Teflon™ Solvent Based Primer

Industrial Coatings

420G-703, 420G-706, 420G-750, 420G-751

Fact Sheet

Solvent based primers designed to work on any metallic substrate that withstand the recommended cure temperature, in combination with FEP and PFA topcoats (powders or liquids). These primers are used in many different applications, like Industrial Bakeware, Textile, Paper, Machinery and several other general industrial applications.

Property Data [1]

Product Code	420G-703	420G-706	420G-750	420G-751
Color	Black	Pewter	Dusty Grey	Mouse Grey
Closest RAL	xx	xx	7037	7005
Coverage,[2] m^2/kg (m^2/L) (ft^2/gal)	6.18 (7.08) (288)	6.40 (7.18) (292)	6.46 (7.19) (292)	6.77 (7.66) (312)
Viscosity,[3] centipoises	800 - 1600	1700 - 2300	550 - 1750	1850 - 3550
Volume Solids, %	17.2 - 18.2	17.4 - 18.4	17.5 - 18.5	18.6 - 19.6
Weight Solids,[4] %	30.1 - 33.1	24.5 – 27.5	28.6 - 32.6	30.2 - 34.2
Density, kg/l (lbs/gal)	1.145 (9.56)	1.122 (9.37)	1.113 (9.29)	1.131 (9.44)
VOC content, Europe,[5] g/kg	684.0	714.9	693.3	678.0
Maximum In-Use Temperature, °C (°F)	The maximum in-use temperature of coating system is defined by the topcoat			
Flash Point, SETA closed cup, °C (°F)	31 (88)	55 (131)	38 (100)	47 (117)

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

[2]Theoretical 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

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

[4]Weight Solids (Measured 15'x220°C+15'x380°C)

[5]Weight % 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. 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 3-4 µm / 0.1–0.2 mil).
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	60 mesh (approx. 250 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 reason, we do not recommend manual electrostatic spray application.
Recommended DFT*	10-12 µm (0.4-0.5 mil). Inter-coat adhesion failure can occur if the primer is applied > 20 µm (0.8 mil)
Recommended Topcoat	PFA 532G-lines, PFA 858G-lines, FEP 532G-lines, FEP 856G-lines
Drying (metal temp.)	Dry primer 10 minutes at 150-170°C before applying powder topcoat (good inter coat adhesion is also experienced when the powder topcoat is applied directly over the wet primer). Dry primer at 220°C before applying liquid coat.
Curing (metal temp.)	See Topcoat Fact Sheet. Baking conditions of the first layer after primer are critical to ensure a good inter-coat adhesion.
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

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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, pls. refer to safety data sheet.

For medical application and development, consult Chemours.

Food Contact

This product, when used in combination with another layer compliant with food legislations, 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.

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) 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

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