**Description**
These Teflon® S single coat, nonstick and dry lubricant finishes are designed for relatively low-temperature curing, suitable for use in conditions of mild abrasion, relatively low operating temperatures and moderate chemical/corrosion potential. The higher level of Teflon® fluoropolymer in this coating enhances lubricity.

**FDA Status**
The Teflon® S 954-line does not comply with FDA regulations governing components of coatings for direct food contact.

**Table 1 Typical Properties**

<table>
<thead>
<tr>
<th>Product Code</th>
<th>954-100</th>
<th>954-101</th>
<th>954-103</th>
</tr>
</thead>
<tbody>
<tr>
<td>Color</td>
<td>Unpigmented</td>
<td>Green</td>
<td>Black</td>
</tr>
<tr>
<td>Weight Solids, %</td>
<td>51.4</td>
<td>54.0</td>
<td>49.0</td>
</tr>
<tr>
<td>Volume Solids, %</td>
<td>38.0</td>
<td>36.9</td>
<td>36.1</td>
</tr>
<tr>
<td>Density, lb/gal (kg/L)</td>
<td>9.2</td>
<td>9.5</td>
<td>9.2</td>
</tr>
<tr>
<td>Coverage, ft²/gal (m²/L)*</td>
<td>610</td>
<td>592</td>
<td>580</td>
</tr>
<tr>
<td>Viscosity, cP</td>
<td>200–900</td>
<td>200–700</td>
<td>200–500</td>
</tr>
<tr>
<td>Maximum Use Temperature, °C (°F)</td>
<td>Continuous: 150 (300)</td>
<td>Intermittent: 165 (325)</td>
<td></td>
</tr>
</tbody>
</table>

**Note:** These figures are averages and may vary.
* Theoretical coverage at 25 µm (1 mil) assuming 100% application efficiency.

**Application**
Roll or mix with a propeller-type mixer until contents are homogeneous.
Strain through 150-mesh wire screen or cheese cloth.
The products are recoatable and can be applied in multiple coats. See Cure section for cure conditions.

Use conventional industrial spray equipment. Reduce to spray viscosity with TN-8748 atomizing pressure should be 40 psi.
Electrostatic application is possible, however a non-polar solvent, such as xylene or TN-8748, must be added in the following ratios to increase resistivity. Ratio is per 100 parts 954-100 series product, and will give a resistivity of 0.05–0.10 megaohms and spray voltage of 60-65 kV.

<table>
<thead>
<tr>
<th>Xylene or TN-8748</th>
<th>100 parts 954-1xx</th>
<th>40-60</th>
<th>50</th>
</tr>
</thead>
</table>

See “Applying Teflon® Coatings” fact sheet.

**Surface Preparation**
Apply over clean, roughened surface. Any residual oil on the surface will affect the color of the cured film and will adversely affect adhesion.
Corrosion resistance is improved when coating is applied over phosphated steel.

**Film Thickness**
13–25 µm (0.5–1.0 mil) DFT.

**Cure**
All temperatures refer to metal temperature.
Force dry 10 min. to drive off volatile substances.

**Single Coat**
Recommended: 20 min. at 260°C (500°F)
Minimum: 20 min. at 232°C (450°F)

**Multiple Coats**
Initial and intermediate coats: 15 min. at 150°C (300°F)
Final coat: Recommended: 20 min. at 260°C (500°F)
Minimum: 20 min. at 232°C (450°F)
Storage and Stability

Shelf life of at least 18 months when stored at normal room temperature, 18°–24°C (65°–75°F).

Material may be exposed briefly to temperatures outside the suggested temperature range without harm. In such cases, check product and properties before extensive use.

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.

For more information on Teflon® coatings:

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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.