

DuPont Industrial Nonstick Coatings

2-COAT SPRAY-ON SYSTEM FOR EXCELLENT ABRASION RESISTANCE AND RELEASE

Product Information

DuPont Industrial Nonstick Coatings are aqueous dispersions that are uniquely blended multi-coat systems of DuPont™ Teflon® PTFE (polytetrafluoroethylene), Teflon® FEP (fluorinated ethylene propylene copolymer), and Teflon® PFA (perfluoroalkoxy) to optimize performance. The exceptional properties provide superior abrasion resistance and extend service life.

Property Data

Product Code	Primer 857G-030	Topcoat 857G-230
Properties¹		
Color	Black	Black
System Color	–	Black
Coverage, ² m ² /kg (m ² /L) (ft ² /gal)	4.10 (4.72) (189)	7.15 (9.44) (378)
Coverage at DFT, ³ m ² /kg	12.8 (at 8μ)	9.9 (at 18μ)
Viscosity, ⁴ centipoises	250 – 375	300 – 400
Volume Solids, %	11.3 – 12.3	23.0 – 24.2
Weight Solids, %	22.5 – 24.5	39.2 – 41.2
Density, kg/l (lbs/gal)	1.15 (9.59)	1.32 (11.01)
Maximum In-Use Temperature, °C (°F)	260 (500)	260 (500)
Flash Point, SETA closed cup, °C (°F)	None	None
Shipping Class	+200L	+200L
Food Contact*	Yes	Yes

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

³Theoretical coverage at given dry film thickness (DFT) and based on 100% application efficiency. It does not take normal production losses into account

⁴Brookfield RVT (Measured with spindle 2 at 20 RPM/25 °C)

*See Food Contact Section



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Application Method

Substrate	required	Rolled and cast aluminum, and stainless steel.
Surface Preparation	recommended	Rolled: Defined profile curve has to be met by alkaline/alkaline-acid cleaning or by light gritblasting / Cast: light gritblast / Stainless Steel: Gritblast Ra value: 120 μinch or 2.6 microns.
Filtering	required	100 mesh (appr. 150μ) stainless steel or nylon
Application	recommended	Spray on. Air pressure of 3-5 kg/cm ² and fluid delivery pressures of 0.8-1.2 kg/cm ² . HVLP gun air has to be increased. Primer spray preferable with conventional spray gun. Primer has to be stirred in the pressure pot at 30 rpm during application
Product DFT	recommended	PRIMER: 7-10μm TOPCOAT: 16-20μm
Total DFT	required	TOTAL: 25μm
Ratio	recommended	PRIMER: 44% TOPCOAT: 56%
Drying	recommended	Primer: Force dry (Ref. 5-8 min. at 120–150 °C (248–302 °F). Temperature of primer between 35–45 °C (95–113 °F) before application of topcoat.
Curing	required	Total system: minimum 5 min. at 428 °C (802 °F) or 3 min. at 435 °C (815 °F) (metal temperature). Peak temperature should not exceed 440 °C (824 °F).
Clean up	recommended	Water
Thinner/Additive	required	Water

All recommendations are based upon best knowledge

Handling and Storage

- Storage life is 12 months maximum at room temperature.
- Storage temperature 18-27 °C.
- Roll for 30 minutes at 30 RPM once per month.
- Warm containers to room temperature and roll completely before use.
- Water-based product, protect from freezing.
- For medical application and development, consult DuPont.

For detailed information on health and safety, refer to the Material Safety Data Sheet and the latest edition of the "Guide to the Safe Handling of Fluoropolymer Resins," published by The Society of the Plastics Industry, Inc. (www.fluoropolymers.org) or by PlasticsEurope (www.plasticseurope.org).

Food Contact

This coating system 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 coating will comply with US FDA food contact regulations in 21CFR and can be sold and/or used for food contact applications for nonstick coatings in Europe following the national legislations of each European country, having specific regulations for this category of coatings (nonstick, high temperature resistant). Any changes or variations of individual coating thickness from what is indicated in this fact sheet should be assessed for food contact applications prior to its use. For details and information please contact your DuPont representative.

In Europe, in the case of incomplete compliance in one country, the product can, on the basis of its full compliance in at least one Member State of the European Union, be used for direct food contact in all Member States according to the Article 28-30 (ex Article 30-36) of the Treaty of Rome as amended.

Compositional statements, referring to relevant national legislation, are available on request.

Disposal and Other Considerations

Please follow these disposal guidelines as outlined in "The Guide to the Safe Handling of Fluoropolymer Resins," (available at www.fluoropolymers.org for download):

- 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 DuPont Industrial Nonstick Coatings:
www.teflon.com/industrial

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CAUTION: Do not use DuPont 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 DuPont under a written contract that is consistent with DuPont policy regarding medical applications and expressly acknowledges the contemplated use. For further information, please contact your DuPont representative. You may also download a copy of the DuPont POLICY Regarding Medical Applications H-50103 and DuPont CAUTION Regarding Medical Applications H-50102 at www.teflon.com/industrial.



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