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ICL INDUSTRIAL PRODUCTS (ICL-IP)

ICL Industrial Products is the industrial chemicals arm of ICL, a major chemical company active in the global markets of performance and specialty chemicals, fertilizers and metallurgy.
ICL Industrial Products produces and markets bromine and bromine based products, magnesia products, phosphorus products and chlorine-based salts.
ICL-IP is divided into 7 business units: Flame Retardants (FR); Brominated Industrial Products (BIP); Agrochemicals (AGR); Biocides (BIO); Magnesia Products (MGP); Dead Sea Salts (DSS) and IMI Research Laboratories.
ICL-IP draws on the vast resources of the Dead Sea, one of the world's largest and most concentrated resources of bromine, magnesium and potassium salts.
ICL-IP services a wide range of industries such as plastics and polymers, intermediates for the pharmaceutical, agrochemical and cosmetics industries, oil completion chemicals, soil and space fumigation, flame retardants, paints and dyes, photographic materials, pesticides, food additives, and water treatment chemicals.

GLOBAL PRESENCE

ICL-IP's main manufacturing facilities are located in Israel, Holland, Germany, the U.S.A. and China. ICL-IP serves hundreds of customers worldwide through a global network of dedicated sales and marketing offices located in the commercial centers of the Far East, Europe and the U.S.A. The company is the largest producer of bromine containing derivatives in China, and is back-integrated into bromine production.
ICL-IP's customers are fully supported by an integrated supply chain which includes global logistics centers and a large fleet of unique transportation vessels especially designed for the shipment of bromine.

RESPONSIBLE CARE

ICL- Industrial Products (ICL-IP) is a member of the World Chemical Industry's Responsible Care program through the MAI (Manufacturers Association of Israel).
Through this program, ICL-IP is committed to responsibly manage the manufacture, distribution, use and disposal of chemicals in a safe, secure and environmentally responsible manner.
To achieve this, ICL-IP will regularly assess, continually improve and responsibly manage health, safety and environmental risks associated with products, processes and services throughout their life-cycles.
1.1 THE PRODUCT

MERQUEL™ 52, containing calcium bromide brine, is used for oxidation of containing mercury present in the coal feed that would otherwise be emitted after combustion.

A number of patented technologies are applying MERQUEL™ 52 for oxidation of mercury and converting it into ionic species, enabling removal by downstream pollution control equipment.

1.2 PHYSICAL PROPERTIES

MERQUEL™ 52 SOLUTION

<table>
<thead>
<tr>
<th>Property</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Boiling Point</td>
<td>130°C (266°F)</td>
</tr>
<tr>
<td>Flash Point</td>
<td>None</td>
</tr>
<tr>
<td>Density at 20°C</td>
<td>1.71 g/ml, 14.3 pounds/gallon</td>
</tr>
</tbody>
</table>

MERQUEL™ 95 SOLID

<table>
<thead>
<tr>
<th>Property</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Decomposition Temperature</td>
<td>&gt; 700°C (1292°F)</td>
</tr>
<tr>
<td>Molecular Weight</td>
<td>200</td>
</tr>
<tr>
<td>Solubility in water for 100% CaBr₂:</td>
<td>142 g/100ml at 30°C (86°F)</td>
</tr>
<tr>
<td>Maximum solubility at room temperature</td>
<td>312 g/100ml at 106°C (223°F)</td>
</tr>
<tr>
<td>Soluble in other solvents</td>
<td>Acetone, Alcohol</td>
</tr>
</tbody>
</table>

Specific gravity 1.837
CRYSTALLIZATION CURVE:

A brine’s true crystallization temperature (TCT) is the temperature at which salt crystals begin to fall out of solution given sufficient time and proper nucleating conditions (the presence of small angular particles that seed crystal formation). Once formed, masses of salt crystals are difficult to remove and can block the system. When the ambient temperature is very low and could reach the TCT for this material (about 0°F or –18°C), the solution should be diluted with water to avoid blockages, or stored in a heated environment.

TABLE 1: CRYSTALLIZATION TEMPERATURES OF CALCIUM BROMIDE SOLUTIONS

<table>
<thead>
<tr>
<th>CaBr₂ %wt</th>
<th>Density lb/gal</th>
<th>Density g/cc</th>
<th>True Crystallization Temperature</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td>TCT (°F)</td>
<td>TCT (°C)</td>
</tr>
<tr>
<td>0</td>
<td>8.35</td>
<td>1.00</td>
<td>32</td>
</tr>
<tr>
<td>10</td>
<td>9.10</td>
<td>1.09</td>
<td>25</td>
</tr>
<tr>
<td>20</td>
<td>10.01</td>
<td>1.20</td>
<td>14</td>
</tr>
<tr>
<td>30</td>
<td>11.10</td>
<td>1.33</td>
<td>-4</td>
</tr>
<tr>
<td>35</td>
<td>11.68</td>
<td>1.40</td>
<td>-15</td>
</tr>
<tr>
<td>40</td>
<td>12.36</td>
<td>1.48</td>
<td>-35</td>
</tr>
<tr>
<td>45</td>
<td>13.11</td>
<td>1.57</td>
<td>-62</td>
</tr>
<tr>
<td>50</td>
<td>13.94</td>
<td>1.67</td>
<td>-31</td>
</tr>
<tr>
<td>51</td>
<td>14.11</td>
<td>1.69</td>
<td>-15</td>
</tr>
<tr>
<td>52</td>
<td>14.28</td>
<td>1.71</td>
<td>1</td>
</tr>
<tr>
<td>53</td>
<td>14.44</td>
<td>1.73</td>
<td>14</td>
</tr>
</tbody>
</table>
**PRODUCT DESCRIPTION**

**TCT (AMERICAN UNITS)**

![Graph showing CaBr₂ (%wt) vs. temperature (°F)]

**TCT (METRIC UNITS)**

![Graph showing CaBr₂ (%wt) vs. temperature (°C)]
### TABLE 2: VISCOSITY OF MERQUEL™ 52 AT VARIOUS TEMPERATURES

<table>
<thead>
<tr>
<th>Temperature °F</th>
<th>Temperature °C</th>
<th>Viscosity cP</th>
</tr>
</thead>
<tbody>
<tr>
<td>5 (-15)</td>
<td></td>
<td>204.8</td>
</tr>
<tr>
<td>10 (-12)</td>
<td></td>
<td>87.2</td>
</tr>
<tr>
<td>20 (-7)</td>
<td></td>
<td>37.5</td>
</tr>
<tr>
<td>30 (-1)</td>
<td></td>
<td>23.0</td>
</tr>
<tr>
<td>40 (4)</td>
<td></td>
<td>16.3</td>
</tr>
<tr>
<td>50 (10)</td>
<td></td>
<td>12.5</td>
</tr>
<tr>
<td>60 (16)</td>
<td></td>
<td>10.1</td>
</tr>
<tr>
<td>70 (21)</td>
<td></td>
<td>8.4</td>
</tr>
<tr>
<td>80 (27)</td>
<td></td>
<td>7.2</td>
</tr>
<tr>
<td>90 (32)</td>
<td></td>
<td>6.3</td>
</tr>
<tr>
<td>100 (38)</td>
<td></td>
<td>5.5</td>
</tr>
</tbody>
</table>

**NOTE:**
Pumps and piping systems should be designed for viscosities at the lowest ambient temperatures encountered at the end user’s location.
2. PACKAGING SPECIFICATIONS

2.1 BULK DELIVERIES

MERQUEL™ 52 can be delivered to customers in bulk. Road tankers or railcars can be sent to the power station and the brine unloaded directly into the customer’s storage tank. MERQUEL™ 52 are not regulated for transportation and do not require placards or storage tank markings.

2.2 TOTES/INTERMEDIATE BULK CONTAINERS (IBC’S)

**PALLETIZATION AND CONTAINERIZATION**

<table>
<thead>
<tr>
<th>Packaging nominal volume:</th>
<th>1000 liter 264 Gallons</th>
</tr>
</thead>
<tbody>
<tr>
<td>Packaging CODE:</td>
<td>617</td>
</tr>
<tr>
<td>IBC net filling:</td>
<td>1700 Kg 3748 pounds</td>
</tr>
<tr>
<td>Packing Dimensions:</td>
<td>1000X1200X1200 mm 39” X47” X47”</td>
</tr>
<tr>
<td>Tare weight IBC:</td>
<td>70 Kg 154 pounds</td>
</tr>
<tr>
<td>IBC Color:</td>
<td>Translucent white</td>
</tr>
<tr>
<td>Total weight:</td>
<td>1770 Kg 3902 pounds</td>
</tr>
</tbody>
</table>
CONTAINERIZATION INSTRUCTIONS

The quantities listed are the maximum for containerization of a 20-ft. long container - gross weight of 24,000 kg or 30,480 kg. Depending on market requirements or customer needs, it is possible to containerize smaller quantities than those listed below. The maximum permissible weight of the container (M.G.W.) and the tare weight are checked prior to containerization.

The maximum number of IBC’s within a container is 10.

---

PLAN TOP VIEW OF THE CONTAINER

---

Container doors
2.3 DRUMS

The palletized drums are stacked in the container in a manner which prevents any movement of the contents during the container handling. These drums are especially designed for their chemical resistance, strength, tightness of closure and ease in emptying.

**NOTE:** These drums are to be used only for **MERQUEL™ 52** brine. Drums should be kept tightly closed except when being emptied.

**PALLETIZATION, PACKING AND CONTAINERIZATION**

### PACKAGING DATA

<table>
<thead>
<tr>
<th>Packaging volume:</th>
<th>208 liter 55 Gallons</th>
<th>Drums per pallet:</th>
<th>4 drums</th>
</tr>
</thead>
<tbody>
<tr>
<td>Packaging CODE:</td>
<td>180</td>
<td>Pallet size:</td>
<td>1140X1140 mm 45”X45”</td>
</tr>
<tr>
<td>Drum dimensions:</td>
<td>Ø580 X 940 mm 23”X37”</td>
<td>Pallet type:</td>
<td>Bearers (black)</td>
</tr>
<tr>
<td>Color of drum:</td>
<td>Black or Blue</td>
<td>Pallet weight:</td>
<td>20 Kg 44 Pounds</td>
</tr>
<tr>
<td>Drum net filling weight:</td>
<td>340 Kg 748 Pounds (USA 781 Pounds)</td>
<td>Tare drum:</td>
<td>10 Kg 22 Pounds</td>
</tr>
</tbody>
</table>

![Drum Image]
PACKAGING SPECIFICATIONS

2.

PACKAGING UNIT ON PALLET PREPARATIONS – 4 DRUMS ON ONE PALLET:

The drums are tied circumferentially with plastic bands in addition to vertical strapping.

CONTAINERIZATION INSTRUCTIONS

The maximum number of pallets within a container is 15 (8 pallets in the first level and 7 pallets in the second level), or 60 drums total. However, this number may be reduced to 13 in view of the maximum permissible loads allowed in certain countries (USA for example). The maximum permissible weight of the container (M.G.W.) and the tare weight are checked prior to containerization.
PACKAGING SPECIFICATIONS

2.4 PRODUCT LABEL FOR MERQUEL™ 52 SOLUTION
**MERQUEL™ 52** solution is shipped to the USA from Israel in bulk shipments or standard 20 foot containers. The brines are transported to one of our storage depots located at strategic locations as close as possible to the power station.

Bulk **MERQUEL™ 52** deliveries are unloaded into storage tanks and are transported to the power stations in 20 ton trucks. It is possible to supply a service package including storage tank, pump, level monitoring, unloading pipework whereby ICL-IP will take the responsibility for inventory control.

A photograph of one of our storage depots is presented below.
4.1 MERQUEL™ 52 BRINE - SAFE HANDLING GUIDE

THE HAZARDS

Like all chemicals, MERQUEL™ 52 can be hazardous to your health if not handled properly.

EFFECTS OF EXPOSURE

- Skin contact — The tendency of brines to absorb water from their surroundings means that they can be quite irritating or even corrosive to the skin. The irritating effect of brines is usually delayed; you may not feel anything for several minutes or even hours after exposure.
- Eye contact — Brines are immediately and severely irritating to the eyes. Permanent eye damage may result from even short exposure to heavy brines. Wash eyes for at least 15 minutes after exposure and get medical attention.
- Inhalation — Inhalation of brine mist or spray can be irritating to the mucous membranes of the nose, mouth and throat.
- Ingestion — Swallowing brine may cause nausea, vomiting and diarrhea in addition to irritation of the mucous membranes of the gastrointestinal tract. Swallowing large quantities may cause more serious toxic effects, depending on the density of the brine and the additives that it contains.

PROTECTING YOURSELF

- Read and follow the instructions in the MSDS (Material Safety Data Sheet) and always have it available on location.
- Use the correct Personal Protective Equipment (PPE)
  The following special equipment is necessary for handling brines:
  **Eyes** — Wear chemical splash goggles designed to seal against the skin around both eyes and give protection against splashes from any angle. A full face shield may be used in addition to goggles to protect the face.
  **Body** — Wear slicker suits in areas where exposure is likely.
  **Hands** — Wear leak-proof gloves made of natural or synthetic-rubber material. Glove cuffs should be worn inside of slicker suit sleeves to prevent brine from running off of sleeves into gloves. Do not use leather gloves.
  **Feet** — Wear leak-proof rubber steel-toe boots. Do not use leather boots.

**NOTE:** Brine is hygroscopic and will take the water out resulting in shrinkage of leather gloves or footwear.
Respiratory — Use a NIOSH-approved P95 half-mask disposable or reusable particulate mask for mist/aerosol. All respiratory protection equipment should be used within a comprehensive respiratory protection program that meets the requirements of 29 CFR 1910.134 (OSHA Respiratory Protection Standard) or local equivalent.

- Practice good skin care:
  - Protection — Before contact with brines apply a barrier cream to areas that are not easily covered by some other form of PPE. Use a barrier cream specifically designed to protect against water-based hazards. Barrier creams should be used in addition to the PPE mentioned above, not as a substitute for it.
  - Cleaning — Wash frequently; use hand soap, not harsh industrial cleaners.
  - Reconditioning — Contact with brines and frequent washing of the skin can result in loss of the skin’s natural oils and moisture. To prevent dry, chafed, and irritated skin, apply a reconditioning skin lotion after work and as needed.

- Safety equipment
  - Emergency eye washes and showers should be installed and made easily accessible in all areas where brines are used. Eye washes and showers should be plainly marked with signs and workers should be trained in their location and proper use.
  - Make sure that brine storage containers and seals are strong enough to hold the brine without rupturing or leaking. Heavy-duty tanks should be used for brines weighing over 13.5 lb/gal (1.62 SG).

SAFETY ISSUES

MERQUEL™ 52 spills can cause a severe slipping hazard. Areas affected by the spill should be roped off and cleaned up immediately to prevent people in the area from being injured by slipping or falling.
4.2 GENERAL SITE RECOMMENDATIONS

This guide provides some standard precautions to be taken at a MERQUEL™ 52 installation. The storage areas can be supplier distribution warehouses, third party distribution houses or user storage areas.

STORAGE FACILITIES

The following is a general guide for choosing and supervising a storage area, especially for storage of quantities of 10 tons or more. Note that all local laws and regulations and codes must be strictly followed; the precautions listed below are in addition to those specified in local codes.

If required by local regulations, low curbs or walls, called dikes, about 200 mm high, should enclose the worksite, to protect the area from external flooding and to minimize the dispersal of MERQUEL™ 52. The minimum diked volume should be equivalent to the largest storage tank plus 10%. The diked area can have a sewer connection if it is provided with a quick closing device, to prevent the entry of MERQUEL™ 52 into the sewer system in case of emergency.

Provide an adequate size sump in the diked area for collecting MERQUEL™ 52 spills and pumping away collected contaminated rain water or fire fighting water.

Drums containing MERQUEL™ 52 should be stored at least 1.2 meters (4 feet) from a wall or ceiling. Minimize areas where MERQUEL™ 52 brine liquid can accumulate, such as pits or confined spaces.

SAFETY AND SECURITY MEASURES

Any area where MERQUEL™ 52 is used or stored should be enclosed so that unauthorized persons and animals are prevented from entering the area. Adequate lighting should be provided to allow sufficient night surveillance.

Provide an adequate supply of clean water for washing and showers.

Provide telephone for reporting accidents, made freely available and accessibly located to permit emergency notifications.
Emergency equipment cabinets should be installed not more than 30 meters or ten seconds walking distance from any location in the storage area.

Non freeze safety showers and eyewash fountains should be provided, clearly marked and with unobstructed access. They should be located close to the MERQUEL™ 52 storage area and not more than 30 meters or 10 seconds walking distance from any location in the storage area. Provide an alternate supply of clean water.

**HANDLING**

All management and operating personnel involved in the use or handling of MERQUEL™ 52, should undergo safety training, in addition to the specific task training. Only experienced well-trained operators should be allowed to receive and unload MERQUEL™ 52 receptacles. Any handling of MERQUEL™ 52 should be carried out with a high standard of housekeeping and personal hygiene.

Ensure that road and rail vehicles cannot be moved during a transfer operation.

Goggles, rubber gauntlets, boots and full body covering clothing should be worn while unloading and handling drums containing MERQUEL™ 52.

The drums should not be handled roughly.

When the MERQUEL™ 52 drums are not in use, the closures should be in place to prevent any accidental spillage. They should be kept dry and tightly closed.
4.3 UNLOADING PROCEDURE FOR ROAD TRUCKS

GENERAL

The following instructions are written for people who are familiar with the physical and chemical properties of MERQUEL™ 52 as well as first aid instructions.

Position the tanker at the designated unloading location. Make sure that the identification number of the tanker is level.

Set the hand brake and place chocks under the wheels.

UNLOADING PROCEDURE

• The driver of the MERQUEL™ 52 truck must coordinate the unloading with plant personnel.
• Wear the recommended personal protective clothing and equipment as outlined in this manual.
• The tanker can be unloaded either by compressed air, or by a pump.
• Make sure that the tanker valves are closed and the blind flanges are in place.
• The tanker should be fitted with two valves:
  The liquid unloading valve – either a bottom unloading valve or a top unloading valve with a dip pipe.
  The vent or pressurizing valve.

UNLOADING WITH COMPRESSED AIR

• Carefully remove the blind flange on the top of the vent/pressurizing valve. Connect the plant compressed air flexible pipe and tighten properly.
• The compressed air pressure should be regulated to a maximum of 3 bars (44 psi) for unloading the tanker.
• Ensure that the plant storage tank is vented.
• Carefully remove the blind flange on the liquid outlet valve. Connect the plant liquid flexible pipe and tighten properly. Open the plant valves in the liquid line (if installed). Slowly open the tanker discharge valve.
• If there is sufficient pressure in the tanker, the flow will begin. Watch out for leaks.
• Open the valves in the pressuring line in the plant and then slowly open the tanker pressurizing valve.
• Apply adequate compressed air pressure to establish a MERQUEL™ 52 flow to the plant storage tank.
• Do not leave tanker unattended while unloading and wear the proper protective clothing and equipment.

• In case of a leakage, shut off the valves immediately. Wash off any spillage immediately with plenty of water to prevent corrosion. For further instructions, please read our Material Safety Data Sheet (MSDS).

• Allow the tanker pressure to be vented to the atmosphere or to a scrubber. Proceed with the necessary repairs to stop the leak, and then continue with the unloading.

• When compressed air is blown through the unloading line into your storage tank, the tanker is empty. Close the pressurizing valve followed by the liquid valve.

• Switch your pressurizing line to atmosphere, or to a vent scrubber line to relieve the pressure on the tanker.

• Once the tanker is depressurized, close the tanker vent valve and the plant line vent valve.

• Disconnect the tanker valves, install the blind flanges. Tighten properly.

**UNLOADING WITH A PUMP**

• Carefully remove the blind flange on the top of the vent/pressurizing valve.

• Open the vent valve and the manhole cover.

• Ensure that the plant storage tank is vented.

• Carefully remove the blind flange on the liquid outlet valve. Connect the plant liquid flexible pipe and tighten properly. Open the plant valves in the liquid line (if installed). Slowly open the tanker discharge valve.

• Start the pump.

• Do not leave tanker unattended while unloading and wear the proper protective clothing and equipment. In case of a leakage, shut off the valves and pump immediately. Wash off any spillage immediately with plenty of water to prevent corrosion. For further instructions, please read our Material Safety Data Sheet (MSDS).

• Proceed with the necessary repairs to stop the leak, and then continue with the unloading.

• When the tanker is empty. Stop the pump and close your liquid valves.

• Disconnect the tanker valves, install the blind flanges. Tighten properly.
4.4 MATERIALS OF CONSTRUCTION GUIDE

STORAGE TANKS

Storage tanks for MERQUEL™ 52 should be constructed from AISI 316 Stainless Steel or Carbon Steel protected by an epoxy lining. It is also possible to use FRP (Fibreglass Reinforced Plastic) tanks.

PIPEWORK

Stainless steel or plastic polypropylene piping can be used.

Stainless steel
Piping between 1/2” and 6” should be schedule 10 S, stainless steel seamed, to ASTM A-312-TP-316L. Piping fittings of 1 1/2” and above should be butt welded or flanged forged carbon steel ASTM 150 pound, with stainless steel stub end. Under 1” through 1/2”, fittings should be socket welded, 3000 pound rating.
Flange gaskets should be 3 mm thick PTFE sandwich with non-asbestos filler. Ball, plug or diaphragm valves can be used.
Hoses should be flexible metal hose with all wetted parts in 316 L stainless steel annular corrugated.

Polypropylene
Piping between 20 mm (1/2”) and 110 mm (4”) diameter should be solid black polypropylene pipe, stress relieved, with plain ends for fusion socket welding connection PN-10, as per DIN 8077. Piping between 160 mm (6”) and 315 mm (12”) diameters should be according to PN 6, for butt welding connection.
Flanges should have a backing ring fabricated from carbon steel, drilled to ANSI 150 pounds rating, painted with epoxy 240 μ.
Flange gaskets should be a PTFE sandwich, 3 mm thick with non-asbestos filler. Teflon lined flanged plug or diaphragm valves are preferred.
Hoses should be PTFE with stainless steel braid covering and carbon steel flanges. Screwed fittings are not used.

PUMPS
Pumps are usually constructed of 316 stainless steel contact parts.
4.5 TESTING PROCEDURES

The following measurements may be required to monitor the brine quality during operation:

- PH OF BRINE
- CRYSTALLIZATION POINT DETERMINATION
- BRINE DENSITY

There are various test methods used, one being API RP 13J, 3rd Edition, December 2003, which is used in the Petroleum Industry.
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