DuraSET2000

Acrylic Enamel w/ optional hardener

TECHNICAL DATA SHEET

FLEET ENAMEL

SET2000 is an outstanding rust preventative finish for fleet and mobile equipment. It has excellent super high gloss and color retention while maintaining excellent chemical resistance.

As a 2-component urethane, use SET2000 Hardener. Using the hardener will give even better chemical and solvent protection and faster dry-through time.

Recommended For:

- Refinish Market
- Trailer and Fleet
- Equipment Manufacturers

Features:

- Excellent Gloss and Color Retention
- Outstanding Flow and Leveling
- Single/Two Component Pkg.
- VOC Compliant

FOR INDUSTRIAL USE ONLY

Surface Preparation: *Surface should be clean and free of all surface contamination, using SET500 or similar cleaner. For light rust, treat with SET400, a rust convertor. For heavily rusted areas, use abrasive blasting. When needed on ferrous metal, prime with SET7500 Organic Zinc or SET7900 Epoxy Mastic. For already painted surfaces sand using 320 grit (dry) or 400 grit (wet). Treat aluminum with a commercial etching solution.*

Recommended Primers:

Nonferrous metals: Use SET7300 or SET7900.
Ferrous metals: Use SET70 or SET7500.

Apply SET2000 to properly cured primers only.

Colors:

Stock colors, custom colors are available upon request.

Shipping Weight:

(approximate due to color, fill level and pigment)

SET2000: 1 Gal–12.5 lbs./5 Gal–61 lbs.

APPLICATION DATA

Optional Enhancers:
- SET2000 Hardener
- Liquid Lightning Accelerator

Will significantly decrease pot life.

Wet Film Thickness:
4–8 wet mils per coat

Dry Film Thickness:
2–4 mils per coat

Pot Life @ 77°F (25°C):
2 hours (avoid moisture contamination)
Consult manufacturer when using in high humidity (above 85%).

EQUIPMENT:

Apply by Air-Assisted Airless or HVLP:
Air pressure not to exceed 10 psi at the air cap.

HVLP:
45–60 psi at the gun
1.4–1.5 mm or equivalent

AA Airless:
60 psi Air / 30 psi Material
Recommended liquid pressure is 1500–3300 psi with a tip size from 411–515.

Roller/Brush:
Not recommended

MIXING AND THINNING:

If using hardener, always thin after adding hardener. Thin up to 15%, depending on application and temperature, with SET601 or SET602 (exempt solvents).

Mixing:	SET2000 (16) : SET2000 Hardener (1) : SET Reducer (2) *SET601 above 80°F (27°C) or SET602 below 80°F (27°C)*
With optional Liquid Lightning Accelerator:	Use only when using hardener. Add 3–8 drops per gallon. (**NOTE:** Will significantly decrease pot life.)

CURE SCHEDULE @ 77°F (25°C):

	Without Hardener	With 2000 Hardener
Tack Free	30 minutes	45 minutes
Drying Time	4 hours	4 hours
Curing Time	7 days	3 days
Recoat	10 minutes minimum No maximum (degloss and recoat)	20 minutes minimum No maximum (degloss and recoat)

STORAGE CONDITIONS:

Store indoors @ 40°F–110°F (4.4°C–43.3°C)

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CHEMICAL RESISTANCE

Although SET2000 exhibits resistance to these environments, this list is not meant to imply an express guarantee in actual service. It is recommended that the user contact Surface Engineered Technologies (SET) for specific recommendations when severe exposure is expected.

WATER

SALTS

ALKALIS

SOLVENTS

PHYSICAL PROPERTIES

PROPERTY	VALUE*
Finish	Super High Gloss
% Solids by Volume	53% ± 2%
% Solids by Weight	62% ± 2%
Theoretical Coverage @ 1 mil	834 sq. ft. per gallon, depending on color *The actual coverage will be less depending on application techniques, job conditions and type of surface to be coated.*
Viscosity at 77°F (25°C)	59 seconds in Zahn 2
VOC Actual	290 g/L / 2.4 lb/gal.
VOC Regulatory	340 g/L (w/2000 hardner 325 g/L) / 2.8 lb/gal.
Flash Point	93°F (34°C)
Weight of Volatiles	37.8% ± 2%
Weight of Exempt	15.4% ± 2%
Volume of Exempt	14.7% ± 2%
Shelf Life (when kept at the recommended storage conditions and in original, unopened containers)	24 months @ 77°F (25°C)
Pigment Type	Chemical Resistant
Solvent Type	Aromatics/Oxsol
Vehicle Type	Acrylic Modified Alkyd
	***Values listed will be color dependent**

SAFETY

Read Safety Data Sheets and container label cautions and warnings for important safety and health information prior to use. KEEP OUT OF REACH OF CHILDREN.

Ventilation: When using in enclosed areas, adequate air circulation must be used during and after application until the coating is fully cured. The ventilation system should be capable of preventing the solvent vapor concentration from reaching the lower explosion limit for the solvents being used. If the user is not sure or not able to monitor the levels, then use an approved (MSHA/NIOSH) respirator.

Caution: This product contains flammable solvents. Keep away from sparks and open flames. All electrical equipment/installations should be grounded in accordance with the National Fire Protection Association's (NFPA 70®)/National Electric Code® (NEC®). In areas where potential explosion hazards exist, personnel should be required to use non-ferrous tools and wear conductive, non-sparking shoes.

DISCLAIMER

At the time of publication, the product and technical data contained herein is believed to be accurate by Surface Engineered Technologies (SET). SET is committed to the continual improvement of its coatings, which may cause future product/technical data to change without prior notice. Our products are intended for use by properly trained personnel in industrial applications. Product performance will depend upon surface preparation, technique, method of application, surface to be coated and environmental conditions. However, there is no guarantee of comprehensiveness, accuracy or product performance given or implied herein. SET recommends that products be tested regarding these parameters prior to final use. ***Always refer to the current Safety Data Sheet before use.***

WARRANTY: *Surface Engineered Technologies (SET) warrants its products to be free of defects in materials and workmanship. Since SET has no control over surface preparation or application methods, no guarantee concerning results is offered, expressed, or implied. If this product is found to be defective, liability shall be limited to the refund of purchase price or replacement of product.*