

DuPont™ Teflon®

Industrial Coatings

Teflon® Primer 855-300

Description

Teflon® 855-300 is a water-based primer and is not recommended as a one coat. Refer to **Table 1** for physical property data.

FDA Status

Teflon® 855-300 does not comply with FDA regulations in 21 CFR governing components of coatings for direct food contact.

Table 1
Typical Properties

855-300	
Color	Blue
Weight Solids, %	23.8
Volume Solids, %	13.4
Density, lb/gal	9.5
kg/L	1.13
Coverage, ft ² /gal*	215
m ² /L	5.4
Viscosity, cP	150–400
Maximum Use Temperature	**

Note: These figures are averages and may vary.

*Theoretical coverage at 1 mil (25 µm) assuming 100% spray efficiency.

** Dependent upon Topcoat. Refer to Fact Sheet on Topcoat.

Substrates

Teflon® 855-300 primer can be used on carbon steel, stainless steel, and aluminum substrates. Substrates must be free of contamination and thoroughly cleaned. To obtain maximum adhesion, grit-blasting is recommended to a profile of 4–8 µm (0.2–0.3 mil). The primer should be applied immediately after blasting on carbon steel to minimize flash rusting. Refer to the Fact Sheet on Application.

Topcoats

Teflon® 855-300 is recommended for liquid topcoats 855-401, 855-403, and 855-500.

Application

1. Bring material to room temperature.
2. Mix thoroughly and filter the material through a 100-mesh stainless steel screen (0.146 mm openings).
3. The primer is supplied ready to spray. Use conventional industrial spray equipment.
4. Apply at dry film thickness of 5–8 µm (0.2–0.3 mil). On carbon steel, cover blast profile for best results.

Bake

As primer for liquid topcoats:

1. Primer should be applied and dried immediately. Force dry at 220°C (430°F) for 10 min.
2. Apply midcoat and/or topcoat and bake as recommended by the Fact Sheet on Topcoat. No problems are encountered if the *primer* is sprayed onto warm (40–60°C [100–140°F]) metal.

Note: First bake should be 500°F (260°C) for 2 minutes and then follow final bake requirement of topcoat.

Storage and Stability

Teflon® 855-300 has a shelf life of at least 12 months when stored at normal room temperature, 18–24°C (65–75°F).

Safety

Follow normal industrial safety practices for handling and applying *Teflon*® products. Industrial experience has clearly shown *Teflon*® materials can be processed and used at elevated temperatures without hazard providing adequate ventilation is used. Ventilation should be available at baking

temperatures of 275°C (525°F) and above. Before using *Teflon*®, read the Material Safety Data Sheet (MSDS) and the detailed information in the “Guide to the Safe Handling of Fluoropolymer Resins,” latest edition, published by the Fluoropolymers Division of The Society of the Plastics Industry.

When grit-blasting *Teflon*® finishes off aluminum or magnesium surfaces, the possibility of explosion exists if the fines are allowed to heat up. Good housekeeping practices, keeping the residue wet, and keeping the ventilation and dust collection systems in good working order reduces this risk.

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CAUTION: Do not use in medical applications involving permanent implantation in the human body. For other medical applications, see “DuPont Medical Caution Statement,” H-50102.

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