

**SALES SPECIFICATIONS**

Sales Specification No : 32465-2

Effective Date : 04/15/2013

Page No. 1 of 1

**EASTMAN****PRODUCT NAME****Eastman 168(TM) SG non-phthalate plasticizer****SPECIFICATIONS**

PROPERTY	LIMITS	TEST METHOD
168 Diethylhexyl Ester, %	96.00 MIN	TCMD-A-AN-G-GC-582
168 Ethylhexyl-Methyl Ester, %	3.00 MAX	TCMD-A-AN-G-GC-582
168 Total Ester, %	99.00 MIN	TCMD-A-AN-G-GC-582
Water, %	0.1000 MAX	TCMD-A-AN-G-VA-336
Acid Number	0.0700 MAX	TCMD-A-AN-G-VA-14
Refractive Index @ 20C	1.487 - 1.492	TCMD-A-AN-G-RI-1
Specific Gravity @ 20/20C	0.983 - 0.988	TCMD-A-AN-G-DEN-2
Visual Color, pcs	15 MAX	TCMD-A-AN-G-VCC-11
2-Ethylhexanol, ppm	50 MAX	TCMD-A-AN-G-GC-146
DOP Di (2-Ethylhexyl) Phthalate, ppm	50 MAX	TCMD-A-AN-G-LC-104
Heavy Metals as Lead, ppm	5 MAX	TCMD-A-AN-G-VCC-81
Appearance	Clear and Free of Suspended Matte	TCMD-A-AN-G-MIS-20

Eastman Chemical Company · P.O. BOX 511 · Kingsport, Tennessee 37662 USA · 1-800-EASTMAN · 1-423-229-2000 · [www.EASTMAN.com](http://www.EASTMAN.com)Sales Specification available on [Eastman.com](http://Eastman.com)

For reasons of safety and accuracy, the person performing this procedure must be thoroughly trained and under the supervision of a professional person who is knowledgeable in the relevant science. Equipment and materials described should be used in accordance with safety precautions recommended by their manufacturers. Limits in this specification are applicable only to data obtained by the referenced test method.

Neither Eastman Chemical Company nor its marketing affiliates shall be responsible for the use of this information, or of any product, method, or apparatus mentioned, and you must make your own determination of its suitability and completeness for your own use, for the protection of the environment, and for the health and safety of your employees and purchasers of your products. No warranty is made of the merchantability or fitness of any product, and nothing herein waives any of the seller's conditions of sale.