

## Product Operating Instructions

**Product system:** organic silicon non-stick coating

**Product No.:** DF- 15xxx \_\_\_\_\_

Applicable materials	Pre-treatment	Baking temperature	Baking time	Dry film thickness	Spraying method
Iron/aluminum	Degreasing, hard anodizing treatment, phosphorization, sand blasting	270°C-280°C	10 minutes	15-20µm Total film thickness 15-20µm	Air spray

### Technological process:

#### I. Pre-treatment:

Substrate: conditioning equipment for aluminum or aluminum alloy and iron products.

Degrease: solvent cleaning, immersion (ultrasonic cleaning), gas cleaning, alkali degreasing, caustic soda or burning solvent emulsification, etc.

Roughening: the roughening treatment is basically unnecessary, but the roughening can improve the quality to a certain degree. (It is suggested that the Puyang treatment should be carried out for aluminum or aluminum alloy products, and the phosphor salt should be carried out for iron products.)

Cleaning: use the high-pressure air (0.4~0.6Mps) for blow wash or the water flow flushing.

#### II. Pre-drying: pre-heating entity temperature: about 60°C.

#### III. Spraying process:

Coating dispersion: suggested: rotating and stirring (container rotation number: 50~100rpm, container rotation time: 20 minutes).

Coating filtration: use the 150~20-mesh filter screen for filtration.

Spraying: spray gun caliber: 0.8~1.2mmφ

Spraying pressure: 0.2~0.3Mpa

Spraying distance: 20~30cm

Film thickness (after sintering): 15~20µm

Spraying viscosity: it will be adjusted according to the actual situation (for stock solution spraying, the direct spraying can be carried out.)

The base coat easily cause the precipitation separation, and therefore the stirring and spraying shall be interrupted for more than 30 minutes during use so as to make the coating in the rubber tube flow backward to the coating container through air.

#### IV. Baking and sintering:

**DEFFOLON** Deffolon Non-stick Coating Co., Ltd.

Address: No.2, No.10 Road, Qijiao Industrial Zone, Maicun Village, Xingtian Town, Shunde District, Foshan City

Tel: 0757-22892248

Fax: 0757-22892249

Website: www.deffolon.com

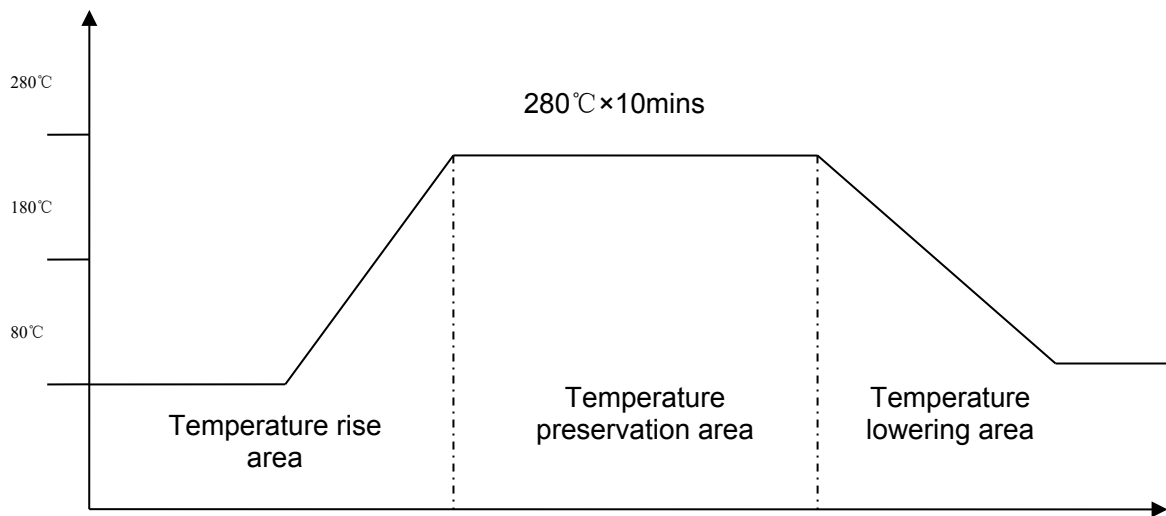
E-mail address: Welch2@deffolon.com

The temperature shall be strictly controlled, otherwise the following situations will occur:

Insufficient sintering: poor adhesive force and coating film properties.

Excessive sintering: it will make the coating film degraded and discolored so as to result in poor coating film properties.

● **Baking curve graph:**



V. Cooling: water cooling or room temperature cooling.