# Teflon Coatings

## PF-600 Water based fluoro resin non stick coating

### DESCRIPTION
PF-600 is designed with two-layer coating system. Thanks to its high density, good inadhesion, easy-to-clean performance and strong practicability. It is applicable for substrates like aluminum, alloy and stainless steel etc.

### TYPE
Water based fluoro resin

### KEY FEATURES
- Eco-friendly
- Excellent heat resistant
- Excellent chemical resistance and abrasive resistance
- Excellent and lasting non-stick performance, easy to clean

<table>
<thead>
<tr>
<th><strong>FEATURES</strong></th>
<th><strong>DESCRIPTION</strong></th>
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</thead>
<tbody>
<tr>
<td>Appearance</td>
<td>Black liquid (Primer and top)</td>
</tr>
<tr>
<td>Solid content (%)</td>
<td>35±1</td>
</tr>
<tr>
<td>Viscosity (cp)</td>
<td>600<del>1000 Primer 400</del>800 Top</td>
</tr>
<tr>
<td>Density (g/ml)</td>
<td>1.20 Primer/1.30 Top</td>
</tr>
<tr>
<td>pH</td>
<td>8-11(Primer and top)</td>
</tr>
<tr>
<td>Color of the film surface</td>
<td>Black with metallic (Flat and smooth)</td>
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<tr>
<td>Curing temperature (°C)</td>
<td>380-420</td>
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<tr>
<td>Gloss (60° glossimeter)</td>
<td>10-20</td>
</tr>
<tr>
<td>Film thickness (μm)</td>
<td>20-30</td>
</tr>
<tr>
<td>Non-stick performance</td>
<td>&gt;10 cycles</td>
</tr>
<tr>
<td>Fry eggs at 170±10°C</td>
<td></td>
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<tr>
<td>Corrosion resistance</td>
<td>No blister</td>
</tr>
<tr>
<td>Boiling 10% salt water for 24 hours</td>
<td>&gt;3000 cycles</td>
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<tr>
<td>Abrasion resistance 3Kg/21cm²</td>
<td>&gt;3000 cycles</td>
</tr>
<tr>
<td>Hardness (ZHONGHUA pencil)</td>
<td>&gt;H</td>
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</tbody>
</table>

### APPLICATION
- Aluminum, die-cast aluminum, alloy and stainless steel
- Frying pan, stock pot, baking tray, electric fry pan and inner pot of electric cooker etc.

### STORAGE AND HANDLING
- Available in 20 kg/barrel or 30 kg/barrel
- Store products in tightly closed original containers at 5-40°C
- Shelf life: 9 months from delivery date
- According to non-dangerous goods transport

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1. Requirement on pre-treatment
- Firstly, apply high-temperature degreasing, then wash with 1%~3% NaOH solution (60℃) for more than 6 minutes, dry it after water rinsing;
- Blast with 80#~120# corundum to make the surface roughness reach 2.0μ~3.0μ, pay attention to sandblast evenly;
- Wash with 1%~3% NaOH solution(60℃) for more than 6 minutes, rinse with water;
- Wash with 1%~3% hydrochloric acid solution (60℃) for more than 6 minutes, rinse with water and dry.

2. Preparation of the coating
- Dispersion of coating: the coating must be fully dispersed before operation;
- Viscosity adjustment: the viscosity could be adjusted according to different spray methods. Dilute with clean water if the viscosity is over high;
- Coating filtration: filtrate the coating with screen (100mesh) before using.

3. Application
- The spraying environment should be dry, well-ventilated, no smoking and fire. We suggest using dedicated spray gun, elevated tank and curing oven;
- The air compressor should be degreased, dewatered and equipped with water oil separator before using;
- Roll the coating at 30rpm speed before using to make sure there is no sediment, and filter with 100 mesh screen;
- Adjust atomization and oil pump capacity of the spraying gun; make sure the unit is clean and flat;
- Preheat the substrate to 35℃ and spray the primer. Dry it at temperature of 120℃~150℃ for 10min-15min. Keep the thickness of primer within 12μm-18μm;
- Spray top coating after the primer is dry and cooling to room temperature, then spray the top. Dry the unit at the temperature of 100℃~150℃ for 10~20 min, and gradually increase the temperature to 380℃~420℃. Keep for 10 min. Keep the thickness of top coat within 10μm~12μm. The thickness of two coat tally should be between 20μm~30μm;
- The oven (or the tunnel drier) must be well ventilated; otherwise, it will lead to color change of coating.