



Teflon™ Solvent Based FEP One-Coat

Industrial Coatings

954G-300, 954G-302, 954G-303, 954G-304

Fact Sheet

954G-3XX One Coat nonstick finishes are designed for relatively low temperature curing. These coatings are suitable for use in conditions of mild abrasion, relatively low operating temperatures and for chemical and corrosion resistance.

Property Data ¹

Product Code	954G-300	954G-302	954G-303	954G-304
Color	Clear	Dark Gray	Black	Green
Coverage, ² m ² /kg (m ² /L) (ft ² /gal)	13(15)(612)	13 (14) (597)	12 (13) (537)	12 (14) (567)
Viscosity, ³ centipoises	250 – 850	450 – 2750	200 – 500	200 – 500
Volume Solids, %	36.5 – 38.0	36.5 – 38.0	32.5 – 34.5	34.2 – 35.3
Weight Solids, ⁴ %	51.5 – 54.5	49.5 – 54.9	46.5 – 48.5	49.5 – 52.5
Density, kg/l (lbs/gal)	1.09 (9.11)	1.12 (9.39)	1.07 (8.91)	1.10 (9.21)
VOC content, US lbs/gal	4.32	4.48	4.6	4.54
Maximum In-Use Temperature, °C (°F)	150 (302)	150 (302)	150 (302)	150 (302)
Flash Point, SETA closed cup, °C (°F)	28 (82)	18 (64)	18 (64)	26 (80)

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 3 at 20 RPM/25°C)

⁴Weight Solids (Measured 30'x105°C+15'x380°C)

Application Method

Substrate	Carbon steel, stainless steel, aluminum. Not high copper containing alloys
Surface Preparation	Degreasing, grit blasting is recommended, but not required
Filtering	Strain through 100-mesh (150μ) wire screen or cheese cloth
Application	Roll or mix prior until contents are homogeneous (30 minutes)
Recommended DFT*	Film Thickness up to 30μ per coat as indicated by the end use.
Drying	Force dry 10 minutes to drive off volatile substances
Curing(metal temperature)	Single coat: Recommended :10min. at 260°C (500°F) Minimum: 10 -20 min. at 160°C (320°F) Note: Higher bake temperature at 288°C(550°F) for 20 min. will provide best Corrosion and chemical resistance, but with noticeable film discoloration Multiple coats: Initial and intermediate coats: 15min. at 150°C (300°F) Final coat: Recommended :20 min. at 260°C (500°F) Minimum: 20min. at 232°C (450°F)
Clean up	TN-8748
Thinner	TN-8748

* Dry Film Thickness (DFT) measured with Dual probe ED10 or FD10 used in combination with the Dualscope MP20 or MP40 E-S

All recommendations are based upon best knowledge

Handling and Storage

- Gently mix (15 min at 30 rpm) before use
- Storage life is 12 months at room temperature.(18-27°C)

For medical application and development, consult Chemours.

Food Contact

This coating system, 954G-3XX, is **not** designed to be used in direct contact with food

Disposal and Other Considerations

Please follow the guidelines as outlined by [SPI](#) (The Society of the Plastics Industry) or [APME](#) (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 ap-

plicable 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

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