



Teflon™ Solvent Based One-Coat Industrial Coatings

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

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

Properties ^a	954G-300	954G-303	954G-304
Color	Clear	Black	Green
Closest RAL	-	9011	6021
Coverage, m ² /kg (m ² /L) (ft ² /gal) ^b	14,0 (15,2) (619)	12,6 (13,35) (544)	12,7 (13,9) (566)
Viscosity, cP ^c	400 – 1000	400 – 1000	400 – 1000
Volume Solids, %	37,5 – 38,5	32,9 - 33,9	34,3 - 35,3
Weight Solids, % ^d	48,4 – 52,4	42,0 – 46,0	45,5 – 49,5
Density, kg/L (lb/gal)	1,09 (9.1)	1,06 (8,84)	1,10 (9,16)
VOC Content, Europe, % ^e	46,2	42,6	43,6
Maximum In-Use Temperature, °C (°F)	150 (302)	150 (302)	150 (302)
Flash Point, SETA Closed Cup, °C (°F)	28 (82)	18 (64)	26 (80)

^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 1.0 mil (25 µm) 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] + 10 min x 220 °C [428 °F])

^eWeight % volatiles based on volatiles with vapor pressure ≥0.1 hPa. U.S. VOC (ap) and VOC (le) are listed on the U.S. Safety Data Sheet (SDS), 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	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	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)
Cleanup	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 30 rpm) before use.
- Shelf life is 12 months at optimal storage conditions: 18–27 °C (65–80 °F). Maximum storage temperature: 30 °C (86 °F).
- Transport conditions: 5–40 °C (40–105 °F). For safe storage conditions, please refer to the Safety Data Sheet (SDS).

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 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 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

The Chemours Company
1007 Market Street
P.O. Box 2047
Wilmington, DE 19899
T: +1 302 773 1000

Asia Pacific
The Chemours Chemical
(Shanghai) Co., Ltd.
Shanghai, China
T: +86 400 8056 528

Europe
Chemours Belgium BV
Kallo, Belgium
T: +32 3 730 2211

Latin America
Chemours do Brasil, S.A.
Sao Paulo, Brasil
T: +55 11 2599 8574

The Teflon™ trademark may only be used under licensing agreement granted by Chemours for use on approved applications.

CAUTION: Do not use or resell Chemours materials in medical applications involving implantation in the human body or contact with internal bodily fluids or tissues unless agreed to by Seller in a written agreement covering such use. For further information, please contact your Chemours representative. For medical emergencies, spills, or other critical situations, call (866) 595-1473 within the United States. For those outside of the United States, call (302) 773-2000.

The information set forth herein is furnished free of charge and based on technical data that Chemours believes to be reliable. It is intended for use by persons having technical skill, at their own discretion and risk. The handling precaution information contained herein is given with the understanding that those using it will satisfy themselves that their particular conditions of use present no health or safety hazards. Because conditions of product use are outside our control, Chemours makes no warranties, express or implied, and assumes no liability in connection with any use of this information. As with any material, evaluation of any compound under end-use conditions prior to specification is essential. Nothing herein is to be taken as a license to operate under or a recommendation to infringe any patents.

NO PART OF THIS MATERIAL MAY BE REPRODUCED, STORED IN A RETRIEVAL SYSTEM OR TRANSMITTED IN ANY FORM OR BY ANY MEANS ELECTRONIC, MECHANICAL, PHOTOCOPYING, RECORDING OR OTHERWISE WITHOUT THE PRIOR WRITTEN PERMISSION OF CHEMOURS.