Additional effects and optimized performance in processing and use

Special molecules known as functional monomers provide a polymer with additional, enhanced performance effects and/or significantly improve processing performance when incorporated in the polymerization process.

SONGWON develops, manufactures and supplies different functional monomers based on three backbone chemistries: dicyclopentadiene (DCPD) phenol, bisphenol, and diacid anhydrides and diamines for high performance resins.

Our functional monomers are used as hardeners in epoxy and phenolic resins as well as in certain polymers, for example polycarbonate, polyester, polyimide and polybenzoxazine. These are suitable for a wide range of industries, end products ranging from tiny electronic components such as integrated circuit chips to large scale composites, for instance wind turbine rotor blades.
SONGWON offers a broad range of functional monomers

DCPD (dicyclopentadiene) type

These are mainly used as an epoxy resin modifier (ERM) in epoxy chain-extending reactions, primarily for the manufacture of epoxy resins and composites.

Bisphenol type

These are used in the manufacture of numerous plastics and epoxy resins. End uses for bisphenol-based plastic, which is clear and tough, include a variety of common consumer goods, such as water bottles, sports equipment, CDs and DVDs. Epoxy resins containing bisphenols are used to line water pipes and coatings, and in the manufacture of thermal paper.

Monomers for high performance polymers

SONGWON’s ongoing expansion of its product offering includes the development, upscaling and commercial sales of a variety of special monomers used in the manufacture of high performance polymers and resins. These are designed for markets focusing on clear resins with low thermal expansion coefficients (CTEs) and high thermal stability. A further key driver of product development is the growing demand for polybenzoxazine (PBO) and polyhydroxystyrene (PHS) resins.
SONGWON’s DCPD phenol adducts are distinguished by their high purity and excellent consistency. If they are to be used as hardeners, we can help customers meet still tighter specifications, depending on their requirements.

In addition to these four standard products, we are also able to provide customer specific monomers with tailor-made softening points (including below 80°C), solution viscosity and oligomer content.
<table>
<thead>
<tr>
<th>Bisphenol Type</th>
<th>Comment</th>
<th>Melting Range (°C)</th>
</tr>
</thead>
</table>
| **BP-Z** 4,4'-cyclohexylidene bisphenol  
CAS NO. 843-55-0  
White PW | Bisphenol Z, purity >99% | 190.0 |
| **BP-TMC** 1,1'-bis(4-hydroxyphenyl)-3,3,5-trimethylcyclohexane  
CAS NO. 129188-99-4  
White PW | High purity grade and epoxy grade | 208.0 |
| **TMBP** 2,2',6,6'-tetramethyl-4,4'-biphenol  
CAS NO. 2417-04-01  
Yellowish PW | Highest purity | 223.0 – 225.0 |
| **BBM** 4,4'-butylidenbis(6-tert-butyl-3-methylphenol)  
CAS NO. 85-60-9  
White PW | Scale up status | 208.0 – 214.0 |
| **BP-Benzoate** Propane-2,2-diyl di-p-phenylene dibenzoate  
CAS NO. 2297-14-5  
White PW | Bisphenol A dibenzoate, high purity | 164.0 |
| **4,4’-Bisphenol F(H)** Bis(4-hydroxyphenyl) methane  
CAS NO. 620-92-8  
White PW | Single isomer Bisphenol F | 160.0 |
| **TPE** 1,1,2,2-Tetrakis (4-hydroxyphenyl) ethane  
CAS NO. 7127-33-5  
White PW | high purity and general grade available | > 310 |

Our bisphenol product range is characterized by high chemical purity and low free phenol content. Since the products are manufactured on multifunctional production lines, we are able to offer high volumes at reasonable cost.

Some products are also available as general grade raw materials for epoxidation or phenolic resins.
SONGWON's high performance monomers fulfill the most stringent chemical purity demands, including in optically clear applications such as displays and optical film. In addition, metal content can if required be minimized using proprietary SONGWON technology.

<table>
<thead>
<tr>
<th>Monomer</th>
<th>Formula</th>
<th>Application</th>
<th>Comment</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>TCAA</strong></td>
<td>3-(Carboxymethyl)-1,2,4-cyclopentanetricarboxylic acid 1,4,2,3-dianhydride</td>
<td>Clear PI varnish and film, alignment layer</td>
<td>Commercial, available</td>
</tr>
<tr>
<td><strong>CBDA</strong></td>
<td>Cyclobutane 1,2,3,4, tetra-carboxylic acid dianhydride</td>
<td>Clear PI varnish and film, alignment layer, PSPI</td>
<td>Commercial, available</td>
</tr>
<tr>
<td><strong>BPDC</strong></td>
<td>Biphenyl 4,4' dicarboxylic chloride</td>
<td>Clear PI varnish and film, PBO, PA, copolymers</td>
<td>Commercial, available</td>
</tr>
<tr>
<td><strong>HBPDA</strong></td>
<td>Dicyclohexyl-3,4,3',4'-tetra-carboxylic dianhydride</td>
<td>Clear PI varnish and film, copolymers</td>
<td>Under scale-up</td>
</tr>
<tr>
<td><strong>BTDA</strong></td>
<td>1,2,3,4-Butanetetracarboxylic 1,2,3,4-dianhydride</td>
<td>Clear PI varnish and film, copolymers, alignment</td>
<td>Under scale-up</td>
</tr>
<tr>
<td><strong>TFMB</strong></td>
<td>2,2':Bis(trifluoromethyl)[1,1'-biphenyl]-4,4'-diamine</td>
<td>Mostly used diamine for clear PI film, varnish, alignment layer</td>
<td>Pilot production</td>
</tr>
<tr>
<td><strong>ASM</strong></td>
<td>Acetoxystyrene</td>
<td>High purity PHS and PHS copolymers for semicon and display</td>
<td>Pilot production</td>
</tr>
</tbody>
</table>
Standard Packaging

- **DCDP type:** 20 kg PE bag, 500 kg bigbag
- **Bisphenol type:** 20 kg PE bag, 500 kg bigbag
- **High performance monomers:** custom package available, 1kg, 2.5 kg, 5 kg sealed aluminium bag in 20 kg carton box

Key to Abbreviations of Physical Forms

- **PW:** Powder
- **SB:** Semi Bead
- **SL:** Solid
- **FF:** Free Flow
- **DW:** Dispersion
- **MB:** Micro Beads
- **FC:** Fusion Crystal
- **LQ:** Liquid or Molten
- **BD:** Beads
- **DF:** Dust Free Flow
- **CP:** Crystalline Powder
- **PS:** Pastilles
- **GR:** Granule
- **FG:** Fine Grind
- **VL:** Viscous Liquid

Transport and Storage

As a general guideline, we recommend storing the products mentioned in this brochure in their original sealed containers in a cold and dry place. For more detailed information on a specific product, please refer to the corresponding **Technical Data Sheet**.

By law, a number of chemical products must be labeled in respect of transport, storage and handling. Thus corresponding care is a prerequisite for their appropriate handling. Furthermore, local legal regulations may apply.

Detailed information is given in the respective **Safety Data Sheets**.
About SONGWON Industrial Group

SONGWON, which was founded in 1965 and is headquartered in Ulsan, South Korea, is a leader in the development, production and supply of specialty chemicals.

The second largest manufacturer of polymer stabilizers worldwide, SONGWON operates group companies all over the world, offering the combined benefits of a global framework and readily accessible local organizations.

Dedicated experts work closely together with customers to develop tailor-made solutions that meet individual requirements.

For further information, please go to: www.songwon.com
SONGWON provides customers with warranties and representations as to the chemical or technical specifications, compositions and/or the suitability for use for any particular purpose exclusively in individual written agreements.

The facts and figures contained herein have been carefully compiled to the best of SONGWON’s knowledge but are essentially intended for informational purposes only.

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