



Safety Data Sheet

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Document Group:	29-7184-4	Version Number:	1.02
Issue Date:	05/08/17	Supersedes Date:	02/02/15

Product identifier

3M™ Scotch-Weld™ Epoxy Adhesive EC-1838 B/A Green

ID Number(s):

87-2500-0440-2, 87-2500-0441-0

Recommended use

Structural adhesive

Supplier's details

MANUFACTURER: 3M
DIVISION: Automotive and Aerospace Solutions Division

ADDRESS: 3M Center, St. Paul, MN 55144-1000, USA
Telephone: 1-888-3M HELPS (1-888-364-3577)

Emergency telephone number

1-800-364-3577 or (651) 737-6501 (24 hours)

This product is a kit or a multipart product which consists of multiple, independently packaged components. A Safety Data Sheet (SDS), Article Information Sheet (AIS), or Article Information Letter (AIL) for each of these components is included. Please do not separate the component documents from this cover page. The document numbers for components of this product are:

29-7186-9, 29-7188-5

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Document Group:	29-7188-5	Version Number:	2.01
Issue Date:	07/26/18	Supersedes Date:	02/02/15

SECTION 1: Identification

1.1. Product identifier

3M™ Scotch-Weld™ Epoxy Adhesive EC-1838 B/A Green, Part B

Product Identification Numbers

LC-B100-0987-4, LC-B100-0987-5

1.2. Recommended use and restrictions on use

Recommended use

Base component for two-part adhesive

1.3. Supplier's details

MANUFACTURER:	3M
DIVISION:	Automotive and Aerospace Solutions Division
ADDRESS:	3M Center, St. Paul, MN 55144-1000, USA
Telephone:	1-888-3M HELPS (1-888-364-3577)

1.4. Emergency telephone number

1-800-364-3577 or (651) 737-6501 (24 hours)

SECTION 2: Hazard identification

2.1. Hazard classification

Serious Eye Damage/Irritation: Category 2B.

Skin Sensitizer: Category 1.

Specific Target Organ Toxicity (repeated exposure): Category 1.

2.2. Label elements

Signal word

Danger

Symbols

Exclamation mark | Health Hazard |

Pictograms

**Hazard Statements**

Causes eye irritation.
May cause an allergic skin reaction.

Causes damage to organs through prolonged or repeated exposure:
respiratory system |

Precautionary Statements**Prevention:**

Do not breathe dust/fume/gas/mist/vapors/spray.
Wear protective gloves.
Do not eat, drink or smoke when using this product.
Wash thoroughly after handling.
Contaminated work clothing must not be allowed out of the workplace.

Response:

IF IN EYES: Rinse cautiously with water for several minutes. Remove contact lenses, if present and easy to do. Continue rinsing.
If eye irritation persists: Get medical advice/attention.
IF ON SKIN: Wash with plenty of soap and water.
If skin irritation or rash occurs: Get medical advice/attention.
Wash contaminated clothing before reuse.
Get medical advice/attention if you feel unwell.

Disposal:

Dispose of contents/container in accordance with applicable local/regional/national/international regulations.

SECTION 3: Composition/information on ingredients

Ingredient	C.A.S. No.	% by Wt
EPOXY RESIN	25068-38-6	70 - 80 Trade Secret *
KAOLIN	1332-58-7	20 - 30 Trade Secret *
CALCIUM CARBONATE	1317-65-3	1 - 5
CLAY	68953-58-2	1 - 5
TITANIUM DIOXIDE	13463-67-7	< 1 Trade Secret *

*The specific chemical identity and/or exact percentage (concentration) of this composition has been withheld as a trade secret.

SECTION 4: First aid measures**4.1. Description of first aid measures****Inhalation:**

Remove person to fresh air. If you feel unwell, get medical attention.

Skin Contact:

Immediately wash with soap and water. Remove contaminated clothing and wash before reuse. If signs/symptoms develop, get medical attention.

Eye Contact:

Flush with large amounts of water. Remove contact lenses if easy to do. Continue rinsing. If signs/symptoms persist, get medical attention.

If Swallowed:

Rinse mouth. If you feel unwell, get medical attention.

4.2. Most important symptoms and effects, both acute and delayed

See Section 11.1. Information on toxicological effects.

4.3. Indication of any immediate medical attention and special treatment required

Not applicable

SECTION 5: Fire-fighting measures

5.1. Suitable extinguishing media

In case of fire: Use a fire fighting agent suitable for ordinary combustible material such as water or foam to extinguish.

5.2. Special hazards arising from the substance or mixture

None inherent in this product.

Hazardous Decomposition or By-Products

Substance

Aldehydes
Hydrocarbons
Carbon monoxide
Carbon dioxide
Ketones

Condition

During Combustion
During Combustion
During Combustion
During Combustion
During Combustion

5.3. Special protective actions for fire-fighters

No special protective actions for fire-fighters are anticipated.

SECTION 6: Accidental release measures

6.1. Personal precautions, protective equipment and emergency procedures

Evacuate area. Ventilate the area with fresh air. For large spill, or spills in confined spaces, provide mechanical ventilation to disperse or exhaust vapors, in accordance with good industrial hygiene practice. Refer to other sections of this SDS for information regarding physical and health hazards, respiratory protection, ventilation, and personal protective equipment.

6.2. Environmental precautions

Avoid release to the environment. For larger spills, cover drains and build dikes to prevent entry into sewer systems or bodies of water.

6.3. Methods and material for containment and cleaning up

Contain spill. Working from around the edges of the spill inward, cover with bentonite, vermiculite, or commercially available inorganic absorbent material. Mix in sufficient absorbent until it appears dry. Remember, adding an absorbent material does not remove a physical, health, or environmental hazard. Collect as much of the spilled material as possible. Place in a closed container approved for transportation by appropriate authorities. Clean up residue with an appropriate solvent selected by a qualified and authorized person. Ventilate the area with fresh air. Read and follow safety precautions on the solvent label and SDS. Seal the container. Dispose of collected material as soon as possible in accordance with

applicable local/regional/national/international regulations.

SECTION 7: Handling and storage

7.1. Precautions for safe handling

Do not breathe dust/fume/gas/mist/vapors/spray. Do not get in eyes, on skin, or on clothing. Do not eat, drink or smoke when using this product. Wash thoroughly after handling. Contaminated work clothing should not be allowed out of the workplace. Avoid release to the environment. Wash contaminated clothing before reuse. Avoid contact with oxidizing agents (eg. chlorine, chromic acid etc.)

7.2. Conditions for safe storage including any incompatibilities

Store away from acids. Store away from oxidizing agents.

SECTION 8: Exposure controls/personal protection

8.1. Control parameters

Occupational exposure limits

If a component is disclosed in section 3 but does not appear in the table below, an occupational exposure limit is not available for the component.

Ingredient	C.A.S. No.	Agency	Limit type	Additional Comments
CALCIUM CARBONATE	1317-65-3	OSHA	TWA(as total dust):15 mg/m ³ ;TWA(respirable fraction):5 mg/m ³	
KAOLIN	1332-58-7	ACGIH	TWA(respirable fraction):2 mg/m ³	A4: Not class. as human carcin
TITANIUM DIOXIDE	13463-67-7	ACGIH	TWA:10 mg/m ³	A4: Not class. as human carcin
TITANIUM DIOXIDE	13463-67-7	OSHA	TWA(as total dust):15 mg/m ³	

ACGIH : American Conference of Governmental Industrial Hygienists

AIHA : American Industrial Hygiene Association

CMRG : Chemical Manufacturer's Recommended Guidelines

OSHA : United States Department of Labor - Occupational Safety and Health Administration

TWA: Time-Weighted-Average

STEL: Short Term Exposure Limit

CEIL: Ceiling

8.2. Exposure controls

8.2.1. Engineering controls

Use general dilution ventilation and/or local exhaust ventilation to control airborne exposures to below relevant Exposure Limits and/or control dust/fume/gas/mist/vapors/spray. If ventilation is not adequate, use respiratory protection equipment.

8.2.2. Personal protective equipment (PPE)

Eye/face protection

Select and use eye/face protection to prevent contact based on the results of an exposure assessment. The following eye/face protection(s) are recommended:

Indirect Vented Goggles

Skin/hand protection

Select and use gloves and/or protective clothing approved to relevant local standards to prevent skin contact based on the results of an exposure assessment. Selection should be based on use factors such as exposure levels, concentration of the substance or mixture, frequency and duration, physical challenges such as temperature extremes, and other use conditions. Consult with your glove and/or protective clothing manufacturer for selection of appropriate compatible gloves/protective

clothing. Note: Nitrile gloves may be worn over polymer laminate gloves to improve dexterity.

Gloves made from the following material(s) are recommended: Butyl Rubber

Polymer laminate

If this product is used in a manner that presents a higher potential for exposure (eg. spraying, high splash potential etc.), then use of protective coveralls may be necessary. Select and use body protection to prevent contact based on the results of an exposure assessment. The following protective clothing material(s) are recommended: Apron – Butyl rubber
Apron - polymer laminate

Respiratory protection

An exposure assessment may be needed to decide if a respirator is required. If a respirator is needed, use respirators as part of a full respiratory protection program. Based on the results of the exposure assessment, select from the following respirator type(s) to reduce inhalation exposure:

Half facepiece or full facepiece air-purifying respirator suitable for organic vapors and particulates

For questions about suitability for a specific application, consult with your respirator manufacturer.

SECTION 9: Physical and chemical properties

9.1. Information on basic physical and chemical properties

General Physical Form:	Liquid
Specific Physical Form:	Viscous Liquid
Odor, Color, Grade:	White; mild epoxy odor
Odor threshold	<i>No Data Available</i>
pH	<i>Not Applicable</i>
Melting point	<i>No Data Available</i>
Boiling Point	>=300 °F
Flash Point	>=200 °F [<i>Test Method</i> :Closed Cup]
Evaporation rate	<i>Not Applicable</i>
Flammability (solid, gas)	Not Applicable
Flammable Limits(LEL)	<i>No Data Available</i>
Flammable Limits(UEL)	<i>No Data Available</i>
Vapor Pressure	<i>No Data Available</i>
Vapor Density	<i>No Data Available</i>
Density	1.3 g/cm ³
Specific Gravity	1.3 [<i>Ref Std</i> :WATER=1]
Solubility in Water	Negligible
Solubility- non-water	Nil
Partition coefficient: n-octanol/ water	<i>No Data Available</i>
Autoignition temperature	<i>No Data Available</i>
Decomposition temperature	<i>No Data Available</i>
Viscosity	400,000 centipoise [<i>@ 73</i>] [<i>Test Method</i> :Brookfield]
Hazardous Air Pollutants	0 % weight [<i>Test Method</i> :Calculated]
Volatile Organic Compounds	2 g/l [<i>Test Method</i> :tested per EPA method 24] [<i>Details</i> :EU VOC content]
Percent volatile	0 - 0.2 % weight [<i>Test Method</i> :ACS METHOD]
VOC Less H₂O & Exempt Solvents	2 g/l [<i>Test Method</i> :tested per EPA method 24]
VOC Less H₂O & Exempt Solvents	3 g/l [<i>Test Method</i> :tested per EPA method 24] [<i>Details</i> :when used as intended with Part A]

SECTION 10: Stability and reactivity

10.1. Reactivity

This material is considered to be non reactive under normal use conditions.

10.2. Chemical stability

Stable.

10.3. Possibility of hazardous reactions

Hazardous polymerization will not occur.

10.4. Conditions to avoid

Heat is generated during cure. Do not cure a mass larger than 50 grams in a confined space to prevent a premature exothermic reaction with production of intense heat and smoke.

10.5. Incompatible materials

Strong acids

Strong oxidizing agents

10.6. Hazardous decomposition products

<u>Substance</u>	<u>Condition</u>
None known.	

Refer to section 5.2 for hazardous decomposition products during combustion.

SECTION 11: Toxicological information

The information below may not be consistent with the material classification in Section 2 if specific ingredient classifications are mandated by a competent authority. In addition, toxicological data on ingredients may not be reflected in the material classification and/or the signs and symptoms of exposure, because an ingredient may be present below the threshold for labeling, an ingredient may not be available for exposure, or the data may not be relevant to the material as a whole.

11.1. Information on Toxicological effects

Signs and Symptoms of Exposure

Based on test data and/or information on the components, this material may produce the following health effects:

Inhalation:

Respiratory Tract Irritation: Signs/symptoms may include cough, sneezing, nasal discharge, headache, hoarseness, and nose and throat pain.

May cause additional health effects (see below).

Skin Contact:

Mild Skin Irritation: Signs/symptoms may include localized redness, swelling, itching, and dryness. Allergic Skin Reaction (non-photo induced): Signs/symptoms may include redness, swelling, blistering, and itching.

Eye Contact:

Moderate Eye Irritation: Signs/symptoms may include redness, swelling, pain, tearing, and blurred or hazy vision.

Ingestion:

Gastrointestinal Irritation: Signs/symptoms may include abdominal pain, stomach upset, nausea, vomiting and diarrhea.

Additional Health Effects:

Prolonged or repeated exposure may cause target organ effects:

Pneumoconiosis: Sign/symptoms may include persistent cough, breathlessness, chest pain, increased amounts of sputum, and changes in lung function tests.

Carcinogenicity:

Ingredient	CAS No.	Class Description	Regulation
TITANIUM DIOXIDE	13463-67-7	Grp. 2B: Possible human carc.	International Agency for Research on Cancer

Toxicological Data

If a component is disclosed in section 3 but does not appear in a table below, either no data are available for that endpoint or the data are not sufficient for classification.

Acute Toxicity

Name	Route	Species	Value
Overall product	Ingestion		No data available; calculated ATE >5,000 mg/kg
EPOXY RESIN	Dermal	Rat	LD50 > 1,600 mg/kg
EPOXY RESIN	Ingestion	Rat	LD50 > 1,000 mg/kg
KAOLIN	Dermal		LD50 estimated to be > 5,000 mg/kg
KAOLIN	Ingestion	Human	LD50 > 15,000 mg/kg
CLAY	Dermal		LD50 estimated to be > 5,000 mg/kg
CLAY	Inhalation-Dust/Mist (4 hours)	Rat	LC50 > 12.6 mg/l
CLAY	Ingestion	Rat	LD50 > 5,000 mg/kg
CALCIUM CARBONATE	Dermal	Rat	LD50 > 2,000 mg/kg
CALCIUM CARBONATE	Inhalation-Dust/Mist (4 hours)	Rat	LC50 3 mg/l
CALCIUM CARBONATE	Ingestion	Rat	LD50 6,450 mg/kg
TITANIUM DIOXIDE	Dermal	Rabbit	LD50 > 10,000 mg/kg
TITANIUM DIOXIDE	Inhalation-Dust/Mist (4 hours)	Rat	LC50 > 6.82 mg/l
TITANIUM DIOXIDE	Ingestion	Rat	LD50 > 10,000 mg/kg

ATE = acute toxicity estimate

Skin Corrosion/Irritation

Name	Species	Value
EPOXY RESIN	Rabbit	Mild irritant
KAOLIN	Professional judgement	No significant irritation
CLAY	Rat	No significant irritation
CALCIUM CARBONATE	Rabbit	No significant irritation
TITANIUM DIOXIDE	Rabbit	No significant irritation

Serious Eye Damage/Irritation

Name	Species	Value
EPOXY RESIN	Rabbit	Moderate irritant
KAOLIN	Professional judgement	No significant irritation
CLAY	Rabbit	No significant irritation
CALCIUM CARBONATE	Rabbit	No significant irritation
TITANIUM DIOXIDE	Rabbit	No significant irritation

Skin Sensitization

Name	Species	Value
EPOXY RESIN	Human and animal	Sensitizing
TITANIUM DIOXIDE	Human and animal	Not classified

Respiratory Sensitization

Name	Species	Value
EPOXY RESIN	Human	Not classified

Germ Cell Mutagenicity

Name	Route	Value
EPOXY RESIN	In vivo	Not mutagenic
EPOXY RESIN	In Vitro	Some positive data exist, but the data are not sufficient for classification
TITANIUM DIOXIDE	In Vitro	Not mutagenic
TITANIUM DIOXIDE	In vivo	Not mutagenic

Carcinogenicity

Name	Route	Species	Value
EPOXY RESIN	Dermal	Mouse	Some positive data exist, but the data are not sufficient for classification
KAOLIN	Inhalation	Multiple animal species	Not carcinogenic
TITANIUM DIOXIDE	Ingestion	Multiple animal species	Not carcinogenic
TITANIUM DIOXIDE	Inhalation	Rat	Carcinogenic

Reproductive Toxicity**Reproductive and/or Developmental Effects**

Name	Route	Value	Species	Test Result	Exposure Duration
EPOXY RESIN	Ingestion	Not classified for female reproduction	Rat	NOAEL 750 mg/kg/day	2 generation
EPOXY RESIN	Ingestion	Not classified for male reproduction	Rat	NOAEL 750 mg/kg/day	2 generation
EPOXY RESIN	Dermal	Not classified for development	Rabbit	NOAEL 300 mg/kg/day	during organogenesis
EPOXY RESIN	Ingestion	Not classified for development	Rat	NOAEL 750 mg/kg/day	2 generation
CALCIUM CARBONATE	Ingestion	Not classified for development	Rat	NOAEL 625 mg/kg/day	prematuring & during gestation

Target Organ(s)**Specific Target Organ Toxicity - single exposure**

Name	Route	Target Organ(s)	Value	Species	Test Result	Exposure Duration
CALCIUM CARBONATE	Inhalation	respiratory system	Not classified	Rat	NOAEL 0.812 mg/l	90 minutes

Specific Target Organ Toxicity - repeated exposure

Name	Route	Target Organ(s)	Value	Species	Test Result	Exposure Duration
EPOXY RESIN	Dermal	liver	Not classified	Rat	NOAEL 1,000 mg/kg/day	2 years
EPOXY RESIN	Dermal	nervous system	Not classified	Rat	NOAEL 1,000 mg/kg/day	13 weeks
EPOXY RESIN	Ingestion	auditory system heart endocrine system hematopoietic system liver eyes kidney and/or bladder	Not classified	Rat	NOAEL 1,000 mg/kg/day	28 days
KAOLIN	Inhalation	pneumoconiosis	Causes damage to organs through prolonged or repeated exposure	Human	NOAEL NA	occupational exposure
KAOLIN	Inhalation	pulmonary fibrosis	Not classified	Rat	NOAEL Not available	
CALCIUM CARBONATE	Inhalation	respiratory system	Not classified	Human	NOAEL Not available	occupational exposure
TITANIUM DIOXIDE	Inhalation	respiratory system	Some positive data exist, but the data are not sufficient for classification	Rat	LOAEL 0.01 mg/l	2 years
TITANIUM DIOXIDE	Inhalation	pulmonary fibrosis	Not classified	Human	NOAEL Not available	occupational exposure

Aspiration Hazard

For the component/components, either no data are currently available or the data are not sufficient for classification.

Please contact the address or phone number listed on the first page of the SDS for additional toxicological information on this material and/or its components.

SECTION 12: Ecological information

Ecotoxicological information

Please contact the address or phone number listed on the first page of the SDS for additional ecotoxicological information on this material and/or its components.

Chemical fate information

Please contact the address or phone number listed on the first page of the SDS for additional chemical fate information on this material and/or its components.

SECTION 13: Disposal considerations

13.1. Disposal methods

Dispose of contents/ container in accordance with the local/regional/national/international regulations.

Dispose of completely cured (or polymerized) material in a permitted industrial waste facility. As a disposal alternative, incinerate uncured product in a permitted waste incineration facility. Proper destruction may require the use of additional fuel during incineration processes. Combustion products will include halogen acid (HCl/HF/HBr). Facility must be capable of handling halogenated materials. If no other disposal options are available, waste product that has been completely cured or polymerized may be placed in a landfill properly designed for industrial waste. Empty drums/barrels/containers used for transporting and handling hazardous chemicals (chemical substances/mixtures/preparations classified as Hazardous as per applicable regulations) shall be considered, stored, treated & disposed of as hazardous wastes unless otherwise defined by applicable waste regulations. Consult with the respective regulating authorities to determine the available treatment and disposal facilities.

EPA Hazardous Waste Number (RCRA): Not regulated

SECTION 14: Transport Information

For Transport Information, please visit <http://3M.com/Transportinfo> or call 1-800-364-3577 or 651-737-6501.

SECTION 15: Regulatory information**15.1. US Federal Regulations**

Contact 3M for more information.

EPCRA 311/312 Hazard Classifications:**Physical Hazards**

Not applicable

Health Hazards

Serious eye damage or eye irritation

Specific target organ toxicity (single or repeated exposure)

15.2. State Regulations

Contact 3M for more information.

15.3. Chemical Inventories

The components of this product are in compliance with the chemical notification requirements of TSCA. All required components of this product are listed on the active portion of the TSCA Inventory.

Contact 3M for more information.

15.4. International Regulations

Contact 3M for more information.

This SDS has been prepared to meet the U.S. OSHA Hazard Communication Standard, 29 CFR 1910.1200.

SECTION 16: Other information**NFPA Hazard Classification**

Health: 2 Flammability: 0 Instability: 1 Special Hazards: None

National Fire Protection Association (NFPA) hazard ratings are designed for use by emergency response personnel to address the hazards that are presented by short-term, acute exposure to a material under conditions of fire, spill, or similar emergencies. Hazard ratings are primarily based on the inherent physical and toxic properties of the material but also include the toxic properties of combustion or decomposition products that are known to be generated in significant quantities.

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user's method of use or application. Given the variety of factors that can affect the use and application of a 3M product, some of which are uniquely within the user's knowledge and control, it is essential that the user evaluate the 3M product to determine whether it is fit for a particular purpose and suitable for user's method of use or application.

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Document Group:	29-7186-9	Version Number:	3.00
Issue Date:	12/15/17	Supersedes Date:	11/21/17

SECTION 1: Identification

1.1. Product identifier

3M™ Scotch-Weld™ Epoxy Adhesive EC-1838 B/A Green, Part A

Product Identification Numbers

LC-B100-0987-2, LC-B100-0987-3

1.2. Recommended use and restrictions on use

Recommended use

Accelerator for two-component adhesive

1.3. Supplier's details

MANUFACTURER:	3M
DIVISION:	Automotive and Aerospace Solutions Division
ADDRESS:	3M Center, St. Paul, MN 55144-1000, USA
Telephone:	1-888-3M HELPS (1-888-364-3577)

1.4. Emergency telephone number

1-800-364-3577 or (651) 737-6501 (24 hours)

SECTION 2: Hazard identification

2.1. Hazard classification

Serious Eye Damage/Irritation: Category 1.

Skin Corrosion/Irritation: Category 2.

Skin Sensitizer: Category 1.

Specific Target Organ Toxicity (repeated exposure): Category 1.

2.2. Label elements

Signal word

Danger

Symbols

Corrosion | Exclamation mark | Health Hazard |

Pictograms

**Hazard Statements**

Causes serious eye damage.

Causes skin irritation.

May cause an allergic skin reaction.

Causes damage to organs through prolonged or repeated exposure:
respiratory system |

Precautionary Statements**Prevention:**

Do not breathe dust/fume/gas/mist/vapors/spray.

Wear protective gloves and eye/face protection.

Do not eat, drink or smoke when using this product.

Wash thoroughly after handling.

Contaminated work clothing must not be allowed out of the workplace.

Response:

IF IN EYES: Rinse cautiously with water for several minutes. Remove contact lenses, if present and easy to do. Continue rinsing.

IF ON SKIN: Wash with plenty of soap and water.

If skin irritation or rash occurs: Get medical advice/attention.

Take off contaminated clothing and wash it before reuse.

Get medical advice/attention if you feel unwell.

Disposal:

Dispose of contents/container in accordance with applicable local/regional/national/international regulations.

SECTION 3: Composition/information on ingredients

Ingredient	C.A.S. No.	% by Wt
Polyamide Resin	68410-23-1	75 - 85 Trade Secret *
Kaolin	1332-58-7	10 - 20 Trade Secret *
Amorphous Silica	112945-52-5	3 - 7
Chromium Oxide	1308-38-9	< 1

*The specific chemical identity and/or exact percentage (concentration) of this composition has been withheld as a trade secret.

SECTION 4: First aid measures**4.1. Description of first aid measures****Inhalation:**

Remove person to fresh air. If you feel unwell, get medical attention.

Skin Contact:

Immediately wash with soap and water. Remove contaminated clothing and wash before reuse. If signs/symptoms

develop, get medical attention.

Eye Contact:

Immediately flush with large amounts of water for at least 15 minutes. Remove contact lenses if easy to do. Continue rinsing. Immediately get medical attention.

If Swallowed:

Rinse mouth. If you feel unwell, get medical attention.

4.2. Most important symptoms and effects, both acute and delayed

See Section 11.1. Information on toxicological effects.

4.3. Indication of any immediate medical attention and special treatment required

Not applicable

SECTION 5: Fire-fighting measures

5.1. Suitable extinguishing media

In case of fire: Use a fire fighting agent suitable for ordinary combustible material such as water or foam to extinguish.

5.2. Special hazards arising from the substance or mixture

None inherent in this product.

Hazardous Decomposition or By-Products

Substance

Amine Compounds
Carbon monoxide
Carbon dioxide
Oxides of Nitrogen

Condition

During Combustion
During Combustion
During Combustion
During Combustion

5.3. Special protective actions for fire-fighters

No special protective actions for fire-fighters are anticipated.

SECTION 6: Accidental release measures

6.1. Personal precautions, protective equipment and emergency procedures

Evacuate area. Ventilate the area with fresh air. For large spill, or spills in confined spaces, provide mechanical ventilation to disperse or exhaust vapors, in accordance with good industrial hygiene practice.

6.2. Environmental precautions

Avoid release to the environment. For larger spills, cover drains and build dikes to prevent entry into sewer systems or bodies of water.

6.3. Methods and material for containment and cleaning up

Contain spill. Working from around the edges of the spill inward, cover with bentonite, vermiculite, or commercially available inorganic absorbent material. Mix in sufficient absorbent until it appears dry. Remember, adding an absorbent material does not remove a physical, health, or environmental hazard. Collect as much of the spilled material as possible. Place in a closed container approved for transportation by appropriate authorities. Clean up residue with an appropriate solvent selected by a qualified and authorized person. Ventilate the area with fresh air. Read and follow safety precautions on the solvent label and SDS. Seal the container. Dispose of collected material as soon as possible in accordance with applicable local/regional/national/international regulations.

SECTION 7: Handling and storage

7.1. Precautions for safe handling

Avoid breathing of dust created by cutting, sanding, grinding or machining. Do not breathe dust/fume/gas/mist/vapors/spray. Do not get in eyes, on skin, or on clothing. Do not eat, drink or smoke when using this product. Wash thoroughly after handling. Contaminated work clothing should not be allowed out of the workplace. Avoid release to the environment. Wash contaminated clothing before reuse. Avoid contact with oxidizing agents (eg. chlorine, chromic acid etc.)

7.2. Conditions for safe storage including any incompatibilities

Store away from oxidizing agents.

SECTION 8: Exposure controls/personal protection**8.1. Control parameters****Occupational exposure limits**

If a component is disclosed in section 3 but does not appear in the table below, an occupational exposure limit is not available for the component.

Ingredient	C.A.S. No.	Agency	Limit type	Additional Comments
SILICA, AMORPHOUS	112945-52-5	OSHA	TWA concentration:0.8 mg/m ³ ;TWA:20 millions of particles/cu. ft.	
CHROMIUM (III) COMPOUNDS	1308-38-9	ACGIH	TWA(as Cr):0.5 mg/m ³	A4: Not class. as human carcin
CHROMIUM (III) COMPOUNDS	1308-38-9	OSHA	TWA(as Cr):0.5 mg/m ³	
Chromium, insoluble salts	1308-38-9	OSHA	TWA(as Cr):1 mg/m ³	
Kaolin	1332-58-7	ACGIH	TWA(respirable fraction):2 mg/m ³	A4: Not class. as human carcin
KAOLIN, TOTAL DUST	1332-58-7	OSHA	TWA(as total dust):15 mg/m ³ ;TWA(respirable fraction):5 mg/m ³	

ACGIH : American Conference of Governmental Industrial Hygienists

AIHA : American Industrial Hygiene Association

CMRG : Chemical Manufacturer's Recommended Guidelines

OSHA : United States Department of Labor - Occupational Safety and Health Administration

TWA: Time-Weighted-Average

STEL: Short Term Exposure Limit

CEIL: Ceiling

8.2. Exposure controls**8.2.1. Engineering controls**

Use general dilution ventilation and/or local exhaust ventilation to control airborne exposures to below relevant Exposure Limits and/or control dust/fume/gas/mist/vapors/spray. If ventilation is not adequate, use respiratory protection equipment.

8.2.2. Personal protective equipment (PPE)**Eye/face protection**

Select and use eye/face protection to prevent contact based on the results of an exposure assessment. The following eye/face protection(s) are recommended:

Full Face Shield

Indirect Vented Goggles

Skin/hand protection

Select and use gloves and/or protective clothing approved to relevant local standards to prevent skin contact based on the results of an exposure assessment. Selection should be based on use factors such as exposure levels, concentration of the substance or mixture, frequency and duration, physical challenges such as temperature extremes, and other use conditions. Consult with your glove and/or protective clothing manufacturer for selection of appropriate compatible gloves/protective clothing. Note: Nitrile gloves may be worn over polymer laminate gloves to improve dexterity. Gloves made from the following material(s) are recommended: Polymer laminate

If this product is used in a manner that presents a higher potential for exposure (eg. spraying, high splash potential etc.), then use of protective coveralls may be necessary. Select and use body protection to prevent contact based on the results of an exposure assessment. The following protective clothing material(s) are recommended: Apron - polymer laminate

Respiratory protection

An exposure assessment may be needed to decide if a respirator is required. If a respirator is needed, use respirators as part of a full respiratory protection program. Based on the results of the exposure assessment, select from the following respirator type(s) to reduce inhalation exposure:

Half facepiece or full facepiece air-purifying respirator suitable for organic vapors and particulates

For questions about suitability for a specific application, consult with your respirator manufacturer.

SECTION 9: Physical and chemical properties

9.1. Information on basic physical and chemical properties

General Physical Form:	Liquid
Specific Physical Form:	Paste
Odor, Color, Grade:	Green, Slight Amine Odor
Odor threshold	<i>No Data Available</i>
pH	<i>No Data Available</i>
Melting point	<i>Not Applicable</i>
Boiling Point	>=250 °F
Flash Point	>=200 °F [<i>Test Method</i> :Closed Cup]
Evaporation rate	<i>Not Applicable</i>
Flammability (solid, gas)	Not Applicable
Flammable Limits(LEL)	<i>No Data Available</i>
Flammable Limits(UEL)	<i>No Data Available</i>
Vapor Pressure	<i>Not Applicable</i>
Vapor Density	<i>Not Applicable</i>
Density	1.04 g/cm ³
Specific Gravity	1.04 [<i>Ref Std</i> :WATER=1]
Solubility in Water	Nil
Solubility- non-water	<i>No Data Available</i>
Partition coefficient: n-octanol/ water	<i>No Data Available</i>
Autoignition temperature	<i>No Data Available</i>
Decomposition temperature	<i>No Data Available</i>
Viscosity	3,000 - 10,000 poise [<i>@</i> 73.4 °F]
Hazardous Air Pollutants	0.9 % weight [<i>Test Method</i> :Calculated]
Volatile Organic Compounds	48 g/l [<i>Test Method</i> :tested per EPA method 24] [<i>Details</i> :EU VOC content]
Percent volatile	0 - 5 % weight
VOC Less H₂O & Exempt Solvents	48 g/l [<i>Test Method</i> :tested per EPA method 24]
VOC Less H₂O & Exempt Solvents	3.4 g/l [<i>Test Method</i> :tested per EPA method 24] [<i>Details</i> :when used as intended with Part B]

SECTION 10: Stability and reactivity

10.1. Reactivity

This material is considered to be non reactive under normal use conditions.

10.2. Chemical stability

Stable.

10.3. Possibility of hazardous reactions

Hazardous polymerization will not occur.

10.4. Conditions to avoid

Heat is generated during cure. Do not cure a mass larger than 50 grams in a confined space to prevent a premature exothermic reaction with production of intense heat and smoke.

10.5. Incompatible materials

Strong oxidizing agents

10.6. Hazardous decomposition products

<u>Substance</u>	<u>Condition</u>
None known.	

Refer to section 5.2 for hazardous decomposition products during combustion.

SECTION 11: Toxicological information

The information below may not be consistent with the material classification in Section 2 if specific ingredient classifications are mandated by a competent authority. In addition, toxicological data on ingredients may not be reflected in the material classification and/or the signs and symptoms of exposure, because an ingredient may be present below the threshold for labeling, an ingredient may not be available for exposure, or the data may not be relevant to the material as a whole.

11.1. Information on Toxicological effects

Signs and Symptoms of Exposure

Based on test data and/or information on the components, this material may produce the following health effects:

Inhalation:

Respiratory Tract Irritation: Signs/symptoms may include cough, sneezing, nasal discharge, headache, hoarseness, and nose and throat pain.

May cause additional health effects (see below).

Skin Contact:

Skin Irritation: Signs/symptoms may include localized redness, swelling, itching, dryness, cracking, blistering, and pain.
Allergic Skin Reaction (non-photo induced): Signs/symptoms may include redness, swelling, blistering, and itching.

Eye Contact:

Corrosive (Eye Burns): Signs/symptoms may include cloudy appearance of the cornea, chemical burns, severe pain, tearing, ulcerations, significantly impaired vision or complete loss of vision.

Ingestion:

Gastrointestinal Irritation: Signs/symptoms may include abdominal pain, stomach upset, nausea, vomiting and diarrhea.

Additional Health Effects:**Prolonged or repeated exposure may cause target organ effects:**

Pneumoconiosis: Sign/symptoms may include persistent cough, breathlessness, chest pain, increased amounts of sputum, and changes in lung function tests.

Toxicological Data

If a component is disclosed in section 3 but does not appear in a table below, either no data are available for that endpoint or the data are not sufficient for classification.

Acute Toxicity

Name	Route	Species	Value
Overall product	Ingestion		No data available; calculated ATE >5,000 mg/kg
Polyamide Resin	Dermal	Rat	LD50 > 2,000 mg/kg
Polyamide Resin	Ingestion	Rat	LD50 > 2,000 mg/kg
Kaolin	Dermal		LD50 estimated to be > 5,000 mg/kg
Kaolin	Ingestion	Human	LD50 > 15,000 mg/kg
Amorphous Silica	Dermal	Rabbit	LD50 > 5,000 mg/kg
Amorphous Silica	Inhalation-Dust/Mist (4 hours)	Rat	LC50 > 0.691 mg/l
Amorphous Silica	Ingestion	Rat	LD50 > 5,110 mg/kg
Chromium Oxide	Dermal	Professional judgment	LD50 estimated to be > 5,000 mg/kg
Chromium Oxide	Inhalation-Dust/Mist (4 hours)	Rat	LC50 > 5.41 mg/l
Chromium Oxide	Ingestion	Rat	LD50 > 5,000 mg/kg

ATE = acute toxicity estimate

Skin Corrosion/Irritation

Name	Species	Value
Polyamide Resin	similar compounds	Irritant
Kaolin	Professional judgment	No significant irritation
Amorphous Silica	Rabbit	No significant irritation
Chromium Oxide	Rabbit	No significant irritation

Serious Eye Damage/Irritation

Name	Species	Value
Polyamide Resin	similar compounds	Corrosive
Kaolin	Professional judgment	No significant irritation
Amorphous Silica	Rabbit	No significant irritation
Chromium Oxide	Rabbit	No significant irritation

Skin Sensitization

Name	Species	Value
Polyamide Resin	Mouse	Sensitizing
Amorphous Silica	Human	Not classified

	and animal	
Chromium Oxide	similar compounds	Not classified

Respiratory Sensitization

For the component/components, either no data are currently available or the data are not sufficient for classification.

Germ Cell Mutagenicity

Name	Route	Value
Amorphous Silica	In Vitro	Not mutagenic
Chromium Oxide	In vivo	Not mutagenic
Chromium Oxide	In Vitro	Some positive data exist, but the data are not sufficient for classification

Carcinogenicity

Name	Route	Species	Value
Kaolin	Inhalation	Multiple animal species	Not carcinogenic
Amorphous Silica	Not Specified	Mouse	Some positive data exist, but the data are not sufficient for classification
Chromium Oxide	Ingestion	Rat	Not carcinogenic

Reproductive Toxicity

Reproductive and/or Developmental Effects

Name	Route	Value	Species	Test Result	Exposure Duration
Amorphous Silica	Ingestion	Not classified for female reproduction	Rat	NOAEL 509 mg/kg/day	1 generation
Amorphous Silica	Ingestion	Not classified for male reproduction	Rat	NOAEL 497 mg/kg/day	1 generation
Amorphous Silica	Ingestion	Not classified for development	Rat	NOAEL 1,350 mg/kg/day	during organogenesis
Chromium Oxide	Ingestion	Not classified for female reproduction	Rat	NOAEL 2,000 mg/kg/day	90 days
Chromium Oxide	Ingestion	Not classified for male reproduction	Rat	NOAEL 2,000 mg/kg/day	90 days
Chromium Oxide	Ingestion	Not classified for development	Rat	NOAEL 2,000 mg/kg/day	90 days

Target Organ(s)

Specific Target Organ Toxicity - single exposure

Name	Route	Target Organ(s)	Value	Species	Test Result	Exposure Duration
Polyamide Resin	Inhalation	respiratory irritation	Some positive data exist, but the data are not sufficient for classification	similar health hazards	NOAEL Not available	
Chromium Oxide	Inhalation	respiratory system	Not classified	Rat	NOAEL 40 mg	

Specific Target Organ Toxicity - repeated exposure

Name	Route	Target Organ(s)	Value	Species	Test Result	Exposure Duration
Kaolin	Inhalation	pneumoconiosis	Causes damage to organs through prolonged or repeated exposure	Human	NOAEL NA	occupational exposure
Kaolin	Inhalation	pulmonary fibrosis	Not classified	Rat	NOAEL Not available	

Amorphous Silica	Inhalation	respiratory system silicosis	Not classified	Human	NOAEL Not available	occupational exposure
Chromium Oxide	Inhalation	immune system respiratory system hematopoietic system liver kidney and/or bladder	Not classified	Rat	NOAEL 44 mg/m3	90 days

Aspiration Hazard

For the component/components, either no data are currently available or the data are not sufficient for classification.

Please contact the address or phone number listed on the first page of the SDS for additional toxicological information on this material and/or its components.

SECTION 12: Ecological information**Ecotoxicological information**

Please contact the address or phone number listed on the first page of the SDS for additional ecotoxicological information on this material and/or its components.

Chemical fate information

Please contact the address or phone number listed on the first page of the SDS for additional chemical fate information on this material and/or its components.

SECTION 13: Disposal considerations**13.1. Disposal methods**

Dispose of contents/ container in accordance with the local/regional/national/international regulations.

Dispose of completely cured (or polymerized) material in a permitted industrial waste facility. As a disposal alternative, incinerate uncured product in a permitted waste incineration facility. Proper destruction may require the use of additional fuel during incineration processes. If no other disposal options are available, waste product that has been completely cured or polymerized may be placed in a landfill properly designed for industrial waste. Empty drums/barrels/containers used for transporting and handling hazardous chemicals (chemical substances/mixtures/preparations classified as Hazardous as per applicable regulations) shall be considered, stored, treated & disposed of as hazardous wastes unless otherwise defined by applicable waste regulations. Consult with the respective regulating authorities to determine the available treatment and disposal facilities.

EPA Hazardous Waste Number (RCRA): Not regulated

SECTION 14: Transport Information

For Transport Information, please visit <http://3M.com/Transportinfo> or call 1-800-364-3577 or 651-737-6501.

SECTION 15: Regulatory information**15.1. US Federal Regulations**

Contact 3M for more information.

EPCRA 311/312 Hazard Classifications:**Physical Hazards**

Not applicable

Health Hazards

Serious eye damage or eye irritation

Skin Corrosion or Irritation

Specific target organ toxicity (single or repeated exposure)

15.2. State Regulations

Contact 3M for more information.

15.3. Chemical Inventories

The components of this product are in compliance with the chemical notification requirements of TSCA.

Contact 3M for more information.

15.4. International Regulations

Contact 3M for more information.

This SDS has been prepared to meet the U.S. OSHA Hazard Communication Standard, 29 CFR 1910.1200.

SECTION 16: Other information

NFPA Hazard Classification

Health: 2 **Flammability:** 0 **Instability:** 1 **Special Hazards:** None

National Fire Protection Association (NFPA) hazard ratings are designed for use by emergency response personnel to address the hazards that are presented by short-term, acute exposure to a material under conditions of fire, spill, or similar emergencies. Hazard ratings are primarily based on the inherent physical and toxic properties of the material but also include the toxic properties of combustion or decomposition products that are known to be generated in significant quantities.

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