

Technical Data of

EL-1309S-611L/EL-3198M-605L1

1. Introduction

1.1 Product features

EL-1309S-611L/EL-3198M-605L1 is a kind of non-stick coating based on PTFE resin. EL series is a popular water-based coating type, which owns a high abrasion resistance applied under matching top coat.

1.2 Main applications

The film obtained can be widely used for ordinary kitchen utensils and household appliance. For example, rice cookers, grills, microwave oven, irons and so on. The highest temperature for continuous use is 260°C.

✧ **This product is not recommended to be applied on casting aluminum stockpot and iron pan.**

1.3 Packaging unit

5kg, 18kg.

2. Physical properties

ITEM	EL-1309S-611L	EL-3198M-605L1	COMMENTS
Appearance	Black liquid	Metallic Gray Liquid	Visual inspection
Solid content (mass%)	33.5~39.5	40.0~45.0	230°C×30min→380°C×30min
Viscosity (cP)	200.0~350.0	380.0~480.0	Rotating viscosimeter
pH	8.0~10.0	8.0~10.0	pH meter
Shelf life	3 months	6 months	——

✧ Typical values, not specifications.

3. Processing technique

✧ **Please operate the whole process using clean compressed air in tidy environment, because the dusts in atmosphere and the oil and water in compressed air will result in small dots or rusty spots.**

✧ **Preheat the workpiece in proper conditions to avoid dewing when the workpiece is too cold or the humidity is too high.**

✧ **The temperatures mentioned below represent bulk temperature.**

3.1 Pretreatment of workpiece

3.1.1 Degreasing

Degrease the surface of workpiece using baking or degreasing solvent to clean oil and dusts.

✧ Baking workpiece 10min above 380°C is recommended and the specific conditions depend on workpiece and request of guests.

3.1.2 Surface roughening

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Sandblast the surface to a consistent 2.0~3.5 μm roughness (Ra value) using 60#~100# alumina sand emery in case of aluminum workpiece. Then clean the surface by air blow.

3.2 Pretreatment of coating

The coating must be dispersed at 30~50rpm for 30~50min, and filtered by filter screen of 100~200 mesh, 200 mesh is recommended.

✧ The coating must be sprayed immediately after thoroughly dispersion.

3.3 Preheating of the substrate material

It is necessary to preheat the substrate material at about 40 $^{\circ}\text{C}$ before spraying.

3.4 Spray of primer

Spray EL-1309S-611L to a thickness of $13 \pm 2 \mu\text{m}$. Too thin film thickness will result in poor adhesion. Too thick film thickness will cause mud cracks. The atomizing pressure is 0.2~0.3Mpa when spraying.

3.5 Drying of primer

Dry the primer at 80~90 $^{\circ}\text{C}$ for 10~15min as soon as possible after spraying. If drying is not enough, coated film may have poor corrosion resistance, bubbling or abnormal appearance.

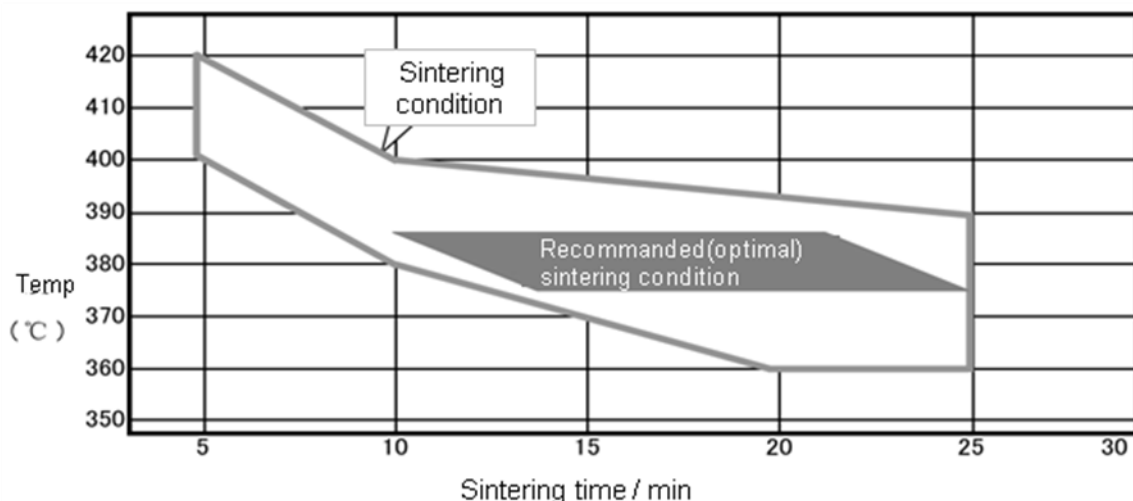
3.6 Spray of topcoat

Spray EL-3198M-605L1 to a thickness of $20 \pm 5 \mu\text{m}$ after the primer has been dried and cooled thoroughly. The atomizing pressure is 0.2~0.3Mpa when spraying.

3.7 Drying and sintering of topcoat

Dry the top coat at 80~120 $^{\circ}\text{C}$ for 10~15min as soon as possible after spraying, then sintering (refer to sintering condition figure below, and recommended at 380 $^{\circ}\text{C}$ for 15~20min).

- ◆ Attention: Total dry film thickness should be controlled in 26~40 μm .
- ◆ Attention: The temperature mentioned above is the temperature of the substrate.



4. Precautions in handling

4.1 Ordinary handling

✧ The working area should be adequately ventilated at all times. Local ventilation is necessary in the heating process (drying and sintering over 100 $^{\circ}\text{C}$), because the containing surfactants begin

to be decomposed by heat higher than approximate 200°C.

- ✧ Maintain equipment regularly (cleaning and exchange) because the decomposed material will accumulate in oven or exhaust duct which is flammable.
- ✧ Put goggles and gloves for protection while handling.
- ✧ Smoking should be prohibited in working area, since smoking tobacco contaminated by fluoropolymer may result in inhalation of decomposed gas. Do not bring tobacco in the working area.
- ✧ Wash hands and face well after handling.
- ✧ Store in a cool and dry place (5~30°C). The case higher than 30°C must be avoided because coagulation and precipitation will occur. And avoid freezing under 5°C, this product cannot be used after being frozen.
- ✧ Roll the container once a week in order to keep product from coagulating.
Rolling condition: 30~50rpm×40min

4.2 Storing conditions

- ✧ Keep containers tightly sealed
- ✧ Keep away from direct sunlight.
- ✧ Be careful to avoid freezing during winter.

4.3 Disposal

Do not release coating into waste water systems. Place it in specially designated container for disposal. Add a coagulation agent (such as nitric acid) to separate the mixture into resin and water, and dispose of the resin portion only through a licensed industrial waste disposal company.

5. Handling emergencies

- 5.1 IF IN EYES: Rinse cautiously with water for 15 minutes. Remove contact lenses, if present and easy to do. Continue rinsing. If eye irritation persists: Get medical advice/attention.
- 5.2 IF ON SKIN: Wash with plenty of water and soap thoroughly. If skin irritation occurs: Get medical advice/attention.
- 5.3 If INHALATION (spray mist or gases from the sintering oven): Move the operator immediately to fresh air, and then seek medical advice.

6. Disclaimer

- ◆ The product is for the industrial use only. We do not guarantee the safety in case the product is used for the other purposes. When using the product for health-care application or food/feed contact application, consult us in advance. This information is based on our present knowledge. However, this shall not constitute a guarantee for any specific product features and shall not establish a legally valid contractual relationship.
- ◆ This data sheet contains the best and latest of our knowledge on the data of issue on laboratory testing and practical application experience, and subject to change without notice. Since the paints are used under unexpected circumstances in some cases, guarantee can not be given except on the quality of those paints themselves.