



Technical Data Sheet

Tangit Dytex

I. Material

Product name:

Tangit Dytex (PC 10)

Material type:

Solvent-containing adhesive based on methylene chloride.

Intended use:

Tangit Dytex is suitable for bonding PVC-U and PVC-C pressure pipes used for transporting inorganic acids. The operable temperature range of Tangit Dytex is below 60°C. For applications outside this range use other Tangit adhesives. Tangit Dytex is not suitable for pipes in drinking water supply. For uncalibrated pipe joints acc. to DIN 8062/8063 it is necessary to use the bonding technique described below.

Packaging:

1.35 kg tins

Shipping units:

6 tins of 1.35 kg each

II. Special features

Bonded joints produced with Tangit adhesive:

In general, bonded joints made of ABS, PVC-U or PVC-C that are produced using the respective Tangit adhesive are as resistant as the material the pipeline is made of.

Exception: the acids listed on the right.

When exposed to these acids, it is recommended to use Tangit Dytex Adhesive for producing bonded joints made of PVC-U resp. PVC-C.

Medium:	Up to a concentration of (%):
Sulphuric acid	> 70 % H ₂ SO ₄ concentration
Chromic-sulphuric acid	> 70 % H ₂ SO ₄ concentration plus 5 % K ₂ Cr ₂ O ₇ , Na ₂ Cr ₂ O ₇
Chromic acid	> 10 % CrO ₃ concentration
Hydrochloric acid	> 25 % HCl concentration
Nitric acid	> 20 % HNO ₃ concentration
Sodium hypochlorite (calcium hypochlorite)	> 6 % NaOCl active chlorine concentration
Hydrogen peroxide	> 5 % H ₂ O ₂ concentration
Hydrofluoric acid	any HF concentration

For all media not listed above or used in lower concentrations, the adhesives Tangit PVC-U or PVC-C can be used.

As these acids affect the pipe material, it is recommended to use pipes of pressure rating DN 16.

Concerning the expected service life and pressure resistance, please contact your local Henkel representative or your pipe resp. fitting manufacturer.

When using Tangit Dytex in the construction of PVC-C pipelines exposed to the acids listed above, it is necessary to observe the pressure and temperature requirements for PVC-U.

Technical data

Raw material basis:

post-chlorinated PVC dissolved in methylene chloride.

Density (spec. gravity):

approx. 1.35 g/cm³

Dilution:

Tangit Dytex comes ready-to-use. It must therefore not be diluted in any way.

Viscosity:

Epprecht-Drage viscosimeter MK2, 20°C,
200-300 mPas.

Brookfield LVT

20°C, spindle 2, 60 rpm, 170-320 mPas.

Handling strength:

is reached after 48 hours.

Final strength:

corresponds to the strength of the bonded material.

Consumption:

For the production of 100 bonded joints the following **approximate** amounts of adhesive and cleaner are required:

Pipe dimensions - DN - OD (mm)	50 63	65 75	80 90	100 110	125 140
Tangit Dytex Solvent Cleaner (kg)	1.8	2.3	3.1	4.7	7.9
Tangit Dytex Adhesive (kg)	1.1	1.5	2.1	2.9	4.5

Please note: The adhesive amounts indicated above are maximum values based on practical experience. The actual consumption in a given application depends on working method, pipe gap and temperature.

III. Instructions for use

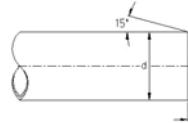
There is sound practical experience with PVC-U pipelines for transporting acids and bases that were bonded using Tangit adhesives.

The bonds lose some of their stability when exposed for longer periods to the media listed under "Special features". This applies in particular to larger differences in pipe diameters (large gaps).

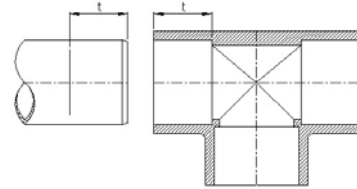
The strength of the bond is also greatly influenced by the time allowed for the fresh bond to dry and by parameters such as operating pressure, operating temperature and concentration of the media. Long-term observations have shown that Tangit Dytex is superior to other Tangit adhesives for bonding PVC-U pipes used for the above-listed media at higher concentrations than those given. Since Tangit Dytex does not have a gap-filling property, a special installation technique must be followed when using today's uncalibrated pipe-fitting joints.



Cut pipe
right-angled



Bevel-cut
outside,
deflash
inside



Pipe Outer Diameter (mm)	Measure b in mm, application with fittings
up to 16	approx. 2
20 – 50	approx. 3
63 – 140	approx. 5

Pipe Outer Diameter (mm)	Plug-in Depth in mm t
16	14
20	16
25	19
32	22
40	26
50	31
63	38
75	44
90	51
110	61
140	76

Preparation of the surfaces to be bonded:

The socket ends should have a design that is suitable for bonding (conical tapering.)
The pipe ends must be cut off at right angles, chamfered and deburred (see fig.)

No tight and durable bond can be produced unless the ends have been properly chamfered.

Pretreatment:

Remove heavy dirt adherent to the surfaces to be bonded (pipe ends outside, fittings inside). Remove any ice by careful heating (luke-warm). Then measure the fitting insertion depth (= bond length) and mark it on the pipe end so that the application of the required amount of adhesive and the complete insertion of the pipe can be assured.

Since Tangit Dytex does not have a gap-filling property, the proper fit of pipe and socket must be checked while still dry. If the pipe end can be inserted easily into the socket of the fitting, it is necessary to apply several layers of adhesive.

Bonding:

The final cleaning is done with Tangit Dytex Solvent Cleaner. Soak white, lint-free tissue paper (from the roll) with the solvent cleaner and thoroughly clean the dry surfaces to be bonded until they are free of dirt and grease. Use a new piece of tissue paper for each cleaning operation. After that, brush Tangit Dytex Solvent Cleaner onto the surfaces to be bonded (pipe ends outside, fittings inside) until the surfaces have partially dissolved (slimy consistency, use fingernail to check).

Apply Tangit Dytex Adhesive with a round brush in axial direction onto the still partly dissolved surfaces and allow to dry for at least 30 seconds.

Brush sizes for pipe bonding:

Up to d 63 mm:
round brush Ø 20 mm

Above d 75 mm:
round brush Ø > 45 mm

The application of the adhesive depends on the gap size (pipe diameter):

d mm < 16 s=±0 mm	d mm 16 - 25 s=±0.0 mm	d mm 32 - 40 s=+0.1 mm	d mm 50 - 63 s=+0.2 mm	d mm 75 - 90 s=+0.3 mm	d mm 110 - 140 1) s=+0.4 mm
2 x both sides	3 x both sides	4 x both sides	6 x both sides	8 x both sides	10 x both sides

¹⁾ Gaps (difference in diameters) must not be larger than 0.4 mm! Pipes/fittings with an OD larger than 110 mm should be measured to determine the permissible size of the gap.

After the last application of adhesive, apply another coat of Tangit Dytex Solvent Cleaner on both surfaces until they have a slimy consistency again. Immediately afterwards insert the pipe end fully into the socket without twisting or jamming. Hold fast for several seconds.

Since the adhesive cures rapidly, the parts must be joined within one minute after the last application of the solvent cleaner. At temperatures above 25°C, the open time decreases to less than 1 minute. When inserting the pipe, firm resistance must be felt. The adhesive bulge forming during insertion must be uniform and consistent. Immediately wipe off any excess adhesive.

Because of its open time of 1 minute, Tangit Dytex Adhesive cannot be used for pipes with diameters larger than 140 mm.

Waiting times / pressure tests:

The joints must not be subjected to mechanical stress for the first 5 minutes after bonding.

Waiting times between the individual steps at tolerances of	
≤ 0.2 mm 10 to 15 min.	> 0.2 mm up to 0.4 mm 30 min. (at temperatures ≤ 10°C = 45 min.)

After drying for approx. 48 hours at 23°C, the bonds have reached their operable strength. Curing takes longer at lower ambient temperatures (see IV: Special Instructions). The pipelines must not be filled or pressure-tested earlier than 48 hours after producing the last bond.

IV. Special instructions

At storage temperatures $\leq 5^{\circ}\text{C}$, the materials (fittings, pipes, adhesives) must be allowed to reach a temperature of $20\text{--}25^{\circ}\text{C}$ before use.

Special measures must be taken when working at temperatures below 5°C . First, heat the parts to be bonded to $20\text{--}25^{\circ}\text{C}$, using a hot-air blower. Then bond using the technique described above. After bonding, the parts must be kept at approx. 25°C for 15-30 minutes in order to speed up the curing process. From 75 mm outer diameter up, the adhesive should be applied to pipe and socket simultaneously by two persons.

When using Tangit Dytex with PVC-C pipes, the operating temperature is limited to max. 60°C !

At high air humidity and/or low temperatures, condensed water or hoarfrost may form. If work is done at temperatures below 10°C , the surfaces to be bonded should therefore be rubbed dry with clean tissue paper (without leaving paper traces) and hoarfrost be removed by the application of heat.

To ensure optimum fit (i.e. narrow gaps with sufficient workability), it is recommended to use a pipe / fitting system with matching dimensions, e.g. pipes for chemical applications made by Fischer-DEKA GmbH.

The pipelines must be thoroughly flushed / blown through in order to remove residual solvent vapours. The pipeline must not be closed during the drying time of the adhesive.

Tangit Dytex Adhesive and Tangit Dytex Solvent Cleaner affect PVC-U. Materials should therefore be kept away from any spilled adhesive, solvent cleaner or the paper tissues used for cleaning. Tightly close the containers immediately after use in order to avoid solvent evaporation and thickening.

Generally, we do not recommend bonding work at temperatures below 10°C since curing is considerably delayed at low temperatures. The installation of acid-proof pipelines requires expert knowledge of the special techniques. Please make sure to follow the installation instructions of the pipe/fitting manufacturers.

The bonded pipelines must be inspected in regular intervals. We recommend that a couple of transparent fittings are installed in the pipeline to facilitate inspection. Discoloration of the bonded joint will then indicate any damage to the system. Transparent fittings are produced e.g. by Georg Fischer Rohr-leitungssysteme AG, Albershausen/D resp. Schaffhausen/CH.

The quality of the joints directly depends on proper workmanship and on the matching dimensions of the pipes and fittings used.

Safety information:

Always keep the containers tightly closed and store them in a cool, well-ventilated place.

Avoid contact with skin, eyes and clothes. Do not empty product remains into sewage systems.

For further information refer to the leaflets and accident prevention regulations of the employers' liability insurance associations and the safety data sheet.

Shelf life:

If stored at $20\text{--}25^{\circ}\text{C}$ in the unopened original containers, Tangit Dytex Adhesive and Tangit Dytex Solvent Cleaner have a shelf life of at least 24 months from the date of filling.

Date of manufacture and batch number are indicated at the bottom of the container.

Internet:

www.tangit.com

This Technical Data Sheet is based on our present knowledge and experience.



Please note:

The above information can only be of a general nature. As materials and conditions may vary with each intended application and thus are beyond our influence, we recommend that the user always carries out sufficient tests to ensure our products are suitable. No liability can be accepted for particular application results based on the information and instructions given in this leaflet.

Henkel KGaA – 40191 Düsseldorf, Germany



Technical Data Sheet

Tangit Cleaner

Cleaner for bonded joints made of PVC-U* and PVC-C** and ABS***

I. Material

Product name:

Tangit Cleaner for bonded joints made of PVC-U, PVC-C and ABS.

Intended use:

Cleaner for pipes and fittings made of PVC-U, PVC-C and ABS.

Packaging:

1 l bottles

Material type:

Cleaning agent based on acetone and methyl ethyl ketone.

Not suitable for polyolefin weld joints.

Shipping units:

12 bottles of 1 l each

II. Special features

Tangit Cleaner has an excellent cleaning performance.

* PVC-U = rigid PVC

** PVC-C = post-chlorinated PVC

*** ABS = acrylonitrile-butadiene styrene

Technical data

Raw material basis:

acetone, methyl ethyl ketone

Density (spec. gravity):

approx. 0.80 g/ml

Consumption:

For the production of 100 bonded joints the following **approximate** amounts of cleaner are required:

Pipe dimensions - DN - OD (mm)	25 32	32 40	40 50	50 63	65 75	80 90	100 110	125 140	150 160	200 225	250 280	300 315
Tangit Cleaner (kg)	0.5	0.7	0.9	1.1	1.3	1.4	1.7	2.1	2.5	4.5	6.5	10.2

III. Instructions for use

Before first use of the cleaner, remove the cap from the bottle. Then use a blunt tool to push the spray sieve through the safety foil right into the neck of the bottle as far as it will go.

Cleaning:

The surfaces to be bonded must first be cleaned of heavy dirt. If pipes are to be bonded, follow the instructions given in the Technical Data Sheets of Tangit PVC-U, Tangit PVC-C and Tangit ABS respectively.

Now the final cleaning is done using Tangit Cleaner. Spray the cleaner onto a piece of white, non-staining soft paper (e.g. tissue paper from the roll) and thoroughly clean the dry surfaces to be bonded until they are free of grease, dirt and lubricant.

Use a new piece of tissue paper for each cleaning operation. The surfaces cleaned with Tangit Cleaner must be dry before applying the adhesive.

Any ice must be removed by careful heating.

Bonding:

For bonding pipes please refer to the instructions given in the Technical Data Sheets of Tangit PVC-U, Tangit PVC-C and Tangit ABS respectively.

IV. Special instructions

Heed the instructions given in the Technical Data Sheets of the respective Tangit products.

Safety measures:

Avoid open light or fire and any sparking. Switch off all electrical devices. Store the containers in a well-ventilated place. Prior to welding, residual solvent vapours must be removed from pipelines, working areas and shafts. For this purpose, fill the pipes with water and thoroughly flush / blow them through. Do not close the pipes while drying.

In case of contact with the eyes, rinse thoroughly with water and obtain medical advice.

Do not allow product remains to enter the sewage system.

For further information refer to the leaflets and accident prevention regulations of the employers' liability insurance associations and the safety data sheets.

Shelf life:

Tangit Cleaner has a shelf life of at least 36 months from the date of filling. Date of manufacture and batch number are printed at the bottom of the bottle.

Disposal:

Product remains must be disposed of as special waste. Only recycle well-emptied containers. The respective codes of the European Waste Catalogue (EWC) can be enquired from the manufacturer.

Internet:

www.tangit.com

This Technical Data Sheet is based on our present knowledge and experience.



Please note:

The above information can only be of a general nature. As materials and conditions may vary with each intended application and thus are beyond our influence, we recommend that the user always carries out sufficient tests to ensure our products are suitable. No liability can be accepted for particular application results based on the information and instructions given in this leaflet.

Henkel AG & Co. KGaA – 40191 Düsseldorf, Germany

Version 08/2008



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Material Safety Data Sheet

This Material Safety Data Sheet (MSDS) is issued by the Supplier in accordance with National Standards and Guidelines from the Australian Safety and Compensation Council (ASCC, formerly National Occupational Health and Safety Commission - NOHSC).

Classified as **Hazardous** according to the criteria of the Australian Safety and Compensation Council ASCC (formerly NOHSC) Approved Criteria For Classifying Hazardous Substances [NOHSC:1008] 3rd Edition.

Methyl Ethyl Ketone is classified as **Dangerous Goods** according to the Australian Code for the Transport of Dangerous Goods by Road and Rail.

1. IDENTIFICATION OF THE MATERIAL AND SUPPLIER

Product Name:	Methyl Ethyl Ketone	Telephone:	+61 07 3821 0333
Other Names:	MEK	Facsimile:	+61 07 3821 2210
Product Code:	RMK05	Internet:	www.totalchemicals.com.au
Supplier:	TOTAL CHEMICALS PTY LTD	e-mail:	info@totalchemicals.com.au
	ABN 26 038 108 730		
	15 Production Street		
	Wacol Qld 4077		

Major Uses and Methods of Application: Thinner for nitrocellulose paints

2. COMPOSITION/INFORMATION ON INGREDIENTS

	CAS No.	Proportion
Methyl Ethyl Ketone (MEK)	78-93-3	> 60 % w/w

3. HAZARDS IDENTIFICATION

STATEMENT OF HAZARDOUS NATURE:

Classified as **Hazardous** according to the criteria of the Australian Safety and Compensation Council ASCC (formerly NOHSC) Approved Criteria For Classifying Hazardous Substances [NOHSC:1008] 3rd Edition.

Methyl Ethyl Ketone is classified as **Dangerous Goods** according to the Australian Code for the Transport of Dangerous Goods by Road and Rail.

Risk Phrases:

- Highly Flammable
- Irritating to eyes
- Repeated exposure may cause skin dryness or cracking
- Vapours may cause drowsiness and dizziness

Poisons Schedule: S5

4. FIRST AID MEASURES

If poisoning occurs contact a doctor or Poisons Information Centre.
Poisons Information Centre: 13 11 26 (available in Australia only).

Swallowed:	Rinse mouth with water. If swallowed DO NOT INDUCE vomiting. If vomiting occurs spontaneously, keep head below hips to prevent aspiration
Eye:	If in eyes, immediately flush eyes with plenty of water for at least 15 minutes, lifting upper and lower eyelids occasionally. Get medical attention
Skin:	If skin contact occurs, flush skin with flowing water for at least 15 minutes. Remove contaminated clothing and shoes. If irritation persists, seek medical attention Decontaminate clothing before re-use or discard
Inhalation:	Remove source of contamination or move person to fresh air. Remove contaminated clothing and keep patient warm and comfortable. Give artificial respiration if breathing has stopped. Seek medical attention



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4. FIRST AID MEASURES

If poisoning occurs contact a doctor or Poisons Information Centre.
Poisons Information Centre: 13 11 26 (available in Australia only).

Advice to doctor: Causes central nervous system depression. Dermatitis may result from prolonged or repeated exposure. Potential for chemical pneumonitis. Consider: gastric lavage with protected airway, administration of activated charcoal.

5. FIRE FIGHTING MEASURES

Clear fire area of all non-emergency personnel.

Use dry chemical or foam to extinguish.
Combustion may cause dense smoke. Carbon monoxide evolved if combustion is incomplete.
Flammable material, keep containers cool with water spray.
Shut off fuel to fire.
Use dry chemical, foam or carbon dioxide
Water may be ineffective, but should be used to keep fire-exposed containers cool.
If a leak or spill has ignited, use waster spray to disperse water vapour and to protect men attempting to stop leak.
Avoid spraying water directly into storage containers due to danger of boil over.
Minimise breathing gases, vapour fumes or decomposition products.
Use supplied air breathing equipment for enclosed areas.

6. ACCIDENTAL RELEASE MEASURES

Eliminate ignition sources.
Contain spills for salvage or disposal.
Minimise dilution water to control spill volume.
Liquid spills should be absorbed prior to disposal. ("Silicate" type absorbent materials are suggested).
Avoid run off into sewers and ditches.

7. HANDLING AND STORAGE

Precautions to be taken in handling and storage:

Practice personal cleanliness by prompt removal of solvent in contact with the skin
Train all employees in special handling procedure prior to working with this product.
DO NOT eat food ext to this product.
Keep containers closed with not in use.
Do not store near heat, sparks, flame or strong oxidants.
Transfer product in effectively bonded system to prevent fire or explosion risk from static accumulation and discharge.
Adequate ventilation required.
Wash skin thoroughly with soap and water after contact.

Other precautions:

Store in original containers in a cool, shaded location, safe from physical damage, with containers tightly closed.
DO NOT reuse containers.
DO NOT pressurize, cut, weld, braze, solder, drill or grind container or contents.
DO NOT expose to heat, flame, sparks, electricity, static electricity or any other sources of ignition as they may cause container/s to explode and may cause injury or death.
Empty containers can retain product residue (liquid and/or vapour) and can be dangerous.
Empty containers should be completely drained, properly bunched and promptly returned to a drum re-conditioner.



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8. EXPOSURE CONTROLS AND PERSONAL PROTECTION

Not established, for the mixture.

Worksafe Australia Exposure Standard [N0HSC:1003(1995)]: for Individual components:

Butanone - TWA 150ppm (445mg/ m³), STEL 300 ppm (890mg/ m³)

TWA – Time-weighted average airborne concentration over an eight hour working day, for a five day working week over an entire working life.

STEL - short term exposure limit – the average airborne concentration over a 15 minute period which should not be exceeded at any time during a normal eight hour work day

Personal Protection:

Eye protection: Safety glasses, goggles or face shield as required

Hand Protection: PVC, neoprene or nitrile rubber gloves

Footwear: Rubber boots

Respiratory Protection: If airborne concentrations are likely to exceed the Exposure Standard, wear approved organic vapour respiratory protection (AS/NZS 1715 and 1716). In high vapour concentrations, wear an air-supplied hood
Safety showers with eyewash should be provided in all areas where product is handled.
No respiratory protection required if engineering, storage and handling controls are adequate

Engineering Controls: General (mechanical) room ventilation plus special local exhaust ventilation at points where vapour could escape to the work environment. All ventilation equipment must be fitted with flame and explosion proof electrical fittings

9. PHYSICAL AND CHEMICAL PROPERTIES

Appearance: Clear liquid. Characteristic odour.

Boiling Range: 79 - 81°C

Vapour Pressure: 9.5kPa @20 °C

Specific Gravity: 0.81

Flash Point: -4 °C

Flammability Limits: LEL 1.8% v/v, UEL 11.5% v/v

Solubility in water: partially soluble

% Volatiles by volume: 100%

10. STABILITY AND REACTIVITY

Stability: Stable under ordinary conditions of use and storage.

Conditions to Avoid: Strong oxidizers, strong alkalies, strong acids and selected amines.

Incompatibility – Materials to avoid for purposes of transport, handling and storage only.

Strong oxidizing agents (eg. liquid chlorine, concentrated oxygen, sodium hypochlorite).

Hazardous Decomposition Products:

Carbon dioxide and carbon monoxide.



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11. TOXICOLOGICAL INFORMATION

Toxicological Data

Oral LD 50(rat) 2737 mg/kg
Oral LD 50 (mice) 4050 mg/kg

No adverse health effects expected if the product is handled in accordance with this MSDS and product label.
Symptoms or effects that may arise if the product is misused and overexposure occurs are:

Swallowed:	Harmful. Irritant to mouth, throat and digestive tract. Large dose may cause drowsiness and lead to unconsciousness. If aspirated into lungs can cause serious lung inflammation and may be fatal
Eye:	Moderate irritant
Skin:	Irritant. May cause dermatitis, liquid & vapour may be absorbed through the skin with subsequent toxic effects
Inhalation:	High concentrations may cause depression, dizziness, nausea, and headache. Irritation of mucous membranes and respiratory tract are possible. Aspiration (e.g. during vomiting) into the lungs can cause serious (even fatal) pneumonitis

12. ECOLOGICAL INFORMATION

Environmental Mobility:	This product is highly volatile and will rapidly evaporate to the air if released into the water.
Environmental Degradability:	Based upon data for a similar component or preparation or estimated data. This substance is expected to be removed in a wastewater treatment facility. This product is expected to biodegrade rapidly and be "readily" biodegradable according to OECD guidelines.
Ecotoxicity & Bioaccumulation:	Based upon data for a similar component of preparation or estimated data. Expected to be toxic to aquatic organisms. Long term adverse effects to aquatic organisms are possible if continuous exposure is maintained.

This product is expected to be toxic to aquatic organisms
CL50 (fish,96h): 1mg/l – 10mg/l
Avoid discharge to sewers, storm drains, surface waters and soil

13. DISPOSAL CONSIDERATIONS

Do not dispose into public waste or sewage system
Recover or recycle waste product, if possible, otherwise incinerate
Absorbed spills or any other contaminated materials (ie. Rags, paper etc), are considered hazardous wastes in preparing for disposal.
Consult Federal, State or Local regulations controlling proper disposal of hydrocarbon containing materials.
Empty containers must also be disposed of in an environmentally safe manner.

14. TRANSPORT INFORMATION

U.N. Number:	1193	Hazchem Code:	2[Y]E
D. G Class:	3	Packaging Group:	II



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15. REGULATORY INFORMATION

The regulatory information is not intended to be comprehensive. Other regulations may apply to this material.

Risk Phrase: R11 Highly Flammable
R36 Irritating to eyes
R66 Repeated exposure may cause skin dryness or cracking
R67 Vapours may cause drowsiness and dizziness

Safety Phrase: S2 Keep out of the reach of children
S9 Keep container in a well ventilated place
S16 Keep away from source of ignition – No smoking

Poisons Schedule: S5

Hazard Category: Xi Irritant, F Flammable

16. OTHER INFORMATION

For further information on this product, please contact:

Contact:	Technical Manager
Telephone:	+61 07 3821 0333

This Material Safety Data Sheet (MSDS) is issued by the Supplier in accordance with National standards and guidelines from the Australian Safety and Compensation Council (ASCC, formerly National Occupational Health and Safety Commission - NOHSC). The information in it must not be altered, deleted or added to. The Supplier will not accept any responsibility for any changes made to its MSDS by any other person or organization. The Supplier will issue a new MSDS when there is a change in product specifications and/or ASCC standards, codes, guidelines, or Regulations.

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END OF MSDS