



Teflon™ Solvent Based One-Coat

Industrial Coatings

958G-406, 958G-414

Fact Sheet

Low bake PTFE-based hard and wear resistant coatings, 958G-406 and 958G-414 combine excellent adhesion, low friction surface and good corrosion resistance. In case higher hardness and wear resistance is needed, 958G-414 should be selected. 958G-4xx can be over-coated and machined.

Property Data ¹

Product Code	958G-406	958G-414
Color	Black	Green (wet product)
Closest RAL	9011	7026
Coverage, ² m ² /kg (m ² /L) (ft ² /gal)	6.42 (6.91) (282)	7.87 (8.52) (347)
Viscosity, ³ centipoises	1400 - 2300	2000 - 3500
Volume Solids, %	16.8 – 17.8	20.8 – 21.8
Weight Solids, ⁴ %	22.1 – 25.1	24.9 – 27.9
Density, kg/l (lbs/gal)	1.077 (8.99)	1.082 (9.03)
VOC content, Europe, ⁵ g/kg	768.6	737.0
Maximum In-Use Temperature, °C (°F)	200 (392)	200 (392)
Flash Point, SETA closed cup, °C (°F)	46 (115)	40 (104)

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 3 at 20 RPM/25°C)

⁴Weight Solids (Measured 15'x105°C+15'x300°C for 958G-406 or 30'x105°C+10'x220°C for 958G-414)

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 2-3µm) 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: 2-5 bar (30-75 psi). For safety reasons, we do not recommend manual electrostatic spray application.
Recommended DFT*	Up to 40µm (1.6 mil) per coat. The coating can be applied from 25-120µm (1.0-4.7 mil), several layers can be sprayed on top of each other, on cold and warm substrates. Never exceed 50°C substrate temperature. Lower preheating temperature results in a smoother coating.
Drying (metal temp.)	5-10 minutes at 60-80°C (140-175°F) or longer if several layers (product should be dry to touch)
Curing (metal temp.)	20 min at 80-100°C (175-210°F), then 60 min at 150°C (300°F). Final cure 958G-414 at 225°C (440°F) for 15 minutes. Final cure 958G-406 at 180°C (360°F) for 60 minutes or 225°C (440°F) for 15 minutes if a harder coating is required.
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

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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