

产品信息单

PRODUCT INFORMATION

第一部分：基本信息

Part I Basic Information

产品名称	水性不粘涂料
Product Description	Water -based PFA coating
产品型号	TBF-3001P(底 /primer)
Product model	TEF-3002M (面/topcoat)
产品特性	1.极佳的耐刮性，优异和持久的不粘性及使用寿命; 2.耐化学性优异，耐摩擦性能优良; 3.符合 FDA、LFGB、ROHS 等要求。
Product Feature	1.Excellent scratch resistance, excellent and long-lasting non-stick performance and service life. 2.Excellent chemical resistance and abrasion resistance. 3.Meet FDA、LFGB、RoHS standards.
产品应用	作为不粘涂层应用于炊具、模具等工业脱模涂层使用，具体应用请贵司做好完整的适用性测试。
Product Usage	As a non adhesive coating applied to industrial demolding coatings such as cookware and molds, please conduct a complete applicability test for the specific application.

第二部分：规格指标

Part II Chemical Performance

检测项目	检测条件	指标	检测方法
Test performance	Test conditions	Index	Test methods
粘度 Viscosity	室温 NK-3 杯 Room temperature, NK4 Cup	18-22 (底 primer) 13-17 (面 topcoat)	GB/T 1723-1993
固含量 % Solid content	380°C×10min	40±2.0 (底 primer) 40.±2.0 (面 topcoat)	JIS K 6893—1995
密度g/ml Density	室温，比重杯 Room temperature,	1.23±0.20 (底 primer) 1.13±0.20 (面 topcoat)	GB 6750— 1986

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	hydrometer cup		
外观 Appearance	目视 visually inspection	涂层表面效果 Coating appearance	Q/TB001
颜色 Color	涂层表面颜色 Coating surface color	和色板一致 The same as color swatches	Q/TB001
膜厚 μm Thickness	测厚仪 Thickness gauge	22-30	GB/T 13452.2—1992
光泽 $^{\circ}$ Glossiness	60 $^{\circ}$ 光泽计 60 $^{\circ}$ glossmeter	10-15	GB/T 9754
漆膜硬度 Hardness	中华铅笔 ZHOANGHUA pencil	$\geq 2H$	GB/T 6739
附着力 Adhesion	1.5mm $\times$ 1.5mm方格 100/100, 3M 胶带 10 次 1.5mm $\times$ 1.5mm, 100/100 squares grids, 3M adhesive tape 10 times	1 级Grade one	JIS K 6894—1996
不粘性 Non-stick performance	160 $\pm$ 10 $^{\circ}\text{C}$ 煎鸡蛋 Fry eggs at 160 $\pm$ 10 $^{\circ}\text{C}$	≥ 10 个 ≥ 10 eggs	Q/TB001
耐磨性 Abrasion resistance	3KG/21cm (250次换一次3M 7447B 百洁布, 5%的洗涤精 溶液) 3KG/21cm ² (250 times once, 3M 7447B scouring pad, 5% detergent solution)	≥ 3000 循环 ≥ 3000 cycles	BS 7069:1988 Q/TB001
耐腐蚀性 Corrosion resistance	5%盐水煮沸 24 小时 Boiling in 10% salty water for 24 hours	无起 泡 No blister	Q/TB001
卫生标准 Certificates	SGS 检 测 SGS Test	通过 RoHS、FDA、LFGB 标准 Meet RoHS、FDA、LFGB standards	Q/TB001
其他说明 Remarks	执 行 Q/TB001 Execute Q/TB001		

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第三部分：施工工艺

Part III Operation Process

(一) 前处理要求 Requirement on Pre-processing

- 首先高温除油，再 1%~3% 氢氧化钠碱液（60℃）清洗 6 分钟以上，水洗干净烘干；

Firstly, substrate degrease at high-temperature, then wash with 1%~3% NaOH solution (60℃) for more than 6 minutes, and dry it after water cleaning;

- 然后 80#~120# 喷砂，使基材粗糙度 $Ra2.0\mu\sim3.0\mu$ ，注意喷砂均匀到位；

Then evenly sandblast with 80#~120# corundum to make the surface roughness reach $2.0\mu\sim3.0\mu$;

- 再然后 1%~3% 氢氧化钠碱液（60℃）清洗 6 分钟以上，水洗干净；

Wash with 1%~3% NaOH solution (60℃) for more than 6 minutes, clean it with water;

- 最后 1%~3% 盐酸溶液（60℃）清洗 6 分钟以上，水洗干净烘干。

At last, wash with 1%~3% HCL solution (60℃) for more than 6 minutes, clean with water and dry.

(二) 涂料的预备 Coating Preparation

- 涂料的分散：底油和面油使用前必须将涂料充分地分散，在滚桶机上以 30rpm 的转速转动 30min，检查底部无沉淀、结团现象，确定底油分散均匀方可使用，滚动时间不可大于 60 min；

Coating Dispersion: the primer and topcoat must be fully dispersed before operation. The coating shall be rolled on the roller machine for 30min at the speed of 30rpm, then checking the bottom of bucket without precipitate, agglomeration. Be sure the rolling not to exceed 60min;

- 涂料的过滤：涂料使用前用 150 目的滤网过滤（面油除外）。

Coating filtration: filtrate the coating with screen (150meshes) before operation. (Except the topcoat).

(三) 涂料施工方法 Coating Operation

- 喷涂环境应相对干燥，通风，无尘，建议使用专用喷枪、压力罐、烧结炉；

The spraying environment should be dry, well-ventilated, dustless, to recommend using dedicated spray gun, pressure tank and sintering furnace;

- 空压机使用前要进行除油、除水、并安装油水分离器；

The air compressor should be oil and water removed, and mounted with water oil separator before using;

- 喷涂前调整好喷枪的雾化和出油量，喷涂工件要保证清洁平整；

Adjust atomizing and oil discharged amount of the spraying gun; make sure the coating artifacts clean and flat;

- 将前处理的基材清理干净，再进行喷涂；将处理好的基材进行底油喷涂，底油用普通水性喷枪即可，底油喷涂完成后，缓慢升温至 180℃，保温 10 分钟，冷却后喷涂面油，均匀喷洒到底油表面，然后缓慢升至 380℃，保温 8 min ~10min；控制底油和面油的厚度，干膜膜厚为 $22\mu\sim30\mu$ ；

Clean the pre-processing substrates before spraying; Spray the substrate primer with normal spray gun; then increase the temperature to 180℃ gradually and keep for 10min; Spray topcoat

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evenly after cooling, then increase the temperature to 380°C gradually and keep for 8min ~10min; Control the film thickness of the primer and top coat in the range of 22μm~30μm.

- 烧结炉应保证排风良好，有 10min 左右的升温过程并且有按操作规定的保温时间，否则会使涂层颜色发生变化。

Make sure the sintering furnace well ventilated, and meet required heat preservation time with about 10 minutes for temperature increasing; otherwise, or it will lead to color change of the coating.

第四部分：储存和有效期

Part IV Storage and Shelf Life

- 涂料要在 5°C-30°C 下保存，保质期为 6 个月，冬季时注意不能冻结，禁止高于 40°C 的运输、保存；

The coating should be stored at the temperature between 5°C-30°C, with the shelf life for 6 months. Note preventing freezing in winter. Not ship or keep at the temperature above 40°C;

- 涂料贮存场地应保持通风、干燥，防止日光直接照射，并应隔绝火源、远离热源。

The storage place should be well-ventilated and dry. Keep it away from direct sun exposure or the source of ignition and heat.

第五部分：包装

Part V Package

- 底油和面油涂料 5 升或 20 升塑料桶包装；

Normal package is 5L or 20L plastic barrel ;

- 样品 0.5 L 或 1.0 L 塑料瓶包装。

Samples are packed with 0.5L or 1.0L plastic bottle.

第六部分：有限保证信息

Part VI Warranty Information

- 此处提供的信息为准确的实验室数据，但是由于使用本公司产品的方法和条件非我们所能控制，本信息不得被当做品质担保和侵犯任何专利的导因。

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TEBANG guarantee that all products are qualified and in line with the sales description, if any

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products in violation of the guarantee, TEBANG need replace any unqualified products.

第七部分：其他信息

Part VII Others

- 产品安全信息请阅读本产品 MSDS ；

About the safety information of product, please refer to the MSDS;

- 再次强烈建议您详细阅读本说明细节，并在使用前对本产品做完整详细的适用性测试；

We recommend strongly to read the instruction carefully. Do complete and detailed applicability test on the product before using.

- 特邦拥有修改本产品资料的权利，请您及时联系特邦，索要更新的产品资料版本。

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(结束 End)

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