

**GENERAL INFORMATION**

1PC-654-2903 is a specially formulated silicone Powder Coating product developed from a blend of resins and pigments to provide service up to 1200°F (649°C) without softening, losing gloss or losing film integrity.

**Product Benefits**

- Designed to clean up well and to reduce cross-contamination with other coatings
- Good long-term performance at 800°F (427°C) while maintaining color, gloss and film integrity
- Excellent UV resistance for outdoor use on aluminum or aluminized substrates
- Thinner film builds

**SPECIFICATIONS**

Cure cycle (substrate temperature)	15 mins at 400°F (204°C) 9 mins at 425°F (218°C) 6 mins at 450°F (232°C)
Specific Gravity	1.89 +/- 0.05
Theoretical cover for 1 mil	102 ft <sup>2</sup> / lb.
Film build between	1.0 and 2.0 mils
Recommended at	1.5 mils
Theoretical coverage at recommended	68 ft <sup>2</sup> / lb.

**Heavier film builds are not recommended.**

**TYPICAL PROPERTIES**

Gloss at 60°	2 - 5
Pencil Hardness	> 3H

**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**

Powder is formulated for electrostatic application to room temperature substrate. Reduced voltages can improve coating film thickness uniformity.

**PERFORMANCE TESTING**

Continuous testing for 48 hours at 800°F (427°C) indicates these products hold gloss, color and physical integrity at this service temperature. Testing at 1000°F (538°C) indicates good performance up to 24 hours with some gloss change at extended times and higher temperatures. ***\*We recommend testing with other products that you use before purchasing.***

**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. Because of the electrostatic properties of this powder a box gun is not suitable.

**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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