



SAFETY DATA SHEET

BLUE CUBE OPERATIONS LLC

Product name: D.E.H.™ 2720 Epoxy Hardener

Issue Date: 05/12/2015

Print Date: 06/01/2015

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.H.™ 2720 Epoxy Hardener

Recommended use of the chemical and restrictions on use

Identified uses: Hardener for epoxy resin.

COMPANY IDENTIFICATION

BLUE CUBE OPERATIONS LLC
2030 DOW CENTER
MIDLAND MI 48674-0000
UNITED STATES

Customer Information Number:

800-258-2436

SDSQuestion@dow.com

EMERGENCY TELEPHONE NUMBER

24-Hour Emergency Contact: 1 800 424 9300

Local Emergency Contact: 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.

Acute toxicity - Category 4 - Dermal

Skin corrosion - Category 1B

Serious eye damage - Category 1

Skin sensitisation - Category 1

Label elements

Hazard pictograms



Signal word: **DANGER!**

Hazards

Harmful in contact with skin.
Causes severe skin burns and eye damage.
May cause an allergic skin reaction.
Causes serious eye damage.

Precautionary statements

Prevention

Avoid breathing dust/ fume/ gas/ mist/ vapours/ spray.
Wash skin thoroughly after handling.
Contaminated work clothing should not be allowed out of the workplace.
Wear protective gloves/ protective clothing/ eye protection/ face protection.

Response

IF SWALLOWED: Rinse mouth. Do NOT induce vomiting.
IF ON SKIN (or hair): Take off immediately all contaminated clothing. Rinse skin with water/shower.
IF INHALED: Remove person to fresh air and keep comfortable for breathing. Immediately call a POISON CENTER or doctor/ physician.
IF IN EYES: Rinse cautiously with water for several minutes. Remove contact lenses, if present and easy to do. Continue rinsing. Immediately call a POISON CENTER or doctor/ physician.
If skin irritation or rash occurs: Get medical advice/ attention.
Wash contaminated clothing before reuse.

Storage

Store locked up.

Disposal

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

Other hazards

no data available

3. COMPOSITION/INFORMATION ON INGREDIENTS

Chemical nature: organic components mixture

This product is a mixture.

Component	CASRN	Concentration
Aminoethylpiperazine	140-31-8	>= 20.0 - <= 40.0 %
Styrenated phenol	61788-44-1	>= 50.0 - <= 75.0 %
Naphthalene, bis(1-methylethyl)-	38640-62-9	>= 5.0 - <= 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: Immediately flush skin with plenty of water for at least 15 minutes while removing contaminated clothing. Seek medical attention if symptoms occur or 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 immediately available.

Eye contact: Wash immediately and continuously with flowing water for at least 30 minutes. Remove contact lenses after the first 5 minutes and continue washing. Obtain prompt medical consultation, preferably from an ophthalmologist. Suitable emergency eye wash facility should be immediately available.

Ingestion: Do not induce vomiting. Give one cup (8 ounces or 240 ml) of water or milk if available and transport to a medical facility. Do not give anything by mouth unless the person is fully conscious.

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. Respiratory symptoms, including pulmonary edema, may be delayed. Persons receiving significant exposure should be observed 24-48 hours for signs of respiratory distress. Chemical eye burns may require extended irrigation. Obtain prompt consultation, preferably from an ophthalmologist. If burn is present, treat as any thermal burn, after decontamination. Due to irritant properties, swallowing may result in burns/ulceration of mouth, stomach and lower gastrointestinal tract with subsequent stricture. Aspiration of vomitus may cause lung injury. Suggest endotracheal/esophageal control if lavage is done. No specific antidote. Treatment of exposure should be directed at the control of symptoms and the clinical condition of the patient.

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.

Unsuitable extinguishing media: Do not use direct water stream. May spread 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: Nitrogen oxides. Carbon monoxide. Carbon dioxide.

Unusual Fire and Explosion Hazards: Container may rupture from gas generation in a fire situation. Violent steam generation or eruption may occur upon application of direct water stream to hot liquids.

Advice for firefighters

Fire Fighting Procedures: Keep people away. Isolate fire and deny unnecessary entry. Use water spray to cool fire exposed containers and fire affected zone until fire is out and danger of reignition has passed. Fight fire from protected location or safe distance. Consider the use of unmanned hose holders or monitor nozzles. Immediately withdraw all personnel from the area in case of rising sound from venting safety device or discoloration of the container. Burning liquids may be extinguished by dilution with water. Do not use direct water stream. May spread fire. 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. 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. Ventilate area of leak or spill. Refer to section 7, Handling, for additional precautionary measures. Use appropriate safety equipment. For additional information, refer to Section 8, Exposure Controls and Personal Protection.

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. Collect in suitable and properly labeled containers. See Section 13, Disposal Considerations, for additional information.

7. HANDLING AND STORAGE

Precautions for safe handling: Do not get in eyes, on skin, on clothing. Avoid breathing vapor or mist. Do not swallow. Avoid prolonged contact with eyes, skin and clothing. Keep container closed. Use with adequate ventilation. Wash thoroughly after handling. Spills of these organic materials on hot fibrous insulations may lead to lowering of the autoignition temperatures possibly resulting in spontaneous combustion. See Section 8, EXPOSURE CONTROLS AND PERSONAL PROTECTION.

Conditions for safe storage: Store in a cool, dry place.

Storage stability

Storage temperature:	Shelf life: Use within
5 - 30 °C (41 - 86 °F)	24 Month

8. EXPOSURE CONTROLS/PERSONAL PROTECTION

Control parameters

Exposure limits are listed below, if they exist.

None established

Exposure controls

Engineering controls: Use engineering controls to maintain airborne level below exposure limit requirements or guidelines. If there are no applicable exposure limit requirements or guidelines, use only with adequate ventilation. Local exhaust ventilation may be necessary for some operations.

Individual protection measures

Eye/face protection: Use chemical goggles.

Skin protection

Hand protection: Use gloves chemically resistant to this material. Examples of preferred glove barrier materials include: Butyl rubber. Chlorinated polyethylene. Neoprene. Polyethylene. Ethyl vinyl alcohol laminate ("EVAL"). Polyvinyl chloride ("PVC" or "vinyl"). Styrene/butadiene rubber. Examples of acceptable glove barrier materials include: Natural rubber ("latex"). Nitrile/butadiene rubber ("nitrile" or "NBR"). Polyvinyl alcohol ("PVA"). Viton. 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, use an approved respirator. When respiratory protection is required, use an approved positive-pressure self-contained breathing apparatus or positive-pressure airline with auxiliary self-contained air supply. For emergency conditions, use an approved positive-pressure self-contained breathing apparatus. In confined or poorly ventilated areas, use an approved self-contained breathing apparatus or positive pressure air line with auxiliary self-contained air supply.

9. PHYSICAL AND CHEMICAL PROPERTIES

Appearance

Physical state	Liquid.
Color	Colorless
Odor	Amine.

Odor Threshold	No test data available
pH	8 - 11 <i>Literature</i>
Melting point/range	Not applicable
Freezing point	No test data available
Boiling point (760 mmHg)	> 200 °C (> 392 °F) <i>Literature</i>
Flash point	closed cup 140 °C (284 °F) <i>Calculated.</i>
Evaporation Rate (Butyl Acetate = 1)	No test data available
Flammability (solid, gas)	Not applicable to liquids
Lower explosion limit	No test data available
Upper explosion limit	No test data available
Vapor Pressure	< 5 hPa at 20 °C (68 °F) <i>Literature</i>
Relative Vapor Density (air = 1)	No test data available
Relative Density (water = 1)	0.97 at 20 °C (68 °F) <i>Calculated.</i>
Water solubility	Soluble
Partition coefficient: n-octanol/water	no data available
Auto-ignition temperature	No test data available
Decomposition temperature	No test data available
Dynamic Viscosity	5,500 mPa.s at 20 °C (68 °F) <i>Calculated.</i>
Kinematic Viscosity	No test data available
Explosive properties	no data available
Oxidizing properties	no data available
Molecular weight	no 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: Polymerization will not occur.

Conditions to avoid: Exposure to elevated temperatures can cause product to decompose. Generation of gas during decomposition can cause pressure in closed systems. Reaction with carbon dioxide may form an amine carbamate. Smoke may be generated depending on vapor pressure of mixture. Product absorbs carbon dioxide from the air.

Incompatible materials: Avoid contact with oxidizing materials. Avoid contact with: Acids. Acrylates. Alcohols. Aldehydes. Halogenated hydrocarbons. Ketones. Nitrites. Avoid contact with metals such as: Brass. Bronze. Copper. Copper alloys.

Hazardous decomposition products: Decomposition products depend upon temperature, air supply and the presence of other materials. Decomposition products can include and are not limited to: Aromatic compounds. Ammonia. Ethylenediamine. Volatile amines. Hydrocarbons. Phenolics.

11. TOXICOLOGICAL INFORMATION

Toxicological information appears in this section when such data is available

Acute toxicity

Acute oral toxicity

Low toxicity if swallowed. Swallowing may result in gastrointestinal irritation or ulceration. Swallowing may result in burns of the mouth and throat.

As product: Single dose oral LD50 has not been determined.
LD50, Rat, > 2,000 mg/kg Estimated.

Acute dermal toxicity

Prolonged or widespread skin contact may result in absorption of potentially harmful amounts.

As product: The dermal LD50 has not been determined.
LD50, Rabbit, > 1,500 mg/kg Estimated.

Acute inhalation toxicity

At room temperature, exposure to vapor is minimal due to low volatility; vapor from heated material may cause respiratory irritation. Vapor from heated material or mist may cause serious adverse effects, even death. Mist may cause irritation of upper respiratory tract (nose and throat).

As product: The LC50 has not been determined.

Skin corrosion/irritation

Brief contact may cause skin burns. Symptoms may include pain, severe local redness and tissue damage.

Serious eye damage/eye irritation

May cause severe irritation with corneal injury which may result in permanent impairment of vision, even blindness. Chemical burns may occur.

Sensitization

Skin contact may cause an allergic skin reaction.

Individuals having an allergic skin reaction to this product may have an allergic skin reaction to similar material(s).

The similar material(s) is/are:

Triethylenetetramine (TETA).

Piperazine.

Contains component(s) which have demonstrated the potential for contact allergy in mice.

For respiratory sensitization:

Relevant data not available.

Specific Target Organ Systemic Toxicity (Single Exposure)

Evaluation of available data suggests that this material is not an STOT-SE toxicant.

Specific Target Organ Systemic Toxicity (Repeated Exposure)

Based on information for component(s):

In animals, effects have been reported on the following organs:

Nervous system.

Gastrointestinal tract.

Respiratory tract.

Carcinogenicity

Contains component(s) which did not cause cancer in laboratory animals.

Teratogenicity

Contains component(s) which did not cause birth defects in laboratory animals.

Reproductive toxicity

Relevant data not available.

Mutagenicity

Contains a component(s) which were negative in in vitro genetic toxicity studies. Contains component(s) which were negative in animal genetic toxicity studies.

Aspiration Hazard

No aspiration toxicity classification Based on physical properties, not likely to be an aspiration hazard.

COMPONENTS INFLUENCING TOXICOLOGY:

Aminoethylpiperazine

Acute inhalation toxicity

The LC50 has not been determined. 8 Hour, vapour, No deaths occurred following exposure to a saturated atmosphere.

Styrenated phenol

Acute inhalation toxicity

Mist may cause irritation of upper respiratory tract (nose and throat).

Naphthalene, bis(1-methylethyl)-

Acute inhalation toxicity

LC50, Rat, 4 Hour, dust/mist, > 5.64 mg/l

12. ECOLOGICAL INFORMATION

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

Toxicity

Aminoethylpiperazine

Acute toxicity to fish

Material is slightly toxic to aquatic organisms on an acute basis (LC50/EC50 between 10 and 100 mg/L in the most sensitive species tested).

LC50, Pimephales promelas (fathead minnow), static test, 96 Hour, 2,190 mg/l, OECD Test Guideline 203 or Equivalent

Acute toxicity to aquatic invertebrates

EC50, Daphnia magna (Water flea), static test, 48 Hour, 58 mg/l, OECD Test Guideline 202 or Equivalent

Acute toxicity to algae/aquatic plants

ErC50, Pseudokirchneriella subcapitata (green algae), 72 Hour, Growth rate inhibition, > 1,000 mg/l, OECD Test Guideline 201 or Equivalent

Styrenated phenol

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).

LL50, Brachydanio rerio (zebrafish), semi-static test, 96 Hour, 14.8 mg/l, OECD Test Guideline 203

Acute toxicity to aquatic invertebrates

EL50, Daphnia magna, Static, 48 Hour, > 1 - 10 mg/l, OECD Test Guideline 202

Acute toxicity to algae/aquatic plants

EL50, Desmodesmus subspicatus (green algae), Static, 72 Hour, 3.14 mg/l, OECD Test Guideline 201

Chronic toxicity to fish

NOEC, Oryzias latipes (Orange-red killifish), flow-through, 14 d, 1.9 mg/l

Chronic toxicity to aquatic invertebrates

NOEC, Daphnia magna, 21 d, 0.2 mg/l

Naphthalene, bis(1-methylethyl)-

Acute toxicity to fish

Material is highly toxic to aquatic organisms on an acute basis (LC50/EC50 between 0.1 and 1 mg/L in the most sensitive species tested).

LC0, Fish., 96 Hour, > 0.5 mg/l, Method Not Specified.

Acute toxicity to aquatic invertebrates

EC50, Daphnia magna (Water flea), 48 Hour, > 0.16 mg/l, Method Not Specified.

EL50, Daphnia magna (Water flea), 48 Hour, 1.7 mg/l, OECD Test Guideline 202 or Equivalent

Chronic toxicity to aquatic invertebrates

NOEC, Daphnia magna (Water flea), 21 d, 0.013 mg/l

Persistence and degradability

Aminoethylpiperazine

Biodegradability: Material is not readily biodegradable according to OECD/EEC guidelines.

10-day Window: Fail

Biodegradation: 0 %

Exposure time: 28 d

Method: OECD Test Guideline 301F or Equivalent

Theoretical Oxygen Demand: 3.34 mg/mg

Chemical Oxygen Demand: 1.84 mg/mg

Photodegradation

Atmospheric half-life: 0.05 d

Method: Estimated.

Styrenated phenol

Biodegradability: Material is expected to biodegrade very slowly (in the environment). Fails to pass OECD/EEC tests for ready biodegradability.

For similar material(s):

Biodegradation: 4 %

Method: OECD Test Guideline 310

Naphthalene, bis(1-methylethyl)-

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: 21 - 30 %

Exposure time: 56 d

Method: OECD Test Guideline 310 or Equivalent

Bioaccumulative potential

Aminoethylpiperazine

Bioaccumulation: Bioconcentration potential is low (BCF < 100 or Log Pow < 3).

Partition coefficient: n-octanol/water(log Pow): -1.48 Measured

Styrenated phenol

Bioaccumulation: No relevant data found.

Naphthalene, bis(1-methylethyl)-

Bioaccumulation: Bioconcentration potential is moderate (BCF between 100 and 3000 or Log Pow between 3 and 5).

Partition coefficient: n-octanol/water(log Pow): > 4

Mobility in soil

Aminoethylpiperazine

Expected to be relatively immobile in soil (Koc > 5000).

Partition coefficient(Koc): 37000 Estimated.

Styrenated phenol

No relevant data found.

Naphthalene, bis(1-methylethyl)-

No relevant data found.

13. DISPOSAL CONSIDERATIONS

Disposal methods: DO NOT DUMP INTO ANY SEWERS, ON THE GROUND, OR INTO ANY BODY OF WATER. 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. 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. 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	N-Aminoethylpiperazine mixture
UN number	UN 2815
Class	8
Packing group	III
Marine pollutant	Naphthalene, bis(1-methylethyl)-

Classification for SEA transport (IMO-IMDG):

Proper shipping name	N-AMINOETHYLPIPERAZINE MIXTURE
UN number	UN 2815
Class	8
Packing group	III
Marine pollutant	Styrenated phenol
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	N-Aminoethylpiperazine mixture
UN number	UN 2815
Class	8
Packing group	III

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

Acute 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:

The following chemicals are listed because of the additional requirements of Pennsylvania law:

Components	CASRN
Aminoethylpiperazine	140-31-8

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

Revision

Identification Number: 101215950 / A476 / Issue Date: 05/12/2015 / Version: 4.0

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

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.