneous liquid and this was tested immediately as follows:

15 10 minutes after mixing, the viscosity was measured at 20°C ("**Viscosity (10')**").

For the determination of **Shore D hardness** to DIN 53505, two cylindrical test specimens (diameter 20 mm, thickness 5 mm) in each case were produced. One was stored under standard climatic conditions and hardness was measured after 1 day and after 2 days (1d SCC and 2d SCC); the other was stored at 8°C and

20 80% relative humidity and hardness was measured after 1 day and after 2 days in the cold state (1d 8°/80% and 2d 8°/80%).

A first film coating was applied to a glass plate in a layer thickness of 500 µm, and this was stored/cured under standard climatic conditions. **König hardness** (König pendulum hardness, measured according to DIN EN ISO 1522) was determined

25 on this film after 1 day ("König hardness (1d SCC)"), after 2 days ("König hardness (2d SCC)"), after 4 days ("König hardness (4d SCC)"), after 7 days ("König hardness (7d SCC)") and after 14 days ("König hardness (14d SCC)").

After 14 days, the appearance of the film was assessed (designated

30 "**Appearance (SCC)**" in the table). A film was described as "nice" if it had a glossy and nontacky surface with no structure. "Structure" refers to any kind of marking or pattern on the surface. A film with a nontacky surface without structure and with reduced gloss was described as "matt".

A second film coating was applied to a glass plate in a layer thickness of 500 μm and immediately after application this was stored/cured for 7 days at 8°C and 80% relative humidity and then for 2 weeks under standard climatic conditions.

24 hours after application, a polypropylene bottle top beneath which a damp
 5 sponge had been positioned was placed onto the film. After a further 24 hours, the sponge and the bottle top were removed and positioned at a new point on the film, from which it was in turn removed and repositioned after 24 hours, and this was done a total of 4 times. The appearance of this film was then assessed (designated "**Appearance (8°/80%)**") in the same way as described
 10 for Appearance (SCC). Also reported in each case here was the number and kind of visible marks that had formed in the film as a result of the damp sponge or the bottle top on top. The number of white-colored spots was reported as "blushing". The intensity of any ring-shaped impression formed by sinking of the first bottle top applied 24 h after application was reported as "ring". Such a ring-shaped
 15 impression indicates that the coating was not ready to be walked upon. The König hardness was again determined on the films thus cured, in each case after 7 days at 8°C and 80% relative humidity ("König hardness (7d 8°/80%)") and then after a further 2 days under SCC ("König hardness (+2d SCC)"), 7 days under SCC ("König hardness (+7d SCC)"), and 14 d under SCC ("König hardness (+14d
 20 SCC)").

Also determined as a measure of yellowing was the change in color after stressing in a weathering tester. For this, a further film was applied to a glass plate in a layer thickness of 500 μm and this was stored/cured under standard climatic conditions for 2 weeks and then stressed for 72 hours (**Q-Sun (72h)**) at a
 25 temperature of 65°C in a model Q-Sun Xenon Xe-1 weathering tester having a Q-SUN Daylight-Q optical filter and a xenon lamp having a light intensity of 0.51 W/m² at 340 nm. The color difference ΔE of the stressed film versus the corresponding unstressed film was then determined using an NH310 colorimeter from Shenzhen 3NH Technology Co. LTD equipped with silicon photoelectric diode
 30 detector, light source A, color space measurement interface CIE L*a*b*C*H*. ΔE values up to 5 represent slight yellowing.

The results are reported in tables 1 to 3.

The examples labeled "(Ref.)" are comparative examples.

Example	1 (Ref.)	2	3 (Ref.)	4 (Ref.)	5	6 (Ref.)
Resin comp.: Sikafloor®-264N (A)	450.0	450.0	450.0	450.0	450.0	450.0
Curing agent comp.:						
B-EDA	50.1	50.1	50.1	50.1	50.1	50.1
Ca nitrate solution	-	2.0	-	-	2.0	-
Salicylic acid ¹	-	-	2.0	-	-	2.0
Ancamine® K54	-	-	-	2.0	2.0	2.0
Viscosity (10') [Pa·s]	2.2	2.6	2.6	2.2	2.4	2.5
Shore D (1d SCC)	74	78	77	80	78	78
(2d SCC)	77	80	80	80	80	80
Shore D (1d 8°/80%)	29	61	51	45	62	53
(2d 8°/80%)	68	75	74	72	64	74
König h. [s] (1d SCC)	63	78	67	97	104	95
[s] (2d SCC)	88	104	104	118	140	132
(4d SCC)	99	120	115	130	147	139
(7d SCC)	115	121	131	126	151	157
(14d SCC)	118	126	140	137	156	162
Appearance (SCC)	nice	nice	nice	nice	nice	nice
Q-SUN (72 h) ΔE	2.9	2.7	5.4	3.8	4.7	6.4
König h. [s] (7d 8°/80%)	17	21	20	25	24	27
[s] (+2d SCC)	35	38	42	55	57	56
(+7d SCC)	52	53	59	70	76	76
(+14d SCC)	67	67	78	89	93	95
Appearance (8°/80%)	nice	nice	matt	matt	nice	matt
Blushing	3	3	3	3	3	3
Ring	average	none	strong	slight	none	slight

Table 1: Composition and properties of examples 1 to 6.

¹ dissolved in B-EDA

Example	7 (Ref.)	8	9	10 (Ref.)	11	12 (Ref.)
Resin comp.: Sikafloor®-264N (A)	450.0	450.0	450.0	450.0	450.0	450.0
Curing agent comp.:						
B-EDA	50.1	50.1	50.1	50.1	42.6	42.6
TETA	-	-	-	-	4.2	4.2
Benzyl alcohol	10.0	10.0	10.0	10.0	10.0	10.0
Ca nitrate solution	-	2.0	2.0	-	2.0	-
Ancamine® K54	-	-	2.0	2.0	2.0	2.0
Viscosity (10') [Pa·s]	1.4	1.9	1.5	1.4	1.7	1.4
Shore D (1d SCC)	48	52	53	64	60	70
(2d SCC)	64	64	72	73	74	76
Shore D (1d 8°/80%)	8	33	23	13	43	32
(2d 8°/80%)	57	69	64	70	73	72
König h. [s] (1d SCC)	17	34	48	41	63	62
[s] (2d SCC)	46	56	78	81	91	90
(4d SCC)	45	73	98	192	105	105
(7d SCC)	73	85	104	109	122	113
(14d SCC)	92	104	113	113	136	125
Appearance (SCC)	nice	nice	nice	nice	nice	nice
Q-SUN (72 h) ΔE	2.7	4.0	4.7	3.4	4.2	2.1
König h. [s] (7d 8°/80%)	7	10	13	10	17	15
[s] (+2d SCC)	14	20	21	18	39	42
(+7d SCC)	14	24	39	35	65	67
(+14d SCC)	35	43	60	60	87	85
Appearance (8°/80%)	nice	nice	nice	nice	nice	nice
Blushing	1	0	1	1	1	1
Ring	average	none	none	slight	none	none

Table 2: Composition and properties of examples 7 to 12.

Example	13	14 (Ref.)	15	16	17 (Ref.)
Resin comp.: Sikafloor®-264N (A)	450.0	450.0	450.0	450.0	450.0
Curing agent comp.:					
B-EDA	32.6	-	-	-	-
B-PDA	-	54.8	54.8	54.8	54.8
Adduct-1	13.5	-	-	-	-
Jeffamine® D-230	12.0	-	-	-	-
Ca nitrate solution	2.0	-	2.0	2.0	-
Ancamine® K54	2.0	-	-	2.0	2.0
Viscosity (10') [Pa·s]	2.9	1.9	1.9	1.7	1.3
Shore D (1d SCC)	71	53	73	70	64
(2d SCC)	76	74	79	77	76
Shore D (1d 8°/80%)	5	n.m.	n.m.	n.m.	n.m.
(2d 8°/80%)	58	29	60	62	48
König h. [s] (1d SCC)	68	85	94	104	108
[s] (2d SCC)	113	144	154	184	175
(4d SCC)	154	164	175	189	189
(7d SCC)	168	188	202	204	200
(14d SCC)	193	193	204	208	204
Appearance (SCC)	nice	nice	nice	nice	nice
Q-SUN (72 h) ΔE	5.9	1.9	3.5	4.6	4.1
König h. [s] (7d 8°/80%)	23	53	62	69	67
[s] (+2d SCC)	67	134	147	148	146
(+7d SCC)	80	140	157	168	165
(+14d SCC)	84	140	158	169	165
Appearance (8°/80%)	nice	nice	nice	nice	matt
Blushing	1	1	1	1	2
Ring	slight	strong	slight	slight	strong

Table 3: Composition and properties of examples **13** to **17**.

“n.m.” means “not measurable” (too soft)

Claims:

1. A composition comprising calcium nitrate, at least one epoxy resin and N-benzylethane-1,2-diamine, wherein 0.5 to 2.5 parts by weight of calcium nitrate is present per 100 parts by weight of all amines having primary and/or secondary amino groups present.
2. The composition as claimed in claim 1, wherein calcium nitrate is in the form of an aqueous solution.
3. The composition as claimed in claim 1 or claim 2, wherein 0.1 to 1.2, preferably 0.2 to 1, especially 0.2 to 0.8, mol of amine hydrogens from amines of the N-benzylethane-1,2-diamine is present per mole of epoxy groups.
4. The composition as claimed in any one of claims 1 to 3, comprising at least one further constituent selected from further accelerators, reactive diluents, further amines, thinners and fillers.
5. The composition as claimed in any one of claims 1 to 4, further comprising 2,4,6-tris(dimethylaminomethyl)phenol.
6. The composition as claimed in any one of claims 1 to 5, comprising at least one further amine selected from the group consisting of 2,2(4),4-trimethylhexane-1,6-diamine, 1,2-, 1,3- or 1,4-diaminocyclohexane, 1,3-bis(aminomethyl)cyclohexane, 1,4-bis(aminomethyl)cyclohexane, bis(4-aminocyclohexyl)methane, 1-amino-3-aminomethyl-3,5,5-trimethylcyclohexane, 2(4)-methyl-1,3-diaminocyclohexane, 1,3-bis(aminomethyl)benzene, polyoxypropylenediamines having an average molecular weight M_n in the range from 200 to 500 g/mol, 3-(3-(dimethylamino)propylamino)propylamine, bis(6-aminoethyl)amine, diethylenetriamine, triethylenetetramine, tetraethylenepentamine, pentaethylenehexamine, dipropylenetriamine, N-(2-aminoethyl)propane-1,3-diamine, N,N'-bis(3-aminopropyl)ethylenediamine, adducts of these or further polyamines with mono- or diepoxides, and Mannich bases.

7. The composition as claimed in any one of claims 1 to 6, comprising at least one thinner selected from the group consisting of benzyl alcohol, styrenized phenol, ethoxylated phenol, aromatic hydrocarbon resins containing phenol groups, diisopropylnaphthalene and cardanol.
- 5
8. A method of coating, comprising the steps of
- (i) mixing the components of the composition as claimed in any one of claims 1 to 7,
- 10 (ii) applying the mixed composition to a substrate within the pot life, followed by the curing of the mixed composition.
9. A method of bonding, comprising the steps of
- (i) mixing the components of the composition as claimed in any one of claims 1 to 7,
- 15 (ii) applying the mixed composition within the pot life,
- either to at least one of the substrates to be bonded and joining the substrates to form a bond within the open time,
- or into a cavity or gap between two or more substrates and optionally
- 20 inserting an anchor into the cavity or gap within the open time, followed by the curing of the mixed composition.
10. An article obtained from the method as claimed in either of claims 8 and 9.