



SAFETY DATA SHEET

BLUE CUBE OPERATIONS LLC

Product name: D.E.N.™ 438-A85 Epoxy Novolac

Issue Date: 07/29/2016

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BLUE CUBE OPERATIONS LLC encourages and expects you to read and understand the entire (M)SDS, as there is important information throughout the document. We expect you to follow the precautions identified in this document unless your use conditions would necessitate other appropriate methods or actions.

1. IDENTIFICATION

Product name: D.E.N.™ 438-A85 Epoxy Novolac

Recommended use of the chemical and restrictions on use

Identified uses: Used in applications such as: Can coatings. Composites. Casting. Tooling. Marine and protective coatings. Adhesives. Potting and encapsulation. Coil coatings.

COMPANY IDENTIFICATION

BLUE CUBE OPERATIONS LLC
190 CARONDELET PLAZA, SUITE 1530
CLAYTON MO 63105-3467
UNITED STATES

Customer Information Number:

+1 844-238-3445
INFO@OLINBC.com

EMERGENCY TELEPHONE NUMBER

24-Hour Emergency Contact: 1 800 424 9300

Local Emergency Contact: 1 800-424-9300

2. HAZARDS IDENTIFICATION

Hazard classification

This material is hazardous under the criteria of the Federal OSHA Hazard Communication Standard 29CFR 1910.1200.

Flammable liquids - Category 2

Skin sensitisation - Category 1

Label elements

Hazard pictograms



Signal word: **DANGER!**

Hazards

Highly flammable liquid and vapour.
May cause an allergic skin reaction.

Precautionary statements**Prevention**

Keep away from heat/sparks/open flames/hot surfaces. No smoking.
Keep container tightly closed.
Ground/bond container and receiving equipment.
Use explosion-proof electrical/ ventilating/ lighting/ equipment.
Use only non-sparking tools.
Take precautionary measures against static discharge.
Avoid breathing dust/ fume/ gas/ mist/ vapours/ spray.
Contaminated work clothing should not be allowed out of the workplace.
Wear protective gloves/ eye protection/ face protection.

Response

IF ON SKIN (or hair): Take off immediately all contaminated clothing. Rinse skin with water/shower.
If skin irritation or rash occurs: Get medical advice/ attention.
Wash contaminated clothing before reuse.
In case of fire: Use dry sand, dry chemical or alcohol-resistant foam to extinguish.

Storage

Store in a well-ventilated place. Keep cool.

Disposal

Dispose of contents/ container to an approved waste disposal plant.

Other hazards

Static-accumulating flammable liquid.

3. COMPOSITION/INFORMATION ON INGREDIENTS

This product is a mixture.

Component	CASRN	Concentration
Reaction product of phenol-formaldehyde Novolac with epichlorohydrin	28064-14-4	85.0%
Acetone	67-64-1	15.0%

4. FIRST AID MEASURES

Description of first aid measures

General advice: First Aid responders should pay attention to self-protection and use the recommended protective clothing (chemical resistant gloves, splash protection). If potential for exposure exists refer to Section 8 for specific personal protective equipment.

Inhalation: Move person to fresh air. If not breathing, give artificial respiration; if by mouth to mouth use rescuer protection (pocket mask, etc). If breathing is difficult, oxygen should be administered by qualified personnel. Call a physician or transport to a medical facility.

Skin contact: Remove material from skin immediately by washing with soap and plenty of water. Remove contaminated clothing and shoes while washing. Seek medical attention if irritation persists. Wash clothing before reuse. Discard items which cannot be decontaminated, including leather articles such as shoes, belts and watchbands. Suitable emergency safety shower facility should be available in work area.

Eye contact: Flush eyes thoroughly with water for several minutes. Remove contact lenses after the initial 1-2 minutes and continue flushing for several additional minutes. If effects occur, consult a physician, preferably an ophthalmologist.

Ingestion: Do not induce vomiting. Call a physician and/or transport to emergency facility immediately.

Most important symptoms and effects, both acute and delayed: Aside from the information found under Description of first aid measures (above) and Indication of immediate medical attention and special treatment needed (below), any additional important symptoms and effects are described in Section 11: Toxicology Information.

Indication of any immediate medical attention and special treatment needed

Notes to physician: Maintain adequate ventilation and oxygenation of the patient. The decision of whether to induce vomiting or not should be made by a physician. If lavage is performed, suggest endotracheal and/or esophageal control. Danger from lung aspiration must be weighed against toxicity when considering emptying the stomach. No specific antidote. Treatment of exposure should be directed at the control of symptoms and the clinical condition of the patient. Skin contact may aggravate preexisting dermatitis.

5. FIREFIGHTING MEASURES

Suitable extinguishing media: Water fog or fine spray. Dry chemical fire extinguishers. Carbon dioxide fire extinguishers. Foam. Alcohol resistant foams (ATC type) are preferred. General purpose synthetic foams (including AFFF) or protein foams may function, but will be less effective. Water fog, applied gently may be used as a blanket for fire extinguishment.

Unsuitable extinguishing media: Do not use direct water stream. Straight or direct water streams may not be effective to extinguish fire.

Special hazards arising from the substance or mixture

Hazardous combustion products: During a fire, smoke may contain the original material in addition to combustion products of varying composition which may be toxic and/or irritating. Combustion products may include and are not limited to: Phenolic compounds. Carbon monoxide. Carbon dioxide.

Unusual Fire and Explosion Hazards: Violent steam generation or eruption may occur upon application of direct water stream to hot liquids. Electrically ground and bond all equipment. Flammable mixtures of this product are readily ignited even by static discharge. Vapors are heavier

than air and may travel a long distance and accumulate in low lying areas. Ignition and/or flash back may occur. Flammable mixtures may exist within the vapor space of containers at room temperature. Flammable concentrations of vapor can accumulate at temperatures above flash point; see Section 9. Dense smoke is emitted when burned without sufficient oxygen.

Advice for firefighters

Fire Fighting Procedures: Keep people away. Isolate fire and deny unnecessary entry. Stay upwind. Keep out of low areas where gases (fumes) can accumulate. Water may not be effective in extinguishing fire. Do not use direct water stream. May spread fire. Eliminate ignition sources. Move container from fire area if this is possible without hazard. Burning liquids may be moved by flushing with water to protect personnel and minimize property damage. Water fog, applied gently may be used as a blanket for fire extinguishment. Contain fire water run-off if possible. Fire water run-off, if not contained, may cause environmental damage. Review the "Accidental Release Measures" and the "Ecological Information" sections of this (M)SDS.

Special protective equipment for firefighters: Wear positive-pressure self-contained breathing apparatus (SCBA) and protective fire fighting clothing (includes fire fighting helmet, coat, trousers, boots, and gloves). Avoid contact with this material during fire fighting operations. If contact is likely, change to full chemical resistant fire fighting clothing with self-contained breathing apparatus. If this is not available, wear full chemical resistant clothing with self-contained breathing apparatus and fight fire from a remote location. For protective equipment in post-fire or non-fire clean-up situations, refer to the relevant sections.

6. ACCIDENTAL RELEASE MEASURES

Personal precautions, protective equipment and emergency procedures: Evacuate area. Only trained and properly protected personnel must be involved in clean-up operations. Keep upwind of spill. Keep personnel out of low areas. Ventilate area of leak or spill. Eliminate all sources of ignition in vicinity of spill or released vapor to avoid fire or explosion. Vapor explosion hazard. Keep out of sewers. For large spills, warn public of downwind explosion hazard. Check area with combustible gas detector before reentering area. Ground and bond all containers and handling equipment. Use appropriate safety equipment. For additional information, refer to Section 8, Exposure Controls and Personal Protection. Refer to section 7, Handling, for additional precautionary measures.

Environmental precautions: Prevent from entering into soil, ditches, sewers, waterways and/or groundwater. See Section 12, Ecological Information.

Methods and materials for containment and cleaning up: Contain spilled material if possible. Absorb with materials such as: Sand. Polypropylene fiber products. Polyethylene fiber products. Use non-sparking tools in cleanup operations. Ground and bond all containers and handling equipment. Collect in suitable and properly labeled containers. Pump with explosion-proof equipment. If available, use foam to smother or suppress. Remove residual with soap and hot water. Residual can be removed with solvent. Solvents are not recommended for clean-up unless the recommended exposure guidelines and safe handling practices for the specific solvent are followed. Consult appropriate solvent Safety Data Sheet for handling information and exposure guidelines. See Section 13, Disposal Considerations, for additional information.

7. HANDLING AND STORAGE

Precautions for safe handling: Keep away from heat, sparks and flame. No smoking, open flames or sources of ignition in handling and storage area. Vapors are heavier than air and may travel a long

distance and accumulate in low lying areas. Ignition and/or flash back may occur. Electrically bond and ground all containers and equipment before transfer or use of material. Never use air pressure for transferring product. Use of non-sparking or explosion-proof equipment may be necessary, depending upon the type of operation. Containers, even those that have been emptied, can contain vapors. Do not cut, drill, grind, weld, or perform similar operations on or near empty containers. Avoid contact with skin and eyes. Avoid prolonged or repeated contact with skin. Avoid breathing vapor. Do not swallow. Keep container closed. Use with adequate ventilation. Wash thoroughly after handling. Handling operations that can promote accumulation of static charges include but are not limited to mixing, filtering, pumping at high flow rates, splash filling, creating mists or sprays, tank and container filling, tank cleaning, sampling, gauging, switch loading, vacuum truck operations. See Section 8, EXPOSURE CONTROLS AND PERSONAL PROTECTION.

Conditions for safe storage: Flammable mixtures may exist within the vapor space of containers at room temperature. Minimize sources of ignition, such as static build-up, heat, spark or flame. Keep container closed.

Storage stability

Storage temperature: 2 - 43 °C (36 - 109 °F) **Shelf life: Use within** 24 Month

8. EXPOSURE CONTROLS/PERSONAL PROTECTION

Control parameters

Exposure limits are listed below, if they exist.

Component	Regulation	Type of listing	Value/Notation
Acetone	Dow IHG	TWA	200 ppm
	Dow IHG	STEL	350 ppm
	ACGIH	TWA	250 ppm
	ACGIH	TWA	BEI
	ACGIH	STEL	500 ppm
	ACGIH	STEL	BEI
	OSHA Z-1	TWA	2,400 mg/m ³ 1,000 ppm

Exposure controls

Engineering controls: Use local exhaust ventilation, or other engineering controls to maintain airborne levels below exposure limit requirements or guidelines. If there are no applicable exposure limit requirements or guidelines, general ventilation should be sufficient for most operations. Local exhaust ventilation may be necessary for some operations.

Individual protection measures

Eye/face protection: Use safety glasses (with side shields). If exposure causes eye discomfort, use a full-face respirator.

Skin protection

Hand protection: Use gloves chemically resistant to this material. Examples of preferred glove barrier materials include: Butyl rubber. Natural rubber ("latex"). Neoprene. Polyethylene. Ethyl vinyl alcohol laminate ("EVAL"). Examples of acceptable glove barrier materials include: Chlorinated polyethylene. Nitrile/butadiene rubber ("nitrile" or "NBR"). Polyvinyl alcohol ("PVA"). Polyvinyl chloride ("PVC" or "vinyl"). NOTICE: The selection of a specific glove for a particular application and duration of use in a workplace should also take into account all relevant workplace factors such as, but not limited to: Other chemicals which may be handled, physical requirements (cut/puncture protection, dexterity, thermal protection),

potential body reactions to glove materials, as well as the instructions/specifications provided by the glove supplier.

Other protection: Use protective clothing chemically resistant to this material. Selection of specific items such as face shield, boots, apron, or full body suit will depend on the task.

Respiratory protection: Respiratory protection should be worn when there is a potential to exceed the exposure limit requirements or guidelines. If there are no applicable exposure limit requirements or guidelines, wear respiratory protection when adverse effects, such as respiratory irritation or discomfort have been experienced, or where indicated by your risk assessment process. For emergency conditions, use an approved positive-pressure self-contained breathing apparatus.

The following should be effective types of air-purifying respirators: Organic vapor cartridge.

9. PHYSICAL AND CHEMICAL PROPERTIES

Appearance	
Physical state	Liquid.
Color	Yellow
Odor	Acetone.
Odor Threshold	No test data available
pH	No test data available
Melting point/range	Not applicable
Freezing point	No test data available
Boiling point (760 mmHg)	56 °C (133 °F) <i>Literature</i> Acetone
Flash point	closed cup -20 °C (-4 °F) <i>Tag Closed Cup ASTM D56</i> Acetone
Evaporation Rate (Butyl Acetate = 1)	No test data available
Flammability (solid, gas)	Not Applicable
Lower explosion limit	2.5 % vol <i>Literature</i> Acetone
Upper explosion limit	13.0 % vol <i>Literature</i> Acetone
Vapor Pressure	181.7 mmHg at 20 °C (68 °F) <i>Literature</i> Acetone
Relative Vapor Density (air = 1)	2.0 <i>Literature</i> Acetone
Relative Density (water = 1)	1.14 <i>Literature</i>
Water solubility	<= 1 % at 25 °C (77 °F) <i>Literature</i>
Partition coefficient: n-octanol/water	No data available
Auto-ignition temperature	No test data available
Decomposition temperature	No test data available
Dynamic Viscosity	500 - 1,200 mPa.s at 25 °C (77 °F) <i>ASTM D 445</i>
Kinematic Viscosity	No test data available
Explosive properties	No data available
Oxidizing properties	No data available
Molecular weight	No data available
Saturated vapour concentration	No test data available

NOTE: The physical data presented above are typical values and should not be construed as a specification.

10. STABILITY AND REACTIVITY

Reactivity: No data available

Chemical stability: Stable under recommended storage conditions. See Storage, Section 7.

Possibility of hazardous reactions: Will not occur by itself. Masses of more than one pound (0.5 kg) of product plus an aliphatic amine will cause irreversible polymerization with considerable heat build-up.

Conditions to avoid: Exposure to elevated temperatures can cause product to decompose. Avoid static discharge.

Incompatible materials: Avoid contact with oxidizing materials. Avoid contact with: Acids. Bases. Avoid unintended contact with amines.

Hazardous decomposition products: Decomposition products depend upon temperature, air supply and the presence of other materials. Uncontrolled exothermic reaction of epoxy resins release phenolics, carbon monoxide, and water.

11. TOXICOLOGICAL INFORMATION

Toxicological information appears in this section when such data is available.

Acute toxicity

Acute oral toxicity

Low toxicity if swallowed. Small amounts swallowed incidentally as a result of normal handling operations are not likely to cause injury; however, swallowing larger amounts may cause injury.

LD50, Rat, > 4,000 mg/kg No deaths occurred at this concentration.

Acute dermal toxicity

Prolonged skin contact is unlikely to result in absorption of harmful amounts.

As product: The dermal LD50 has not been determined.

LD50, Rabbit, > 2,000 mg/kg Estimated. No deaths occurred at this concentration.

Acute inhalation toxicity

Excessive exposure to solvent(s) may cause respiratory irritation and central nervous system depression. Symptoms may include headache, dizziness and drowsiness, progressing to incoordination and unconsciousness.

As product: The LC50 has not been determined.

Skin corrosion/irritation

Prolonged contact may cause skin irritation with local redness.

Serious eye damage/eye irritation

May cause slight eye irritation.

Corneal injury is unlikely.

Vapor may cause eye irritation experienced as mild discomfort and redness.

Sensitization

Has caused allergic skin reactions when tested in guinea pigs.

For respiratory sensitization:

No relevant information found.

Specific Target Organ Systemic Toxicity (Single Exposure)

Contains component(s) which are classified as specific target organ toxicant, single exposure, category 3.

Specific Target Organ Systemic Toxicity (Repeated Exposure)

Contains component(s) which have been reported to cause effects on the following organs in animals:

Blood.

Kidney.

Liver.

Symptoms of excessive exposure may be anesthetic or narcotic effects; dizziness and drowsiness may be observed.

Development of cataracts has been reported in laboratory animals after prolonged repeated skin exposure to acetone.

Carcinogenicity

No relevant data found.

Teratogenicity

Contains component(s) which, in laboratory animals, have been toxic to the fetus only at doses toxic to the mother.

Reproductive toxicity

No relevant data found.

Mutagenicity

Genetic toxicity studies in animals were negative for component(s) tested.

Aspiration Hazard

No aspiration toxicity classification

COMPONENTS INFLUENCING TOXICOLOGY:

Reaction product of phenol-formaldehyde Novolac with epichlorohydrin

Acute inhalation toxicity

At room temperature, exposure to vapor is minimal due to low volatility; vapor from heated material may cause respiratory irritation.

The LC50 has not been determined.

Acetone**Acute inhalation toxicity**

LC50, Rat, 4 Hour, vapour, 76 mg/l

12. ECOLOGICAL INFORMATION

*Ecotoxicological information appears in this section when such data is available.***Toxicity****Reaction product of phenol-formaldehyde Novolac with epichlorohydrin****Acute toxicity to fish**

Material is moderately toxic to aquatic organisms on an acute basis (LC50/EC50 between 1 and 10 mg/L in the most sensitive species tested).

LC50, Leuciscus idus (Golden orfe), 96 Hour, 5.7 mg/l, OECD Test Guideline 203 or Equivalent

Acute toxicity to aquatic invertebrates

EC50, Daphnia magna (Water flea), 48 Hour, 3.5 mg/l, OECD Test Guideline 202 or Equivalent

Acetone**Acute toxicity to fish**

Material is practically non-toxic to aquatic organisms on an acute basis (LC50/EC50/EL50/LL50 >100 mg/L in the most sensitive species tested).

LC50, Oncorhynchus mykiss (rainbow trout), 96 Hour, 5,500 - 6,100 mg/l

Acute toxicity to aquatic invertebrates

EC50, Daphnia magna (Water flea), 48 Hour, 6,084 mg/l, Method Not Specified.

LC50, Ceriodaphnia dubia (water flea), 48 Hour, 8,098 mg/l

Acute toxicity to algae/aquatic plants

EC50, Skeletonema costatum (marine diatom), 5 d, Biomass, 11,800 - 14,400 mg/l

Toxicity to bacteria

IC50, activated sludge, 3 Hour, > 1,000 mg/l, OECD 209 Test

Toxicity to Above Ground OrganismsMaterial is practically non-toxic to birds on a dietary basis (LC50 > 5000 ppm).
dietary LC50, Coturnix japonica (Japanese quail), > 20,000 ppm**Persistence and degradability****Reaction product of phenol-formaldehyde Novolac with epichlorohydrin****Biodegradability:** Based on stringent OECD test guidelines, this material cannot be considered as readily biodegradable; however, these results do not necessarily mean that the material is not biodegradable under environmental conditions.

10-day Window: Fail

Biodegradation: 10 - 16 %**Exposure time:** 28 d**Method:** OECD Test Guideline 301B or Equivalent

Acetone

Biodegradability: Material is readily biodegradable. Passes OECD test(s) for ready biodegradability.

10-day Window: Pass

Biodegradation: 91 %

Exposure time: 28 d

Method: OECD Test Guideline 301B or Equivalent

Theoretical Oxygen Demand: 2.20 mg/mg Estimated.

Biological oxygen demand (BOD)

Incubation Time	BOD
5 d	69.1 %
10 d	72.7 %
20 d	73.6 %

Photodegradation

Test Type: Half-life (indirect photolysis)

Sensitizer: OH radicals

Atmospheric half-life: 52 d

Method: Estimated.

Bioaccumulative potential

Bioaccumulation: No data available

Mobility in soil**Reaction product of phenol-formaldehyde Novolac with epichlorohydrin**

No data available.

Acetone

Potential for mobility in soil is very high (Koc between 0 and 50).

Partition coefficient (Koc): 0.37 - 2.0 Estimated.

13. DISPOSAL CONSIDERATIONS

Disposal methods: AS YOUR SUPPLIER, WE HAVE NO CONTROL OVER THE MANAGEMENT PRACTICES OR MANUFACTURING PROCESSES OF PARTIES HANDLING OR USING THIS MATERIAL. THE INFORMATION PRESENTED HERE PERTAINS ONLY TO THE PRODUCT AS SHIPPED IN ITS INTENDED CONDITION AS DESCRIBED IN MSDS SECTION: Composition Information. All disposal practices must be in compliance with all Federal, State/Provincial and local laws and regulations. Regulations may vary in different locations. Waste characterizations and compliance with applicable laws are the responsibility solely of the waste generator. DO NOT DUMP INTO ANY SEWERS, ON THE GROUND, OR INTO ANY BODY OF WATER. FOR UNUSED & UNCONTAMINATED PRODUCT, the preferred options include sending to a licensed, permitted: Incinerator or other thermal destruction device.

14. TRANSPORT INFORMATION

DOT

Proper shipping name	Resin solution
UN number	UN 1866
Class	3
Packing group	II
Reportable Quantity	Acetone

Classification for SEA transport (IMO-IMDG):

Proper shipping name	RESIN SOLUTION
UN number	UN 1866
Class	3
Packing group	II
Marine pollutant	Epoxy resin
Transport in bulk according to Annex I or II of MARPOL 73/78 and the IBC or IGC Code	Consult IMO regulations before transporting ocean bulk

Classification for AIR transport (IATA/ICAO):

Proper shipping name	Resin solution
UN number	UN 1866
Class	3
Packing group	II

This information is not intended to convey all specific regulatory or operational requirements/information relating to this product. Transportation classifications may vary by container volume and may be influenced by regional or country variations in regulations. Additional transportation system information can be obtained through an authorized sales or customer service representative. It is the responsibility of the transporting organization to follow all applicable laws, regulations and rules relating to the transportation of the material.

15. REGULATORY INFORMATION

OSHA Hazard Communication Standard

This product is a "Hazardous Chemical" as defined by the OSHA Hazard Communication Standard, 29 CFR 1910.1200.

Superfund Amendments and Reauthorization Act of 1986 Title III (Emergency Planning and Community Right-to-Know Act of 1986) Sections 311 and 312

Fire Hazard
Acute Health Hazard
Chronic Health Hazard

Superfund Amendments and Reauthorization Act of 1986 Title III (Emergency Planning and Community Right-to-Know Act of 1986) Section 313

This material does not contain any chemical components with known CAS numbers that exceed the threshold (De Minimis) reporting levels established by SARA Title III, Section 313.

Pennsylvania Worker and Community Right-To-Know Act:

To the best of our knowledge, this product does not contain chemicals at levels which require reporting under this statute.

California Proposition 65 (Safe Drinking Water and Toxic Enforcement Act of 1986)

This product contains no listed substances known to the State of California to cause cancer, birth defects or other reproductive harm, at levels which would require a warning under the statute.

United States TSCA Inventory (TSCA)

All components of this product are in compliance with the inventory listing requirements of the U.S. Toxic Substances Control Act (TSCA) Chemical Substance Inventory.

16. OTHER INFORMATION

Hazard Rating System**NFPA**

Health	Fire	Reactivity
1	3	0

Revision

Identification Number: 101201624 / A476 / Issue Date: 07/29/2016 / Version: 6.0

Most recent revision(s) are noted by the bold, double bars in left-hand margin throughout this document.

Legend

ACGIH	USA. ACGIH Threshold Limit Values (TLV)
BEI	Biological Exposure Indices
Dow IHG	Dow Industrial Hygiene Guideline
OSHA Z-1	USA. Occupational Exposure Limits (OSHA) - Table Z-1 Limits for Air Contaminants
STEL	Short-term exposure limit
TWA	8-hour time weighted average

Information Source and References

This SDS is prepared by Product Regulatory Services and Hazard Communications Groups from information supplied by internal references within our company.

BLUE CUBE OPERATIONS LLC urges each customer or recipient of this (M)SDS to study it carefully and consult appropriate expertise, as necessary or appropriate, to become aware of and understand the data contained in this (M)SDS and any hazards associated with the product. The information herein is provided in good faith and believed to be accurate as of the effective date shown above. However, no warranty, express or implied, is given. Regulatory requirements are subject to change and may differ between various locations. It is the buyer's/user's responsibility to ensure that his

activities comply with all federal, state, provincial or local laws. The information presented here pertains only to the product as shipped. Since conditions for use of the product are not under the control of the manufacturer, it is the buyer's/user's duty to determine the conditions necessary for the safe use of this product. Due to the proliferation of sources for information such as manufacturer-specific (M)SDSs, we are not and cannot be responsible for (M)SDSs obtained from any source other than ourselves. If you have obtained an (M)SDS from another source or if you are not sure that the (M)SDS you have is current, please contact us for the most current version.