



# Teflon™ Water Based Primer

## Industrial Coatings

### 459G-804

## Fact Sheet

Water based primer intended to be used in combination with PTFE or FEP topcoats. It does contain some rust inhibitors that delay corrosion of substrate when used on steel.

### Property Data <sup>1</sup>

Product Code	459G-804
Color	Green
Closest RAL	6011
Coverage, <sup>2</sup> m <sup>2</sup> /kg (m <sup>2</sup> /L) (ft <sup>2</sup> /gal)	5.71 (6.83) (278)
Viscosity, <sup>3</sup> centipoises	150 - 375
Volume Solids, %	16.6 – 17.6
Weight Solids, <sup>4</sup> %	27.4 – 30.4
Density, kg/l (lbs/gal)	1.195 (9.98)
VOC content, Europe, <sup>5</sup> g/kg	232.3
Maximum In-Use Temperature, °C (°F)	See topcoat
Flash Point, SETA closed cup, °C (°F)	None

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

<sup>2</sup>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

<sup>3</sup>Brookfield RVT (Measured with spindle 1 at 20 RPM/25°C)

<sup>4</sup>Weight Solids (Measured 30'x105°C+6'x430°C)

<sup>5</sup>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. 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	Gently mix 15 minutes or more until contents are homogeneous. Set the mixer speed so that a strong vortex is appearing while avoiding air entrapment. We recommend the use of an axial flow impeller. Insufficient mixing can result in application defects.
Filtering	150 mesh (approx. 100 µm) stainless steel or nylon
Application	RP (Reduced Pressure), conventional or HVLP gun. Nozzle: 0.8-1.2 mm. Atomizing air pressure: 2-3 bar (30-45 psi). Spray at room temperature of 20°C minimum. The primer is to be applied directly after grit blasting and dried as soon as possible
Recommended DFT*	Primer DFT 10-15 µm (0.4-0.6 mil), Clear Topcoat DFT equal to or greater than Primer DFT.
Recommended Topcoat	PTFE (851G-line, 852G-line, 857G-line) or FEP (856G-line).
Drying (metal temp.)	15 minutes at 230-250°C (445-480°F).
Curing (metal temp.)	See Topcoat Fact Sheet. A bake at min. 250°C (480°F) is important.
Clean up	Water
Thinner / Additive	Deionised water

\* 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 40°C (105°F).
- Transport conditions: 5°C-40°C (40°F-105°F). For safe storage conditions, pls. refer to safety data sheet.
- Waterbased product, protect from freezing

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](http://www.chemours.com) or [www.teflon.com](http://www.teflon.com)**

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**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