



## SAFETY DATA SHEET

### 1. PRODUCT AND COMPANY IDENTIFICATION

**Product Identifier:** INDALLOY WITH RMA FLUX VEHICLE

**SDS Number:** SDS-IN 354-C

**Revised Date:** 24 SEPTEMBER 2018

**Product Use:** Rosin-based mildly activated solder paste consisting of a flux vehicle blended with a 83-92 % pre-alloyed metal powder.

#### MANUFACTURER:

##### In America:

The Indium Corporation of America®.

34 Robinson Rd., Clinton, NY 13323

Information: (315) 853-4900

[nswarts@indium.com](mailto:nswarts@indium.com)

##### In Europe:

The Indium Corporation of America® (European Operations)

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Kingston, Milton Keynes, UK, MK 10 OAG

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##### In Asia:

Indium Corporation of America

Asia-Pacific Operations-Singapore

29 Kian Teck Avenue

Singapore 628908

Information: +65 6268-8678

#### EMERGENCY PHONE:

**CHEMTREC 24 hrs.**

**USA: 1 (800) 424-9300**

**Outside USA: +1 (703) 527-3887**

**China: Emergency 86+ 4008417580**

##### In China:

Indium Corporation (Suzhou), Co., Ltd.

No. 428 Xinglong Street

Suzhou Industrial Park

Suchun Industrial Square

Unit No. 14-C

Jiangsu Province, China 215126

Information: (86) 512-6283-4900

**2. HAZARDS IDENTIFICATION****PRIMARY ROUTES OF ENTRY:**

Eye    Inhalation    Skin    Ingestion    NTP

**Carcinogen listed in**

IARC    OSHA    Not Listed  
See Section 11

GHS:

Lead free products



Signal Word: Warning

Hazard statement(s)

H317            May cause an allergic skin reaction  
H319            Causes serious eye irritation  
H334            May cause allergy or asthma symptoms or breathing difficulties if inhaled  
EUH208        Contains rosin. May produce an allergic reaction

Precautionary statement(s)

P233            Keep container tightly closed  
P261            Avoid breathing dust/fume/gas/mist/vapors/spray  
P270            Do not eat, drink or smoke when using this product  
P273            Avoid release to the environment  
P280            Wear protective gloves/protective clothing/eye protection/face protection  
P362 +P364    Take off contaminated clothing and wash before reuse  
P301 + P314    IF SWALLOWED: Get Medical advice/attention if you feel unwell  
P302 +P352    IF ON SKIN: Wash with plenty of soap and water  
P304 + 341    IF INHALED: If breathing is difficult, remove victim to fresh air and keep at rest in a position comfortable for breathing  
P305 + 351    IF IN EYES: Rinse continuously with water for several minutes (15 mins)

Lead containing products



Signal Word: Warning

Hazard statement(s)

H317            May cause an allergic skin reaction  
H319            Causes serious eye irritation  
H334            May cause allergy or asthma symptoms or breathing difficulties if inhaled  
H335            May cause respiratory irritation  
H351            Suspected of causing cancer  
H361            Suspected of damaging fertility or the unborn child  
H373            May cause damage to organs through prolonged or repeated exposure  
H410            Very toxic to aquatic life with long lasting effects  
EUH201A        Warning! Contains lead. Review listing.  
EUH208        Contains rosin. May produce an allergic reaction

Precautionary statement(s)

P233            Keep container tightly closed  
P261            Avoid breathing dust/fume/gas/mist/vapors/spray  
P270            Do not eat, drink or smoke when using this product  
P273            Avoid release to the environment  
P280            Wear protective gloves/protective clothing/eye protection/face protection  
P362 +P364    Take off contaminated clothing and wash before reuse

P301 + P314 IF SWALLOWED: Get Medical advice/attention if you feel unwell  
 P302 +P352 IF ON SKIN: Wash with plenty of soap and water  
 P304 + 341 IF INHALED: If breathing is difficult, remove victim to fresh air and keep at rest in a position comfortable for breathing  
 P305 + 351 IF IN EYES: Rinse continuously with water for several minutes (15 mins)

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**Classification:**

Carcinogenicity (Category 2) (lead)

Reproductive toxicity (Category 2 ) (lead)

Skin sensitizer-Category 1B

Respiratory sensitizer-Category 1B

Eye irritation-Category 2A

Acute aquatic toxicity – Category 1 for lead containing products (H400)

Chronic aquatic toxicity – Category 1 for lead containing products (H410)

**POTENTIAL HEALTH EFFECTS:**

**Eye Contact:** Contact with material at room temperature or fume from material at typical re-flow temperatures over 100°C may cause eye irritation.

**Ingestion:** This product contains metal alloy powder and organic chemicals. May be harmful if swallowed.

**Inhalation:** Vapors or fumes from this material at typical re-flow temperatures over 100°C may cause local irritation to the respiratory system. Rosin has been known to cause occupational asthma.

**Skin Contact:** May cause skin irritation. ANTIMONY has been known to cause dermatitis.

**Chronic:** LEAD: Prolonged exposure to vapors or fumes at higher temperatures may cause respiratory irritation and systematic lead poisoning. Symptoms of lead poisoning include headache, nausea, abdominal pain, muscle and joint pain and damage to the nervous system, blood system and kidneys.

SILVER: Chronic skin contact or ingestion of silver dust, salts, or fume can result in a condition known as Argyria, a condition with bluish pigmentation of the skin and eyes.

TIN: Has been shown to increase incidence of sarcoma in animal tests.

BISMUTH: May cause kidney damage.

INDIUM: May cause damage to respiratory system.



**WARNING:** This product can expose you to chemicals including [lead] which is known to the State of California to cause cancer, and can cause birth defects or other reproductive harm. For more information go to [www.P65Warnings.ca.gov](http://www.P65Warnings.ca.gov)

**NOTE:** The Indium Corporation does not recommend, manufacture, market or endorse any of its products for human consumption.

**WARNING:** This product may contain lead. Lead may be harmful to your health. US Federal law prohibits the use of leaded solders in making joints or fittings in any private or public water supply system. Keep out of the reach of children.

**3. COMPOSITION / INFORMATION ON INGREDIENTS**

<b>Components</b>	<b>% wt</b>	<b>CAS Registry #</b>	<b>PEL mg/m<sup>3</sup></b>	<b>TLV-TWA mg/m<sup>3</sup></b>	<b>TLV-STEL mg/m<sup>3</sup></b>
<b>TIN</b>	+	7440-31-5			
		(US)	2	2	-
		(EU)	-	2	4
		(Canada)	-	2	4
		(Singapore)	2	-	-
<b>LEAD</b>	+	7439-92-1			
		(US)	0.05	0.05	-
		(EU)	-	0.15	-
		(Canada)	0.05	0.05	-
		(Singapore)	0.15	-	-
		(Mexico)	-	0.15	-
		(China)	-	0.05(dust) 0.03 (fume)	-
<b>SILVER</b>	+	7440-22-4			
		(US)	0.01	0.1	-
		(EU)	-	0.1	-
		(Canada)	-	0.1	0.3
		(Singapore)	0.1	-	-
		(Mexico)	-	0.1	-
<b>GOLD</b>	+	7440-57-5	N.E.	N.E.	N.E.
<b>ANTIMONY</b>	+	7440-36-0			
		(US)	0.5	0.5	-
		(EU)	0.5	-	-
		(Canada)	-	0.5	1.5
		(Singapore)	0.5	-	-
		(Mexico)	-	0.5	-
		(China)	-	0.5	-
<b>GERMANIUM</b>	+	7440-56-4	N.E.	N.E.	N.E.

<b>BISMUTH</b>	+	7440-69-9	N.E.	N.E.	N.E.
<b>INDIUM</b>	+	7440-74-6			
		(US)	0.1	0.1	-
		(EU)	-	0.1	0.3
		(Canada)	-	0.1	0.3
		(Singapore)	0.1	-	-
		(Mexico)	-	0.1	0.3
		(China)	-	0.1	0.3
<b>ROSIN</b>	3.5-8.0	65997-05-9 (US)	N.E.	N.E.	N.E.
		(EU)	0.05	N.E.	0.15 (sensitiser)
<b>POLYGLYCOL ETHER</b>	2.5 – 6.0	9038-95-3	N.E.	N.E.	N.E.
<b>PROPRIETARY</b>	1.0-3.0	-	N.E.	N.E.	N.E.

N.E. = Not established      + See alloy table

## ALLOY TABLE

Indalloy	%TIN	%SILVER	%LEAD	%ANTIMONY	%INDIUM	%GOLD	%GERMANIUM	%BISMUTH	RoHS 2/3* Compliance
1 (50In/50Sn)	41.5-46.0	-	-	-	41.5-46.0	-	-	-	YES
1E (52In/48Sn)	39.8-44.2	-	-	-	43.2-47.8	-	-	-	YES
2 80In/15Pb/ 5Ag)	-	4.2-4.6	12.5-13.8	-	66.4-73.6	-	-	-	NO
3 (90In/10Ag)	-	8.3-9.2	-	-	74.7-82.8	-	-	-	YES
4 (100In)	-	-	-	-	83.0-92.0	-	-	-	YES
7 50In/50Pb)	-	-	41.5-46.0	-	41.5-46.0	-	-	-	NO
9 (70Sn/18Pb/12In)	58.1-64.4	-	14.9-16.6	-	10-11	-	-	-	NO
10 (75Pb/25In)	-	-	63.3-69.0	-	20.8-23.0	-	-	-	NO

Indalloy	%TIN	%SILVER	%LEAD	%ANTIMONY	%INDIUM	%GOLD	%GERMANIUM	%BISMUTH	RoHS 2/3* Compliance
11 (95Pb/5In)	-	-	78.9-87.4	-	4.2-4.6	-	-	-	YES
42 (46Bi/34Sn/20Pb)	28.2-31.3	-	16.6-18.4	-	-	-	-	38.2-42.3	NO
53 (67Bi/33In)	-	-	-	-	27.4-30.4	-	-	55.6-61.6	YES
70 (40In/40Sn/20Pb)	33.2-36.8	-	16.6-18.4	-	33.2-36.8	-	-	-	NO
97 (43Sn/43Pb/14Bi)	36.7-39.6	-	36.7-39.6	-	-	-	-	11.6-12.9	NO
104/Sn62 (62.5Sn/36.1Pb/1.4Ag)	51.9-57.5	1.2-1.8	29.9-33.2	-	-	-	-	-	NO
106/Sn63 (63Sn/37Pb)	52.3-58.0	-	30.7-34.0	-	-	-	-	-	NO
109 (60Sn/40Pb)	49.8-55.2	-	33.2-36.8	-	-	-	-	-	NO
116 (50Sn/50Pb)	41.5-46.0	-	41.5-46.0	-	-	-	-	-	NO
118 (90Sn/10Pb)	74.7-82.8	-	8.3-9.2	-	-	-	-	-	NO
121 (96.5Sn/3.5Ag)	80.1-88.8	1.2-1.8	-	-	-	-	-	-	YES
122 (95Sn/5Pb)	78.9-87.4	-	4.2-4.6	-	-	-	-	-	NO
123 (97.5Sn/2.5Ag)	80.9-89.7	2.1-2.3	-	-	-	-	-	-	YES
127 (60Pb/37Sn/3Ag)	30.7-34.0	2.5-2.8	49.8-55.2	-	-	-	-	-	NO
130 (60Pb/40Sn)	33.2-36.8	-	49.8-55.2	-	-	-	-	-	NO
132 (95Sn/5Ag)	78.9-87.4	4.2-4.6	-	-	-	-	-	-	YES
133 (95Sn/5Sb)	78.9-87.4	-	-	4.2-4.6	-	-	-	-	YES
141 (70Pb/30Sn)	24.9-27.6	-	58.1-64.4	-	-	-	-	-	NO

Indalloy	%TIN	%SILVER	%LEAD	%ANTIMONY	%INDIUM	%GOLD	%GERMANIUM	%BISMUTH	RoHS 2/3* Compliance
143 (90Pb/10Sn)	-	-	74.4-82.8	8.3-9.2	-	-	-	-	YES
145 (75Pb/25Sn)	20.8-23.0	-	62.3-69.0	-	-	-	-	-	NO
149 (80Pb/20Sn)	16.6-18.4	-	66.4-73.6	-	-	-	-	-	NO
150 (81Pb/19In)	-	-	67.2-74.5	-	15.8-17.5	-	-	-	NO
151 (92.5Pb/5Sn/2.5Ag)	4.2-4.6	2.0-2.3	76.8-85.0	-	-	-	-	-	YES
155 (90Pb/5Ag/5Sn)	4.2-4.6	4.2-4.6	74.7-82.8	-	-	-	-	-	YES
159 (90Pb/10Sn)	8.3-9.2	-	74.7-82.8	-	-	-	-	-	YES
161 (97.5Pb/2.5Ag)	-	2.1-2.3	80.9-89.7	-	-	-	-	-	YES
164 (92.5Pb/5In/2.5Ag)	-	2.1-2.3	76.8-85.1	-	4.2-4.6	-	-	-	YES
165 (97.5Pb/1.5Ag/1Sn)	0.8-0.9	1.2-1.4	80.9-89.7	-	-	-	-	-	YES
171 (95Pb/5Sn)	4.2-4.6	-	78.9-87.4	-	-	-	-	-	YES
175 (95Pb/5Ag)	-	4.2-4.6	78.9-87.4	-	-	-	-	-	YES
182 (80Au/20Sn)	16.6-18.4	-	-	-	-	66.4-73.6	-	-	YES
183 (88Au/12Ge)	-	-	-	-	-	73.0-81.0	10.0-11.0	-	YES
204 (70In/30Pb)	-	--	24.9-27.6	-	58.1-64.4	-	-	-	NO
205 (60In/40Pb)	-	-	33.2-36.8	-	49.8-55.2	-	-	-	NO
206 (60Pb/40In)	-	-	49.8-55.2	-	33.2-36.8	-	-	-	NO

Indalloy	%TIN	%SILVER	%LEAD	%ANTIMONY	%INDIUM	%GOLD	%GERMANIUM	%BISMUTH	RoHS 2/3* Compliance
209 (65Sn/25Ag/10Sb)	54.0-59.8	20.8-23.0	-	8.3-9.2	-	-	-	-	YES
227 (77.2Sn/20In/2.8Ag)	64.0-71.0	2.3-2.6	-	-	16.6-18.4	-	-	-	YES
228 (88Pb/10Sn/2Ag)	8.3-9.2	1.7-1.8	73.0-81.0	-	-	-	-	-	YES
230 (54Sn/26Pb/20In Dopant Cu)	44.8-49.7	-	21.6-23.9	-	16.6-18.4	-	-	-	NO
233 (85Pb/10Sn/5Sn)	4.2-4.6	-	70.6-78.2	8.3-9.2	-	-	-	-	YES
240 (46Sn/46Pb/8Bi)	38.2-42.3	-	38.2-42.3	-	-	-	-	6.6-7.4	NO
255 (55.5Bi/44.5Pb)	-	-	36.9-40.9	-	-	-	-	46.1-51.1	NO
281 (58Bi/42Sn)	34.9-38.6	-	-	-	-	-	-	48.1-53.4	YES
281- 338 (60Sn/40Bi)	49.8-55.2	-	-	-	-	-	-	33.2-36.8	YES
290 (97In/3Ag)	-	2.5-2.8	-	-	80.5-89.2	-	-	-	YES
NS (50Sn/47Pb/3Bi)	41.5-46.0	-	39.0-43.2	-	-	-	-	2.5-2.8	NO
NS (93.5Pb/5Sn/1.5Ag)	4.2-4.6	1.2-1.4	77.6-86.0	-	-	-	-	-	YES
NS (67Pb/33In)	-	-	55.6-61.6	-	27.4-30.4	-	-	-	NO

NS = Non Standard Alloy

\*RoHS = Restriction of Hazardous Substances EU Directive 2002/95/EC

RoHS 3 = products do not contain any listed phthalates

#### 4. FIRST AID MEASURES

- Eye Contact:** Hold eyelids apart and flush eyes with plenty of tepid water for at least 15 minutes. Seek medical attention if irritation persists.
- Ingestion:** If patient is conscious, ONLY induce vomiting as directed by trained personnel. NEVER give anything by mouth to an unconscious person. Seek medical attention immediately.
- Inhalation:** Remove to fresh air. If not breathing, give artificial respiration or oxygen by trained personnel. Seek immediate medical attention.
- Skin Contact:** Remove contaminated clothing. Wash affected area with soap and water. Wash clothing before reuse. If irritation persists, obtain medical attention.



## 5. FIRE FIGHTING MEASURES

<b>Flash Point:</b>	Not established.	<b>Method:</b>	Not established.
<b>Auto-ignition Temperature:</b>	Not established.		
<b>Flammable Limits:</b>	Limits not established, not flammable.		
<b>Extinguishing Media:</b>	Use extinguishers appropriate for the surrounding fire conditions.		
<b>Special Fire Fighting Procedures:</b>	Firefighters must wear NIOSH approved self-contained breathing apparatus and full protective clothing.		

## 6. ACCIDENTAL RELEASE MEASURES

<b>Spill or Leak Procedures:</b>	Using a spatula, scoop up paste and place in a plastic or glass jar and tightly cap. Remove traces of paste residue using cloth rags or paper towels moistened with ethyl or isopropyl alcohol. Dispose of contaminated cloth rags or paper towels following all Federal, State and Local regulations.
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## 7. HANDLING AND STORAGE

<b>Handling Precautions:</b>	Keep containers tightly closed when not in use. Use care to avoid spills. Use only with production equipment specifically designed for use with solder paste. Wear appropriate personal protective equipment when working or handling solder paste. Always thoroughly wash your hands after handling this product. DO NOT touch or rub eyes until hands are washed.
<b>Storage Precautions:</b>	Store product in tightly capped original containers in a cool, dry area. Refer to product label for specific storage temperature requirements. Rotate stock to ensure use before expiration date on the label.

## 8. EXPOSURE CONTROLS / PERSONAL PROTECTION

<b>Engineering Controls:</b>	Use only with production equipment ( such as stencil printers and re-flow furnaces) with adequate ventilation and other safety features specifically designed for use with solder paste. Control concentration of all components so that they're permissible exposure levels are not exceeded.
<b>Personal protection:</b>	
<b>Eyes:</b>	Chemical safety glasses/goggles. Face shield for splash hazards.
<b>Respirator:</b>	An authority approved or compliant marked air-purifying respirator with a fume/organic chemical cartridge is recommended under certain circumstances (i.e. when re-flowing manually on a plate instead of a ventilated re-flow furnace) where airborne concentrations are expected to be elevated or exceed exposure limits.
<b>Skin:</b>	Compatible chemical resistant gloves. Latex gloves not recommended.
<b>Other:</b>	Lab coat, eye-wash fountain in work area. Avoid the use of contact lenses in high fume areas.
<b>Work/Hygienic Practices:</b>	Maintain good housekeeping. Clean up spills immediately. DO NOT allow rags or paper towels contaminated with solder paste to accumulate in the work area. Good personal hygiene is essential. Avoid eating, smoking or drinking in the work area. Wash hands thoroughly with soap and water immediately upon leaving the work area.

**9. PHYSICAL AND CHEMICAL PROPERTIES**

<b>Appearance:</b>	Grey colored paste.	<b>Boiling Point:</b>	Not applicable.
<b>Odor:</b>	Mild characteristic odor.	<b>Melting Point:</b>	Not applicable
<b>Specific Gravity:</b>	Not applicable	<b>pH:</b>	Not applicable
<b>Vapor Pressure:</b>	Not applicable.	<b>Solubility in Water:</b>	Insoluble (paste)
<b>Vapor Density:</b>	(air=1) Not applicable.		

**10. STABILITY AND REACTIVITY**

<b>General:</b>	Stable.
<b>Conditions to Avoid:</b>	Not established.
<b>Incompatible Materials:</b>	Avoid contact with acids, bases or oxidizing agents.
<b>Hazardous Decomposition / Combustion:</b>	Harmful organic fumes and toxic oxide fumes may form at elevated temperatures.
<b>Hazardous Polymerization:</b>	Will not occur.

**11. TOXICOLOGICAL INFORMATION**

<b>Carcinogenicity:</b>	<b>NTP:</b> No	
	<b>OSHA:</b> No	
	<b>IARC:</b> Yes	Lead and lead compounds are listed as possible carcinogens.
<b>LD50:</b>	Not established.	<b>LC50:</b> Not established.

**Other:** Chronic Toxicity: Prolonged or repeated exposure to rosin flux fume may cause workers to develop occupational asthma. Lead can cause potential harm to the developing fetus.

Reviewing epidemiological studies the IARC concluded in inadequate evidence for the carcinogenicity of lead and lead compounds in humans and sufficient evidence for the carcinogenicity of inorganic lead compounds in animals. According to the IARC, the lead and lead compounds tested for carcinogenicity in animals are almost soluble salts that were selected on the basis of ease of administration. Metallic lead, lead oxide and lead tetra alkyls have not been tested adequately. The final evaluation was thus that lead and inorganic lead compounds are possibly carcinogenic to humans.

RTECS#: OF7525000 (lead) NL1050000 (indium) VM3500000 (silver) XP7320000 (tin) CC4025000 (antimony)

**12. ECOLOGICAL INFORMATION**

Product not tested.

**13. DISPOSAL CONSIDERATION**

<b>Waste Disposal Method:</b>	Scrap metal alloy usually has value. Contact a commercial reclaimer for recycling. Otherwise, dispose of in accordance with all Federal, State and Local environmental regulations.
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**14. TRANSPORT INFORMATION**

Transport in accordance with applicable international regulations and requirements. Not regulated under US DOT (United States Department of Transportation). Non - hazardous under shipping.

Un – none

Not regulated under USDOT/IATA/IMDG.

## 15. REGULATORY INFORMATION

The information in this Safety Data Sheet meets the requirements of the United States Occupational Safety and Health Act and regulations promulgated hereunder (29 CFR 1910.1200 ET. SEQ.).

This product has been classified in accordance with the hazard criteria of the Canadian Controlled Products Regulation (CPR).

Canadian WHMIS: D2A-Materials Causing Other Toxic Effects-Very Toxic Material (Chronic) (lead)



D2B Materials Causing Other Toxic Effects –irritant

This product has been classified in accordance with the guidelines set by the Dept of Industrial Health of the Republic of Singapore.



**WARNING:** This product can expose you to chemicals including [lead] which is known to the State of California to cause cancer, and birth defects or other reproductive harm. For more information go to [www.P65Warnings.ca.gov](http://www.P65Warnings.ca.gov)

For Compliance with EU directive 2002/95/EC, Restriction on Hazardous Substances (RoHS) see Alloy Table.

### Malaysia:

This product has been classified in accordance with: Malaysian – OCCUPATIONAL SAFETY AND HEALTH (CLASSIFICATION, LABELING AND SAFETY DATA SHEET OF HAZARDOUS CHEMICALS) REGULATION OCTOBER 2013 – (CLASS). (GHS)

### In China:

Decree No. 591: Regulations on the Control over Safety of Hazardous Chemicals  
GB 30000.2-29-2013, Rules for classification and labeling of chemicals. (GHS)  
GB/T 16483-2008, GB/T 17517-2013

This product has been classified using the Chinese Occupational Exposure Limit of Hazardous Agents in the Workplace, GBZ2-2007.

This product has been classified in accordance with Mexican regulations NOM-018-STPS-2015 and NOM-010-STPS-2014

For Compliance with EU directive 2002/95/EC, Restriction on Hazardous Substances (RoHS) see Alloy Table.

SARA 313 Listing - 40 CFR 372.65

Lead CAS# 7439-92-1      Silver CAS# 7440-22-4      Antimony CAS# 7440-36-0  
Polyglycol ether (1 – 4.5%)

EPA Genetic Toxicology Program – Lead CAS# 7439-92-1

All ingredients are listed on the EPA TSCA Inventory.

Some ingredients are listed on the Canadian Domestic Substance List. No more than 2.2 % by weight is listed on the Non-domestic substance list.

**16. OTHER INFORMATION**

<b>HMIS Hazard Rating:</b>	<b>Health:</b>	2
	<b>Fire:</b>	1
	<b>Physical Hazard:</b>	0

**Revised Date:** 24 SEPTEMBER 2018

**Prepared by:** Nancy Swarts, Indium Corporation of America

**Approved by:** Nancy Swarts, Indium Corporation of America

The information and recommendations contained herein are, to the best of The Indium Corporation of America's knowledge and belief, accurate and reliable as of the date issued. The Indium Corporation of America does not warrant or guarantee their accuracy or reliability, and The Indium Corporation of America shall not be liable for any loss or damage arising out of the user thereof. The information and recommendations are offered for the user's consideration and examination, and it is the user's responsibility to satisfy itself that they are suitable and complete for its particular use. If buyer repackages this product, legal counsel should be consulted to insure proper health, safety and other necessary information is included on the container.