



VICTREX® PEEK COATING TECHNOLOGY

## 800 SERIES AQUEOUS DISPERSIONS PRODUCT DATA SHEET

### VICOTE® F804Blk (Black) Aqueous Dispersion For Use on Ferrous and Non-Ferrous Metals

VICOTE® is the brand name for the Victrex range of coatings. VICOTE Coatings are available through Victrex or its preferred coater network.

VICOTE F804Blk has been specifically formulated to provide a resilient coating with high wear and abrasion resistance on ferrous and non-ferrous substrates such as carbon steel, cast steel and aluminium. These properties are retained at high temperatures where other coatings would potentially fail. Typical properties are high continuous use temperature of 260°C, excellent wear, abrasion and cut through resistance at these high temperatures, combined with excellent chemical and radiation resistance. VICOTE dispersions have a low level of extractables and inherently flame retardant. Contact Victrex for further details.

#### VICOTE F804Blk Dispersion

VICOTE F804Blk dispersions are aqueous based; however there are small amounts of solvents present. Refer to the appropriate MSDS sheet for details.

The VICTREX® PEEK polymer contained in the VICOTE dispersion like other non-coating grades of VICTREX PEEK polymer are thermoplastic in nature and exhibit flow above the melt temperature. When processed using the correct guidelines the coatings will exhibit the excellent properties that VICTREX PEEK polymer is renowned for. For further chemical resistance information consult the Victrex Chemical Resistance Data brochure.

#### SUBSTRATES AND PREPARATION

VICOTE can be applied to most ferrous and non-ferrous substrates. A primer is not required. Cast metals need to be de-gassed in an oven to prevent pin holes in the coating surface. Substrates should be free from grease, oils and corrosion prior to coating. Solvent de-greasing and grit blasting with aluminium oxide with final solvent wash should ensure a suitable

surface for coating. *Note: Phosphate pre treated substrates are not recommended for VICOTE grades as the high processing temperatures required for processing can result in de-lamination of the coating.*

#### SPRAYING

A conventional gravity fed spray gun with a nozzle size between 0.7 and 1.0mm has been found suitable for applying VICOTE dispersions. Edges of components should be sprayed first before applying a complete coating. An air pressure to the gun of between 35 and 50 psi has been found to be a suitable spray pressure. Spray at right angles to the substrate wherever possible. The spray gun and cup can be cleaned with water after use.

#### PROCESSING

For general processing information consult the VICOTE dispersion coating guides. Coated parts should be dried in air for 5 minutes then dried in an oven for 5 minutes at 120°C before placing in an oven at 400°C to melt and fuse the coating.

By following the processing guide smooth coatings should be achievable. Because VICOTE materials are semi crystalline thermoplastics, as with all these types of products shrinkage will take place when the coating cools. Depending on the mass of the substrate, coating thickness and the rate of cooling will determine the amount of shrinkage.

Normally processed and cooled coatings should result in crystalline coatings which should not require further post processing treatment. However an increase in crystallinity may enhance certain properties such as wear and scratch resistance. To anneal the coating the part should be placed in an air circulating oven and the temperature raised at 10°C per minute to 250°C and held at that temperature for 30 minutes to 1 hour.

With coated parts that are subject to a high service temperature it may be beneficial to anneal the parts at 10°C above the maximum service temperature to prevent further volume change of the coating.

## STORAGE AND HANDLING CONSIDERATIONS

VICOTE drums should be stored in a clean dry environment and should not be stored with the lids removed as this may result in airborne dust contaminating the product, which could cause coating defects.

The VICOTE dispersions will soft settle after prolonged standing. They can be re-dispersed readily by stirring of the liquid suspension. The drums can also be rolled to agitate the dispersion to ensure homogeneity. High shear dispersing should be avoided as the wetting agent is prone to shear thinning. Although it is recommended that the dispersion is not allowed to freeze, re-dispersing after thawing is possible. Optimum storage temperature is 5°C – 25°C.

VICOTE F804Blk is packed in 20 kg polythene UN drums enclosed in a strong cardboard box with the VICOTE logo.

## SAFETY PRECAUTIONS

Before applying VICOTE dispersions, read the appropriate Material Safety Data Sheet (MSDS) and the processing guide, available from Victrex.

VICOTE F804Blk coatings should be only applied using suitable exhaust ventilation. Care should be taken not to inhale fumes or vapours. The washing of hands and good housekeeping are a prerequisite before handling these products.

*Note: these products are not for human implantation.*

## FDA

Materials and articles manufactured from VICOTE F804Blk comply with the compositional requirements of regulation 21 CFR 175.300 for resinous and polymeric coatings of the Food and Drug Administration (FDA) of the United States of America.

Regulation 21 CFR 175.300 further specifies that the finished coated part which is in contact with food is subject to extractive limitations. Compliance with any applicable extractive limits can only be demonstrated by testing carried out on the finished article.

### Typical Property Data for VICOTE F804Blk – Coating film thickness 25 – 30µm

Property	Test Method	Units	Nominal Value
Cross Hatch Adhesion	BS EN ISO 2409	Rating 0-5	0 - mild steel 0 - stainless steel 0 - aluminium
Direct Impact	BS EN ISO 6272 Part 1 (pass criterion)	Height (m) Weight (kg) Indentation depth (mm)	1 1 15
Conical Bend	BS EN ISO 6860	mm	Pass at 3.2
Konig Hardness*	BS EN ISO 1522	seconds	205
Coefficient of Friction	ASTM G 133 Using 100N Load	µm @ 10 min.	0.608

\* Minimum coating thickness required for this test was 30µm. Coatings tested were between 40 and 50µm.

#### World Headquarters

Victrex plc  
Hillhouse International  
Thornton Cleveleys  
Lancashire FY5 4QD  
United Kingdom  
Tel: + (44) 1253 897700  
Fax: + (44) 1253 897701  
Email: victrexplc@victrex.com

#### Americas

Victrex USA Inc  
300 Conshohocken State Road  
Suite 120  
West Conshohocken, PA 19428  
USA  
Tel: + (1) 800-VICTREX  
Tel: + (1) 484-342-6001  
Fax: + (1) 484-342-6002  
Email: americas@victrex.com

#### Europe

Victrex Europa GmbH  
Langgasse 16  
65719 Hofheim/Ts.  
Germany  
Tel: + (49) 6192 96490  
Fax: + (49) 6192 964948  
Email: eurossales@victrex.com

#### Asia Pacific

Victrex Japan Inc.  
Mita Kokusai Building Annex  
4-28, Mita 1-chome  
Minato-ku  
Tokyo 108-0073  
Japan  
Tel: +81 (0)3 5427 4650  
Fax: +81 (0)3 5427 4651  
Email: japansales@victrex.com

#### Asia Pacific

Victrex High Performance  
Materials (Shanghai) Co Ltd  
Part B Building G  
No. 1688 Zhuanxing Road  
Xinzhuan Industry Park  
Shanghai 201108  
China  
Tel: + (86) 21-6113 6900  
Fax: + (86) 21-6113 6901  
Email: scsales@victrex.com

VICTREX PLC BELIEVES THAT THE INFORMATION CONTAINED IN THIS BROCHURE IS AN ACCURATE DESCRIPTION OF THE TYPICAL CHARACTERISTICS AND/OR USES OF THE PRODUCT OR PRODUCTS, BUT IT IS THE CUSTOMER'S RESPONSIBILITY TO THOROUGHLY TEST THE PRODUCT IN EACH SPECIFIC APPLICATION TO DETERMINE ITS PERFORMANCE, EFFICACY AND SAFETY FOR EACH END-USE PRODUCT, DEVICE OR OTHER APPLICATION. SUGGESTIONS OF USES SHOULD NOT BE TAKEN AS INDUCEMENTS TO INFRINGE ANY PARTICULAR PATENT. THE INFORMATION AND DATA CONTAINED HEREIN ARE BASED ON INFORMATION WE BELIEVE RELIABLE. MENTION OF A PRODUCT IN THIS DOCUMENTATION IS NOT A GUARANTEE OF AVAILABILITY. VICTREX PLC RESERVES THE RIGHT TO MODIFY PRODUCTS, SPECIFICATIONS AND/OR PACKAGING AS PART OF A CONTINUOUS PROGRAM OF PRODUCT DEVELOPMENT. VICTREX® IS A REGISTERED TRADEMARK OF VICTREX MANUFACTURING LIMITED. VICTREX PIPES™ IS A TRADEMARK OF VICTREX MANUFACTURING LIMITED. PEEK-ESD™, HT™, ST™ AND WGT™ ARE TRADEMARKS OF VICTREX PLC. VICOTE® AND APTIV® ARE REGISTERED TRADEMARKS OF VICTREX PLC.

VICTREX PLC MAKES NO WARRANTIES, EXPRESS OR IMPLIED, INCLUDING, WITHOUT LIMITATION, A WARRANTY OF FITNESS FOR A PARTICULAR PURPOSE OR OF INTELLECTUAL PROPERTY NON-INFRINGEMENT, INCLUDING, BUT NOT LIMITED TO PATENT NON-INFRINGEMENT, WHICH ARE EXPRESSLY DISCLAIMED, WHETHER EXPRESS OR IMPLIED, IN FACT OR BY LAW. FURTHER, VICTREX PLC MAKES NO WARRANTY TO YOUR CUSTOMERS OR AGENTS, AND HAS NOT AUTHORIZED ANYONE TO MAKE ANY REPRESENTATION OR WARRANTY OTHER THAN AS PROVIDED ABOVE. VICTREX PLC SHALL IN NO EVENT BE LIABLE FOR ANY GENERAL, INDIRECT, SPECIAL, CONSEQUENTIAL, PUNITIVE, INCIDENTAL OR SIMILAR DAMAGES, INCLUDING WITHOUT LIMITATION, DAMAGES FOR HARM TO BUSINESS, LOST PROFITS OR LOST SAVINGS, EVEN IF VICTREX HAS BEEN ADVISED OF THE POSSIBILITY OF SUCH DAMAGES, REGARDLESS OF THE FORM OF ACTION.