

POLI W 180/38700 PEI K

Safety Data Sheet

According to ABNT NBR 14725: 2023
Issue date: 9/9/2022 Revision date: 4/7/2025 SAP export date: 1/27/2025 Version: 7.0



SECTION 1: Identification

1.1. GHS Product identifier

Product form : Mixture
Trade name : POLI W 180/38700 PEI K
Product code : 16268228
Type of product : Varnish
Product group : Trade product

1.2. Other means of identification

No additional information available

1.3. Recommended use of the chemical and restrictions on use

Recommended use : Wire Enamel

1.4. Supplier's details

WEG TINTAS LTDA - GRUPO WEG

Guaramirim - Santa Catarina / Brasil

Rodovia BR 280 – Km 50, 6.918 – Bloco A. Caixa D'Água – 89270-000 - +55 (47) 3276-4000

Mauá - São Paulo / Brasil

Rua Dr. Ulysses Guimarães, nº 918 – Bloco A. Loteamento Industrial Coral 09372-050 – Fone: +55 (11) 4547-6100

Cabo de Santo Agostinho - Pernambuco / Brasil

Via VII, 314 Distrito Industrial DIPER – 54590-000 - Fone: +55 (81) 3512-3000

Betim - Minas Gerais / Brasil

Avenida Juiz Marco Tulio Isaac, 2994 Betim Industrial – 32671-198, Fone: +55 (31) 3268-0687 / +55 (31) 3268-0686

Macaé - Rio de Janeiro / Brasil

Rua Itacolomi, 528 – Quadra H – Lote 11 Cabiúnas – 27977-340

Atotonilco de Tula - Estado de Hidalgo / México

Av. Hidalgo, lote 40, 41, 42 y 43 - Parque Industrial Bicentenario, CP 42980 - Fone: +52 (55) 5321-4231

Buenos Aires - Provincia de Buenos Aires / Argentina

Av. José Melián, 2983 - Parque Industrial Burzaco, B1852 - Fone: +54 (11) 4299-8000

1.5. Emergency phone number

Emergency number :

24-HOUR EMERGENCY - AMBIPAR		0800 117 2020	
CHEMTREC international number		+1-703-527-3887 e 1-800-424-9300	
Country	City	Local Number	Toll-Free Number
Austria	Vienna	+43-1-3649237	
Austria			0800 293702
China		400 120 4937	
France		+33-975181407	
Germany			0800-181-7059

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India	Bangalore	+91 8071 279 207	
India			000 800 1007 141
Italy	Milan	+39-02 4555 7031	
Italy			800 789 767
Netherlands		+31-85 888 0596	
Russia			8(800)100-63-46
South Africa			080-001-4676
United Kingdom	London	+44 20 3807 3798	
South korea			080-880-0454
Japan			0800-300-5842

SECTION 2: Hazard identification

2.1. Classification of the substance or mixture

Classification according to GHS BR (ABNT NBR 14725: 2023)

Flammable liquids, Category 3

Acute toxicity (oral), Category 4

Acute toxicity (dermal), Category 4

Skin corrosion/irritation, Category 1B

Specific target organ toxicity — Repeated exposure, Category 2

Hazardous to the aquatic environment - Acute Hazard, Category 3

Hazardous to the aquatic environment - Chronic Hazard, Category 3

2.2. GHS Label elements, including precautionary statements

GHS BR labelling

Hazard pictograms (GHS BR)



Signal word (GHS BR)

: Danger

Hazard statements (GHS BR)

: H226 - Flammable liquid and vapour
H302+H312 - Harmful if swallowed or in contact with skin
H314 - Causes severe skin burns and eye damage
H373 - May cause damage to organs through prolonged or repeated exposure.
H412 - Harmful to aquatic life with long lasting effects
P210 - Keep away from heat, hot surfaces, sparks, open flames and other ignition sources. No smoking.
P233 - Keep container tightly closed.
P240 - Ground and bond container and receiving equipment.
P241 - Use explosion-proof equipment.
P242 - Use non-sparking tools.
P243 - Take action to prevent static discharges.
P260 - Do not breathe dust, fume, gas, mist, vapours or spray.
P264 - Wash hands, forearms and face thoroughly after handling.
P270 - Do not eat, drink or smoke when using this product.
P273 - Avoid release to the environment.
P280 - Wear protective gloves, protective clothing, eye protection, face protection and hearing protection.
P301+P312 - IF SWALLOWED: Call a POISON CENTER or a doctor if you feel unwell.
P301+P330+P331 - IF SWALLOWED: Rinse mouth. Do NOT induce vomiting.
P302+P352 - IF ON SKIN: Wash with plenty of water.

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P303+P361+P353 - IF ON SKIN (or hair): Take off immediately all contaminated clothing. Rinse skin with water .
P304+P340 - IF INHALED: Remove person to fresh air and keep comfortable for breathing.
P305+P351+P338 - IF IN EYES: Rinse cautiously with water for several minutes. Remove contact lenses, if present and easy to do. Continue rinsing.
P310 - Immediately call a POISON CENTER or a doctor.
P312 - Call a POISON CENTER or a doctor if you feel unwell.
P314 - Get medical advice or attention as appropriate.
P321 - Specific treatment (see supplemental first aid instruction on this label).
P330 - Rinse mouth.
P362+P364 - Take off contaminated clothing and wash it before reuse.
P363 - Wash contaminated clothing before reuse.
P370+P378 - In case of fire: Use appropriate media to extinguish.
P403+P235 - Store in a well-ventilated place. Keep cool.
P405 - Store locked up.
P501 - Dispose of contents and/or container to hazardous or special waste collection point, in accordance with local, regional, national and international regulations.

2.3. Other hazards which do not result in classification

No additional information available

SECTION 3: Composition/information on ingredients

3.1. Substances

Not applicable

3.2. Mixtures

Name	GHS Product identifier	%	Classification according to GHS BR (ABNT NBR 14725: 2023)
Trade Secret	-	30 – 50	Acute Tox. 4 (Oral), H302 Eye Irrit. 2A, H319
MIXED XYLENES	CAS-No.: 1330-20-7	10 – 20	Flam. Liq. 3, H226 Acute Tox. 5 (Oral), H303 Acute Tox. 4 (Dermal), H312 Acute Tox. 4 (Inhalation), H332 Skin Irrit. 2, H315 STOT SE 3, H335 STOT RE 2, H373 Asp. Tox. 1, H304 Aquatic Acute 2, H401 Aquatic Chronic 2, H411
CRESOL, MIXTURE OF ISOMERS	CAS-No.: 1319-77-3	10 – 20	Acute Tox. 3 (Oral), H301 Acute Tox. 3 (Dermal), H311 Skin Corr. 1B, H314
XYLENOL - ISOMERS	CAS-No.: 1300-71-6	1 – 5	Acute Tox. 3 (Oral), H301 Acute Tox. 3 (Dermal), H311 Skin Corr. 1B, H314 Aquatic Chronic 2, H411

SECTION 4: First-aid measures

4.1. Description of necessary first-aid measures

First-aid measures general : Seek medical attention immediately.

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First-aid measures after inhalation	: Remove person to fresh air and keep comfortable for breathing. Immediately call a POISON CENTER/doctor.
First-aid measures after skin contact	: After contact with skin, take off immediately all contaminated clothing, and wash immediately with plenty of water. Do not remove clothing if it sticks to the skin. Be careful, the product may remain trapped under clothing, footwear or a wrist-watch.
First-aid measures after eye contact	: IF IN EYES: Rinse cautiously with water for several minutes. Remove contact lenses, if present and easy to do. Continue rinsing.
First-aid measures after ingestion	: If swallowed, seek medical advice immediately and show this container or label. Do not induce vomiting because of corrosive effects.

4.2. Most important symptoms and effects, acute and delayed

Symptoms/effects	: May cause damage to organs through prolonged or repeated exposure. Swallowing a small quantity of this material presents some health hazard. Causes severe skin burns and eye damage.
Symptoms/effects after inhalation	: May cause irritation to the respiratory tract, sneezing, coughing, burning sensation of throat with constricting sensation of the larynx and difficulty in breathing.
Symptoms/effects after skin contact	: Harmful in contact with skin. Highly corrosive to skin. Causes severe burns. irritation (itching, redness, blistering).
Symptoms/effects after eye contact	: stinging. Redness. Causes serious eye burns. redness, itching, tears.
Symptoms/effects after ingestion	: Harmful if swallowed. Ingestion may cause nausea and vomiting. Burns or irritation of the linings of the mouth, throat, and gastrointestinal tract.

4.3. Indication of any immediate medical attention and special treatment needed, if necessary

Notes to physician	: Treat symptomatically
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SECTION 5: Fire-fighting measures

5.1. Suitable extinguishing media

Suitable extinguishing media	: Dry chemical, CO ₂ , or water spray or regular foam.
Unsuitable extinguishing media	: Do not use a heavy water stream.

5.2. Specific hazards arising from the chemical

Fire hazard	: Flammable liquid and vapour. The vapours are denser than air and may travel along the ground. Distance ignition possible. Agitation can cause build up of electrostatic charge. Vapours may cause fire/explosion if source of ignition is present. In case of fire and/or explosion do not breathe fumes. In case of fire, corrosive gases come free.
Explosion hazard	: Vapours may form explosive mixture with air. Prolonged exposure to fire may cause containers to rupture/explode.

5.3. Special protective actions for fire-fighters

Precautionary measures fire	: Keep container closed when not in use. This product is not to be used under conditions of poor ventilation.
Firefighting instructions	: Get the package away from the fire if this can be done without risk. Fight fire from a safe distance or use hoses with support or cannon engine. Cool laterally with water containers exposed to flames, even after the fire is extinguished. Do not enter fire area without proper protective equipment, including respiratory protection.
Protection during firefighting	: Use self-contained breathing apparatus and chemically protective clothing.
Other information	: In case of fire, corrosive and harmful gases come free.

SECTION 6: Accidental release measures

6.1. Personal precautions, protective equipment and emergency procedures

General measures	: Eliminate every possible source of ignition. Prevent from entering sewers, basements and workpits, or any place where its accumulation can be dangerous. Avoid contact with skin and eyes. May be harmful to aquatic organisms, to flora, to soil organisms. Clean up any
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spills as soon as possible, using an absorbent material to collect it. Stop leak if safe to do so. Notify authorities if product enters sewers or public waters. Absorb spillage to prevent material damage.

6.1.1. For non-emergency personnel

- | | |
|----------------------|---|
| Protective equipment | : Wear recommended personal protective equipment. |
| Emergency procedures | : No flames, no sparks. Eliminate all sources of ignition. Do not touch or walk on the spilled product. Evacuate area. Only qualified personnel equipped with suitable protective equipment may intervene. Notify fire brigade and environmental authorities. |

6.1.2. For emergency responders

- | | |
|----------------------|--|
| Protective equipment | : Use self-contained breathing apparatus and chemically protective clothing. Gloves. Wear security glasses which protect from splashes. Self-contained breathing apparatus. Total impervious protective suits, gloves, and boots must be worn to prevent any contact with the product. Corrosionproof suit. Equip cleanup crew with proper protection. |
| Emergency procedures | : Keep away from combustible material. All equipment used when handling the product must be grounded. Evacuate unnecessary personnel. Stop leak if safe to do so. |

6.2. Environmental precautions

Prevent from entering sewers, basements and workpits, or any place where its accumulation can be dangerous. Harmful to aquatic life with long lasting effects. Do not allow product to spread into the environment. Harmful to aquatic life. Notify authorities if product enters sewers or public waters.

6.3. Methods and materials for containment and cleaning up

- | | |
|-------------------------|---|
| For containment | : Absorb spilled material with sand or earth. Contain any spills with dikes or absorbents to prevent migration and entry into sewers or streams. Stop leak without risks if possible. |
| Methods for cleaning up | : Absorb remaining liquid with sand or inert absorbent and remove to safe place. Clean contaminated surfaces with an excess of water. Absorb spillage to prevent material damage. Take up liquid spill into absorbent material. |

SECTION 7: Handling and storage

7.1. Precautions for safe handling

- | | |
|-----------------------------------|---|
| Additional hazards when processed | : Flammable vapours may accumulate in the container. |
| Precautions for safe handling | : Provide adequate ventilation to minimize dust and/or vapour concentrations. Keep away from heat, hot surfaces, sparks, open flames and other ignition sources. No smoking. Handle carefully. Ground/bond container and receiving equipment. Use only non-sparking tools. Take precautionary measures against static discharge. Wear personal protective equipment. Do not eat, drink or smoke when using this product. When heated, material emits highly irritating vapours, affecting the eyes. Ensure good ventilation of the work station. Keep only in original container. Do not handle until all safety precautions have been read and understood. |
| Hygiene measures | : Always wash hands after handling the product. Take off immediately all contaminated clothing and wash it before reuse. Do not eat, drink or smoke when using this product. |

7.2. Conditions for safe storage, including any incompatibilities

- | | |
|------------------------|---|
| Technical measures | : Ensure adequate ventilation, especially in confined areas. Store locked up. Store in tightly closed, leak-proof containers. |
| Storage conditions | : Keep cool. Store in a well-ventilated place. Keep container tightly closed. Keep cool. Protect from sunlight. |
| Incompatible materials | : combustible materials. |
| Packaging materials | : Store always product in container of same material as original container. |

SECTION 8: Exposure controls/personal protection

8.1. Control parameters

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CRESOL, MIXTURE OF ISOMERS 1319-77-3	
USA - ACGIH - Occupational Exposure Limits	
Local name	Cresol, all isomers
ACGIH OEL TWA	20 mg/m³ (IFV - Inhalable fraction and vapor)
Remark (ACGIH)	TLV® Basis: URT irr. Notations: Skin; A4 (Not classifiable as a Human Carcinogen)
Regulatory reference	ACGIH 2024
USA - OSHA - Occupational Exposure Limits	
Local name	Cresol, all isomers
OSHA PEL TWA	22 mg/m³
	5 ppm
Regulatory reference (US-OSHA)	OSHA Annotated Table Z-1
MIXED XYLENES 1330-20-7	
USA - ACGIH - Occupational Exposure Limits	
Local name	Xylene, mixed isomers (Dimethylbenzene)
ACGIH OEL TWA	20 ppm
Remark (ACGIH)	TLV® Basis: URT & eye irr; hematologic eff; ototoxicity (for mixtures containing p-xylene); CNS impair. Notations: OTO (for mixtures containing p-xylene); A4 (Not classifiable as a Human Carcinogen); BEI
Regulatory reference	ACGIH 2024
USA - OSHA - Occupational Exposure Limits	
Local name	Xylenes (o-, m-, p-isomers)
OSHA PEL TWA	435 mg/m³
	100 ppm
Regulatory reference (US-OSHA)	OSHA Annotated Table Z-1

8.2. Appropriate engineering controls

Appropriate engineering controls : Emergency eye wash fountains and safety showers should be available in the immediate vicinity of any potential exposure.

8.3. Individual protection measures

Personal protective equipment:

Corrosionproof clothing.

Hand protection:
Protective gloves made of PVC. Nitrile rubber gloves. cold-insulating gloves
Eye protection:
Wear closed safety glasses
Skin and body protection:
Long sleeved protective clothing. Or chemical resistant apron. Safety shoes

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Respiratory protection:

Where exposure through inhalation may occur from use, respiratory protection equipment is recommended

Personal protective equipment symbol(s):



SECTION 9: Physical and chemical properties

9.1. Basic physical and chemical properties

Physical state	: Liquid
Appearance	:
Colour	: amber
Odour	: characteristic
Odour threshold	: Not available
pH	: Not available
Melting point	: Not available
Freezing point	: Not available
Boiling point	: Not available
Flash point	: $\geq 35^{\circ}\text{C}$
Relative evaporation rate (butylacetate=1)	: Not available
Flammability	: Not available
Explosive limits	: 0.8 – 10.9 vol %
Vapour pressure	: Not available
Relative vapour density at 20°C	: Not available
Relative density	: Not available
Density	: 1.10 1.1 (1.08 – 1.12) g/cm ³
Solubility	: Material insoluble in water.
Partition coefficient n-octanol/water (Log Kow)	: Not available
Auto-ignition temperature	: 464
Decomposition temperature	: Not available
Viscosity, kinematic	: Not available
Viscosity, dynamic	: 600 – 700 cP
Particle size	: Not applicable
Particle size distribution	: Not applicable
Particle shape	: Not applicable
Particle aspect ratio	: Not applicable
Particle specific surface area	: Not applicable

MIXED XYLENES1330-20-7

Boiling point	139.6 °C
Flash point	30 °C (ASTM D 93)
Auto-ignition temperature	488 °C
Vapour pressure	4.8 kPa 55°C

9.2. Data relevant with regard to physical hazard classes

No additional information available

9.3. Further safety characteristics

No additional information available

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SECTION 10: Stability and reactivity

Chemical stability	: In use may form flammable/explosive vapour-air mixture.
Conditions to avoid	: Keep away from heat, hot surfaces, sparks, open flames and other ignition sources. No smoking. Avoid contact with hot surfaces. High temperature. Avoid formation of vapours.
Hazardous decomposition products	: May liberate toxic gases. On exposure to high temperature, may decompose, releasing corrosive gases.
Incompatible materials	: Combustible materials.
Possibility of hazardous reactions	: Liquids/vapours may ignite or react with other materials.
Reactivity	: The product is non-reactive under normal conditions of use, storage and transport.
Handling temperature	: No additional information available

SECTION 11: Toxicological information

11.1. Information on toxicological effects

Acute toxicity (oral)	: Harmful if swallowed.
Acute toxicity (dermal)	: Harmful in contact with skin.
Acute toxicity (inhalation)	: Not available

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ATE BR (oral)	487.425 mg/kg bodyweight
ATE BR (dermal)	1771.631 mg/kg bodyweight

MIXED XYLENES (1330-20-7)

LD50 dermal rabbit	12126 mg/kg bodyweight Animal: rabbit, Animal sex: male
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Skin corrosion/irritation	: Causes severe skin burns.
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MIXED XYLENES (1330-20-7)

pH	7
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Serious eye damage/irritation	: Assumed to cause serious eye damage
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MIXED XYLENES (1330-20-7)

pH	7
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Respiratory or skin sensitisation	: Not available
Germ cell mutagenicity	: Not available
Carcinogenicity	: Not available

MIXED XYLENES (1330-20-7)

IARC group	3 - Not classifiable
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Reproductive toxicity	: Not available
STOT-single exposure	: Not available

MIXED XYLENES (1330-20-7)

STOT-single exposure	May cause respiratory irritation.
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STOT-repeated exposure	: May cause damage to organs through prolonged or repeated exposure.
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MIXED XYLENES (1330-20-7)

LOAEL (oral, rat, 90 days)	150 mg/kg bodyweight Animal: rat, Animal sex: male, Guideline: OECD Guideline 408 (Repeated Dose 90-Day Oral Toxicity Study in Rodents), Guideline: EPA OPP 82-1 (90-Day Oral Toxicity)
STOT-repeated exposure	May cause damage to organs through prolonged or repeated exposure.

Aspiration hazard	: Not classified.
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MIXED XYLENES (1330-20-7)

Viscosity, kinematic	≈ 0.76 mm ² /s Temp.: '20°C' Parameter: 'kinematic viscosity (in mm ² /s)'
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11.2. Most important symptoms and effects, both acute and delayed

Symptoms/effects	: May cause damage to organs through prolonged or repeated exposure. Swallowing a small quantity of this material presents some health hazard. Causes severe skin burns and eye damage.
Symptoms/effects after inhalation	: May cause irritation to the respiratory tract, sneezing, coughing, burning sensation of throat with constricting sensation of the larynx and difficulty in breathing.
Symptoms/effects after skin contact	: Harmful in contact with skin. Highly corrosive to skin. Causes severe burns. irritation (itching, redness, blistering).
Symptoms/effects after eye contact	: stinging. Redness. Causes serious eye burns. redness, itching, tears.
Symptoms/effects after ingestion	: Harmful if swallowed. Ingestion may cause nausea and vomiting. Burns or irritation of the linings of the mouth, throat, and gastrointestinal tract.

SECTION 12: Ecological information

12.1. Toxicity

Hazardous to the aquatic environment, short-term (acute)	: Harmful to aquatic life.
Hazardous to the aquatic environment, long-term (chronic)	: Harmful to aquatic life with long lasting effects.

MIXED XYLENES1330-20-7

LC50 - Fish [1]	≈ 2.6 mg/l
EC50 - Crustacea [1]	> 3.4 mg/l Test organisms (species): Ceriodaphnia dubia
ErC50 algae	≈ 2.2 mg/l
LOEC (chronic)	3.16 mg/l Test organisms (species): Daphnia magna Duration: '21 d'
NOEC chronic fish	> 1.3 mg/l Test organisms (species): Oncorhynchus mykiss (previous name: Salmo gairdneri) Duration: '56 d'

12.2. Persistence and degradability

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Persistence and degradability	Not rapidly degradable
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CRESOL, MIXTURE OF ISOMERS1319-77-3

Persistence and degradability	Not rapidly degradable
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XYLENOL - ISOMERS1300-71-6

Persistence and degradability	Not rapidly degradable
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Trade Secret

Persistence and degradability	Not rapidly degradable
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MIXED XYLENES1330-20-7

Persistence and degradability	Not rapidly degradable
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12.3. Bioaccumulative potential

No additional information available

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12.4. Mobility in soil

No additional information available

12.5. Other adverse effects

Hazardous to the ozone layer

: Not available

Other adverse effects

: May cause pH changes in aqueous ecological systems. Before neutralisation, the product may represent a danger to aquatic organisms.

SECTION 13: Disposal considerations

Regional waste regulation

: Law No. 12.305 on the National Policy on Solid Waste Management, 02 August 2010.

Waste treatment methods

: Must follow special treatment according to local regulation.

Sewage disposal recommendations

: Disposal must be done according to official regulations.

Product/Packaging disposal recommendations

: Disposal must be done according to official regulations.

Additional information

: Flammable vapours may accumulate in the container. Do not re-use empty containers.

SECTION 14: Transport information

14.1 National and international Regulations

In accordance with IMDG / IATA / ANTT

ANTT	IMDG	IATA
UN number		
1263	1263	1263
UN Proper Shipping Name		
TINTA	PAINT	Paint
Transport document description		
Not applicable	UN 1263 PAINT, 3, III (35°C c.c.)	UN 1263 Paint, 3, III
Transport hazard class(es)		
3	3	3
Danger labels		
3	3	3
		
Subsidiary risk		
Not applicable	Not applicable	Not applicable
Risk Number		
30	Not applicable	Not applicable
Packing group		
III	III	III
Special provisions		
163,223,367	163,223,367,955	A3,A72,A192

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Dangerous for the environment

No

No

No

14.2 Other informations

No additional information available

SECTION 15: Regulatory information

15.1. National regulations

Brazil Local Regulations

: Standard ABNT NBR 14725.
Federal Decree no. 10.088, of 5 November 2019 – Promulgates Convention no. 170 of the WLO, relating to Safety in the Use of Chemicals in the Workplace, ratified by the Federative Republic of Brazil.
Ministerial Order no. 2.770, of 5 September 2022 – Approves the new wording of Regulatory Standard No. 26
Federal Decree no. 96.044, of 18 May 1988 - Approves Regulations for Road Transportation of Hazardous Materials
Resolution no. 5998, of November 3, 2022, updates the regulation for road transport of dangerous goods, approves its Complementary Instructions, and other measures.

SECTION 16: Other information

Abbreviations and acronyms

: CAS-No. - Chemical Abstract Service number
ADN - European Agreement concerning the International Carriage of Dangerous Goods by Inland Waterways
ADR - European Agreement concerning the International Carriage of Dangerous Goods by Road
BCF - Bioconcentration factor
EC50 - Median effective concentration
LC50 - Median lethal concentration
VOC - Volatile Organic Compounds
LD50 - Median lethal dose
DMEL - Derived Minimal Effect level
DNEL - Derived-No Effect Level
COD - Chemical oxygen demand (COD)
ATE - Acute Toxicity Estimate
IMDG - International Maritime Dangerous Goods
IATA - International Air Transport Association
EC-No. - European Community number
vPvB - Very Persistent and Very Bioaccumulative
WGK - Water Hazard Class
IOELV - Indicative Occupational Exposure Limit Value
BLV - Biological limit value
TRGS - Technical Rules for Hazardous Substances
TLM - Median Tolerance Limit
IARC - International Agency for Research on Cancer

Important information, but not specifically described in the previous sections: This MSDS was prepared based on current knowledge about the handling of the product under normal conditions of use, according to the application specified on the packaging and recommended usage in Section 1 of this MSDS. Any other use of the product involving its combination with other materials, as well as forms of use different from those indicated, are the user's responsibility. The company advises that the handling of any chemical substance requires prior knowledge of its hazards by the user. In the workplace it is responsibility of the company user of the product to provide training of its employees and contractors about the possible risks arising from exposure to the chemical. We reserve the right to change the information contained in this document without prior notice, due to the improvement and continuous evolution of the product and technical knowledge.

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