



Eco-Friendly

**NON-STICK COATING**

Non-Toxic

**SINOGRACE**

The Chemical Company

## Non-stick Coatings

### PF-612 Water based Three-layer Marble-Coating (Starry Sky)

#### DESCRIPTION

PF-612 is Water based Two-layer Marble-Coating (Starry Sky). It is widely applied to internal coating of non-stick kitchenware such as aluminum-made frying pans, woks, stockpots, electric stewpots, electric bake wares and cake molds.

#### TYPE

Water based marble-coating

#### KEY

- Eco-friendly and PFOA free
- Showing the effect of natural marble

#### FEATURES

- Excellent chemical resistance and abrasive resistance
- Excellent and lasting non-stick performance, easy to clean

#### TYPICAL

#### PROPERTIES

<b>Product model</b>	PF-612P (Primer) PF-612T (Top) PF-612D1 (Dot 1) PF-612D2 (Dot 2)
<b>Recommended dosage</b>	10kg Primer: 10kg Top 0.5kg Dot 1: 0.5kg Dot 2
<b>Appearance</b>	Black (Primer) Black (Top) White (Dot 1) Light yellow (Dot 2)
<b>Solid content (%)</b>	35±1 (Primer) 45±1 (Top) 40±1 (Dot 1) 39±1 (Dot 2)
<b>Viscosity (cp)</b>	600~1000 (Primer) 300~800 (Top) 300~800 (Dot 1) 300~800 (Dot 2)
<b>Density (g/ml)</b>	1.20±0.20 (Primer) 1.30±0.20 (Top) 1.25±0.20 (Dot 1) 1.25±0.20 (Dot 2)
<b>pH</b>	8~11 (Primer) 8~11 (Top) 8~11 (Dot 1) 8~11
<b>Gloss (60 °glossimeter)</b>	10-20
<b>Film thickness (µm)</b>	35-45

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<b>Non-stick performance</b> Fry eggs at 160±10°C	>10 cycles
<b>Corrosion resistance</b> Boiling 10% salt water (24 hours)	No blister
<b>Abrasion resistance</b> 3KG/21cm <sup>2</sup>	>5000 cycles
<b>Hardness (ZHONGHUA pencil)</b>	2H
<b>Adhesion (1mm*1mm)</b>	Grade 1

## Appearance of coating



## APPLICATION

- Inside of tensile aluminum and die-casting fry pan, wok, soup pot, etc.

## STORAGE

## AND

## HANDLING

- Available in 20 kg/ barrel or 30 kg/ barrel
- Store products in tightly closed original containers at 5-35°C
- Shelf life: 6-9 months from delivery date
- According to non-dangerous goods transport

## HOW TO USE

### 1. Requirement on pre-treatment

- Firstly, apply high-temperature degreasing, then wash with 1%~3% NaOH solution (60°C) 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°C) for more than 6 minutes, rinse with water.
- Wash with 1%~3% hydrochloric acid solution (60°C) 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. Rolling the coating at the speed of 30rpm with rolling machine for 30mins, shouldn't exceed 60 mins.
- 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)

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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.
  - Adjust atomization and oil pump capacity of the spraying gun; make sure the unit is clean and flat.
  - Preheat the substrate to 35°C and spray the primer. Dry it at temperature of 120°C~180°C for 10min-15min. Keep the thickness of primer within 15µm-20µm.
  - Spray top coating after the primer is dry and cooling to room temperature, then spray the dot. Dry the unit at the temperature of 150 °C ~200 °C for 10min~20min, and gradually increase the temperature to 400 °C ~410 °C (the temperature of substrates), keep for 10 min~15 min. Keep the thickness of top coat within 8µm~12µm. The total thickness of final coating film should be between 35µm~45µm.
  - In spraying process, keep stirring inside of the elevated tank, the size of spraying nozzle should be between 1.3mm ~ 1.5mm, the pressure is about 2.5-4 bar.
  - The oven (or the tunnel drier) must be well ventilated; otherwise, it will lead to color changing of coating.
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