

### GENERAL INFORMATION

Formula 1PC-630-9507 is an improvement on and replacement for 1PC-630-9504 – 93P.2800 Grey Textured HT Powder. This powder is a specially formulated silicone product developed from a blend of resins and pigments to provide service at high temperatures without softening, losing gloss or losing film integrity.

### BENEFITS

- Continuous performance at 590°F (310°C) while maintaining color, gloss and film integrity.
- Low gloss, uniform textured finish.
- Excellent UV resistance for outdoor use on mild steel, cold rolled steel, aluminum or aluminized substrates.
- Improved adhesion, coverage and fluidization
- Provides excellent flow and leveling over a wide range of film thickness.

### SPECIFICATIONS

Cure Cycle [Substrate temperature]	30 minutes @ 410°F (210°C)
Specific Gravity	1.96 +/- 0.05
Theoretical coverage for 25 microns	20.13 m <sup>2</sup> / kg.
Theoretical coverage for 1 mil	98.3 ft. <sup>2</sup> / lb.
Film builds between	46.80 microns 1.8 -3.2 mils

**Heavier film builds are not recommended**

### TYPICAL PROPERTIES

Adhesion (ASTM D3359)	5B
Gloss @ 60° (D523)	<3.5
Pencil Hardness (ASTM D3363)	>3H

### PERFORMANCE TESTING

Testing indicates good film integrity after continuous exposure to temperature at 590°F (310°C).

**\*We recommend testing with other products that you use before purchasing.**

### SURFACE PREPARATION

High temperature coatings require clean substrates to maintain a good bond between metal and coating. Abrasive media blast is an excellent method of surface preparation. Chemical pretreatments are effective, but must be rinsed to a clean surface with no dirt or cleaner residue. **Phosphate pretreatments have their own temperature limits that must be observed.** Contact your chemical pretreatment supplier. Also substrates have limits that must be observed.

### APPLICATION

This material is designed primarily for electrostatic powder spray application to room temperature substrate with a voltage of approximately 20 - 30 KeV. In order to prevent excessive film builds and to limit the potential problem of the "Faraday Cage Effect," reduced voltages can improve coating film thickness uniformity. Excessive film builds can lead to bubbling and blistering of the cured film. Because of the electrostatic properties of this powder a box gun is not suitable. The air supply line should be equipped with traps to remove water and oil. Drain and service these traps frequently.

### FINISHED PRODUCT HANDLING

The finished coated product may not be as tough as standard powder chemistries. Care must be exercised in handling and packing to ensure that finish is not damaged.

### STORAGE

This product should be stored at temperatures below 77°F (25°C) for up to 6 months.

### PRECAUTIONS

**READ AND UNDERSTAND THE MSDS BEFORE USING.**

This product is more temperature sensitive than normal powders and must be stored and used at temperatures below 77°F (25°C). This product is very sensitive to heat in storage and transit. Even brief exposures to higher temperatures can cause sintering. This product is more susceptible to moisture contamination than other powder products. If caking occurs, pass the material through a 100 mesh (150 micron) sieve until the powder is free flowing.

### LIMITATIONS

The technical data and suggestions for use in this product data sheet are currently correct to the best of our knowledge, but are subject to change without notice. Because application and conditions vary, and are beyond our control, we are not responsible for results obtained in using this product, even when used as suggested. The user should conduct tests to determine the suitability of the product for the intended use under then existing conditions. Our liability for breach of warranty, strict liability in tort, negligence or otherwise is limited exclusively to replacement of the product or refund of its price. Under no circumstance are we liable for incidental and consequential damages.

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