



# Teflon™ Solvent Based One-Coat

## Industrial Coatings

958G-203

## Fact Sheet

FEP based One Coat non-stick finishes suitable for use under moderate abrasion and where non-stick properties contribute to product performance. This product is applicable for moderate cure temperatures and can also be used as primer on specific applications.

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

Product Code	958G-203
Color	Black
Closest RAL	9004
Coverage, <sup>2</sup> m <sup>2</sup> /kg (m <sup>2</sup> /L) (ft <sup>2</sup> /gal)	6.96 (7.3) (297)
Viscosity, <sup>3</sup> centipoises	600 - 1100
Volume Solids, %	17.7 – 18.7
Weight Solids, <sup>4</sup> %	21.8 – 24.8
Density, kg/l (lbs/gal)	1.05 (8.75)
VOC content, Europe, <sup>5</sup> g/kg	678.0
Maximum In-Use Temperature, °C (°F)	215 (420)
Flash Point, SETA closed cup, °C (°F)	36 (97)

<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 2 at 20 RPM/25°C)

<sup>4</sup>Weight Solids (Measured 30'x105°C+15'x350°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, 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 (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	150 mesh (approx. 100 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*	15-30 µm (0.6-1.2 mil). Maximum DFT in multiple coats: 64 µm (2.5 mil)
Drying (metal temp.)	Flash dry in air 1–5 min. prior to bake. If humidity is 85% or above, do not air flash. Instead, place in oven immediately to minimize absorption of moisture which may cause pinholes and water blisters.
Curing (metal temp.)	15 min. at 150°C (300°F), followed by 15 min. at 345°C (650°F). For dry film builds greater than 30 µm (1.2 mil), bake initial coat and any intermediate coats: 15 min at 150°C (300°F) Final bake: 15 min. at 345°C (650°F).
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



### 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, please refer to safety data sheet.

For medical application and development, consult Chemours.

### Food Contact

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

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