



Teflon™ One Coat Blue

Industrial Coatings

857G-018

Fact Sheet

857G-018 is a low VOC water-based one coat industrial coating designed for use in corrosive environments. It is specifically designed for coating of offshore fasteners and for use on substrates, such as carbon steel, stainless steel, and aluminum. It is applied with conventional spray application equipment that may be easily cleaned with just water. A typical application procedure includes spray application with conventional equipment at 2-3 atm (30-45 psi) to a dry film thickness (DFT) of 0.8-1.2 mil followed by minimal pre-drying and baking at 232 °C (450 °F) for 15-20 min.

Property Data

Properties ^a	857G-018
Color	Blue
Coverage, m ² /kg (ft ² /gal) ^b	8.65 (9.52) (388)
Viscosity, cP ^c	450-750
Volume Solids, %	25.6-29.6
Weight Solids, % ^d	30.6-34.6
Density, kg/L (lb/gal)	1.10 (9.17)
Maximum In-Use Temperature, °C (°F)	204 (400)
Flash Point, SETA Closed Cup, °C (°F)	None

^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, aluminum, except high copper-containing alloys
Surface Preparation	For aluminum, stainless steel, and carbon steel: 1. Clean (vapor degrease, prebake, or other). 2. Lightly grit-blast with aluminum oxide (e.g., 120-180 µm). Other pretreatments for corrosion resistance can be carried out as well prior to application of the coating to the part. Application of conversion coatings is suggested where grit blasting is not practical and/or additional corrosion protection is specified. The coating should be applied immediately after blasting on carbon steel to avoid flash rusting. If a conversion coating is applied, 857G-018 should then be applied before the reported shelf life of the applied conversion coating is realized.
Application	1. Bring material to room temperature (21-26 °C [70-79 °F] is optimal). 2. Mix thoroughly, and filter the material through a 100-mesh stainless steel screen (0.146 mm openings). Use conventional industrial spray equipment. 3. Apply at a minimum dry film thickness of 20-30 µm (0.8-1.2 mil). Higher film thicknesses are possible.
Drying/Curing (Metal Temp)	Typical Drying and Baking: The required bake window for this product is 15-20 min at a metal temperature of 232-260 °C (450-500 °F). The optimum temperature and time will depend on the size and mass of the part. An uncoated part should be measured by thermocouple to ensure that the substrate stays within the proper bake window during the processing of the part.
Cleanup	Water

^aDry 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, consult Chemours.

Food Contact

This product is not intended for use in direct contact with food.

Disposal and Other Considerations

Please follow the guidelines as outlined by The Plastics Industry Association (PIA) 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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