



Teflon™ One Coat Dipping Green

Industrial Coatings

856G-114

Fact Sheet

Property Data

Properties ^a	Teflon™ 856G-114
Color	Green
Coverage, m ² /kg (ft ² /gal) ^b	6.36 (8.20) (334)
Viscosity, cP ^c	1300–2300
Volume Solids, %	10.32
Weight Solids, % ^d	23–27
Density, kg/L (lb/gal)	1.16 (10.75)
Maximum In-Use Temperature, °C (°F)	205 (400)
Flash Point, SETA Closed Cup, °C (°F)	Does not flash

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

^bTheoretical coverage at dry film thickness (DFT) of 25 µm (1.0 mil) based on 100% application efficiency. It does not take normal production losses into account.

^cBrookfield RVT (Measured with spindle 2 at 20 rpm/25 °C [77 °F])

^dWeight Solids (Measured 30 min x 105 °C [221 °F] + 15 min x 380 °C [716 °F])

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. 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 min or more until contents are homogeneous. Set the mixer speed so that a vortex appears while avoiding air entrapment. We recommend the use of an axial flow impeller. Insufficient mixing can result in application defects.
Filtering	40 mesh (approx. 400 µm) stainless steel or nylon
Application	Dipping to get 50 µm
Recommended DFT*	Recommended DFT up to 50 µm (2 mil) per coat depending on the speed for dipping. Total DFT up to 75 µm (3 mil). A thinner film can also be obtained after dilution of the product with water.
Drying (Metal Temp.)	20–30 min at 120–150 °C (248–302 °F)
Curing (Metal Temp.)	Ramp oven temperature from 125 °C to 345 °C (257 °F to 653 °F) if you only apply 1 coat. Metal temperature should be 30 min in the range of 340–350 °C (644–662 °F). It is important to keep the difference between metal and air temperature small to prevent bubbling.
Bath Maintenance	When not used, the bath should be covered to reduce evaporation. When evaporation is observed (viscosity increase), a correction can be done by adding water and gentle stirring to come back to the viscosity. Although the stability of this product is very good, a daily mixing is recommended.
Preparation	If the coating needs to be repaired, it is possible to sandpaper the coating. For high thickness, use P80–120, for thin layers, use P400.
Spark Test	This coating is electrostatically dissipating; 106–1012 ohms/square; spark testing will not determine porosity.
Cleanup	Water
Thinner/Additive	Dilution can be done with water, but will reduce the thickness applied and decrease the stability.

*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 30 rpm) before use.
- Shelf life is 12 months at optimal storage conditions: 18–27 °C (65–80 °F). Maximum storage temperature: 40 °C (105 °F).
- Transport conditions: 5–40 °C (40–105 °F). For safe storage conditions, please refer to Safety Data Sheet (SDS).
- Water-based product, protect from freezing.

For medical application and development, please consult Chemours.

Food Contact

Teflon™ 856G-114 does not comply with FDA regulations in 21CFR governing components of coatings for direct food contact.

Disposal and Other Considerations

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

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 (1475 °F) 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 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.

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