



Teflon™ Solvent Based One-Coat

Industrial Coatings

954G-300, 954G-303, 954G-304, 954G-308

Fact Sheet

FEP based One Coat non-stick finishes 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-303	954G-304	954G-308
Color	Clear	Black	Green	Orange
Closest RAL	-	9011	6021	2003
Coverage, ² m ² /kg (m ² /L) (ft ² /gal)	14.0 (15.2) (619)	13.1 (14.1) (573)	13.1 (14.5) (590)	13.4 (14.8) (604)
Viscosity, ³ centipoises	400 - 1000	150 - 550	150 - 550	400 - 1000
Volume Solids, %	37.5 – 38.5	34.6 – 35.6	35.7 – 36.7	36.5 – 37.5
Weight Solids, ⁴ %	49.3 – 53.3	45.5 – 49.5	48.6 – 52.6	46.9 – 50.9
Density, kg/l (lbs/gal)	1.085 (9.1)	1.070 (8.9)	1.107 (9.2)	1.107 (9.2)
VOC content, Europe, ⁵ g/kg	458.8	423.5	433.6	304.8
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)	26 (80)	36 (97)

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 2 at 20 RPM/25°C)

⁴Weight Solids (Measured 30'x105°C+10'x220°C)

⁵Weight % 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, other suitable. 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 (Ra 3-4 µm) although grit blasting not always required.
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	100 mesh (approx. 150 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 reasons, we do not recommend manual electrostatic spray application.
Recommended DFT*	Up to 30 µm (1.2 mil) per coat
Drying (metal temp.)	10 minutes at 120°C (250°F). If humidity is high, put in oven immediately.
Curing (metal temp.)	Minimum 20-30 min. at 160°C (320°F), recommended 10 min. at 260°C (500°F). Higher bake at 290°C (550°F) for 20 min. will provide best corrosion and chemical resistance, but with noticeable film discoloration. For multiple coats: Initial and intermediate coats: 15 min. at 150°C (300°F)
Clean up	TN-8748
Thinner / Additive	TN-8748

* 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 12 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, please refer to safety data sheet.

For medical application and development, consult Chemours.

Food Contact

Those products are not intended for use in direct contact with food.

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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