



## Material Safety Data Sheet

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**PRODUCT NAME:** Scotch-Weld(TM) Epoxy Adhesive DP-4XL-EG  
**MANUFACTURER:** 3M  
**DIVISION:** Electronics Markets Materials Division

**ADDRESS:** 3M Center  
St. Paul, MN 55144-1000

**EMERGENCY PHONE: 1-800-364-3577 or (651) 737-6501 (24 hours)**

**Issue Date:** 05/18/09  
**Supersedes Date:** 05/13/09

**Document Group:** 09-2472-0

### ID Number(s):

62-2793-1430-6, 62-2793-1435-5, XA-0041-3805-4

**This product is a kit or a multipart product which consists of multiple, independently packaged components. An MSDS for each of these components is included. Please do not separate the component MSDSs from this cover page. The document numbers of the MSDSs for components of this product are:**

09-2471-2, 09-2467-0

### Revision Changes:

Kit: Component document group number(s) was modified.

Kit: ID Number(s) was modified.

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### SECTION 1: PRODUCT AND COMPANY IDENTIFICATION

**PRODUCT NAME:** Scotch-Weld (TM) Epoxy Adhesive DP-4XL-EG (Part B)

**MANUFACTURER:** 3M

**DIVISION:** Electronics Markets Materials Division

**ADDRESS:** 3M Center  
St. Paul, MN 55144-1000

**EMERGENCY PHONE:** 1-800-364-3577 or (651) 737-6501 (24 hours)

**Issue Date:** 05/19/09

**Supersedes Date:** • "/18/09

**Document Group:** 09-2467-0

**Product Use:**

Intended Use: part B of 2 part adhesive

### SECTION 2: INGREDIENTS

<u>Ingredient</u>	<u>C.A.S. No.</u>	<u>% by Wt</u>
EPOXY RESIN	25068-38-6	60 - 100
METHYL METHACRYLATE-BUTADIENE-STYRENE POLYMER	25053-09-2	10 - 30

### SECTION 3: HAZARDS IDENTIFICATION

#### 3.1 EMERGENCY OVERVIEW

**Specific Physical Form:** Viscous

**Odor, Color, Grade:** white, very mild odor.

**General Physical Form:** Liquid

**Immediate health, physical, and environmental hazards:** May cause allergic skin reaction.

#### 3.2 POTENTIAL HEALTH EFFECTS

**Eye Contact:**

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

**Skin Contact:**

Mild Skin Irritation: Signs/symptoms may include localized redness, swelling, and itching.

Prolonged or repeated exposure may cause:

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

**Inhalation:**

Vapors from heated material may cause irritation of the respiratory system. Signs/symptoms may include cough, sneezing, nasal discharge, headache, hoarseness, and nose and throat pain.

**Ingestion:**

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

## SECTION 4: FIRST AID MEASURES

### 4.1 FIRST AID PROCEDURES

The following first aid recommendations are based on an assumption that appropriate personal and industrial hygiene practices are followed.

**Eye Contact:** Flush eyes with large amounts of water. If signs/symptoms persist, get medical attention.

**Skin Contact:** Remove contaminated clothing and shoes. Immediately flush skin with large amounts of water. Get medical attention. Wash contaminated clothing and clean shoes before reuse.

**Inhalation:** If signs/symptoms develop, remove person to fresh air. If signs/symptoms persist, get medical attention.

**If Swallowed:** Do not induce vomiting unless instructed to do so by medical personnel. Give victim two glasses of water. Never give anything by mouth to an unconscious person. Get medical attention.

## SECTION 5: FIRE FIGHTING MEASURES

### 5.1 FLAMMABLE PROPERTIES

<b>Autoignition temperature</b>	<i>No Data Available</i>
<b>Flash Point</b>	$\geq 170$ °C [ <i>Test Method: Closed Cup</i> ]
<b>Flammable Limits - LEL</b>	<i>No Data Available</i>
<b>Flammable Limits - UEL</b>	<i>No Data Available</i>

## 5.2 EXTINGUISHING MEDIA

Ordinary combustible material. Use fire extinguishers with class A extinguishing agents (e.g., water, foam).

## 5.3 PROTECTION OF FIRE FIGHTERS

**Special Fire Fighting Procedures:** Water may be used to blanket the fire. Wear full protective equipment (Bunker Gear) and a self-contained breathing apparatus (SCBA).

**Unusual Fire and Explosion Hazards:** Not applicable.

**Note:** See STABILITY AND REACTIVITY (SECTION 10) for hazardous combustion and thermal decomposition information.

## SECTION 6: ACCIDENTAL RELEASE MEASURES

**Accidental Release Measures:** Ventilate the area with fresh air. Collect as much of the spilled material as possible. Clean up residue with an appropriate organic solvent. Read and follow safety precautions on the solvent label and MSDS. Place in a closed container approved for transportation by appropriate authorities.

**In the event of a release of this material, the user should determine if the release qualifies as reportable according to local, state, and federal regulations.**

## SECTION 7: HANDLING AND STORAGE

### 7.1 HANDLING

Do not eat, drink or smoke when using this product. Wash exposed areas thoroughly with soap and water. For industrial or professional use only. Use general dilution ventilation and/or local exhaust ventilation to control airborne exposures to below Occupational Exposure Limits. If ventilation is not adequate, use respiratory protection equipment.

### 7.2 STORAGE

Store away from acids. Keep container in well-ventilated area. Store away from oxidizing agents.

## SECTION 8: EXPOSURE CONTROLS/PERSONAL PROTECTION

### 8.1 ENGINEERING CONTROLS

Use in a well-ventilated area. Provide ventilated enclosure for heat curing. Curing enclosures must be exhausted to outdoors or to a suitable emission control device.

### 8.2 PERSONAL PROTECTIVE EQUIPMENT (PPE)

#### 8.2.1 Eye/Face Protection

Avoid eye contact.

The following eye protection(s) are recommended: Safety Glasses with side shields, Indirect Vented Goggles.

#### 8.2.2 Skin Protection

Avoid skin contact.

Select and use gloves and/or protective clothing to prevent skin contact based on the results of an exposure assessment. Consult with your glove and/or protective clothing manufacturer for selection of appropriate compatible materials.

Gloves made from the following material(s) are recommended: Polyethylene/Ethylene Vinyl Alcohol.

### 8.2.3 Respiratory Protection

Avoid breathing of vapors, mists or spray.

Select one of the following NIOSH approved respirators based on airborne concentration of contaminants and in accordance with OSHA regulations: Half facepiece or fullface air-purifying respirator with organic vapor cartridges. Consult the current 3M Respiratory Selection Guide for additional information or call 1-800-243-4630 for 3M technical assistance.

### 8.2.4 Prevention of Swallowing

Do not eat, drink or smoke when using this product. Wash exposed areas thoroughly with soap and water.

## 8.3 EXPOSURE GUIDELINES

None Established

## SECTION 9: PHYSICAL AND CHEMICAL PROPERTIES

Specific Physical Form:	Viscous
Odor, Color, Grade:	white, very mild odor.
General Physical Form:	Liquid
Autoignition temperature	<i>No Data Available</i>
Flash Point	$\geq 170$ °C [ <i>Test Method</i> : Closed Cup]
Flammable Limits - LEL	<i>No Data Available</i>
Flammable Limits - UEL	<i>No Data Available</i>
Boiling point	<i>No Data Available</i>
Density	1.16 g/ml
Vapor Density	Negligible
Vapor Pressure	$\leq 0.03$ mmHg [@ 25 °C]
Specific Gravity	1.16 [ <i>Ref Std</i> : WATER=1]
pH	<i>Not Applicable</i>
Melting point	<i>Not Applicable</i>
Solubility in Water	Negligible
Evaporation rate	<i>Not Applicable</i>
Volatile Organic Compounds	2 g/l [ <i>Test Method</i> : tested per EPA method 24A]
Percent volatile	0 % weight
VOC Less H <sub>2</sub> O & Exempt Solvents	2 g/l [ <i>Test Method</i> : tested per EPA method 24A]
Viscosity	100000 centipoise [@ 20 °C]

## SECTION 10: STABILITY AND REACTIVITY

**Stability:** Stable.

**Materials and Conditions to Avoid:** Strong acids; Strong oxidizing agents; Heat is generated during cure. Do not cure a mass larger than 50 grams in a confined space to prevent a premature reaction (exotherm) with production of intense heat and smoke.

**Hazardous Polymerization:** Hazardous polymerization will not occur.

### Hazardous Decomposition or By-Products

**Substance**

Aldehydes  
Carbon monoxide  
Carbon dioxide

**Condition**

During Combustion  
During Combustion  
During Combustion

**SECTION 11: TOXICOLOGICAL INFORMATION**

Please contact the address listed on the first page of the MSDS for Toxicological Information on this material and/or its components.

**SECTION 12: ECOLOGICAL INFORMATION**

**ECOTOXICOLOGICAL INFORMATION**

Not determined.

**CHEMICAL FATE INFORMATION**

Not determined.

**SECTION 13: DISPOSAL CONSIDERATIONS**

**Waste Disposal Method:** Dispose of completely cured (or polymerized) wastes in a sanitary landfill.

As a disposal alternative, incinerate uncured product in an industrial or commercial incinerator in the presence of a combustible material.

Since regulations vary, consult applicable regulations or authorities before disposal.

**SECTION 14: TRANSPORT INFORMATION**

LA-M100-0170-4

Please contact the emergency numbers listed on the first page of the MSDS for Transportation Information for this material.

**SECTION 15: REGULATORY INFORMATION**

**US FEDERAL REGULATIONS**

Contact 3M for more information.

**311/312 Hazard Categories:**

Fire Hazard - No Pressure Hazard - No Reactivity Hazard - No Immediate Hazard - Yes Delayed Hazard - Yes

**STATE REGULATIONS**

Contact 3M for more information.

**CHEMICAL INVENTORIES**

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

All applicable chemical ingredients in this material are listed on the European Inventory of Existing Chemical Substances (EINECS), or are exempt polymers whose monomers are listed on EINECS.

Contact 3M for more information.

**INTERNATIONAL REGULATIONS**

Contact 3M for more information.

**This MSDS 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: 1 Reactivity: 0 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.

**Revision Changes:**

Section 14: ID Number(s) Template 1 was modified.

Section 14: ID Number Heading Template 1 was deleted.

Section 1: Product use information was modified.

Copyright was modified.

Section 4: First aid for inhalation - termination of exposure - was modified.

Section 4: First aid for inhalation - medical assistance - was modified.



Section 4: First aid for ingestion (swallowing) - decontamination - was modified.  
Section 4: First aid for ingestion (swallowing) - medical assistance - was modified.  
Section 5: Flash point information was modified.  
Section 9: Flash point information was modified.  
Section 2: Ingredient table was added.  
Section 8: Exposure guidelines information - none - was added.

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### SECTION 1: PRODUCT AND COMPANY IDENTIFICATION

**PRODUCT NAME:** Scotch-Weld™ Epoxy Adhesive DP-4XL-EG (Part A)

**MANUFACTURER:** 3M

**DIVISION:** Electronics Markets Materials Division

**ADDRESS:** 3M Center  
St. Paul, MN 55144-1000

**EMERGENCY PHONE:** 1-800-364-3577 or (651) 737-6501 (24 hours)

**Issue Date:** 05/19/09

**Supersedes Date:** 05/18/09

**Document Group:** 09-2471-2

**Product Use:**

Intended Use: part A of 2 part adhesive

### SECTION 2: INGREDIENTS

<u>Ingredient</u>	<u>C.A.S. No.</u>	<u>% by Wt</u>
POLYAMINE CURATIVE	9046-10-0	40 - 70
MODIFIED EPOXY RESIN - N.J. Trade Secret (T.S.) Registry #04499600-5431P	Trade Secret	10 - 30
EPOXY RESIN	25068-38-6	10 - 30
SILICA FILLER	92797-60-9	1 - 5

### SECTION 3: HAZARDS IDENTIFICATION

#### 3.1 EMERGENCY OVERVIEW

**Specific Physical Form:** Viscous

**Odor, Color, Grade:** amber color, amine odor

**General Physical Form:** Liquid

**Immediate health, physical, and environmental hazards:** May cause chemical eye burns. May cause allergic skin reaction. May cause chemical skin burns. May cause chemical gastrointestinal burns.

#### 3.2 POTENTIAL HEALTH EFFECTS

**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.

Vapors released during curing may cause eye irritation. Signs/symptoms may include redness, swelling, pain, tearing, and blurred or hazy vision.

**Skin Contact:**

Corrosive (Skin Burns): Signs/symptoms may include localized redness, swelling, itching, intense pain, blistering, ulceration, and tissue destruction.

Prolonged or repeated exposure may cause:

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

**Inhalation:**

Vapors released during curing may cause irritation of the respiratory system. Signs/symptoms may include cough, sneezing, nasal discharge, headache, hoarseness, and nose and throat pain.

**Ingestion:**

Gastrointestinal Corrosion: Signs/symptoms may include severe mouth, throat and abdominal pain; nausea; vomiting; and diarrhea; blood in the feces and/or vomitus may also be seen.

## SECTION 4: FIRST AID MEASURES

### 4.1 FIRST AID PROCEDURES

The following first aid recommendations are based on an assumption that appropriate personal and industrial hygiene practices are followed.

**Eye Contact:** Immediately flush eyes with large amounts of water for at least 15 minutes. Get immediate medical attention.

**Skin Contact:** Remove contaminated clothing and shoes. Immediately flush skin with large amounts of water for at least 15 minutes. Get immediate medical attention. Wash contaminated clothing and clean shoes before reuse.

**Inhalation:** If signs/symptoms develop, remove person to fresh air. If signs/symptoms persist, get medical attention.

**If Swallowed:** Do not induce vomiting. Give victim two glasses of water. Never give anything by mouth to an unconscious person. Get immediate medical attention.

## SECTION 5: FIRE FIGHTING MEASURES

## 5.1 FLAMMABLE PROPERTIES

Autoignition temperature	No Data Available
Flash Point	>=120 °C [Test Method: Closed Cup]
Flammable Limits - LEL	No Data Available
Flammable Limits - UEL	No Data Available

## 5.2 EXTINGUISHING MEDIA

Ordinary combustible material. Use fire extinguishers with class A extinguishing agents (e.g., water, foam).

## 5.3 PROTECTION OF FIRE FIGHTERS

**Special Fire Fighting Procedures:** Wear full protective equipment (Bunker Gear) and a self-contained breathing apparatus (SCBA).

**Unusual Fire and Explosion Hazards:** No unusual fire or explosion hazards are anticipated.

**Note:** See STABILITY AND REACTIVITY (SECTION 10) for hazardous combustion and thermal decomposition information.

## SECTION 6: ACCIDENTAL RELEASE MEASURES

**Accidental Release Measures:** Evacuate unprotected and untrained personnel from hazard area. The spill should be cleaned up by qualified personnel. Ventilate the area with fresh air. Contain spill. For larger spills, cover drains and build dikes to prevent entry into sewer systems or bodies of water. Collect as much of the spilled material as possible. Clean up residue with an appropriate organic solvent. Read and follow safety precautions on the solvent label and MSDS. Place in a metal container approved for use in transportation by appropriate authorities. The container must be lined with polyethylene plastic or contain a plastic drum liner made of polyethylene. Dispose of collected material as soon as possible.

**In the event of a release of this material, the user should determine if the release qualifies as reportable according to local, state, and federal regulations.**

## SECTION 7: HANDLING AND STORAGE

### 7.1 HANDLING

Avoid eye contact. Avoid eye contact with vapors, mists, or spray. Avoid skin contact. Avoid breathing of vapors. Use general dilution ventilation and/or local exhaust ventilation to control airborne exposures to below Occupational Exposure Limits. If ventilation is not adequate, use respiratory protection equipment. Do not ingest. Do not eat, drink or smoke when using this product. Wash exposed areas thoroughly with soap and water. Avoid contact with oxidizing agents. For industrial or professional use only.

### 7.2 STORAGE

Store in a cool, dry place. Store away from heat. Store out of direct sunlight. Keep container tightly closed. Keep container in well-ventilated area. Store away from oxidizing agents. Store away from acids.

## SECTION 8: EXPOSURE CONTROLS/PERSONAL PROTECTION

### 8.1 ENGINEERING CONTROLS

Use in a well-ventilated area. Provide ventilated enclosure for heat curing. Curing enclosures must be exhausted to outdoors or to a

suitable emission control device.

## 8.2 PERSONAL PROTECTIVE EQUIPMENT (PPE)

### 8.2.1 Eye/Face Protection

Avoid eye contact.

The following eye protection(s) are recommended: Safety Glasses with side shields, Indirect Vented Goggles.

### 8.2.2 Skin Protection

Avoid skin contact.

Select and use gloves and/or protective clothing to prevent skin contact based on the results of an exposure assessment. Consult with your glove and/or protective clothing manufacturer for selection of appropriate compatible materials.

Gloves made from the following material(s) are recommended: Polyethylene/Ethylene Vinyl Alcohol.

### 8.2.3 Respiratory Protection

Select one of the following NIOSH approved respirators based on airborne concentration of contaminants and in accordance with OSHA regulations: Half facepiece or fullface air-purifying respirator with organic vapor cartridges. Consult the current 3M Respiratory Selection Guide for additional information or call 1-800-243-4630 for 3M technical assistance.

### 8.2.4 Prevention of Swallowing

Do not eat, drink or smoke when using this product. Wash exposed areas thoroughly with soap and water.

## 8.3 EXPOSURE GUIDELINES

None Established

## SECTION 9: PHYSICAL AND CHEMICAL PROPERTIES

<b>Specific Physical Form:</b>	Viscous
<b>Odor, Color, Grade:</b>	amber color, amine odor
<b>General Physical Form:</b>	Liquid
<b>Autoignition temperature</b>	<i>No Data Available</i>
<b>Flash Point</b>	>=120 °C [ <i>Test Method:</i> Closed Cup]
<b>Flammable Limits - LEL</b>	<i>No Data Available</i>
<b>Flammable Limits - UEL</b>	<i>No Data Available</i>
<b>Boiling point</b>	<i>No Data Available</i>
<b>Density</b>	1.02 g/ml
<b>Vapor Density</b>	Nil
<b>Vapor Pressure</b>	<=0.6 mmHg [@ 20 °C]
<b>Specific Gravity</b>	1.02 [ <i>Ref Std:</i> WATER=1]
<b>pH</b>	<i>Not Applicable</i>
<b>Melting point</b>	<i>Not Applicable</i>
<b>Solubility in Water</b>	Nil
<b>Evaporation rate</b>	<i>Not Applicable</i>
<b>Volatile Organic Compounds</b>	<i>Not Applicable</i>
<b>Percent volatile</b>	0 %
<b>VOC Less H2O &amp; Exempt Solvents</b>	<i>Not Applicable</i>
<b>Viscosity</b>	40000 - 80000 centipoise [@ 20 °C]

## SECTION 10: STABILITY AND REACTIVITY

**Stability:** Stable.

**Materials and Conditions to Avoid:** Strong acids; Strong oxidizing agents

**Hazardous Polymerization:** Hazardous polymerization will not occur.

### Hazardous Decomposition or By-Products

<u>Substance</u>	<u>Condition</u>
Aldehydes	During Combustion
Amine Compounds	During Combustion
Carbon monoxide	During Combustion
Carbon dioxide	During Combustion
Hydrogen Chloride	During Combustion
Hydrogen Cyanide	During Combustion
Oxides of Nitrogen	During Combustion
Toxic Vapor, Gas, Particulate	During Combustion

## SECTION 11: TOXICOLOGICAL INFORMATION

Please contact the address listed on the first page of the MSDS for Toxicological Information on this material and/or its components.

## SECTION 12: ECOLOGICAL INFORMATION

### ECOTOXICOLOGICAL INFORMATION

Not determined.

### CHEMICAL FATE INFORMATION

Not determined.

## SECTION 13: DISPOSAL CONSIDERATIONS

**Waste Disposal Method:** Dispose of completely cured (or polymerized) wastes in a sanitary landfill. Incinerate uncured product in a permitted hazardous waste incinerator in the presence of a combustible material. As a disposal alternative, dispose of waste product in a permitted hazardous waste facility.

**EPA Hazardous Waste Number (RCRA):** D002 (Corrosive)

Since regulations vary, consult applicable regulations or authorities before disposal.

## SECTION 14: TRANSPORT INFORMATION

Please contact the emergency numbers listed on the first page of the MSDS for Transportation Information for this material.

## SECTION 15: REGULATORY INFORMATION

### US FEDERAL REGULATIONS

Contact 3M for more information.

#### 311/312 Hazard Categories:

Fire Hazard - No Pressure Hazard - No Reactivity Hazard - No Immediate Hazard - Yes Delayed Hazard - No

### STATE REGULATIONS

Contact 3M for more information.

### CHEMICAL INVENTORIES

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

All applicable chemical ingredients in this material are listed on the European Inventory of Existing Chemical Substances (EINECS), or are exempt polymers whose monomers are listed on EINECS.

Contact 3M for more information.

### INTERNATIONAL REGULATIONS

Contact 3M for more information.

**WHMIS:** Hazardous

### ADDITIONAL INFORMATION

UN Number = 2735

Hazard Class = 8  
Pkg Group = 2

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

## **SECTION 16: OTHER INFORMATION**

### **NFPA Hazard Classification**

**Health: 3 Flammability: 1 Reactivity: 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.

### **Revision Changes:**

Section 14: ID Number Heading Template 1 was deleted.

Section 14: ID Number(s) Template 1 was deleted.

Section 5: Flash point information was modified.

Section 9: Flash point information was modified.

Section 2: Ingredient table was modified.

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# Transport Information Document

**Date:** June 18, 2010

**3M ID Number:** XA-0041-3805-4

**Product Description:** 3M(TM) Scotch-Weld(TM) Epoxy Adhesive DP4XLEG, 37 ml, 12 per case

**Transport Protective Service:** PROTECTIVE SERVICE NOT REQUIRED

**NMFC Item:** 044155

**NMFC Sub:** 04

**NMFC Class:** 070.0

**Flash Point (Closed-cup):** >248°F/120°C

## UNITED STATES DEPARTMENT OF TRANSPORTATION - GROUND (U.S. DOT, 49 CFR)

UN2735, POLYAMINES, LIQUID, CORROSIVE, N.O.S., (CONTAINS POLYAMINE CURATIVE), 8, III, LIMITED QUANTITY

## UNITED STATES DEPARTMENT OF TRANSPORTATION - VESSEL (U.S. DOT, 49 CFR)

UN2735, POLYAMINES, LIQUID, CORROSIVE, N.O.S., (CONTAINS POLYAMINE CURATIVE), 8, III, LIMITED QUANTITY

## INTERNATIONAL AIR TRANSPORT ASSOCIATION (IATA)

UN2735, POLYAMINES, LIQUID, CORROSIVE, N.O.S., (CONTAINS POLYAMINE CURATIVE), 8, III

## INTERNATIONAL MARITIME ORGANIZATION (IMO)

UN2735, POLYAMINES, LIQUID, CORROSIVE, N.O.S., (CONTAINS POLYAMINE CURATIVE), 8, III, LIMITED QUANTITY

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