

DEK STANDARD ENGINEERING INSTRUCTION

Title

Page 1 of 6

PAINT: "Silver Metallic"

DSF 2.9.17

If TRIMITE paint is used:

TWO PACK ACRYLIC

Paint Type and Specification; please refer to pages 2 to 9.

Use ESD undercoat see DSF 2.1.10 prior to this coat.

PRODUCT REF

M46265/AE262/9

Issue	01	02	03	04	05	06	07	08
DCR	7135	31336	31671					

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PLASTILAC AE262 TWO PACK ACRYLIC TOPCOAT

FEATURES:

This two pack acrylic finish, although free from the use of isocyanates, still offers many of the important properties of a two pack polyurethane material. A versatile product which can be used on a range of plastic substrates, many metal surfaces as well as a variety of timber and related products.

This material is available in a wide range of standard colours and gloss levels. Special colours can be supplied by our rapid and efficient colour matching service. Durability and excellent colour retention are a feature of selected paint systems incorporating this product, which makes it ideal for both interior and exterior use.

Lower gloss levels are frequently used on business machines and similar types of equipment: applied conventionally to exhibit a smooth low sheen or a variety of attractive spatter finishes. Full gloss finishing systems have been found suitable for use by many machine tool manufacturers.

AVAILABILITY:

Full details of the container sizes, prices, standard glosses and colour ranges may be obtained from your local Trimite Service Centre by telephoning 0870 605 1234.

FLASH POINT:

Flash point in the range of 21°C - 32°C. Tested to BS 3900 Part A 8.

STORAGE:

The recommended temperature range for storage is between 10°C - 15°C. It is not considered advisable to store this material outside this temperature range or to exceed a storage period of six months prior to use.

(See below for details of the pot life of the material when the two components are mixed together.)

MIXING RATIO:

Plastilac AE262 Two Pack Acrylic Topcoat **must** be mixed with Curing Agent J2621 in the ratio of 4 parts Topcoat to 1 part Curing Agent, by volume.

MIXTURE (POT) LIFE:

The mixed material will remain usable for a period of up to 8 hours under normal working conditions (20°C).

COVERAGE:

Calculated on a dry film thickness of 25 microns.

Conventional Spraying: 9 - 10 square metres per litre of mixed material.

The coverage figures shown are approximate and will vary with the type of equipment used and the shape of the component.

Note: When applying a spatter coat, allow for a reduction of approximately 50% on the coverage figures shown.

PREPARATION:

Plastic: The substrate must be thoroughly clean and free from mould release agents and static charges. Owing to the sensitivity of many plastics to certain solvents, Antistatic Cleaner J131 should be used. However, T Wipes No. 3 - MP0305 (Antistatic Quality) are available and may be more convenient.

Note: It may be necessary to use a suitable electronic or radioactive source static eliminator immediately prior to painting.

PRIMING:

Plastic: The recommended primer is Plastilac AP262 Two Pack Acrylic Primer or Plastilac AP200 Air Drying Primer.

Metal: In the absence of a chemical pretreatment the recommended primer is SAP3 Two Pack Self Etching Primer.

FINISHING:

Application: Plastilac AE262 Two Pack Acrylic Topcoat may be applied by the following method:

Conventional Spraying: High Volume Low Pressure (HVLP).

*The Paint Makers — for Industry*

Conventional Spraying: To the blend of mixed material (see **MIXING RATIO**), approximately 20% by volume of Thinner PT1002 may be added up to obtain a suitable viscosity of between 25 - 35 seconds viscosity BS B4 cup. Adjustments may be made to the viscosity dependant on finish required.

Film Thickness: A wet film thickness of 50 - 60 microns will result in a dry film thickness of approximately 25 microns.

Spatter Finish:

- a). Apply the first coat normally and allow to "flash-off" for approximately 5 minutes.
- b). Reduce air pressure to between 5 - 15 pounds per square inch and apply "spatter" coat to the desired pattern. (This application process is made easier by the use of a pressure pot which permits greater control of the resultant pattern).

Note: A higher profile may be achieved by using the material unthinned.

AIR DRYING:

At an ambient temperature of 20°C, the drying time is approximately as follows:

Surface Dry:	10 - 15 minutes
Hard Dry:	2 - 4 hours
Full Properties:	7 days

Note: Lower temperatures will increase the drying time.

FORCE DRYING:

When it is required to accelerate the drying process, a "flash-off" period of approximately 10 minutes should be allowed for the solvents to evaporate.

Plastic: Force drying must be carried out with care to avoid component deformation. The type of plastic, conditions of moulding and post-mould time will determine the maximum temperature that can be employed. A typical curing schedule would be 2 - 3 hours at 60°C.

Metal: Temperatures up to 120°C for 20 - 30 minutes are normally recommended.

CLEANING:

High Flash Gun Cleaning Solvent J113 is suitable for cleaning all equipment after use.

SAFETY:

Before use, refer to our individual Safety Information Sheets.

TRIMITE LTD.,

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Safety Information Sheet

AE262 TWO PACK ACRYLIC FINISH

1. Identification of Product and Company

Intended use: - A two pack paint for a variety of substrates - base component. Application of mixed product by a variety of spraying techniques.

Supplier: Trimite Limited, Arundel Road, Uxbridge, Middlesex UB8 2SD

Emergency Telephone: 01895 251234

2. Composition/Information on Ingredients

Synthetic resins and organic/inorganic pigments in organic solvents. Certain colours may contain lead based pigments, as indicated on the label.

For more detailed information on hazardous ingredients present, see Section 8.

3. Hazards Identification

Toxic, Flammable The classification "Toxic" of this product results from the possible lead content and hence will vary according to the colour. Consult the product label for relevant hazards.

Harmful by inhalation, in contact with skin and if swallowed - May cause harm to the unborn child. - Danger of cumulative effects - Limited evidence of a carcinogenic effect.

4. First Aid Measures

	Equipment	Symptom	First Aid
Inhalation	Chemical fume quality masks normally advisable. Air-fed masks in cases of uncertain ventilation.	Nausea, dizziness, drowsiness. Irritating to eyes and respiratory system.	Remove to fresh air, keep warm and at rest. If breathing is irregular or stopped give artificial respiration. If unconscious place in recovery position. Seek medical advice.
Eye Contact	Goggles or face visor - Chemical splash or BS 2092 according to precise work.	Irritation, swelling.	Irrigate copiously with clean, fresh water for at least ten minutes, holding the eyelids apart. If irritation persists, seek medical advice.
Skin Contact	Regularly laundered and effectively impervious overall, PVC or Nitrile rubber gloves.	Prolonged contact with the skin may have a de-fatting effect which may lead to skin irritation and in some cases, dermatitis.	Remove contaminated clothing. Wash skin thoroughly with soap and water or use a proprietary skin cleaner. Do NOT use solvents or thinners.
Ingestion	Not applicable.	Nausea.	If accidentally swallowed, drink milk or water. DO NOT INDUCE VOMITING. Keep at rest and obtain medical attention.

5. Fire Fighting Measures

Extinguishing media: Carbon dioxide, Dry Powder, Fine water spray, Alcohol Resistant Foam.

Not to be used: Water Jet.

Fire will produce dense black smoke containing harmful products of combustion. Cool containers exposed to fire with water spray. For large fires, self contained breathing apparatus should be worn. Carbon monoxide and carbon dioxide will be the main gases formed.

6. Accidental Release Measures

Contain and collect spillage with non-combustible absorbent materials, e.g. sand or earth. Do not allow to enter drains or water courses. Exclude sources of ignition. Ventilate area. For large spillages, respiratory protection may be necessary.

7. Handling and Storage

Avoid the inhalation of vapour, particles and spray mist. Refer to Section 8 for advice on exposure control. Avoid contact with skin and eyes. Wear appropriate clothing and eye protection to BS 2092. Barrier creams may help to protect exposed areas of skin but are no substitute for full physical protection. Prevent the creation of flammable concentrations of vapour in air. The product should only be used in areas from which all naked lights and other sources of ignition have been excluded. The accumulation of dry overspray or contaminated rags etc and the overloading of spray booth filters may result in spontaneous combustion. Regular cleaning of spraying areas will minimise the risk.

Conformance with the Highly Flammable Liquids and Liquefied Petroleum Gases Regulations 1972 (S.I. 1972 No. 917) is required.

8. Exposure Controls/Personal Protection

Adequate ventilation should be provided. Where reasonable practicable, this should be achieved by the use of local exhaust ventilation and good general ventilation. If this is not sufficient to maintain concentrations of particulates or solvent vapour below the OEL, suitable respiratory protection must be worn (see Section 4).

Substance Name	% Conc Range	Symbol	OEL 8hr mg/m3	OEL 15min mg/m3	Risk Phrases	Notes
Aromatic Hydrocarbons nos	> 25% & = < 100%	Xn	500.00	1500.00	65	SUP OES
Xylene, mixture of isomers	> 10% & = < 25%	Xn, Xi	220.00	441.00	20/21-38	Sk OES
Lead chromate (OES as CrVI cpds)	> 0% & = < 25%	T	0.15		61-62-40-33	MEL
Lead (as metal)	> 0% & = < 15%		0.15			MEL
1-Methoxypropyl-2-acetate	> 1% & = < 10%	Xi	274.00	822.00	36	OES
Trimethylbenzenes, all isomers	> 1% & = < 10%	Xi	125.00		37	OES
Barium compounds (not sulphate)	> 1% & = < 10%	Xn	0.50		20/22	OES

Notes: OES - Occupational Exposure Standard. MEL - Maximum Exposure Limit (on NO account should these figures be exceeded). SUP - categorised from suppliers' literature.
Notations = SK - Risk of absorption through skin SEN - Respiratory Sensitiser Bmgv - Biological Monitoring may be appropriate (see Biological Monitoring Guidance Value in EH40 Table 3)
The quantity of lead compounds present in the product depends on the colour concerned. Refer to the product label and to Section 11 for appraisal of the hazards of lead in paints. For guidance on Personal Protective measures, see Section 4.

9. Physical and Chemical Properties

Physical State:	Viscous liquid	V.O.C. Content:	.613 Kgs/lt
Flash point:	≥ 21 °C & < 32 °C Method BS 3900: Part A8	Vapour Density:	Heavier than Air
Viscosity:	140-150 secs Method BS Cup B4	Lower Explosion Limit:	.7 % Vol.
Specific Gravity:	0.98-1.18 gms/cc Method Calculation (dependent on colour)	Solubility in water:	Immiscible

10. Stability and Reactivity

Stable under the recommended storage and handling conditions (see Section 7). When exposed to high temperatures, hazardous decomposition products may be produced. Keep away from oxidising agents and strongly alkaline or acid materials to prevent the possibility of an exothermic reaction.

11. Toxicological Information

There is no formal data available on the product itself. Over exposures are irritating to the eyes and respiratory system. Excessive concentrations may produce effects on the central nervous system including drowsiness. Loss of consciousness may result. Prolonged contact with skin may cause irritation and possibly dermatitis. Splashes in the eyes may cause discomfort and possible damage. Long term exposure to vapour may cause adverse health effects. Whilst increased incidences of lung cancer have been noted in chromate pigment manufacturing industry, epidemiological studies show no cancer excesses where lead chromates alone were manufactured. Data from animal studies on the carcinogenicity of chromates does not extend to lead chromates. There is, however, no evidence of a risk of lung cancer from using lead chromate containing paints. Recent studies have shown a link between elevated maternal blood lead levels and developmental effects in the offspring. The EC has therefore classified all lead compounds as "Toxic to Reproduction".

12. Ecological Information

There is no formal data available on the product itself, however it should not be allowed to enter drains or water courses. Should it do so, the local water authority should be contacted immediately. The Environmental Protection Act 1990 may apply to the use of this product.

13. Disposal Considerations

Waste materials should be regarded as controlled wastes and should be disposed of in accordance with the relevant regulations. Do not allow waste to enter drains. The Control of Pollution Act 1974, the Special Waste Regulations 1996 (S.I. 1996 No. 972), the Environmental Protection Act 1990 and/or any local regulations will apply.

14. Transport Information

Road/Rail	SI Number.....1263 Designation.....Paint product	Packing Group...III	Class.....3.3
Sea	Packing Grp. < = 30lts....III Marine Pollutant.....No Shipping Name.....Paint product	Packing Grp. > 30lts....III UN Number.....1263	Class.....III
Air	Packing Grp. < = 30lts....III UN Number.....1263 Shipping Name.....Paint	Packing Grp. > 30lts....III	Class.....3.3

15. Regulatory Information

The product is classified and labelled for supply in accordance with the Chemicals (Hazard Information & Packaging for Supply) (Amendment) Regulations 1997 (S.I. 1997 No. 1460) as follows:

Classification	T - Toxic Flammable
Contains	Xylene, mixture of isomers Lead chromate Barium compounds (not sulphate)
Risk Phrases	20/21/22 Harmful by inhalation, in contact with skin and if swallowed 61 May cause harm to the unborn child. 33 Danger of cumulative effects 40 Limited evidence of a carcinogenic effect.
Safety Phrases	7 Keep container tightly closed 20/21 When using do not eat drink or smoke. 24/25 Avoid contact with skin and eyes.

P Phrases

If swallowed seek medical advice immediately and show this container or label.

Do not breathe vapour or spray. In case of insufficient ventilation, wear suitable respiratory equipment.

Contains Lead. Should not be used on surfaces that are liable to be *chewed or sucked by children*.

The information contained in this sheet does not constitute the user's own assessment of the workplace risks as required by other health and safety legislation.

The provisions of the Health & Safety at Work etc. Act and the Control of Substances Hazardous to Health Regulations apply to the use of this product.

16. Other Information

Text of any Risk Phrases listed in Section 8

R20/21	Harmful by inhalation and in contact with skin
R20/22	Harmful by inhalation and if swallowed
R33	Danger of cumulative effects
R36	Irritating to eyes
R37	Irritating to respiratory system
R38	Irritating to skin
R40	Limited evidence of a carcinogenic effect.
R61	May cause harm to the unborn child.
R62	Possible risk of impaired fertility.
R65	Harmful: may cause lung damage if swallowed.

Date of Origination 01/11/94

Date of last revision 01/11/94

The risk phrase texts listed above are included to ensure compliance with the CHIP Regulations. They apply only to the pure chemical compounds listed in Section 8 and NOT to the product as supplied. For guidance on the risk phrases applicable to the product, see Section 15 and product label. The V.O.C. contents quoted are for the full gloss black version and may be considered the "worst case". Other colours or gloss levels may have appreciably lower V.O.C. contents. Some of the risk, safety and "P" phrases listed in Section 15 are applicable to certain colours only. Consult the product label for details. Refer to Occupational Exposure Limits Guidance Note EH40 /- and Spraying of highly flammable liquids EH9 (both available from H.M.S.O.) Refer to Safety Information Sheet for Curing Agent/Hardener prior to use.

This Safety Data Sheet has been prepared in line with the Chemicals (Hazard Information and Packaging for Supply) (Amendment) Regulations 1997 (S.I. 1997 No. 1460) and EC Directive 96/54/EC.

The sheet is designed to enable the user to use the product safely, being based on the latest knowledge available to Trimite Limited and no relevant information has been omitted.

The user should not assume on the basis of the information provided that the product is suitable for any abnormal use. Before such applications are undertaken, further advice should be sought.

Further information and relevant advice can be found in:-

The Control of Substances Hazardous to Health (Amendment) Regulations 1997 (S.I. 1997 No. 11)

The Manual Handling Operations Regulations 1992 (S.I. 1992 No. 2793)

Storage of Flammable Liquids in Containers. HS(G)51

Storage of Packaged Dangerous Substances. HS(G)71

The Environmental Protection (Duty of Care) Regulations 1992 (S.I. 1988 No. 2839)

Occupational Exposure Limits Guidance Note EH 40/-

**J188
 ELECTROSTATIC DISCHARGE COATING BLACK**

1. Identification of Product and Company

Intended use: - A paint for reducing the electrostatic charge on electrical equipment.

Supplier: Trimite Limited, Arundel Road, Uxbridge, Middlesex UB8 2SD

Emergency Telephone: 01895 251234

2. Composition/Information on Ingredients

Synthetic resins and organic/inorganic pigments in organic solvents.

For more detailed information on hazardous ingredients present, see Section 8.

3. Hazards Identification

Harmful, Highly flammable

Harmful by inhalation, in contact with skin and if swallowed - Irritating to eyes

4. First Aid Measures

	Equipment	Symptom	First Aid
Inhalation	Chemical fume quality masks normally advisable. Air-fed masks in cases of uncertain ventilation.	Nausea, dizziness, drowsiness. Irritating to eyes and respiratory system.	Remove to fresh air, keep warm and at rest. If breathing is irregular or stopped give artificial respiration. If unconscious place in recovery position. Seek medical advice.
Eye Contact	Goggles or face visor - Chemical splash or BS 2092 according to precise work.	Irritation, swelling.	Irrigate copiously with clean, fresh water for at least ten minutes, holding the eyelids apart. If irritation persists, seek medical advice.
Skin Contact	Regularly laundered and effectively impervious overall, PVC or Nitrile rubber gloves.	Prolonged contact with the skin may have a de-fatting effect which may lead to skin irritation and in some cases, dermatitis.	Remove contaminated clothing. Wash skin thoroughly with soap and water or use a proprietary skin cleaner. Do NOT use solvents or thinners.
Ingestion	Not applicable.	Nausea.	If accidentally swallowed, drink milk or water. DO NOT INDUCE VOMITING. Keep at rest and obtain medical attention.

5. Fire Fighting Measures

Extinguishing media: Carbon dioxide, Dry Powder, Fine water spray, Alcohol Resistant Foam.

Not to be used: Water Jet.

Fire will produce dense black smoke containing harmful products of combustion. Cool containers exposed to fire with water spray. For large fires, self contained breathing apparatus should be worn. Carbon monoxide and carbon dioxide will be the main gases formed.

6. Accidental Release Measures

Contain and collect spillage with non-combustible absorbent materials, e.g. sand or earth. Do not allow to enter drains or water courses. Exclude sources of ignition. Ventilate area. For large spillages, respiratory protection may be necessary.

7. Handling and Storage

Avoid the inhalation of vapour, particles and spray mist. Refer to Section 8 for advice on exposure control. Avoid contact with skin and eyes. Wear appropriate clothing and eye protection to BS 2092. Barrier creams may help to protect exposed areas of skin but are no substitute for full physical protection. Prevent the creation of flammable concentrations of vapour in air. The product should only be used in areas from which all naked lights and other sources of ignition have been excluded. The accumulation of dry overspray or contaminated rags etc and the overloading of spray booth filters may result in spontaneous combustion. Regular cleaning of spraying areas will minimise the risk. When flattening, avoid the inhalation of airborne particles.

Conformance with the Highly Flammable Liquids and Liquefied Petroleum Gases Regulations 1972 (S.I. 1972 No. 917) and the Petroleum (Consolidation) Act 1928 is required.

9. Exposure Controls/Personal Protection									
Adequate ventilation should be provided. Where reasonable practicable, this should be achieved by the use of local exhaust ventilation and good general ventilation. If this is not sufficient to maintain concentrations of particulates or solvent vapour below the OEL, suitable respiratory protection must be worn (see Section 4).									
Substance Name	% Conc Range	Symbol	OEL 8hr mg/m ³	OEL 15min mg/m ³	Risk Phrases	Notes			
Butanone (MEK) Xylene, mixture of isomers	> 25% & < 100% > 10% & < 25% > 1% & < 10%	Xn, Xi, Xn,Xi	600.00 220.00 724.00	900.00 441.00 154.00	36-66-67 20/21-38 22-37/38-41-67	SK OES SK OES SK OES			
n-Butyl acetate	> 1% & < 10%				66-67	SK OES			
Notes: OES - Occupational Exposure Standard, MEL - Maximum Exposure Limit (on NO account should these figures be exceeded), SUP - catagorised from suppliers' literature, SEN - Risk of absorption through skin, SEN - Respiratory Sensitiser, Bmgv - Biological Monitoring Guidance Value in EH40 Table 3) For guidance on Personal Protective measures, see Section 4.									
9. Physical and Chemical Properties									
Physical State:		Viscous liquid		Flash point:		Vapour Density:		Solubility in water:	
Flash point:		≥ 0°C & < 21°C Method BS 3900: Part A8		Vapour Density:		Lower Explosion Limit:		Heavier than Air	
Specific Gravity:		0.94 gms/cc Method Calculation		Vapour Density:		Lower Explosion Limit:		7% Vol.	
10. Stability and Reactivity									
Stable under the recommended storage and handling conditions (see Section 7). When exposed to high temperatures, hazardous decomposition products may be produced. Keep away from oxidising agents and strongly alkaline or acid materials to prevent the possibility of an exothermic reaction.									
11. Toxicological Information									
There is no formal data available on the product itself. Over exposures are irritating to the eyes and respiratory system. Excessive concentrations may produce effects on the central nervous system including drowsiness. Loss of consciousness may result. Prolonged contact with skin may cause irritation and possibly dermatitis. Splashes in the eyes may cause discomfort and possible damage. Long term exposure to vapour may cause adverse health effects. Nickel is a known skin sensitizer and a possible carcinogen. Although the paint medium may reduce any sensitisation risk, contact of wet and dry paint with the skin should be avoided.									
12. Ecological Information									
There is no formal data available on the product itself, however it should not be allowed to enter drains or water courses. Should it do so, the local water authority should be contacted immediately. The Environmental Protection Act 1990 may apply to the use of this product.									
13. Disposal Considerations									
Waste materials should be regarded as controlled wastes and should be disposed of in accordance with the relevant regulations. Do not allow waste to enter drains. The Control of Pollution Act 1974, the Special Waste Regulations 1996 (S.I. 1996 No. 972), the Environmental Protection Act 1990 and/or any local regulations will apply.									
14. Transport Information									
Road/Rail	SI Number.....1263	Designation.....Paint		Packing Group.....II		Class.....3			
Sea	Packing Grp. < = 30lts.....II	Marine Pollutant.....No		UN Number.....1263		Class.....3.2			
Air	Packing Grp. < = 30lts.....II	UN Number.....1263		Shipping Name.....Paint		Class.....3.2			
15. Regulatory Information									
The product is classified and labelled for supply in accordance with the Chemicals (Hazard Information & Packaging for Supply) (Amendment) Regulations 1997 (S.I. 1997 No. 1460) as follows:									
Classification	Xn - Harmful		F - Highly Flammable						
Contains	Butanone (MEK)								
Risk Phrases	20/21/22 Harmful by inhalation, in contact with skin and if swallowed								
Safety Phrases	7 Keep container tightly closed								
	20/21 Avoid contact with skin and eyes.								
	46 If swallowed seek medical advice immediately and show this container or label.								
P. Phrases	Do not breathe vapour or spray. In case of insufficient ventilation, wear suitable respiratory equipment.								
The information contained in this sheet does not constitute the user's own assessment of the workplace risks as required by other health and safety legislation. The provisions of the Health & Safety at Work etc. Act and the Control of Substances Hazardous to Health Regulations apply to the use of this product.									

16. Other Information

Text of any Risk Phrases listed in Section 8

R20/21 Harmful by inhalation and in contact with skin

R22 Harmful if swallowed

R36 Irritating to eyes

R37/38 Irritating to respiratory system and skin.

R38 Irritating to skin

R41 Risk of serious damage to eyes.

R66 Repeated exposure may cause skin dryness or cracking

R67 Vapours may cause drowsiness and dizziness

Date of Origin 16/09/98

Date of last revision 16/09/98
The risk phrase text listed above are included to ensure compliance with the CHIP Regulations. They apply only to the pure chemical compounds listed in Section 8 and NOT to the product as supplied. For guidance on the risk phrases applicable to the product, see Section 15 and product label. Refer to Occupational Exposure Limits Guidance Note EH40 /- and Spraying of highly flammable liquids EH9 (both available from H.M.S.O.)

This Safety Data Sheet has been prepared in line with the Chemicals (Hazard Information and Packaging for Supply) (Amendment) Regulations 1997 (S.I. 1997 No. 1460) and EC Directive 96/54/EC.
The sheet is designed to enable the user to use the product safely, being based on the latest knowledge available to Trimite Limited and no relevant information has been omitted.
The user should not assume on the basis of the information provided that the product is suitable for any abnormal use. Before such applications are undertaken, further advice should be sought.

Further information and relevant advice can be found in:-
The Control of Substances Hazardous to Health (Amendment) Regulations 1992 (S.I. 1992 No. 2793)
The Manual Handling Operations Regulations 1992 (S.I. 1992 No. 2793)
Storage of Flammable Liquids in Containers, HS(G)71
Storage of Packaged Dangerous Substances, HS(G)71
The Environmental Protection (Duty of Care) Regulations 1992 (S.I. 1988 No. 2839)
Occupational Exposure Limits Guidance Note EH 40/-