PF-610 Water based Three-layer Marble-Coating (Caffa)

**DESCRIPTION**
PF-610 is Water based Three-layer Marble-Coating (Caffa style). 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.

<table>
<thead>
<tr>
<th>TYPE</th>
<th>Water based marble-coating</th>
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<tbody>
<tr>
<td><strong>KEY</strong></td>
<td>Eco-friendly and PFOA free</td>
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<td>Showing the effect of natural marble</td>
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<td><strong>FEATURES</strong></td>
<td>Excellent chemical resistance and abrasive resistance</td>
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<td>Excellent and lasting non-stick performance, easy to clean</td>
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| **Product model** | PF-610P (Primer) |
|                  | PF-610T (Top)    |
|                  | PF-610D1 (Dot-1) |
|                  | PF-610D2 (Dot-2) |

| **Recommended dosage** | 10kg primer: 10kg top |
|                        | 0.5kg Dot-1: 0.5kg Dot-2 |

| **Appearance** | Light brown (Primer) |
|                | Light brown (Top)    |
|                | Light yellow (Dot-1) |
|                | Black (Dot-2)        |

| **Solid content (%)** | 35±1 (Primer) |
|                       | 45±1 (Top)     |
|                       | 40±1 (Dot-1)   |
|                       | 39±1 (Dot-2)   |

| **TYPICAL PROPERTIES** | 600~1000 (Primer) |
|                       | 300~800 (Top)     |
|                       | 300~800 (Dot-1)   |
|                       | 300~800 (Dot-2)   |

| **Viscosity (cp)** | 1.20±0.20 (Primer) |
|                    | 1.30±0.20 (Top)    |
|                    | 1.25±0.20 (Dot-1)  |
|                    | 1.25±0.20 (Dot-2)  |

| **Density (g/ml)** | 8~11 (Primer) |
|                   | 8~11 (Top)    |
|                   | 8~11 (Dot-1)  |
|                   | 8~11 (Dot-2)  |

| **Gloss (60° glossimeter)** | 10-20 |
|                            |      |

| **Film thickness (μm)** | 35-45|
|                        |      |

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**Non-stick Coating**

**Non-stick performance**
Fry eggs at 160±10°C >10 cycles

**Corrosion resistance**
Boling 10% salt water (24 hours) No blister

**Abrasion resistance 3KG/21cm²** >5000 cycles

**Hardness (ZHONGHUA pencil)** HB

**Adhesion (1mm*1mm)** Grade 1

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**Appearance of coating**

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**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

**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.

**HOW TO USE**
- 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 the 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) 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 (as the rules of: darker dots first, then lighter dots). 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, total thickness of two dots is 12μ-18μ. 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.