



PRODUCT DATA SHEET
HEAT RESISTANT
POWDER COATING
GRAY SMOOTH
1PC-653-9057

DESCRIPTION

1PC-653-9057 is a specially formulated silicone powder coating product developed from a blend of resins and pigments to provide service up to 700°F (371°C) without softening, losing gloss or losing film integrity.

Product Benefits

- Provides temperature resistance up to 700°F (371°C)
- Good color and gloss retention to 500°F (260°C)

SPECIFICATIONS

Cure Cycle [Substrate temperature]	20 minutes @ 450°F (232°C)
Specific Gravity	2.10 +/- 0.05
Theoretical coverage at 1 mil	88 ft. ² / lb.
Film builds between	1.8 and 3.0 mils
Recommended at	2.0 mils
Theoretical coverage at recommended	44 ft. ² / lb.

TYPICAL PROPERTIES

Gloss at 60° (ASTM 523)	20-30
Pencil Hardness (ASTM D3363)	>H

PERFORMANCE TESTING

Continuous testing for 48 hours at 400°F (204°C) shows this product holds gloss, color and physical integrity at this service temperature. Testing at 700°F (371°C) indicates good performance up to 24 hours with some color change at extended times and higher temperatures.

SURFACE PREPARATION

High temperature coatings require cleaner 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.

FINISHED PRODUCT HANDLING

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

PRECAUTIONS

This product is more temperature sensitive than normal powders and should be used at temperatures below 77°F (25°C). This product is more susceptible to moisture than other powder products. Because of the electrostatic properties of this powder a fluidizing feed hopper with higher air flow must be used.

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

READ AND UNDERTSAND THE MSDS BEFORE USING

STORAGE

This product should be stored at temperatures below 77°F (25°C) for up to 6 months. Under carefully controlled conditions, shelf life may be extended.

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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