SECTION 1: Identification

Product identifiers:

- **Product trade name:** EPALLOY* 8250
- **Company product number:** 8250
- **Other means of identification:** BPFDGE, Epoxy phenol novolac resin

Recommended use of the chemical and restrictions on use:

- **Uses:** Epoxy resin
- **Restrictions on use:** None identified

Details of the supplier:

- **Manufacturer/Supplier:** CVC Thermoset Specialties
  2980 Route 73 North
  Maple Shade, New Jersey 08052 United States
  Customer service telephone: +1-856-533-3000

  
  **For further information about this SDS:** Email: cts.customerservice@huntsman.com

Emergency telephone number:

  ChemTel (24 hours): 1-800-255-3924 (USA); +1-813-248-0585 (outside USA);
  1-300-954-583 (Australia); 000-800-100-4086 (India).

SECTION 2: Hazard(s) identification

Classification of the substance or mixture:

- Skin Irritation, category 2, H315
- Skin Sensitizer, category 1, H317
- Hazardous to the aquatic environment, Acute, category 2, H401
- Hazardous to the aquatic environment, Chronic, category 2, H411

Label elements:

- **Hazard pictogram(s):**

  ![Warning](image)
  ![Skin Irritation](image)

- **Signal word:** Warning

  **Hazard statements:**
  - H315 Causes skin irritation.
  - H317 May cause an allergic skin reaction.
  - H401 Toxic to aquatic life.
  - H411 Toxic to aquatic life with long lasting effects.

  **Precautionary statements:**
  - P261 Avoid breathing dust/fume/gas/mist/vapours/spray.
  - P264 Wash skin thoroughly after handling.
  - P272 Contaminated work clothing should not be allowed out of the workplace.
  - P273 Avoid release to the environment.
  - P280 Wear protective gloves.
  - P302+P352 IF ON SKIN: Wash with plenty of soap and water.
  - P333+P313 If skin irritation or rash occurs: Get medical advice/attention.
  - P362+P364 Take off contaminated clothing and wash it before reuse.
SECTION 3: Composition/information on ingredients

Substance:

<table>
<thead>
<tr>
<th>CAS-No.</th>
<th>Chemical Name</th>
<th>Weight%</th>
</tr>
</thead>
<tbody>
<tr>
<td>0028064-14-4</td>
<td>Epoxy phenol novolac resin (BPFDGE)</td>
<td>99-100</td>
</tr>
</tbody>
</table>

Notes: EPOXY PHENOL NOVOLAC RESIN (BPFDGE): Reaction mass of 2,2'-[methylenebis(2,1-phenyleneoxymethylene)] bis(oxirane) and 2,2'-[methylenebis(4,1-phenyleneoxymethylene)] bis(oxirane) and 2-([2-[4-(oxiran-2-ylmethoxy)benzyl] phenoxy]methyl)oxirane).

Amounts specified are typical and do not represent a specification. Remaining components are proprietary, non-hazardous, and/or present at amounts below reportable limits.

SECTION 4: First-aid measures

Description of first aid measures:

General: If irritation or other symptoms occur or persist from any route of exposure, remove the affected individual from the area: see a physician/get medical attention.

Eye contact: Any material that contacts the eye should be washed out immediately with water. Get medical attention if symptoms occur.

Skin contact: Immediately remove contaminated clothing and shoes. Wash the affected area with plenty of soap and water until no evidence of the chemical remains (at least 15-20 minutes). Launder clothing before reuse. If skin irritation occurs: Get medical advice/attention.

Inhalation: If affected, remove to fresh air. If breathing is difficult, give oxygen. If not breathing, give artificial respiration. Call a POISON CENTER or doctor/physician if you feel unwell.

Ingestion: Do not induce vomiting. Never give anything by mouth to an unconscious person. Rinse out the mouth with water. Get medical attention immediately.

Protection of first aid responders: Wear proper personal protective clothing and equipment.

Most important symptoms and effects, both acute and delayed: Irritation. Pre-existing skin problems may be aggravated by prolonged or repeated contact. See section 11 for additional information.

Indication of any immediate medical attention and special treatment needed, if necessary: Treat symptomatically.

SECTION 5: Fire-fighting measures

Extinguishing media:

Suitable: Use water spray, ABC dry chemical, foam or carbon dioxide. Water or foam may cause frothing. Use water to keep fire-exposed containers cool. Water spray may be used to flush spills away from exposures.

Unsuitable: None known.

Special hazards arising From the chemical:

Unusual fire/explosion hazards: Product is not considered a fire hazard, but will burn if ignited. Closed container may rupture (due to build up in pressure) when exposed to extreme heat.

Hazardous combustion products: Irritating or toxic substances may be emitted upon burning, combustion or decomposition. See section 10 (Hazardous decomposition products) for additional information.
Special protective equipment and precautions for fire-fighters: Wear self-contained breathing apparatus (SCBA) equipped with a full facepiece and operated in a pressure-demand mode (or other positive pressure mode) and approved protective clothing. Personnel without suitable respiratory protection must leave the area to prevent significant exposure to hazardous gases from combustion, burning or decomposition. In an enclosed or poorly ventilated area, wear SCBA during cleanup immediately after a fire as well as during the attack phase of firefighting operations.

See section 9 for additional information.

SECTION 6: Accidental release measures

Personal precautions, protective equipment and emergency procedures: See Section 8 for recommendations on the use of personal protective equipment. If spilled in an enclosed area, ventilate. Eliminate ignition sources. Personal Protective Equipment must be worn.

Environmental precautions: Do not flush liquid into public sewer, water systems or surface waters.

Methods and materials for containment and cleaning up: Contain by diking with sand, earth or other non-combustible material. Wear proper personal protective clothing and equipment. Absorb spill with an inert material. Place into labeled, closed container; store in safe location to await disposal. Change contaminated clothing and launder before reuse. Eliminate ignition sources.

SECTION 7: Handling and storage

Precautions for safe handling: As with any chemical product, use good laboratory/workplace procedures. Do not cut, puncture, or weld on or near the container. Wash thoroughly after handling this product. Always wash up before eating, smoking or using the facilities. Use under well-ventilated conditions. Avoid eye and skin contact. Avoid inhalation of aerosol, mist, spray, fume or vapor. Avoid drinking, tasting, swallowing or ingesting this product. Wash contaminated clothing before reuse. Discard shoes contaminated with this product. Provide eyewash fountains and safety showers in the work area.

Conditions for safe storage, including any incompatibilities: Store cool and dry, under well-ventilated conditions. Keep away from heat, sparks and open flames. Store this material away from incompatible substances (see section 10). Do not store in open, unlabeled or mislabeled containers. Keep container closed when not in use. Do not reuse empty container without commercial cleaning or reconditioning. Empty container contains residual product which may exhibit hazards of product.

SECTION 8: Exposure controls / personal protection

Control parameters:

Occupational exposure limits (OEL):

<table>
<thead>
<tr>
<th>Chemical Name</th>
<th>ACGIH - TWA/Ceiling</th>
<th>ACGIH - STEL</th>
</tr>
</thead>
<tbody>
<tr>
<td>Epoxy phenol novolac resin (BPFDGE)</td>
<td>N/E</td>
<td>N/E</td>
</tr>
<tr>
<td>Epoxy phenol novolac resin (BPFDGE)</td>
<td>N/E</td>
<td>N/E</td>
</tr>
<tr>
<td>Epoxy phenol novolac resin (BPFDGE)</td>
<td>N/E</td>
<td>N/E</td>
</tr>
<tr>
<td>Epoxy phenol novolac resin (BPFDGE)</td>
<td>N/E</td>
<td>N/E</td>
</tr>
</tbody>
</table>

N/E=Not established (no exposure limits established for the listed substances for listed country/region/organization).

Exposure controls:

Appropriate engineering controls: Always provide effective general and, when necessary, local exhaust ventilation to draw spray, aerosol, fume, mist and vapor away from workers to prevent routine inhalation. Ventilation must be adequate to maintain the ambient workplace atmosphere below the exposure limit(s) outlined in the SDS.

Individual protection measures, such as personal protective equipment:

Eye/face protection: Wear eye protection.

Skin and body protection: Wear chemical resistant (impervious) gloves. Wear chemical resistant protective clothing. Use good laboratory/workplace procedures including personal protective clothing: labcoat, safety glasses and protective gloves.

Respiratory protection: Wear an approved respirator (e.g., an organic vapor respirator, a full face air purifying respirator for organic vapors, or a self-contained breathing apparatus) whenever exposure to aerosol, mist, spray, fume or vapor
SECTION 9: Physical and chemical properties

Form: Viscous liquid
Appearance: Clear, Pale yellow
Odor: Slight aromatic
pH: Not Available
Relative density: 1.20
Partition coefficient (n-octanol/water): 3.6
Odor threshold: Not Available
% Volatile by weight: Not Available
Solubility in water: Negligible
Evaporation rate: Not Available
Vapor pressure: <1 mm Hg @ 20°C
Vapor density: Heavier than air
Viscosity: 18000-28000 cps @ 25°C
Melting point/Freezing point: Not Available
Flash point: >200 °C (>392 °F) Setaflash (Closed Tester)
Auto-Ignition temperature: Not Available
Flammability (solid, gas): Not Applicable (liquid)
Flammability or explosive limits: LFL/LEL: Not Available
UFL/UEL: Not Available
Surface tension: Not Available

Other information: Amounts specified are typical and do not represent a specification.

SECTION 10: Stability and reactivity

Reactivity: Exothermic reactions including polymerization may occur in contact with amines, strong acids, strong bases, alcohols, strong oxidizing agents and excessive heat.

Chemical stability: This product is stable.

Possibility of hazardous reactions: Hazardous polymerization will occur. This product will autopolymerize at very high temperatures.

Conditions to avoid: Excessive heat and ignition sources.

Incompatible materials: Avoid strong acids, bases, and oxidizing agents. Avoid contact with amines.

Hazardous decomposition products: Thermal decomposition may produce smoke, carbon monoxide, carbon dioxide, aldehydes and other products of incomplete combustion. Phenolics.

SECTION 11: Toxicological information

Information on likely routes of exposure:

General: Caution must be exercised through the prudent use of protective equipment and handling procedures to minimize exposure.

Eyes: May cause eye irritation.

Skin: May cause allergic skin reaction. Causes skin irritation.

Inhalation: High airborne concentrations of vapors resulting from heating, misting or spraying may cause irritation of the respiratory tract and mucous membranes.

Ingestion: Ingestion may cause irritation.

Acute toxicity information: Not classified (based on available data, the classification criteria are not met).
**SDS Name: EPALLOY* 8250**

### Inhalation LC50
**Chemical Name**: Epoxy phenol novolac resin (BPFDGE)  
**Species**: N/E

### Oral LD50
**Species**: Rat/ adult  
**LD50**: >5000 mg/kg

### Dermal LD50
**Species**: Rat/ adult  
**LD50**: >2000 mg/kg

### Skin corrosion/irritation:
**Chemical Name**: Epoxy phenol novolac resin (BPFDGE)  
**Species**: Rabbit/ adult  
**Skin irritation**: Irritant  
**Category**: 2

### Serious eye damage/irritation:
**Chemical Name**: Epoxy phenol novolac resin (BPFDGE)  
**Species**: Rabbit/ adult  
**Eye irritation**: Non-irritant (OECD 405)

### Respiratory or skin sensitization:
**Chemical Name**: Epoxy phenol novolac resin (BPFDGE)  
**Species**: Local Lymph Node Assay (OECD 429)  
**Skin sensitisation**: Sensitizer  
**Category**: 1

### Carcinogenicity:
**Chemical Name**: Epoxy phenol novolac resin (BPFDGE)  
**Species**: Not classified (no relevant information found)

### Germ cell mutagenicity:
**Chemical Name**: EPOXY PHENOL NOVOLAC RESIN (BPFDGE)  
**Species**: Mutagenicity was negative in multiple in-vivo genotoxicity assays. Mutagenicity was positive in several in-vitro genotoxicity assays.

### Reproductive toxicity:
**Chemical Name**: EPOXY PHENOL NOVOLAC RESIN (BPFDGE)-READ-ACROSS  
**Species**: Reproductive toxicity, oral study in rats: NOAEL (no-observed-adverse-effect-level) of 750 mg/kg bw/day. Developmental toxicity: oral, rat - NOAEL of 180 mg/kg bw/day; dermal, rabbit - NOAEL of 300 mg/kg bw/day.

### Specific target organ toxicity (STOT) - single exposure:
**Chemical Name**: EPOXY PHENOL NOVOLAC RESIN (BPFDGE)  
**Species**: Not classified (based on available data, the classification criteria are not met).

### Specific target organ toxicity (STOT) - repeated exposure:
**Chemical Name**: EPOXY PHENOL NOVOLAC RESIN (BPFDGE)  
**Species**: Repeated dose study, 90 day gavage, rat: NOAEL (no-observed-adverse-effect-level)=250 mg/kg bw/day.

### Aspiration hazard:
**Chemical Name**: Not classified (based on available data, the classification criteria are not met).

### Other toxicity information:
**Chemical Name**: No additional information available.

---

### SECTION 12: Ecological information

#### Ecotoxicity:

<table>
<thead>
<tr>
<th>Chemical Name</th>
<th>Species</th>
<th>Acute</th>
<th>Chronic</th>
</tr>
</thead>
<tbody>
<tr>
<td>Epoxy phenol novolac resin (BPFDGE)</td>
<td>Fish</td>
<td>LC50 2.54 mg/L (96 hours)</td>
<td>N/E</td>
</tr>
<tr>
<td>Epoxy phenol novolac resin (BPFDGE)</td>
<td>Invertebrates</td>
<td>EC50 2.55 mg/L (48 hours) (weight of evidence)</td>
<td>NOEC 0.3 mg/L (21 days) (similar materials)</td>
</tr>
<tr>
<td>Epoxy phenol novolac resin (BPFDGE)</td>
<td>Algae</td>
<td>EC50 &gt;1.8 mg/L (72 hours)</td>
<td>N/E</td>
</tr>
<tr>
<td>Epoxy phenol novolac resin (BPFDGE)</td>
<td>Micro-organisms</td>
<td>IC50 &gt;100 mg/L (3 hours) (similar materials)</td>
<td></td>
</tr>
</tbody>
</table>

#### Persistence and degradability:

**Chemical Name**: Epoxy phenol novolac resin (BPFDGE)  
**Biodegradation**: Not readily biodegradable

#### Bioaccumulative potential:

**Chemical Name**: Epoxy phenol novolac resin (BPFDGE)  
**Bioconcentration Factor (BCF)**: 150 L/kg (calculated)  
**Bioconcentration Factor (BCF)**: 3.6 (OECD 117)

### Mobility in soil:

**Chemical Name**: Epoxy phenol novolac resin (BPFDGE)  
**Mobility in soil (Koc/Kow)**: 4460 (OECD 121)

### Other adverse effects:
**Chemical Name**: No additional information available.

---

### SECTION 13: Disposal considerations
SDS Name: EPALLOY* 8250

Dispose of unused contents (incineration) in accordance with national and local regulations. Dispose of container in accordance with national and local regulations. Ensure the use of properly authorized waste management companies, where appropriate.

See Section 8 for recommendations on the use of personal protective equipment.

## SECTION 14: Transport information

The information below is provided to assist in documentation. It may supplement the information on the package. The package in your possession may carry a different version of the label depending on the date of manufacture. Depending on inner packaging quantities and packaging instructions, it may be subject to specific regulatory exceptions.

**UN number:** UN3082

**UN proper shipping name:** Environmentally hazardous substance, liquid, n.o.s. (Epoxy phenol novolac resin)

**Transport hazard class(es):**
- U.S. DOT hazard class: N/A
- Canada TDG hazard class: N/A
- Europe ADR/RID hazard class: 9
- IMDG Code (ocean) hazard class: 9
- ICAO/IATA (air) hazard class: 9

A "N/A" listing for the hazard class indicates the product is not regulated for transport by that regulation.

**Packing group:** III

**Environmental hazards:**
- Marine pollutant: Marine Pollutant (IMDG code 2.9.3).
- Hazardous substance (USA): Not Applicable

**Special precautions for user:** Not Applicable

**Transport in bulk according to Annex II of MARPOL 73/78 and the IBC code:** Not Applicable

**Notes:** For surface shipments within the United States: Not regulated.

## SECTION 15: Regulatory information

Safety, health and environmental regulations specific for the product in question:

### Japan regulations:

- **Japan Industrial Safety and Health Law:**
  - Chemical name
  - Category
  - No subject chemicals

- **Japan Fire Service Law:**
  - Chemical name
  - Category
  - No subject chemicals

- **Japan Poisonous and Deleterious Substances:**
  - Chemical name
  - Category
  - No subject chemicals

- **Japan Prevention of Marine Pollution and Disaster:**
  - Chemical name
  - Category
  - No subject chemicals

- **Japan Chemical Substances Control Law:**
  - Chemical name
  - Category
  - Notes
  - No subject chemicals

### Korean regulations:

- **Korea Industrial Safety and Health Act:**
  - Chemical name
  - Category
  - Threshold
  - No subject chemicals

- **Korea Act on Registration and Evaluation of Chemical Substances (K-REACH) - Substances subject to registration:**
  - No subject chemicals

- **Korea Chemical Control Act (CCA):**
  - Chemical name
  - Category
  - Code
  - Threshold
  - No subject chemicals
Korea Safety Control of Dangerous Substances Act (MPSS):

<table>
<thead>
<tr>
<th>Chemical name</th>
<th>Class</th>
<th>Threshold</th>
</tr>
</thead>
<tbody>
<tr>
<td>No subject chemicals</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

Korea Waste Control Act: Waste disposal methods must comply with local and national laws.

<table>
<thead>
<tr>
<th>Chemical name</th>
<th>Notes</th>
</tr>
</thead>
<tbody>
<tr>
<td>No subject chemicals</td>
<td></td>
</tr>
</tbody>
</table>

Other regulations: No Additional Information

Chemical inventories:

<table>
<thead>
<tr>
<th>Regulation</th>
<th>Status</th>
</tr>
</thead>
<tbody>
<tr>
<td>Australian Inventory of Chemical Substances (AICS):</td>
<td>Y</td>
</tr>
<tr>
<td>Canadian Domestic Substances List (DSL):</td>
<td>Y</td>
</tr>
<tr>
<td>Canadian Non-Domestic Substances List (NDSSL):</td>
<td>N</td>
</tr>
<tr>
<td>China Inventory of Existing Chemical Substances (IECSC):</td>
<td>Y</td>
</tr>
<tr>
<td>European EC Inventory (EINECS, ELINCS, NLP):</td>
<td>Y</td>
</tr>
<tr>
<td>Japan Existing and New Chemical Substances (ENCS):</td>
<td>Y</td>
</tr>
<tr>
<td>Japan Industrial Safety and Health Law (ISHL):</td>
<td>Y</td>
</tr>
<tr>
<td>Korean Existing and Evaluated Chemical Substances (KECL):</td>
<td>Y</td>
</tr>
<tr>
<td>New Zealand Inventory of Chemicals (NZIoC):</td>
<td>Y</td>
</tr>
<tr>
<td>Philippines Inventory of Chemicals and Chemical Substances (PICCS):</td>
<td>Y</td>
</tr>
<tr>
<td>Taiwan Inventory of Existing Chemicals:</td>
<td>Y</td>
</tr>
<tr>
<td>U.S. Toxic Substances Control Act (TSCA) (Active):</td>
<td>Y</td>
</tr>
</tbody>
</table>

A "Y" listing indicates all intentionally added components are either listed or are otherwise compliant with the regulation. A "N" listing indicates that for one or more components: 1) there is no listing on the public inventory (or is not on the ACTIVE inventory for U.S. TSCA); 2) no information is available; or 3) the component has not been reviewed. A "Y" for New Zealand may mean that a qualified group standard may exist for the components in this product.

Chemical inventory notes: New Zealand: One or more components may be covered by a group standard.

Europe REACh (EC) 1907/2006: Applicable components are registered, exempt or otherwise compliant. For Europe REACh, Reaction mass of 2,2'-(methylenebis(2,1-phenyleneoxymethylene)) bis(oxirane) and 2,2'-[methylenebis(4,1-phenyleneoxymethylene)] bis(oxirane) and 2-((2-[4-(oxiran-2-yldimethylenebenzyloxy)aminomethyl]phenoxyl)methyl)oxirane) (EC 701-263-0). REACh is only relevant to substances either manufactured or imported into the EU. Huntsman Corporation has met its obligations under the REACh regulation. REACh information regarding this product is provided for informational purposes only. Each Legal Entity may have differing REACh obligations, depending on their place in the supply chain. For material manufactured outside of the EU, the importer of record must understand and meet their specific obligations under the regulation.

SECTION 16: Other information

Legend:

* : Trademark owned by Huntsman Corporation.
ACGIH: American Conference of Governmental Industrial Hygienists
N/A: Not Applicable
N/E: None Established
STEL: Short Term Exposure Limit
TWA: Time Weighted Average (exposure for 8-hour workday)

Users Responsibility/Disclaimer of Liability:
The information set forth herein is based on our current knowledge, and is intended to describe the product solely with respect to health, safety and the environment. As such, it must not be interpreted as a guarantee of any specific property of the product. As a result, the customer shall be solely responsible for deciding whether said information is suitable and beneficial.

Safety Data Sheet Preparer:
Product Compliance Department