



Eco-Friendly

**NON-STICK COATING**

Non-Toxic

**SINOGRACE**

The Chemical Company

## Teflon Coatings

### PF-600 Water based fluororesin 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 fluororesin

#### KEY

- Eco-friendly
- Excellent heat resistant

#### FEATURES

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

#### TYPICAL

<b>Appearance</b>	Black liquid (Primer and top)
<b>Solid content (%)</b>	35±1
<b>Viscosity (cp)</b>	600~1000 Primer 400~800 Top
<b>Density (g/ml)</b>	1.20 Primer/1.30 Top
<b>pH</b>	8-11(Primer and top)
<b>Color of the film surface</b>	Black with metallic (Flat and smooth)
<b>Curing temperature (°C)</b>	380-420
<b>Gloss (60 ° glossimeter)</b>	10-20
<b>Film thickness (µm)</b>	20-30
<b>Non-stick performance Fry eggs at 170±10°C</b>	>10 cycles
<b>Corrosion resistance Boiling 10% salt water for 24 hours</b>	No blister
<b>Abrasion resistance 3KG/21cm<sup>2</sup></b>	>3000 cycles
<b>Hardness (ZHONGHUA pencil)</b>	>H

#### PROPERTIES

#### 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°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;
- 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°C and spray the primer. Dry it at temperature of 120°C~150°C 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°C~150°C for 10~20 min, and gradually increase the temperature to 380°C~420°C. 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.

## HOW TO USE

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