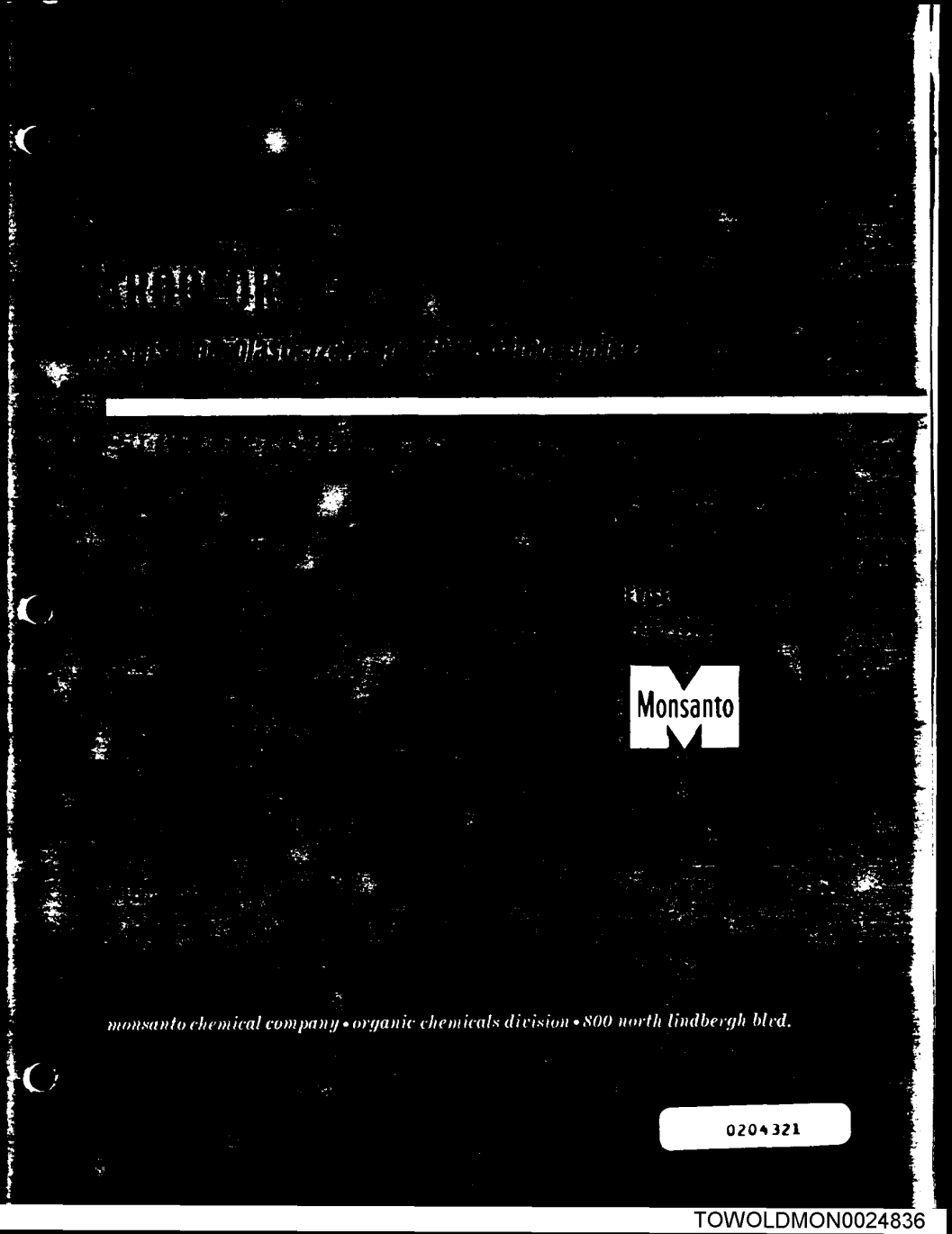

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AROCLOR® RESINS AND PLASTICIZERS FOR CHLORINATED RUBBER

Some important **applications** for protective and decorative chlorinated-rubber-based coatings plasticized with AROCLOR* compounds—

Wood and metal on yachts, barges, and other marine craft

Structural steel for bridges, buildings, roofs, and powerlines

Structural materials at chemical plants, pulp-and-paper mills, textile mills, petroleum refineries, and gas works for protection against acid fumes, alkalies, and gas

Tank cars and other railroad equipment and construction machinery for protection against corrosive materials and weathering

Equipment and stop-off lacquers used in electroplating

Masonry floors and walls, concrete swimming pools, and highway markings

Cable coatings requiring flame retardance, chemical resistance, and excellent electrical properties

Textile coatings resistant to chemicals, flame, and water

Food-processing buildings

Flame-retardant finishes

Important **properties** imparted to chlorinated-rubber coatings by AROCLOR plasticizers and resin extenders—

Chemical Resistance

Corrosion Resistance

Adhesivity

Flame Retardance

Flexibility

Electrical Resistance

Weather Resistance

*AROCLOR: Monsanto Chemical Company trademark, registered in the U. S. Patent Office.

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CONTENTS

INTRODUCTION 1

NUMBERING AROCLOR COMPOUNDS 1

PROPERTIES OF CHLORINATED RUBBER

- General 2
- Physical 2
- Chemical Resistance 2
- Electrical 3
- Mechanical 3
- Thermal 3
- Physical-Chemical 3

VISCOSITY TYPES 4

SOLVENT COMPATIBILITY 4

FORMULATION AND PROPERTIES OF CHLORINATED RUBBER 5

- Formulations for Aroclor Resins and Plasticizers 5
- Properties of Formulated Films 6

APPLICATIONS 7

- Alkali-Resistant Coatings 7
- Chemical-Resistant Finishes 8
- Continuous Metal-Painting Process 9
- Marine Finishes 9
- Emulsion Paints 10
- Mastics 10
- Paper and Textile Coatings 10
- Adhesives 11
- Electrical Coatings 11
- Printing Inks 11

OTHER MONSANTO PLASTICIZERS FOR CHLORINATED RUBBER 11

TOXICITY AND SAFE HANDLING 12

SHIPPING 13

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INTRODUCTION

Monsanto's AROCLOR chlorinated biphenyls and chlorinated triphenyls are used as plasticizers and resins for chlorinated-rubber-based lacquers, varnishes, and paints. These protective coatings are flame retardant, corrosion resistant, chemical resistant (to acids, alkalies, and water), and have good electrical insulating properties.

When properly pigmented, these coatings have unusually good weatherability. Chlorinated-rubber films plasticized with an AROCLOR compound grip common structural materials in strong adhesive bonds, and the addition of an AROCLOR compound improves the flexibility and life of chlorinated-rubber coatings.

The formulations suggested in this bulletin are common in commercial practice. They are given as starting points or guides for development of new formulations that capitalize on the outstanding qualities of these compounds.

NUMBERING AROCLOR COMPOUNDS

The first two digits of the number of an AROCLOR compound represent its molecular type, as:

12—chlorinated biphenyls

25—blend of chlorinated biphenyls, 75 per cent, and chlorinated terphenyls, 25 per cent

44—blend of chlorinated biphenyls, 60 per cent, and chlorinated terphenyls, 40 per cent

54—chlorinated terphenyls

The last two digits indicate the weight percentage of chlorine in the product. For example:

AROCLOR 1248 is a chlorinated biphenyl that contains 48-weight-per cent chlorine

AROCLOR 4465 is a 60 biphenyl : 40 terphenyl mixture chlorinated to 65-per cent chlorine

AROCLOR 5460 is a chlorinated terphenyl with 60-weight-per cent chlorine

The physical properties of the AROCLOR plasticizers vary gradually with the degree of chlorination. Compounds with low percentages of chlorine, such as AROCLOR 1221 and 1232, are clear and very fluid. AROCLOR 1242, with 42-per cent chlorine, resembles vegetable oil; the product with 48-per cent chlorine is slightly more viscous and looks like a medium-grade mineral oil. At 54-per cent chlorine, the compound is quite viscous; if a bottle containing it is turned upside down, the bubble rises slowly to the top. At higher chlorine percentages, the chlorinated biphenyls become gumlike, and a fingerprint on the surface lasts several days. Then at 68-per cent chlorine, the range is complete; AROCLOR 1268 is a white powder. Both chlorinated terphenyls (AROCLOR 5442 and 5460) are yellow solids.

The gradual change in physical properties often allows a processor to select a plasticizer particularly suited for his operation. For example, if he wants to dry mix the plasticizer, AROCLOR 1268 could be used. It melts at higher processing temperature and can act as a solvent-plasticizer. Complete physical properties and specifications for the AROCLOR compounds are listed in technical bulletin PL-306, "AROCLOR Plasticizers."

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PROPERTIES OF CHLORINATED RUBBER

Chlorinated-rubber-based coatings are widely used because of their resistance to corrosive agents, moisture, fungus, mold, and other destructive agents.

*Parlon** chlorinated rubber is a mixture of two polymers, with an average chlorine content of 67 per cent, made by chlorination of natural rubber. Its typical properties, according to the manufacturer, Hercules Powder Company, Wilmington, Delaware, are listed in Table I:

TABLE I—TYPICAL PROPERTIES OF CHLORINATED RUBBER

General

Form as shipped	White, granular powder
Color of film	Water white
Odor	None
Clarity of film	Good
Taste	None
Moisture, per cent, as shipped	0.5 Maximum

Physical

Specific gravity	1.64
Specific volume, as shipped, cubic inches per pound	16.9
Bulking value, gallons per pound	0.0735
Refractive Index, at 25°C	1.554

Chemical Resistance to:

Acids, weak	excellent
Acids, strong	excellent
Alkalies, weak	excellent
Alkalies, strong	excellent
Salt spray	good
Alcohols	excellent
Ketones	soluble
Esters	soluble
Hydrocarbons, aromatic	soluble
Hydrocarbons, aliphatic	good
Oils, mineral	good
Oils, animal	poor
Oils, vegetable	poor

**Parlon* is a registered trademark of Hercules Powder Co.*

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Electrical (clear, unplasticized film*)

Specific surface resistance, ohms x 10^{10}	2000
Dielectric strength, volts per mil (ASTM method)	2300
Dielectric constant at 25°C and 1000 cycles	3.1
Power factor at 25°C and 1000 cycles	0.0015 to 0.0030
Power factor at 25°C and 1000 cycles, after immersion in water for 140 hours and surface wiped dry	0.0027

Mechanical (clear, unplasticized film*)

	20-cp. type	1000-cp. type
Tensile strength, dry, pounds per square inch	4270	4850
Tensile strength, wet, pounds per square inch	4100	4360
Elongation, dry, per cent	3.6	3.3
Elongation, wet, per cent	3.8	3.4
Modulus of elasticity, pounds per square inch	1.4 x 10^5	.....
Hardness, Sward index, per cent of glass	90	.....

Note: Flexibility of *Parlon* film increases with viscosity of *Parlon* used.

Thermal (clear, unplasticized film*)

Burning rate	nonflammable
Effect of dry heat on film	stable at 125°C
Softening point, °C	decomposes at 135 to 150

Physical-Chemical (clear, unplasticized film*)

Effect of sunlight	Discolors and embrittles
Effect of aging	Very slight
Effect of hot water	Blushes
Effect of cold water	None
Moisture absorption (80% relative humidity for 24 hours), per cent	0.27
Moisture-vapor permeability of 0.003-inch film (grams water/square centimeter/0.01 centimeter/hour at 21°C)	0.2 x 10^4

*Laid down from toluene solution

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VISCOSITY TYPES

TABLE II—"PARLON" VISCOSITY TYPES

Viscosity Type	Viscosity Range (centipoises)
5 cp.	5 to 7
10 cp.	8 to 12
20 cp.	16 to 25
125 cp.	110 to 190
1000 cp.	800 to 2000

Examples of actual or suggested applications of the several viscosity types are as follows:

Type	Example of Use
5 cp.	In printing inks and as a fortifier for alkyd resin enamels
10 cp.	In high-solids finishes and as a fortifier for alkyd resin and oleoresinous varnishes and enamels
20 cp.	As a film-former in protective coatings and as a fortifier in enamels and varnishes
125 cp.	As a film-former in protective coatings, in paper lacquers, adhesives, and textile finishes
1000 cp.	As a film-former in adhesives, textile finishes, and other finishes where flexibility is important

SOLVENT COMPATIBILITY

Solvents and solvent mixtures suggested for use in preparing formulations with AROCLOR and *Parlon* are given in Table III:

TABLE III—SUGGESTED SOLVENTS FOR COMPOSITIONS WITH AROCLOR AND PARLON

Amsco Solv[a] B and E	Methyl isobutyl ketone
Amyl acetate	Methyl salicylate
Butyl acetate	*Mobilsol*[c] Nos. 74, 75
Carbon tetrachloride	*Notol*[d]
Cellosolve[b]	Octyl acetate
Diacetone alcohol	*Solvesso*[e] 100
Diethyl carbonate	*Tollac*[d]
Ethyl acetate	Toluene
Ethylene dichloride	Trichloroethylene
Hi-Flash naphtha	*Union*[f] Aromatic Solvent 3553-10
Methyl acetate	*Union* Solvent No. 30
Methyl ethyl ketone	Xylene

a) Trademark of American Mineral Spirits Co.
b) Trademark of Union Carbide Chemical Co.
c) Trademark of Socony Mobil Oil Co.
d) Trademark of Neville Chemical Co.
e) Trademark of Esso Standard Oil Co.
f) Trademark of Union Oil Co.

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Chlorinated-Rubber Films

Although chlorinated rubber is unaffected by acids, alkalies, salts, moisture, and fungus, it is very hard and brittle. Consequently plasticizers and plasticizing resins must be added to make useful coatings. To make chemical- and corrosion-resistant coatings, the modifiers must likewise be nonreactive with acids, alkalies, and salts. As little as five per cent of a saponifiable material, such as linseed oil, alkyd resin, or ester plasticizer, seriously detracts from the alkali resistance of the finished coating. Monsanto AROCLOR compounds, such as AROCLOR 5460 and AROCLOR 1254 or 1260, are the best available plasticizing resin and plasticizers, respectively, since they are unaffected by acids, alkalies, or salts. The following table summarizes some of the benefits imparted to chlorinated rubber coatings by the presence of AROCLOR plasticizers:

TABLE IV—BENEFITS OF AROCLOR PLASTICIZERS IN CHLORINATED RUBBER

	GOOD ADHESION TO				RESISTANCE TO					
Aroclor	Alum-inum	Steel	Transite	Cello-phane	10% Hydro-chloric Acid	5% Sodium Hydrox-ide	Sodium Chlor-ide	Water	Sward Hard-ness	Cold-Check Resist-ance
1254	—	—	X	X	X	X	X	X	35	3
1260	—	—	X	X	X	X	X	X	40	4
5460	X	X	X	—	X	X	X	X	22	2

AROCOLOR 1262 and 5460, resinous types, show good compatibility in chlorinated-rubber films laid down from toluene solution containing 20-per cent of the plastic in ratios of 2:1 and 1:1 (*Parlon* to AROCLOR). The plasticizer types, AROCLOR 1252, 1254, and 1260, also show good compatibility. Formulations and properties of films derived from both resin- and plasticizer-type AROCLOR are listed in Table V:

TABLE V—FORMULATIONS CONTAINING AROCLOR RESINS OR PLASTICIZERS

Ingredient	Parts by Weight								
Parlon, 20-cp	16	16	16	12	12	12	20	20	20
AROCLOR 5460	8	8	8	12	12	12	—	—	—
AROCLOR 1254 or 1260	—	—	—	—	—	—	4	7	20
Dibutyl phthalate	—	4	—	—	3	—	—	—	—
Tung oil, Thermolyzed, 976	—	—	5	—	—	3.75	—	—	—
Xylene or butyl acetate	76	72	71	76	73	72.25	76	73	70

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The AROCLOR compounds impart characteristics to the films cast from these lacquers, including the following advantages:

Adhesion

Unplasticized chlorinated-rubber films have very poor adhesion. The lacquer film containing AROCLOR 5460 adheres well to aluminum, bare steel, primed steel, galvanized iron, and *Transite* surfaces. The lacquer films plasticized with AROCLOR 1254 or 1260 give good adhesion to *Transite*, cellophane, galvanized iron, and primed-steel surfaces.

Though compounds with an AROCLOR alone possess pronounced adhesion qualities, better adhesion to all of the surfaces results if mixtures of AROCLOR or varied contents are used.

Resistance to Aqueous Solutions

Chlorinated-rubber films with AROCLOR 1254 or 1260 (plasticizers) and AROCLOR 5460 (resin) show satisfactory resistance to solutions of 10-per cent hydrochloric acid, 5-per cent sodium hydroxide, 5-per cent sodium chloride, and water-spot tests.

Film Hardness

Softer films are produced with AROCLOR 5460 in ratios of 5:10 and 10:10 (AROCLOR-*Parlon*) than with other commercial resins in similar mixtures. Likewise, softer films result from AROCLOR 1254 or 1260 in ratios of 2:10 and 5:10 (AROCLOR:*Parlon*) than with other commercial plasticizers at these concentrations. These tests show that AROCLOR compounds have strong plasticizing action on chlorinated rubber.

Cold-Check Resistance

AROCLOR 5460 is superior to phenol-formaldehyde resins in cold-check resistance imparted to chlorinated-rubber films, but not as good as long-oil-alkyd modification. AROCLOR 1260 is a somewhat better plasticizer than AROCLOR 1254.

Weather Resistance

Pigmented chlorinated-rubber finishes containing AROCLOR have consistently withstood outdoor weather tests, but unpigmented finishes do not weather well regardless of the resin or plasticizer used.

Poor resistance to ultraviolet light is also a weakness of chlorinated rubber. Most pigments (except ultramarine blue) are usable with *Parlon* and are recommended if the coating is to be subjected to outdoor weather or ultraviolet light. However, pigment protection varies considerably. Inspection of alkyd enamels fortified with *Parlon* showed weatherability varied from 63 months with chrome green to 4 months for titanium dioxide-iron blue combinations.

Sanding and Polishing Properties

Plastic films compounded with *Parlon* and AROCLOR 5460, 1254, or 1260 have showed satisfactory sanding and polishing characteristics.

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APPLICATIONS

Alkali-Resistant Coatings

Products containing AROCLOR and chlorinated rubber are highly resistant to alkalies and moisture. Paints with combinations of AROCLOR and chlorinated rubber are used in large quantities for concrete floors, walls, swimming pools, and other surfaces. Paint formulations are suggested in Table VI:

TABLE VI—PAINTS FOR ALKALINE SURFACES

Ingredients	Basement Floors (parts)	Fed-Spec. TT-P-91 (parts)	Concrete Swimming Pool (parts)
Parlon (20-cp.) chlorinated rubber	100	100	100
Medium-oil, drying alkyd resin	.....	.....	50
Long-oil, drying alkyd resin	45	.....	.....
AROCLOR 1254	55	56	50
AROCLOR 5460	.....	33	.....
Titanium Dioxide	89	89	112
Zinc Oxide	11	11	.....
Silica Flour	17	.....	.....
Carbon Black	1	3	.....
Magnesium Silicate	.....	.....	115
*Bentone** 34 gelling agent	12	12	13
Epichlorohydrin	.....	.....	1
Xylene	239	.....	.....
Hi-Flash naphtha	.....	.....	450
Turpentine	.....	26	.....
Solvesso 100	.....	.....	90
Solvesso 150	.....	237	.....

*Trademark of National Lead Co.

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Chemical-Resistant Finishes

Particular care is necessary in choosing resins and plasticizers for chemical-resistant paints. Chlorinated-rubber formulations with an AROCLOR plasticizer have proved outstanding for acid and alkali resistance. Five suggested formulations are shown in Table VII.

TABLE VII—FORMULATIONS FOR CHEMICAL-RESISTANT PAINTS

Ingredients	Exterior[a] use, acids (parts)	Exterior[b] use, alkalies (parts)	Interior[c] use, acids and alkalies (parts)	Maximum[d] resistance, acids and alkalies (parts)	Soap[e] resistant (parts)
Parlon, (20-cp.) chlorinated rubber	100	100	100	100	100
Phenolic resin	.....	40	.....	.....	.....
Alkyd resin	40	.....	.....	.....	.....
AROCLOR 1254	30	30	50	45	.....
AROCLOR 1260	.....	.....	.....	33	.....
AROCLOR 5460	.....	.....	40	.....	50
Tung oil, Thermolyzed, 976	30	30	.....	.....	64
Iron oxide	100	100	100	100	.....
Titanium dioxide	.....	.....	.....	.....	150
Zinc oxide	.....	.....	.....	.....	50
Epichlorohydrin	.....	.....	.....	0.5	.....
Stabilizer	.....	.....	.....	5	.....
Xylene	325	325	330	.....	245
Toluene	.....	.....	.....	.....	100
Solvesso 100	.....	.....	.....	250	.....
Hi-Flash naphtha	.....	.....	.....	.....	86
Turpentine	.....	.....	.....	28	.....

These formulations were applied to metal bars or panels and tested for resistance:

a) Excellent outdoor protection to metal surfaces in acid-manufacturing plants

b) Good performance on exteriors of alkali-producing plants

c) Good resistance to 10-per cent hydrochloric acid and 5-per cent sodium hydroxide solutions

d) Excellent resistance to acids, alkalies, and salt solutions (Also adhered well to glass and other surfaces)

e) Good resistance to warm, soapy water

Note: No finishes with AROCLOR or chlorinated rubber are recommended for continuous exposure at temperatures above 140° F.

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Continuous Metal-Painting Process

A recently-developed continuous-painting process for finishing metal offers savings on capital investment, plant space, and operating costs. The technique utilizes the physical properties of trichloroethylene, the only solvent in the paint. Metal parts enter the unit covered with grease and leave the other end completely painted and dry to the touch. Detailed information about the process can be obtained from Du Pont, Wilmington, Delaware. The formulation in Table VIII has given good characteristics in this continuous-painting system:

TABLE VIII—FORMULATION FOR CONTINUOUS-PAINTING PROCESS

	Parts by Weight	
Ingredients	Vehicle	Pigment[a] Dispersion
Parlon (20-cp) chlorinated rubber	100	.....
Long-oil, drying, alkyd resin	15	23.7
AROCLOR 1254	50	.....
Titanium Dioxide (Rutile)	.....	100
Bentone 38 gelling agent	.....	1.25[b]
Epoxy stabilizer	3.9	.....
Trichloroethylene	217	53.5

a) Add pigment dispersion to vehicle after 24 hours in pebble mill

b) Add gelling agent to pigment dispersion during last two hours of grind

Marine Finishes

The marine industry makes great use of chlorinated-rubber coatings plasticized with AROCLOR compounds to protect wood and metal on boats, barges, and other marine equipment. They resist salt water, and their hard finish deters algae and other marine growth. A suggested formula for a white marine paint is given in Table IX:

TABLE IX—FORMULATION FOR A WHITE MARINE PAINT

Ingredients	Parts by Weight
Parlon (20-cp) chlorinated rubber	77
Long-oil, oxidizing, alkyd resin	23
AROCLOR 1254	23
Titanium dioxide	96.5
Xylene	87.5
Hi-Flash Naphtha	77

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Emulsion Paints

If chemical resistance is required on porous surfaces, AROCLOR 1254 is often added to chlorinated-rubber-emulsion paints. Hercules Powder Company reports that preferred water phases for such paints are either a 1-per cent-distilled-water solution of *Aerosol** OT or a 4-per-cent-distilled-water solution of sodium oleate. A lacquer-to-water weight ratio of 2.5 to 1 is suggested for the complete emulsion. Chlorinated rubber of any viscosity may be used. A typical lacquer phase for such an emulsion paint is given in Table X:

TABLE X—FORMULATION FOR LACQUER PHASE OF EMULSION PAINT

Ingredients	Parts by Weight
Parlon chlorinated rubber	28
AROCLOR 1254	14
AROCLOR 5460	10
Xylene	24
Hi-Flash naphtha	24

Mastics

Mastic compositions are used to deposit thick films with a minimum number of coats. Mastics modified with AROCLOR compounds can effectively seal cracks in concrete, smooth rough concrete surfaces for subsequent glossy coatings, give excellent corrosion resistance under severe conditions, and retard fire. A typical starting formulation is given in Table XI:

TABLE XI—MASTIC COMPOSITION

Ingredients	Parts by Weight
Parlon (20-cp) chlorinated rubber	100
AROCLOR 1254	30
AROCLOR 5460	49
Asbestos	160
Titanium Dioxide (Rutile)	25
Toluene	300

Although this mastic formulation adheres well to either wood or masonry, a primer is suggested before application to steel. To further increase fire retardance, replacement of 33 parts of the asbestos by 47 parts of antimony oxide is suggested as a starting formulation.

Paper and Textile Coatings

Chlorinated-rubber coatings with AROCLOR plasticizers are worthy of consideration for specific end uses on paper and textiles, although they are generally restricted by odor. Unpigmented finishes are suitable for certain fabrics used indoors, but not for exposure to high temperatures or direct sunlight.

*Trademark of American Cyanamid Co.

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Adhesives

Chlorinated-rubber adhesives with an AROCLOR plasticizer were developed originally for acid-bottle labels because of their general resistance to chemicals. These adhesives are also of unusual interest because they are flame resistant. A typical formulation is given in Table XII:

TABLE XII—FORMULATION FOR ACID- AND FLAME-RESISTANT ADHESIVE

Ingredients	Parts by Weight
Parlon (125-cp.) chlorinated rubber	20
AROCLOR 1254	6
AROCLOR 1260	6
Toluene	68

Electrical Coatings

Because of their desirable electrical properties, these compositions are useful for insulating and protecting electrical wire and apparatus from moisture. With selected fungistats and waxes, coatings of this type are used to protect electronic equipment in the tropics against moisture and fungi. The fire retardance of AROCLOR-*Parlon* combinations is an added dividend in the electrical field.

Printing Inks

Printing inks requiring fast drying time and chemical resistance are often based on chlorinated-rubber compositions plasticized with an AROCLOR compound. These inks are especially useful on soap wrappers and boxes, bottle labels, and many other commodities because of their alkali resistance.

OTHER MONSANTO PLASTICIZERS COMPATIBLE WITH CHLORINATED RUBBER

The following Monsanto plasticizers (Table XIII) are also compatible with chlorinated rubber, but none gives the over-all desired qualities attained by using an AROCLOR plasticizer:

TABLE XIII—OTHER MONSANTO PLASTICIZERS COMPATIBLE WITH CHLORINATED RUBBER

Dibutyl phthalate	*Santicizer* M-17
Diethyl phthalate	*Santolite** MHP
Dimethyl phthalate	Tricresyl phosphate
*Santicizer** B-16	Triphenyl phosphate

*Santicizer and Santolite are Monsanto Chemical Company trademarks, registered in the U.S. Patent Office.

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TOXICITY AND SAFE HANDLING

Inhalation

At ordinary temperatures the AROCLOR chlorinated polyphenyls have not presented industrial toxicological problems. The hazard of potential toxic exposure varies with their volatility: the lower-chlorinated, more-volatile ones present more of a potential problem from the standpoint of both inhalation and skin contact. When AROCLOR compounds are used at elevated temperatures, engineering controls must be applied, either by the use of closed systems or by effective local-exhaust ventilation together with general workroom exhaust.

Vapor of the liquid AROCLOR compounds at room temperature should not be breathed in a confined space, and no vapor of any AROCLOR compound evolved at elevated temperatures should be allowed to be dispersed into the general workroom.

Inhalation tests on animals indicate that the maximum safe concentration of vapor is in the range of from 0.5 to 1.0 milligram of the lower-chlorinated AROCLOR compounds per cubic meter of air. The threshold limits (maximum allowable concentration for an 8-hour working day) set by the American Conference of Government Hygienists are 1.0 milligram of the lower-chlorinated AROCLOR compounds per cubic meter of air and 0.5 milligram of the more-highly-chlorinated compounds, such as AROCLOR 1254, per cubic meter of air.

Skin Contact

Schwartz patch tests on 200 volunteers showed that AROCLOR 1254 was neither a primary skin irritant or a sensitizer.

Continuous or repeated skin contact with the AROCLOR compounds must be avoided by the use of gloves and protective garments, because of the possible occurance of a condition called chloracne. Although reports of this condition caused by AROCLOR compounds are rare, it can be produced by excessive skin contact. If any AROCLOR compound is spilled on the skin, the skin should be washed in the usual manner with a soap solution.

A burn caused by contact with a hot AROCLOR compound should be treated like any ordinary burn. AROCLOR compound adhering to the burned area need not be removed immediately, unless treatment of the burn demands it, in which case either soap and water or repeated washings with a vegetable oil are recommended.

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SHIPPING

Freight Classification

AROCLOR 1221, 1243, 1242, 1248, 1254, 1260, 1262	Synthetic Resin, Liquid, NOIBN

Rail Classification

AROCLOR 1268, 2565, 4465, 5442, 5460	Synthetic Resin, Other Than Liquid, NOIBN

Truck Classification

AROCLOR 1268, 2565	Synthetic Resin, Powder, NOI
AROCLOR 4465, 5442, 5460	Synthetic Resin, Lumps or Solid Mass, NOI

Shipping Regulations None

Standard Containers

AROCLOR 1221	Tank car, 520-lb. steel drum, 50-lb. can
AROCLOR 1232	Tank car, 550-lb. steel drum, 50-lb. can
AROCLOR 1242, 1248, 1254, 1260, 1262	Tank car, 600-lb. steel drum, 50-lb. can
AROCLOR 1268	200-lb. fiber drum, 50-lb. can
AROCLOR 2565, 4465	500-lb. steel drum, 50-lb. can
AROCLOR 5442	450-lb. steel drum, 50-lb. can
AROCLOR 5460 (flaked)	100-lb. bag

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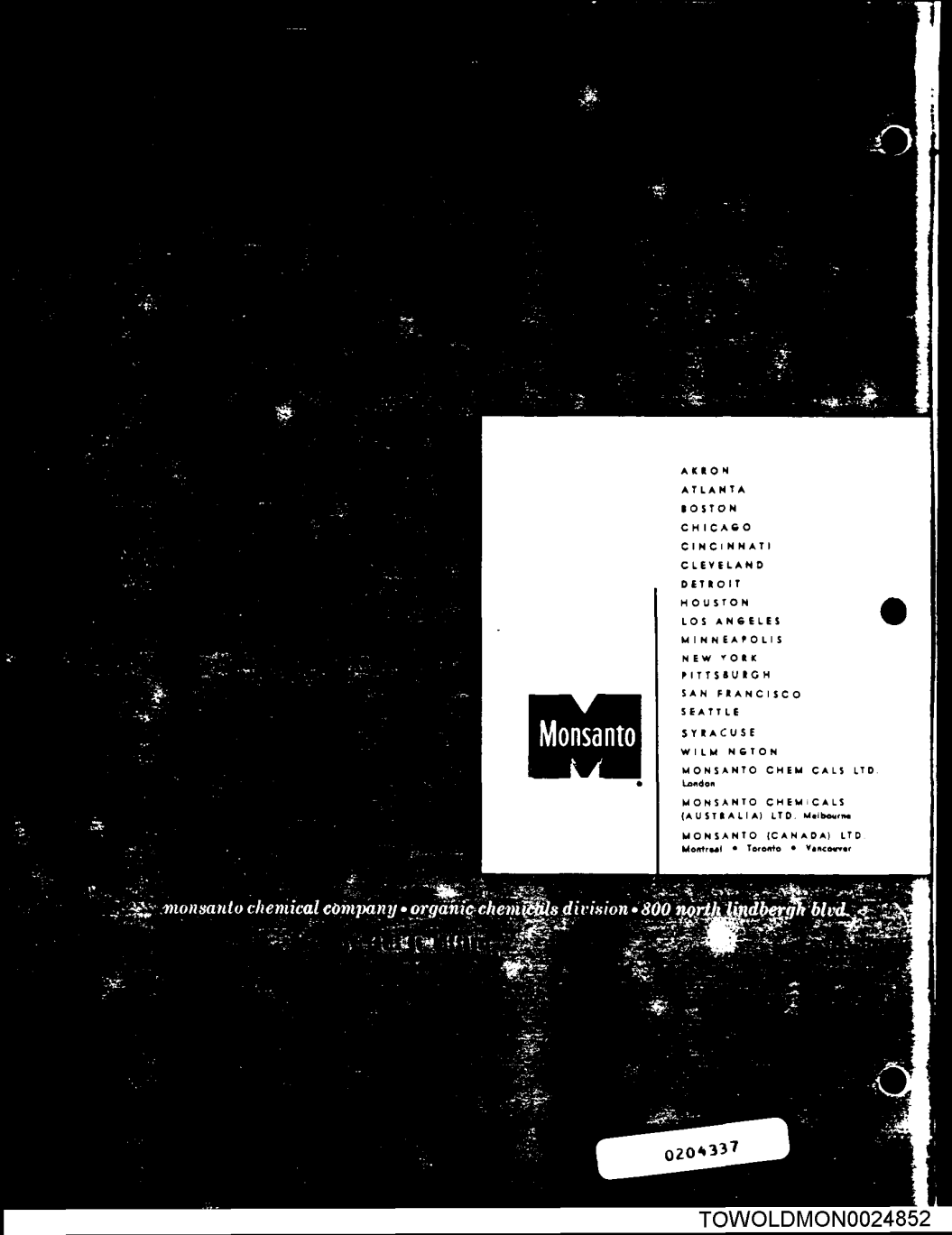

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