



Teflon™ Solvent Based One-Coat

Industrial Coatings

420G-104, 420G-111, 420G-117, 420G-109, 420G-129

Fact Sheet

Solvent Based PTFE One-Coat with excellent adhesion, durability, heat resistance and non-stick qualities, making this coating a good choice in variety of situations where dry lubrication and release in an abrasive or high-temperature environment are needed.

Property Data ¹

Product Code	420G-104	420G-111	420G-117	420G-109	420G-129
Color	Gray	Pewter	Green	Met. Black	Black
Closest RAL	7001				
Coverage, ² m ² /kg (m ² /L) (ft ² /gal)	5.3 (5.8) (236)	6.5 (7.2) (293)	5.6 (6.3) (256)	5.1 (5.4) (218)	5.2 (5.4) (221)
Viscosity, ³ centipoises	800 - 1400	700 - 1300	800 - 1400	800 - 1400	800 - 1400
Volume Solids, %	14.1 – 15.1	17.5 – 18.5	15.3 – 16.3	12.9 – 13.9	13.1 – 14.1
Weight Solids, ⁴ %	24.9 – 27.9	25.5 – 28.5	26.7 – 29.7	20.3 – 23.3	20.6 – 23.6
Density, kg/l (lbs/gal)	1.105 (9.2)	1.107 (9.2)	1.126 (9.4)	1.052 (8.8)	1.052 (8.8)
VOC content, Europe, ⁵ g/kg	736.0	702.7	717.7	781.3	778.9
Maximum In-Use Temperature, °C (°F)	260 (500)	260 (500)	260 (500)	260 (500)	260 (500)
Flash Point, SETA closed cup, °C (°F)	29 (84)	29 (84)	42 (108)	34 (93)	34 (93)

¹Physical constants are averages only and are not to be used as product specifications. They may vary up to ±5% of the values shown

²Theoretical coverage at dry film thickness (DFT) of 1.0 mils (25µ) based on 100% application efficiency. It does not take normal production losses into account

³Brookfield RVT (Measured with spindle 2 at 20 RPM/25°C)

⁴Weight Solids (Measured 30'x105°C+6'x430°C, 10'x220°C+6'x430°C for 420G-111)

⁵Weight % volatiles based on volatiles with vapor pressure ≥ 0.1 hPa. US VOC (ap) and VOC (le) are listed on the US Safety data sheet, available upon request

Application Method

Substrate	Carbon steel, stainless steel, aluminium, aluminized steel, other suitable. Elements of impurity can have a reverse impact on quality of the coated article. Pre-treatments, which withstand the curing temperature, are suitable. The part to be coated shall be of design and degree of workmanship such as to produce excellent quality merchandise based on accepted industry standards.
Surface Preparation	Apply over a clean, roughened surface (recommended profile: Ra 1.5 µm / 0.06 mil). Adhesion is also excellent over smooth metal. Any residual oil on the surface will affect the color of the cured film and will adversely affect adhesion.
Coating Preparation	Mix 15 minutes or more until contents are homogeneous. Set the mixer speed so that a strong vortex appears while avoiding air entrapment. We recommend the use of an axial flow impeller. Insufficient mixing can result in application defects.
Filtering	100 mesh (approx. 150 µm) stainless steel or nylon
Application	Preferable RP (Reduced Pressure) guns, HVLP or conventional guns are also possible. Nozzle: 1.0-1.4 mm. Atomizing air pressure: 2-4 bar (30-60 psi). For safety reasons, we do not recommend manual electrostatic spray application.
Recommended DFT*	20 µm/coat (0.8 mil), can be obtained with several passes of a spray gun - wet on wet.
Drying (metal temp.)	10 minutes at 150-200°C (300-390°F). If humidity is high, put in oven immediately.
Curing (metal temp.)	3-5 min at 400°C (750°F) for dry-lub applications or 10 min at 360-370°C (680-700°F)
Clean up	TN-8596, N-Methyl-Pyrrolidone
Thinner / Additive	TN-8596, TN-8595

* Dry Film Thickness (DFT) measured with Dual probe ED10 or FD10 used in combination with the Dualscope MP20, MP40, FMP20 or FMP40

All recommendations are based upon best knowledge



Handling and Storage

- Gently mix (15 min at 30RPM) before use
- Shelf life is 18 months at optimal storage conditions: 18°C-27°C (65°F-80°F). Maximum storage temperature 30°C (86°F).
- Transport conditions: 5°C-40°C (40°F-105°F). For safe storage conditions, please refer to safety data sheet.

For medical application and development, consult Chemours.

Food Contact

This product is designed to be used in direct contact with food. Applied according to the application method and instructions on this fact sheet, the fully cured system will comply with US FDA food contact regulations.

420G-117 is not FDA compliant.

In the European Union this product complies with:

- Regulation (EC) n° 1935/2004 on materials and articles intended to come into contact with food and is safe to be used and/or sold in accordance with article 3 of this Regulation; and
- Specific national legislations/ recommendations applicable to this category of coatings (non-stick, high temperature resistant) listed in the detailed compliance documentation for food contact applications.

In case this product is not compliant with the specific legal requirements in one EU Member State; This product, in accordance with Article 34-36 of the Treaty on the Functioning of the European Union (TFEU), can still be used and/or sold for food contact applications in all EU Member States, on the basis of its full compliance in at least one Member State of the European Union.

The above is only valid on condition that the product is applied: according to the information outlined in the application method section of this fact sheet, on substrates that are suitable for use in food contact applications, and for EU presuming appropriate processing by the coater/applicator following the Good Manufacturing Practices Regulation (EC) n°2023/2006 /EC.

Any changes or variations from application method indicated in this fact sheet for food contact applications shall be assessed prior to its use.

For detailed regulatory compliance information and/or any potential regulatory restrictions on the use of this (primer, midcoat, topcoat, one-coat) product within one of the corresponding Industrial Finishes coating systems from Chemours, we refer you to the US FDA and/or EU compliance documentation from Chemours for the specific coating system utilizing this product, as well as the technical advice included in this product factsheet.

For details and information please contact your Chemours representative.

Disposal and Other Considerations

Please follow the guidelines as outlined by [SPI](#) (The Society of the Plastics Industry) or [PlasticsEurope](#) (Association of Plastics Manufacturers Europe). For detailed information on health and safety, refer to the Safety Data Sheet.

For disposal, please follow these guidelines:

- All treatment, storage, transportation, and disposal of this product and/or container must be in accordance with applicable national and local regulations.
- Do not discharge aqueous dispersions to lakes, streams or waterways.
- Separate solids from liquid by precipitation and decanting or filtering. Dispose of dry solids in a landfill that is permitted, licensed or registered to manage industrial solid waste. Discharge liquid filtrate to a wastewater treatment system.
- Incinerate only if incinerator operates at 800°C or higher and is capable of scrubbing out hydrogen fluoride and other acidic combustion products.
- Industrial fluoropolymer waste containing additives such as solvents, primers or thinners must be regarded as special waste. Companies should contact their local waste disposal authorities for details of the relevant waste disposal regulations.
- Empty containers should preferably be cleaned and recycled. If this is not possible, the containers should be punctured or otherwise destroyed before disposal.

For more information on Chemours Nonstick coatings: www.chemours.com or www.teflon.com

The Chemours Company
1007 Market Street
P.O. Box 2047
Wilmington, DE 19899
T: +1 302 773 1000

Asia Pacific
The Chemours Chemical
(Shanghai) Co., Ltd.
Shanghai, China
T: +86 21 3862 2888

Europe
Chemours Belgium BVBA
Kallo, Belgium
T: +32 3 730 2211

Latin America
Chemours do Brasil, S.A.
Sao Paulo, Brasil
T: +55 11 2599 8574

Teflon™ is a trademark of the Chemours Company FC, LLC, only available for use under license.

NO PART OF THIS MATERIAL MAY BE REPRODUCED, STORED IN A RETRIEVAL SYSTEM OR TRANSMITTED IN ANY FORM OR BY ANY MEANS ELECTRONIC, MECHANICAL, PHOTOCOPYING, RECORDING OR OTHERWISE WITHOUT THE PRIOR WRITTEN PERMISSION OF Chemours.

All technical advice, recommendations and services are rendered by Seller free of charge. They are based on technical data which the Seller believes to be reliable, and are intended for use by persons having skill and know-how, at their own discretion and risk. Seller assumes no responsibility for results obtained or damages incurred from their use by Buyer in whole or in part. Such recommendations and technical advice or services are not to be taken as a license to operate under or intended to suggest infringement of any existing patent. All coverage figures are based on 100% application efficiency. These calculations do not take into account normal losses due to production conditions.

CAUTION: Do not use Chemours materials in medical applications involving implantation in the human body or contact with internal body fluids or tissues unless the material has been provided from Chemours under a written contract that is consistent with Chemours policy regarding medical applications and expressly acknowledges the contemplated use. For further information, please contact your Chemours representative. You may also request a copy of the Chemours POLICY Regarding Medical Applications