

DTM INDUSTRIAL MAINTENANCE

SET2400 is a high-solids direct-to-metal industrial maintenance coating with excellent chip resistance, flexibility and with a super-high gloss and high-clarity finish.

Recommended For:

- Structural Steel
- Tanks
- Equipment Manufacturers
- Refinish Markets
- Trailer and Fleet

Features:

- Chip, Abrasion and Mar Resistance
- Excellent Gloss and Color Retention
- Outstanding Flow and Leveling
- 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 nonferrous metal, prime with SET7300 or SET7900 Epoxy Mastic. For previously 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 SET 70 or SET 7500.

Apply SET2400 to properly cured primers only.

Colors:

Standard stock colors and custom matches are available upon request.

Shipping Weight:

(approximate due to color, fill level and pigment)

SET2400 Gal Kit: (A)10.2 lbs. / (B)2.5 lbs.

APPLICATION DATA

- Optional Enhancers:**
Liquid Lightning Accelerator
Will significantly decrease pot life.
- Wet Film Thickness:**
4–8 wet mils per coat
- Dry Film Thickness:**
3–6 mils per coat
- Pot Life @ 77°F (25°C):**
2.5–3 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 mm or equivalent
- AA Airless:**
60 psi at the gun
Recommended liquid pressure is 1800–3300 psi with a tip size from 413–517.
- Roller/Brush:**
Not recommended

MIXING AND THINNING:

Two-component packaging. If necessary, depending on application and temperature, thin up to 25% with SET601 or SET602 (exempt solvent). Always thin after adding catalyst.

Mixing:

SET2400 (A) : SET2400 (B) Catalyst : SET Reducer
5 : 1 : 1

SET601 above 80°F (27°C) or SET602 below 80°F (27°C)

With optional Liquid Lightning Accelerator:

Add 3–8 drops per gallon.
(NOTE: Will significantly decrease pot life.)

CURE SCHEDULE @ 77°F (25°C):

Tack Free	4 hours
Drying Time	12 hours
Curing Time	7 days (Time may be shortened with addition of accelerator.)
Recoat	20 minutes minimum/24 hours maximum (degloss and recoat)

STORAGE CONDITIONS:

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

CHEMICAL RESISTANCE

Although SET2400 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

ACIDS

SOLVENTS

ALKALIS

PHYSICAL PROPERTIES

PROPERTY	VALUE*
Finish	Super High Gloss
% Solids by Volume	56% ± 2%
% Solids by Weight	67% ± 2%
Theoretical Coverage @ 1 mil	899 sq. ft. per gallon, depending on color <i>The actual coverage will be less depending on application techniques, job conditions and type of surface to be coated.</i>
Viscosity at 77°F (25°C)	70 KU
VOC Actual	193 g/L / 1.6 lbs./gal.
VOC Regulatory	250 g/L / 2.0 lbs./gal.
Flash Point	Part A: 55°F (13°C) / Part B: >338°F (>170°C)
Weight of Volatiles	32.4% ± 2%
Weight of Exempt	16.6% ± 2%
Volume of Exempt	20.5% ± 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	Ketone
Vehicle Type	Acrylic Polyurethane
	* Values listed will be color dependent Values blended 5A:1B

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.

