

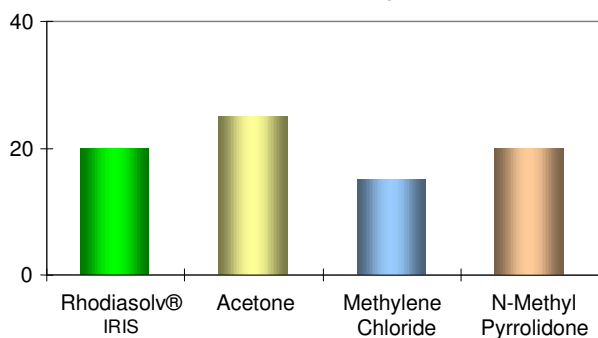
Rhodiasolv® IRIS expands the range of the Rhodiasolv® safe, non-toxic, and biodegradable solvents. The advantages of Rhodiasolv® IRIS for resin clean-up operations are:

- Cost Efficient:**
 - Comparable dissolution speeds to Acetone and Methylene Chloride
 - Reduced solvent loss due to low rate of evaporation (3-5x less than acetone)
 - Powerful solvent for dissolving a wide range of resins and polymers including:
 - Alkyds, Amino and Phenol Formaldehydes,
 - Epoxy, Polyurethanes and Unsaturated Polyesters
- Excellent Health and Safety Profile:** Non-flammable, Low Odour
Non-carcinogenic, Not an irritant or sensitizer
- Regulatory Compliance:** Non-VOC according to EU directive 1999/13/EC
Readily Biodegradable

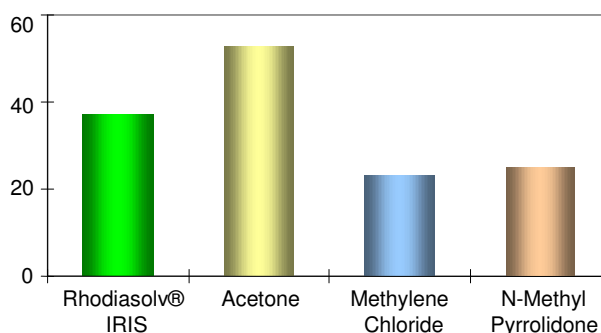
Performance Evaluation of Rhodiasolv® IRIS

The data below details the time required in seconds for complete dissolution of 1 part resin in 1 part solvent at 21°C. In all cases the maximum solubility of the resin in the solvent is >4 parts resin in 1 part solvent:

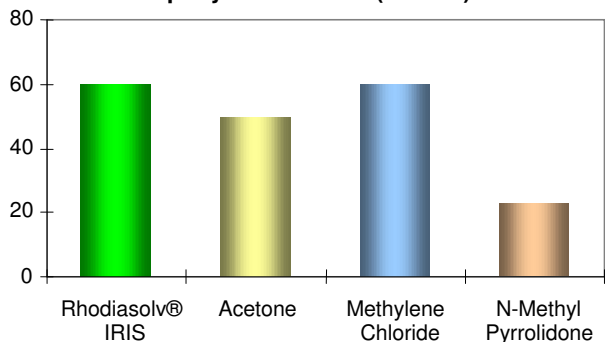
**Time To Dissolve
Unsaturated Polyester**



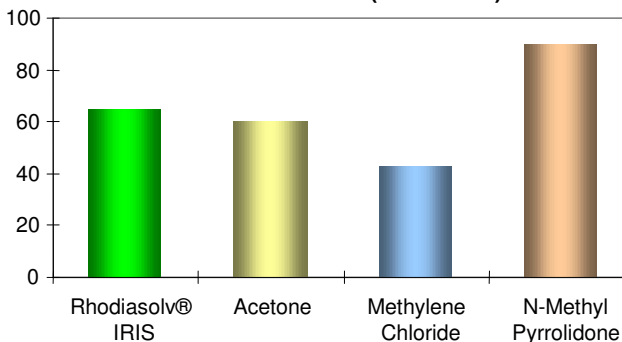
**Time To Dissolve
Alkyd**



**Time To Dissolve Epoxy
Epoxydharz L1100 (Hexion)**



**Time To Dissolve Epoxy
Araldite GY250 (Huntsman)**



Guidance for use of Rhodiasolv® in Resin Clean-up Operations

Rhodiasolv® IRIS is a safe and efficient solvent. It can be applied using all the standard techniques employed in resin clean-up, e.g. brushes, wipes, nozzles, spray-guns or in dip tanks. Rhodiasolv® IRIS is usually applied at room temperature, but it can also be applied at higher temperatures (flash point: 98°C) when resins are more difficult to remove from the substrates. However, we recommend that Rhodiasolv® IRIS is used in closed equipment when application temperatures above 50 °C are required.







Rhodiasolv® IRIS is an effective solvent and we recommend it is used as the sole solvent for clean-up of uncured and partially cured resin systems. However, it may be necessary to Rhodiasolv® IRIS as part of a formulated system when cleaning resin systems that have been fully cured.

For further information on the use of Rhodiasolv® IRIS in Resin Clean-up operations refer to the technical bulletin; "Using Rhodiasolv® Dibasic Esters in Resin Clean-up"

Comparison of the Physical Chemical Properties of Rhodiasolv® IRIS with other solvents

Solvent	CAS Number	Boiling point @ 760 mm Hg	Flash point Closed cup	Density (g/cm ³) @ 20°C	Vapour Pressure @ 20°C	Evaporation Rate @ 25°C (n-Bu.Ac.=1)
Rhodiasolv® IRIS	14035-94-0	222-224°C	98°C	1,05	<10 Pa	0,006
Acetone	67-64-1	56,5°C	-18°C	0,79	24100 Pa	7,7
Methylene Chloride	75-09-2	40°C	Non flammable	1,335	46900 Pa	9,9
N-Methyl Pyrrolidone	872-50-4	202°C	86°C	1,029	40 Pa	0,03

Comparison of the Health & Safety Properties of Rhodiasolv® IRIS with other solvents

Solvent	Odour	Risk Phrases	Labelling	Symbols	Environmental
Rhodiasolv® IRIS	Mild	None	None	None	Readily biodegradable
Acetone	Fragrant mint-like	R11 R36 R66 R67	F+, Xi	 	BOD5 0.85; COD 1.12-2.07 ThOD 2.21
Methylene Chloride	Penetrating ether-like	R20 R22 R40	40, Xn		ThOD 0.38
N-Methyl Pyrrolidone current labelling	Amine-like	R36/38	Xi		Readily biodegradable
N-Methyl Pyrrolidone future labelling after 31.ATP (2009)	Amine-like	R36/38 R61	T, Xi	 	Readily biodegradable

WARNING

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