

Techyours™
Industrial
Coatings

PFA Powder



C&F

Techyours™ PFA Powder coatings have extremely high temperature resistance as well as excellent surface release properties. They are used in consumer and institutional bakeware and as release coatings on conveyors used in automated cooking and baking processes. PFA coatings are also used in semiconductor high purity chemical storage and handling equipment, as well as vessels and piping for the chemical process industry.

Typical Property Data for Techyours™ PFA Powders

Properties	JP04	DQ04
Colour	White	Colored
Melt Flow Rate	6-30	6-30
Coverage,m ² /kg (ft ² /lb)	18.6 (90)	18.6 (90)
Particle size,Average, μm	20 - 60	20 - 60
Bulk Density, g/100 cc	57 – 87	57 – 87
Density, kg/l (lbs/gal)	2.15 (17.9)	2.15 (17.9)

Handling and Storage

Powders should be stored in closed plastic bags.

Powders may form lumps under prolonged storage; sieving through a coarse screen will restore the powder.

Powders should be usable for an indefinite period of time without caking or deteriorating if stored at optimal storage conditions: 18°C-27°C (65°F-80°F). Maximum storage temperature 40°C (105°F).

Transport conditions:5°C-40°C (40°F-105°F). For safe storage conditions, pls. refer to safety data sheet.

Characteristics of Techyours™ PFA coating film

ITEM	Unit	Data
Specific gravity	g/ml	2.15
Hardness	Shore	D60
Taber abrasion	mg/1000r	5-15
Friction coefficient		0.06
Contact angle		102-106
Adhesion	N/mm	80-120
Tensile strength	MPa	>20
Elongation	%	>250

Application Method

Coating Preparation	Homogenize powder before opening bag
Screen	60 mesh (approx. 250 μm) stainless steel or nylon. Insufficient screening can result in application defects.
Application	Use fluidized bed with or without vibration system (depends on powder quantity and particle size of the powder). On flat and/or conductive parts high voltage and higher amperage can be used. On insulated and complex parts amperage should be lowered. In some situations a fixed voltage may be more effective than using an automatic current control setting. The gun settings depend on the gun type and complexity of the part. Recommended general settings: • Product supply: 30%-50% • Air carrier: 3.0 Nm³/h • Fluidization bed: 0.3 Nm³/h • Electrode fluidization: flat jet 0.2 Nm³/h • Amperage: 10 μA • Voltage: 60 KV
Recommended Dry Film Thickness	25-60 μm (1.0-2.4 mil) per coat
Drying (metal temp.)	Powders can be applied dry on wet. Full coating system should be dried before final cure.
Curing (metal temp.)	20-30 minutes at 380-390°C (715-735°F). Bake temperature of the first coat is important for adhesion to the primer.
Multiple coats	The powder can be hot flocked, cure temperature reduced to 330-360°C (625-680°F).
Repair	Cut out the imperfection-touch up with a spray of powder-bake at 330°C.

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