

# DuPont™ Teflon®

## Industrial Coatings

### Teflon® S Coatings 958-303 and 958-313

#### Description

Teflon® S 958-303 and Teflon® S 958-313 are one-coat, solvent-based coatings specially formulated to provide a tough, durable film for dry lubrication, with excellent salt spray resistance. In addition, Teflon® S 958-313 has exceptionally good abrasion resistance. They can be cured at temperatures as low as 177°C (350°F). Refer to **Table 1** for physical property data.

#### FDA Status

Teflon® S 958-303 and Teflon® S 958-313 do not comply with FDA regulations governing components of coatings for direct food contact.

**Table 1**  
**Typical Properties**  
**Teflon® S Resin-Bonded Lubricant**

Code	958-303	958-313
Color	Black	Black
Weight Solids, %	26.3	24.2
Volume Solids, %	19.4	18.0
Density, kg/L (lb/gal)	1.04 (8.7)	1.04 (8.6)
Coverage, m <sup>2</sup> /L (ft <sup>2</sup> /gal)*	7.8 (311)	7.2 (289)
Viscosity, cP	200–800	200–800
Maximum Use Temperature**, °C (°F)	260 (500)	260 (500)

**Note:** These figures are averages and may vary.

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

\*\* Abrasion resistance is reduced at temperatures above 205°C (400°F).

#### Surface Preparation

For aluminum, stainless steel, and carbon steel:

1. Clean (vapor degrease, prebake, or other).

2. Lightly grit-blast with aluminum oxide.

For **carbon steel**, a zinc or manganese phosphate conversion coating should be applied after grit-blast. These products also adhere well to most hard anodized aluminum surfaces.

#### Application

1. Bring coating to room temperature. Shake or agitate to reincorporate any settled material.
2. Product is supplied ready-to-spray. If thinning is desired, add a small amount of TN-8718 (n-methyl pyrrolidone NMP) with steady mixing. If faster evaporation is needed use TN-8595 or a 50:50 mixture of NMP:MIBK with care. This thinner must be added slowly with constant stirring.
3. Use conventional industrial spray equipment.
4. Recommended film thickness is 15–20 µm (0.6–0.8 mil). The heavier film build will improve salt spray corrosion resistance.

#### Baking

**Note:** All temperatures refer to metal temperature.

1. Flash or force dry for 5 min.
2. Recommended bake for 15 min at 343°C (650°F).

These products can be cured at temperatures as low as 177°C (350°F) by extending the cure time. However, the toughness and durability of the coating decreases as the cure temperature is reduced below 343°C (650°F).

The color will change at the higher bakes to a brown cast, but performance will not be affected.

## **Storage and Stability**

*Teflon*<sup>®</sup> S 958-303 is stable for at least 18 months when stored at normal room temperature of 18–24°C (65–75°F).

*Teflon*<sup>®</sup> S 958-313 is stable for at least 12 months when stored at normal room temperature of 18–24°C (65–75°F).

## **Safety**

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

used. Ventilation should be available at baking temperatures 275°C (525°F) and above. Before using *Teflon*<sup>®</sup> S, 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 Fluoro-polymers Division of The Society of the Plastics Industry.

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

**Table 2  
Typical Test Data**

<b>Test</b>	<b>Method</b>	<b>Value Teflon® S958-303 (Black)</b>	<b>Value Teflon® S958-313 (Black)</b>
<b>Dry Film Thickness (DFT)</b>	Electromagnetic method ASTM D1400-87	25 µm (1 mil)	25 µm (1 mil)
<b>Film Appearance</b>	Eye and power magnification microscope	OK	OK
<b>Adhesion</b>			
Post Water Cross-Hatch Adhesion	Adhesive tape after boiling ASTM D335	OK(A)	OK(A)
Impact	ASTM D4145	OK(A)	OK(A)
<b>Abrasion</b>			
Taber Abrasion	Weight loss after wear of two abrasive wheels DFT loss ASTM D4060-95 Load: 1,000 g Number of cycles: 1,000 Set of abrasive wheels: CS17	80 mg 19 µm (0.8 mil)	24 mg 9 µm (0.4 mil)
Pencil Hardness	ASTM D3363	2B	
<b>Corrosion</b>			
Atlas Cell (hours)	Chemical resistance of coating ASTM B117-73 Temperature: 98°C (208°F) Test solution: 0.05 N HCl	<168 hr	<168 hr
Salt Spray	ASTM B117-73 Test solution: 5% salt in water Temperature: 35°C (95°F)	168 hr <x <336 hr	168 hr <x <336 hr
<b>Gloss</b>	ASTM 523		
	20°	0.2	0
	60°	4.5	3.0
	85°	18.4	13.0

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**For more information on Teflon® coatings:**

DuPont  
Teflon® Industrial Coatings  
Chestnut Run Plaza  
P.O. Box 80702  
Wilmington, DE 19880-0702

**(800) 441-7515**  
**Fax: (302) 366-8602**  
**[www.dupont.com/teflon/coatings](http://www.dupont.com/teflon/coatings)**

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**Europe**

DuPont de Nemours (Belgium)  
A. Spinostraat 6  
B-2800 Mechelen  
Belgium  
Tel.: 33-15-441188  
Fax: 33-15-441160

**Pacific**

DuPont Australia, Ltd.  
254 Canterbury Road  
Bayswater, Victoria 3153  
Australia  
Tel.: 61-3-9721-5617  
Fax: 61-3-9721-5690

**Japan**

DuPont K. K. (Teflon® Finishes)  
4th Floor, Chiyoda Honsha Building  
5-18 Sarugaku-cho, 1-chome  
Chiyoda-ku, Tokyo, 101 Japan  
Tel.: 81-3-5281-5888  
Fax: 81-3-5281-5899

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**Asia**

DuPont China, Ltd.  
26/F., Tower 6, The Gateway  
9 Canton Road, Tsimshatsui  
Kowloon, Hong Kong  
Tel.: 852-2734-5459  
Fax: 852-2368-3512

DuPont Korea  
4/5th Floor Asia Tower  
#726 Yeoksam-dong, Kangnam-ku  
Seoul, Korea  
Tel.: 82-2-2222-5385  
Fax: 82-2-2222-5478

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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.

