T E C H N I C A L B U L L E T I N

AROCLOR® PLASTICIZERS

A series of inert, chemically-resistant, fire-retarding plasticizers compatible with wide variety of resins.

TECHNICAL BULLETIN O/PL-306A

Monsanto

EXHIBIT
WBP M-45

MON-MT-000844

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TECHNICAL BULLETIN O/PL-306A

CAUTION: see sections entitled Toxicity and Safe Handling, and Environmental Hazzards, on page 12.

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Organic Chemicals Division/800 N. Lindbergh Blvd./St. Louis, Missouri 63166

MON-MT-000845

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Introduction

The unique Aroclor® plasticizers are among the most versatile chemically produced materials available. One outstanding characteristic — *inertness* — makes Aroclor useful in many ways for many different applications. The major benefits offered by Aroclor include:

- Chemical Resistance
- Fire Retardance
- Compatibility with most resins
- Nonoxidation
- Adhesivity
- Low Cost

Monsanto's Aroclor plasticizers comprise a series of chlorinated biphenyls and chlorinated polyphenyls. They vary from mobile, oily liquids to white crystals and hard, transparent resins.

Twelve of the Aroclor plasticizers, each of which represents a series, are discussed in this bulletin. An understanding of the system for designation of each Aroclor should prove useful in the evaluation of the property gradations among them. The last two digits indicate the approximate weight percentage of chlorine in the product, and the first two digits indicate the type of material, as follows:

12 — chlorinated biphenyls

25 — blend of chlorinated biphenyls and chlorinated triphenyls (75:25)

44 — blend of chlorinated biphenyls and chlorinated triphenyls (60:40)

54 — chlorinated triphenyls

For nearly every Aroclor mentioned, a darker, less-pure grade exists, with about the same physical and chemical characteristics, but lower in price.

Solubility

The Aroclor liquids and resins are readily soluble in most common organic solvents and drying oils. Although all Aroclor plasticizers are insoluble in water, the hard, crystalline materials are generally less soluble than the liquids and softer resins. Solubilities of some Aroclor plasticizers are shown in Table 1.

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TABLE 1

SOLUBILITIES OF AROCLOR® PLASTICIZERS IN VARIOUS SOLVENTS

Solvent	Aroclor 1242 25°C	Aroclor 1242 Hot	Aroclor 1248 25°C	Aroclor 1248 Hot	Aroclor 1254 25°C	Aroclor 1254 Hot	Aroclor 1268 Cold	Aroclor 1268 Hot	Aroclor 4465 Cold	Aroclor 4465 Hot	Aroclor 5460 25°C
Acid											
Acetic Acid	S	S	—	—	S	S	—	—	SS	S	—
Oleic Acid	S	S	—	—	S	S	—	—	S	VS	—
Benzoic Acid	10.0[31°C]	—	10.0[32°C]	—	—	—	—	—	—	—	—
Aldehyde											
40% Formaldehyde	I	I	I	I	I	I	I	I	I	I	—
Furfural	VS	VS	VS	VS	VS	VS	SS	SS	VS	VS	—
Amine											
Aniline	S	S	—	—	S	S	—	—	VS	VS	—
Pyridine	132.5[30°C]	440[99°C]	—	—	114.3[9°C]	425[100°C]	—	—	VS	VS	—
Chloro derivatives											
Amyl chlorides — mixed	S	S	S	S	S	S	—	—	VS	VS	—
Carbon Tetrachloride	S	S	S	S	S	S	—	—	VS	VS	156
Chloroform	S	S	S	S	S	S	S	S	VS	VS	—
Dichlorethylene	—	—	—	—	—	—	—	—	VS	VS	—
Ethylene Dichloride	S	S	S	S	S	S	S	S	VS	VS	—
Monochlorobenzene	S	S	S	S	S	S	—	—	VS	VS	—
Orthodichlorobenzene	—	—	—	—	—	—	—	—	VS	VS	—
Tetrachlorethane	S	S	S	S	S	S	—	—	VS	VS	—
Trichlorethane	S	S	S	S	S	S	—	—	VS	VS	—
Trichlorethylene	S	S	S	S	S	S	—	—	VS	VS	—
Drying Oil											
Tung Oil	S	S	S	S	S	S	—	—	VS	VS	—
Linseed Oil	S	S	S	S	S	S	I	S	VS	VS	—
Ester											
Amyl Acetate	S	S	S	S	S	S	S	S	VS	VS	—
Butyl Acetate	S	S	S	S	S	S	S	S	VS	VS	—
"Cellosolve"® Acetate	S	S	S	S	S	S	—	—	VS	VS	—
Cottonseed Oil	S	S	S	S	S	S	—	—	S	VS	—
Dibutyl Phthalate	S	S	S	S	S	S	S	S	S	VS	—

MON-MT-000847

TOWOLDMON0003378

Diethyl Phthalate	S	S	S	S	S	S	—	—	S	VS	—
Ethyl Acetate	S	S	S	S	S	S	SS	SS	S	VS	—
Ethyl Lactate	S	S	S	S	S	S	I	S	VS	VS	—
Ethylene Glycol Diacetate	S	S	S	S	S	S	—	—	VS	VS	—
Methyl Acetate	S	S	S	S	S	S	SS	SS	S	S	—
Tricresyl Phosphate	S	S	S	S	S	S	—	—	SS	S	—
Ether: Ethyl Ether	S	S	S	S	S	S	S	S	S	—	—
Ether Alcohol											
Carbitol®	$224^{31°C}$	$307^{99°C}$	VS	VS	$173^{26°C}$	$259^{98°C}$	I	S	SS	—	—
Cellosolve	S	S	S	S	S	S	I	S	S	—	—
Diethylene Glycol	—	—	—	—	—	—	—	—	S	—	—
p,p'-Dihydroxy Ethyl Ether	$16.9^{23°C}$	$19^{99°C}$	SS	SS	$8^{30°C}$	$10^{100°C}$	—	—	SS	—	—
Hydrocarbon											
Benzene	VS	VS	VS	VS	VS	VS	S	S	VS	VS	143
Gasoline	VS	VS	VS	VS	VS	VS	—	—	VS	VS	—
Kerosene	VS	VS	VS	VS	VS	VS	SS	S	VS	VS	—
Mineral Spirits	VS	VS	VS	VS	VS	VS	S	S	VS	VS	—
Paraffin	$2.0^{27.5°C}$	S	$2.0^{28°C}$	S	—	S	—	—	5.0	S	—
Pine Oil	S	S	VS	VS	S	S	S	S	S	S	—
Toluene	VS	VS	VS	VS	VS	VS	S	S	VS	VS	142
Turpentine	VS	VS	VS	VS	VS	VS	S	S	VS	VS	—
Xylene	VS	VS	VS	VS	VS	VS	S	S	VS	VS	178
Hydroxy derivatives											
Amyl Alcohol	S	S	—	—	S	S	SS	S	S	S	—
n-Butyl Alcohol	S	S	—	—	S	S	I	SS	SS	S	—
Ethyl Alcohol (3-A)	$23.3^{29°C}$	$80.0^{70°C}$	—	—	$10^{27°C}$	$28^{78°C}$	I	I	SS	—	—
Glycerine	I	I	I	I	I	I	I	I	I	I	—
Methyl Alcohol	$42.5^{29°C}$	$88.5^{60°C}$	—	—	$15^{26°C}$	$22.2^{65°C}$	—	—	SS	—	—
Phenol — 90%	$194^{30°C}$	S	—	—	SS	S	SS	S	S	S	—
Ketone: Acetone	S	S	—	—	S	S	I	I	S	S	260
Miscellaneous											
Carbon Disulfide	S	S	—	—	S	S	S	S	VS	VS	—
Nitrobenzene	S	S	—	—	S	S	—	—	VS	—	—
Water	I	I	I	I	I	I	I	I	I	I	—

I — Insoluble SS — Slightly Soluble S — Soluble VS — Very Soluble.
Figures show grams of Aroclor per 100 milliliters of solvent at 25°C unless otherwise indicated.

*Trademark of Union Carbide Corp.

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TABLE 2

CHEMICAL AND PHYSICAL PROPERTIES OF REPRESENTATIVE AROCLOR® PLASTICIZERS AND RESINS

Property	*Aroclor 1221*	*Aroclor 1232*	*Aroclor 1242*	*Aroclor 1248*	*Aroclor 1254*
Appearance	Clear, mobile oil	Clear, mobile oil	Clear, mobile oil	Clear, mobile oil	Light-yellow viscous liquid
Color, maximum	*100 APHA	*100 APHA	*100 APHA	*100 APHA	*100 APHA
Chlorine, percent	20.5-21.5	31.5-32.5	42	48	54
Acidity, mg KOH/g, maximum	*0.014	*0.014	*0.015	*0.010	*0.010
Moisture, ppm, maximum	—	—	*50	*50	*50
Ave. Coefficient of Expansion, cc/cc/°C	0.00071 (15°-40°C)	0.00073 (25°-100°C)	0.00068 (25°-65°C)	0.00070 (25°-65°C)	0.00066 (25°-65°C)
Specific Gravity	*1.182-1.192 (25°/15.5°C)	*1.270-1.280 (25°/15.5°C)	*1.381-1.392 (25°/15.5°C)	*1.405-1.415 (65°/15.5°C)	*1.495-1.505 (65°/15.5°C)
Density, pounds per gallon, 25°C	9.85	10.55	11.50	12.04	12.82
Distillation Range, °C, corrected (ASTM D-20, modified)	275-320	290-325	325-366	340-375	365-390
Evaporation Loss, %, 100°C, 6 hours (ASTM D-6, mod.) 163°C, 5 hours	1.0-1.5	1.0-1.5	0-0.4 3.0-3.6	0-0.3 3.0-4.0	0-0.2 1.1-1.3
Flash Point (Cleveland Open Cup), °C °F	141-150 286-302	152-154 305-310	176-180 348-356	193-196 379-384	None to boiling point
Fire Point (Cleveland Open Cup), °C °F	176 349	238 460	None to boiling point	None to boiling point	None to boiling point
Pour Point (ASTM E-97), °C °F	1 (crystals) 34 (crystals)	—35.5 —32	—19 2	—7 19.4	10 50
Softening Point (ASTM E-28), °C °F	—	—	—	—	—
Refractive Index, n D-20 20°C	1.617-1.618	1.620-1.622	1.627-1.629	1.630-1.631	1.639-1.641
Viscosity, Seconds Saybolt Universal (ASTM D-88) 100°F (37.8°C)	*38-41	*44-51	*82-92	185-240	1800-2500
130°F (54.4°C)	35-37	39-41	49-56	*73-80	260-340
210°F (98.9°C)	30-31	31-32	34-35	36-37	*44-48

*Monsanto Specifications.

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Aroclor 1260	*Aroclor 1262*	*Aroclor 5442*	*Aroclor 4465*	*Aroclor 2565*	*Aroclor 5460*	*Aroclor 1268*
Light-yellow, soft, sticky resin	Light-yellow sticky, viscous resin	Clear yellow sticky resin	Clear, light-yellow, resin	Black, opaque, brittle resin	Clear, yellow-to-amber, brittle resin or flakes	White to off-white powder
*150 APHA	*150 APHA	*2 NPA (molten)	*2 NPA (molten)	—	*2 NPA (molten)	*1.5 NPA (molten)
60	61.5-62.5	42	65	65	58.5-60.6	68
*0.014	*0.014	0.05	0.05	1.4	0.05	0.05
*50	—	—	—	—	—	—
0.00067 (20°-100°C)	0.00064 (25°-65°C)	0.00123 (25°-99°C)	0.00061 (25°-65°C)	0.00066 (25°-65°C)	0.00179 (25°-124°C)	0.00067 (20°-100°C)
*1.555-1.566 (90°/15.5°C)	*1.572-1.583 (90°/15.5°C)	1.470 (25°/25°C)	1.670 (25°/25°C)	1.734 (25°/25°C)	1.670 (25°/25°C)	1.804-1.811 (25°/25°C)
13.50	13.72	12.24	13.91	14.44	13.91	15.09
385-420	390-425	215-300 (4 mm. Hg)	230-320 (4 mm. Hg)	—	280-335 (5 mm. Hg)	435-450
0-0.1 0.5-0.8	0-0.1 0.5-0.6	0.01 0.2	0-0.02 0.2-0.3	0.2-0.3	0.03	0-0.06 0.1-0.2
None to boiling point	None to boiling point	247 477	None to boiling point	—	None to boiling point	None to boiling point
None to boiling point	None to boiling point	> 350 > 662	None to boiling point	—	None to boiling point	None to boiling point
31 88	38-38 99	46 115	—	—	—	—
—	—	*46-52 115-126	*60-66 140-151	*66-72 149-162	*98-105 208-222	*150-170 (hold 302-338 point)
1.647-1.649	1.6501-1.6517	—	1.664-1.667	—	1.660-1.665	—
3200-4500 *72-78	600-850 (160°F; 71°C) *86-100	300-400	90-150 (266°F; 130°C)	—	—	—

*Monsanto Specifications.

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Density

All the Aroclor plasticizers are heavier than water, a valuable property for many applications. Densities are shown in Figure 1.

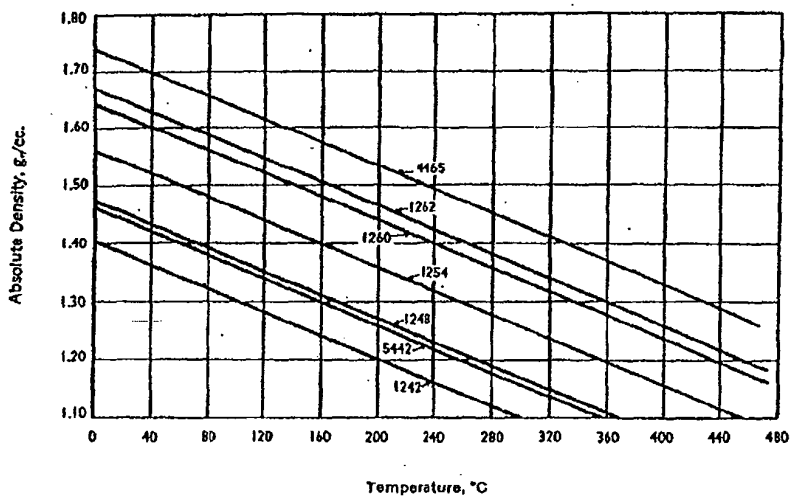

Fig. 1 — Densities of Aroclor® Plasticizers at Various Temperatures

Specific Volume

The specific volume of Aroclor 1248 at different temperatures is as follows:

Temperature (°F)	*Aroclor® 1248 Specific Volume (ml/g)*
0	0.674
100	0.699
200	0.726
300	0.755
400	0.790
500	0.828
600	0.870

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Volatility

The low vaporization loss of Aroclor plasticizers is indicated in Table 3.

TABLE 3

VAPORIZATION RATES OF AROCLOR® PLASTICIZERS

Plasticizer (Surface area: 12.28 sq. cm.)	*Wt. Loss (g)*	*Exposure at 100°C (hr.)*	*Vaporization Rate (g/sq. cm./hr.)*
Aroclor 1221	0.5125	24	0.00174
Aroclor 1232	0.2572	24	0.000874
Aroclor 1242	0.0995	24	0.000338
Aroclor 1248	0.0448	24	0.000152
*Cloralin**-42-S	0.0745	48	0.000126
Dioctyl phthalate	0.0686	48	0.000117
*Dutrex*** 25	0.0258	24	0.000087
Aroclor 1254	0.0156	24	0.000053
Shell Dutrex 20	0.0047	24	0.000016
Aroclor 1262	0.0039	24	0.000013
Aroclor 1260	0.0026	24	0.000009
Aroclor 4465	0.0064	72	0.000007
Aroclor 5442	0.0039	72	0.000004
Aroclor 5460	0.0032	72	0.000004
Tricresyl phosphate	0.0010	24	0.000003

It is concluded that the vaporization rates of Aroclor plasticizers — especially the most widely used 1254 and 1260 — compare most favorably with the similar constants of other plasticizers selected specifically for these tests because of their low vaporization rates.

*Trademark of Hercules, Inc.
**Trademark of Shell Oil Co.

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The vapor pressures of several Aroclor plasticizers are indicated in Figure 2 over the temperature range 150° to 300°C.

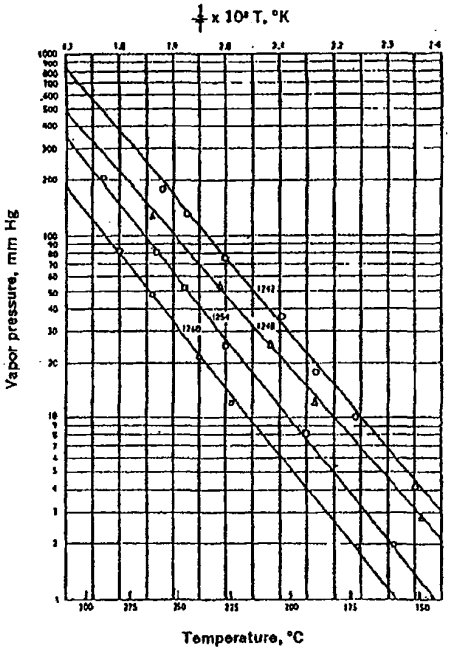

Fig. 2 — Vapor Pressures of Aroclor® Plasticizers

The estimated vapor pressures of several Aroclor plasticizers at 100°F shown in the following table were determined by extrapolation from the values shown in Figure 2.

Approximate Vapor Pressure of Aroclor® Plasticizers Estimated at 100° F (37.8° C)

Aroclor 1232	0.005 mm. Hg
Aroclor 1242	0.001 mm. Hg
Aroclor 1248	0.00037 mm. Hg
Aroclor 1254	0.00006 mm. Hg

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Viscosity

The viscosities of the Aroclor plasticizers vary according to whether the base material is a biphenyl or a polyphenyl and on the degree of chlorination. In general the low-chlorinated biphenyls have the lowest viscosities (Figure 3).

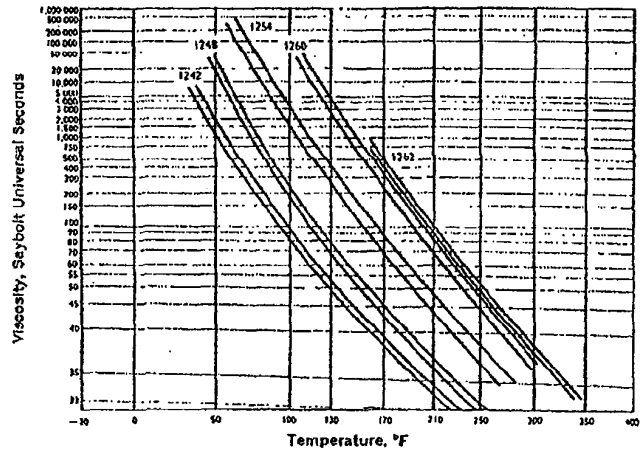

Fig. 3 — Viscosity Ranges of Some Aroclor® Plasticizers

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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 plasticizers 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 plasticizers at room temperature should not be breathed in a confined space, and no vapor of any Aroclor 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 plasticizers per cubic meter of air. The threshold limit values (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.

Prolonged or repeated skin contact with the Aroclor plasticizers must be avoided by the use of gloves and protective garments, because of the possible occurrence of a condition called chloracne. Although reports of this condition caused by Aroclor are rare, it can be produced by excessive skin contact. If any Aroclor 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 should be treated like any ordinary burn. Aroclor plasticizer 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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Environmental Hazards

Aroclor 1232, Aroclor 1242, Aroclor 1248, Aroclor 1254, Aroclor 1260, Aroclor 1262, Aroclor 1268, Aroclor 4465, and Montar 1 all contain polychlorinated biphenyls (PCB) of various types and in varying amounts. PCB residues in small amounts have been found in the environment and some studies have indicated that they may be harmful to certain forms of animal life. Extreme care should therefore be taken by all users of PCB-containing products to prevent any entry into the environment through spills, leakage, use, disposal, vaporization or otherwise. Further, the products in which PCB materials are used, or which are formulated using PCB materials as a component, should be given careful study to eliminate the possibility that PCB might reach the environment as a result of use in a given application.

Some specific applications where the use of PCB should definitely be avoided are in paints and sealants for swimming pools, paints and waterproofing agents in silos and other buildings where food products for humans or animals are stored, and as a component of any container or wrapping used in the packaging of food products.

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Shipping

Freight Classification	
Aroclor 1221, 1232, 1242, 1248, 1254, 1260, 1262	Synthetic Resin, Liquid, NOIBN
Rail Classification	
Aroclor 1268, 4465, 5442, 5460	Synthetic Resin, Other Than Liquid, NOIBN
Truck Classification	
Aroclor 1268	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, 25-lb. fiber drum
Aroclor 4465	500-lb. steel drum, 50-lb. can
Aroclor 5442	450-lb. steel drum, 50-lb. can
Aroclor 5460 (flaked)	50-lb. bag

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