

DTM PERFORMANCE ENAMEL

SET1600 is a single-stage coating for mobile equipment exterior steel in mild to moderate industrial environments. Using optional SET1600 Hardener will give even better chemical and solvent protection and a faster dry-through time.

Recommended For:

- Refinish Market
- Trailer and Fleet
- Equipment Manufacturers

Features:

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

FOR INDUSTRIAL USE ONLY

Surface Preparation: Clean the surface thoroughly to remove oil, grease, wax, dirt, etc. Acid-etch prime galvanized parts. Prime aluminum with an acid-etch primer. For best results bare steel can be primed (waterborne primers are recommended). Body filler may be used but care must be taken to ensure that it is properly catalyzed. Under-cured body filler may cause primer to lift. For best results, use polyester filler. Surfaces previously painted with synthetic enamels or water reducible enamels may be recoated without sanding, although scuff sanding is recommended. Repainting over catalyzed paints, like urethanes and epoxies, scuff sanding is necessary for good adhesion. Be sure to remove sanding dust with a tack rag. If you are in doubt about what the old finish might be, sand it prior to repainting.

Optional Primers:

Use SET7000, SET7300 or SET7400.

Colors:

Standard stock colors, custom matches available upon request.

Shipping Weight:

(approximate due to color, fill level and pigment)

SET1600: 1 Gal–12 lbs. / 5 Gal–56.5 lbs.

APPLICATION DATA

Optional Enhancers:

- SET1600 Hardener
- SET1600 Accelerator

For a faster cure and tougher finish

When temperature is below 60°F (16°C)*

- SET1600 Retarder

When temperature is above 90°F (32°C)*

*Addition of accelerator or retarder may result in a non-compliant ready to spray VOC. Verify local regulations prior to use.

Wet Film Thickness:

3 wet mils per coat

Dry Film Thickness:

1.5 mils to 2.0 mils per coat

Pot Life @ 77°F (25°C):

This isn't applicable unless using SET1600 Hardener (with hardener, 60 minutes).

EQUIPMENT:

Apply by Air-Assisted Airless or HVLV:

Air pressure not to exceed 10 psi at the air cap.

HVLV:

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 900–3300 psi with a tip size from 411–515.

Roller/Brush:

- Shed-resistant 1/4" nap roller
- Nylon polyester 3/8" brush for field repair

MIXING AND THINNING:

For airless equipment no reduction is necessary. For pressure pot conventional or electrostatic guns, reduce 10% (12 oz. per gal.). Use 10 lbs. pot pressure for adequate paint flow rate and adjust atomizing air to get proper fan width and particle size. If you don't get a good fan pattern, add more water, a little at a time. Viscosity drops very fast and over-reduction will cause sagging. For HLPV, a little more reduction may be necessary, perhaps as much as 10% (3 oz. per qt.). Always thin after adding hardener or accelerator. **Avoid over-thinning!**

With optional
SET1600 Hardener:

SET1600 : SET1600 Hardener : Water
8 : 1 : 2

CURE SCHEDULE @ 77°F (25°C):

	Without Hardener	With SET1600 Hardener
Tack Free	2.5 hours	3 hours
Drying Time	8.5 hours	7 hours
Curing Time	7 days	3 days
Recoat	30 minutes minimum No maximum (degloss and recoat)	30 minutes minimum No maximum (degloss and recoat)

STORAGE CONDITIONS:

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

CHEMICAL RESISTANCE

Although SET1600 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

OIL

SOLVENTS

PETROLEUM

PHYSICAL PROPERTIES

PROPERTY	VALUE*
Finish	High Gloss
% Solids by Volume	29% ± 2%
% Solids by Weight	45% ± 2%
Theoretical Coverage @ 1 mil	463 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)	86 KU
VOC Actual	160 g/L / 1.3 lbs./gal.
VOC Regulatory	340 g/L / 2.8 lbs./gal.
Flash Point	146°F (63°C)
Weight of Volatiles	55.8% ± 2%
Weight of Exempt	42.8% ± 2%
Volume of Exempt	52.8% ± 2%
Shelf Life (when kept at the recommended storage conditions and in original, unopened containers)	8 months @ 77°F (25°C)
Pigment Type	Chemical Resistant
Solvent Type	Glycol Ether Blend
Vehicle Type	Water Reducible 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.

