



Eco-Friendly

NON-STICK COATING

Non-Toxic

SINOGRACE

The Chemical Company

Teflon Coatings

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.

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

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)
Viscosity (cp)	600~1000 (Primer) 300~800 (Top) 300~800 (Dot-1) 300~800 (Dot-2)
Density (g/ml)	1.20±0.20 (Primer) 1.30±0.20 (Top) 1.25±0.20 (Dot-1) 1.25±0.20 (Dot-2)
pH	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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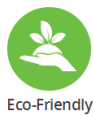
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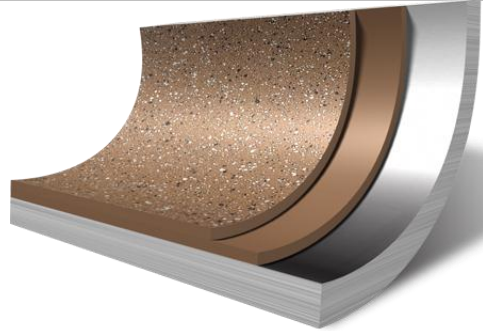
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Non-stick performance	>10 cycles
Fry eggs at 160±10°C	
Corrosion resistance	No blister
Boiling 10% salt water (24 hours)	
Abrasion resistance 3KG/21cm²	>5000 cycles
Hardness (ZHONGHUA pencil)	HB
Adhesion (1mm*1mm)	Grade 1

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.

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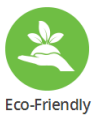
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- Coating filtration: filtrate the coating with screen (100mesh) before using.

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.

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