DuPont™ 850G-204 Acid Primer is generally used as a primer for other polytetrafluoroethylene (PTFE)-based topcoats. It can also be used as a primer for perfluoralkoxy (PFA) and fluorinated ethylene propylene (FEP) topcoats applied in thin films.

### Property Data

<table>
<thead>
<tr>
<th>Properties</th>
<th>One Coat 850G-204</th>
</tr>
</thead>
<tbody>
<tr>
<td>Color</td>
<td>Green</td>
</tr>
<tr>
<td>Coverage,² m²/kg (ft²/gal)</td>
<td>7.8 (439)</td>
</tr>
<tr>
<td>Viscosity,² centipoises</td>
<td>25 – 500</td>
</tr>
<tr>
<td>Volume Solids, %</td>
<td>26.5 – 28.5</td>
</tr>
<tr>
<td>Weight Solids, %</td>
<td>45.0 – 47.8</td>
</tr>
<tr>
<td>Density, kg/l (lbs/gal)</td>
<td>1.36 (11.38)</td>
</tr>
<tr>
<td>Maximum In-Use Temperature, °C (°F)</td>
<td>260 (500)</td>
</tr>
<tr>
<td>Shipping Class</td>
<td>+200L</td>
</tr>
<tr>
<td>Food Contact⁴</td>
<td>NO</td>
</tr>
</tbody>
</table>

¹Physical constants are averages only and are not to be used as product specifications. They may vary up to 6% of the values shown.

²Theoretical coverage at dry film thickness (DFT) of 1.0 mils (25µ) based on 100% application efficiency. It does not take normal production losses into account.

³Brookfield RVT (measured with spindle 2 at 20 RPM/25 °C)

⁴This coating is not designed to be used in direct contact with food.

### Application Method

<table>
<thead>
<tr>
<th>Substrate</th>
<th>Adhesion to most metals as well as glass, ceramics, etc. that are stable at the baking temperature required.</th>
</tr>
</thead>
<tbody>
<tr>
<td>Surface Preparation</td>
<td>Apply to clean substrate, preferably roughened (e.g., by grit-blasting). Any residual oil on the surface will affect the color of the cured film and will adversely affect adhesion.</td>
</tr>
<tr>
<td>Filtering</td>
<td>Strain through 100-mesh stainless steel screen. Product may be thinned with distilled or deionized water if desired.</td>
</tr>
<tr>
<td>Product DFT¹</td>
<td>One coat: 0.5–0.7 mil (13–18 microns) DFT</td>
</tr>
<tr>
<td>Curing (metal temperature)</td>
<td>Cure depends on whether the product is used as a primer or a one-coat finish. For a one-coat finish, the metal temperature during baking must be 400 °C (750 °F) for 10 minutes. If used as a primer, bake at a metal temperature of 323 °C (650 °F) for 15 minutes and then 288 °C (550 °F) for 3 minutes. See top coat fact sheets for additional curing information but never bake system lower than 375 °C (707 °F)</td>
</tr>
</tbody>
</table>

All recommendations are based upon best knowledge.

¹DFT = dry film thickness
Handling and Storage
Refrigerated storage [4 °C (40 °F)] is recommended and will allow for a 12-month shelf life. When this is not possible, the following is an indication of shelf life: 27 °C (80 °F) – 2 weeks, 16 °C (60 °F) – 4 weeks.

- Irreversible coagulation will occur at temperatures above 27 °C (80 °F) or if the product freezes. Unrefrigerated 850G-204 Acid Primer may show evolution of gas and pressure build-up. Use caution when opening containers. Increases in viscosity over time are common and can be reversed to a point by adding deionized or distilled water.

- Roll for 30 min. at 30 rpm once per month.

- 850G-204 is a pre-mixed acid primer. Face shield, Neoprene gloves and apron should be worn during this procedure, and at all times when handling acidic products. To neutralize acid primer, move the material to a larger, open neck container and SLOWLY add solid (powder or granular) sodium sulfite (Na₂SO₃, available through any chemical supply house) to the liquid product, stirring constantly to assure the sodium sulfite is well mixed into the product. The chemical reaction will cause heat to be given off. For green products, the color of the liquid will turn from dark to light green. Continue adding sodium sulfite and stirring until the neutralization is complete (no further color change and no more heat generation). This indicates sufficient sodium sulfite has been added. It is better to add too much rather than too little. REMEMBER: This product, before neutralization, is very acidic and can cause burns to skin or eyes. DO NOT perform the neutralization in the original narrow-neck plastic container since it is difficult to mix thoroughly or prevent rapid generation of fumes and bubbling over from occurring.

Food Contact
DuPont™ 850G-204 does not comply with FDA regulations in 21 CFR governing components of coatings for direct food contact.

Disposal and Other Considerations

For disposal, please follow these guidelines:

- All treatment, storage, transportation, and disposal of this product and/or container must be in accordance with applicable national and local regulations.

- Do not discharge aqueous dispersions to lakes, streams or waterways.

- Separate solids from liquid by precipitation and decanting or filtering. Dispose of dry solids in a landfill that is permitted, licensed or registered to manage industrial solid waste. Discharge liquid filtrate to a wastewater treatment system.

- Incinerate only if incinerator operates at 800 °C or higher and is capable of scrubbing out hydrogen fluoride and other acidic combustion products.

- Industrial fluoropolymer waste containing additives such as solvents, primers or thinners must be regarded as special waste. Companies should contact their local waste disposal authorities for details of the relevant waste disposal regulations.

- Empty containers should preferably be cleaned and recycled. If this is not possible, the containers should be punctured or otherwise destroyed before disposal.

- Visit OSHA’s Safety and Health Topics page on Hexavalent Chromium for more information on protecting workers from exposure to this chemical.

- Small Entity Compliance Guide for the Hexavalent Chromium Standards [286 KB PDF, 63 pages]. OSHA Publication 3320, (2006). Includes guidance on regulated areas, methods of control, respiratory protection, protective work clothing and equipment, hygiene areas and practices, housekeeping, medical surveillance, communication of hazards to employees, recordkeeping covered by the new standards and an extensive appendix of industry operations or processes associated with occupational exposure to Cr(VI).
For more information on DuPont Industrial Nonstick Coatings:
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