ExoSET6100
Polyaspartic Coating

TECHNICAL DATA SHEET

EXTERIOR BRUSH/ROLLER INDUSTRIAL COATING

SET6100 is a high-gloss premium abrasion and corrosion-resistant topcoat for exterior vertical surfaces. The slower curing time makes for better adhesion and a stronger coating system.

Recommended For:

- Storage Tanks
- OEM Manufacturers
- Mobile equipment
- Structural Steel

Features:

- Excellent Gloss Retention
- Puncture/Abrasion Resistant Film
- Easy to Clean
- UV Resistance
- Low VOC
- Two-Component Pkg.

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 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:

Use SET7900

Colors:

Clear, custom colors available upon request.

Shipping Weight:

(approximate due to color, fill level and pigment)

SET6100 2 Gal Kit: (A)11.6 lbs. / (B)9.4 lbs.

APPLICATION DATA

Optional Enhancers:
Not applicable

Wet Film Thickness:
6–7 mils per coat

Dry Film Thickness:
5–6 mils per coat; 10–12 mils total.

Pot Life @ 77°F (25°C):
1½ hours dependent upon volume and temperature.
30-minute work time @ 77°F (25°C)

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
1.5–1.7 mm or equivalent

AA Airless:
60 psi Air / 30 psi Material
Recommended liquid pressure is 1500–3300 psi with a tip size from 515–619.

Roller:
Urethane 3/8"–1/2" nap roller

Brush:
Natural China brush

MIXING AND THINNING:

Do not mix until ready to use. Thoroughly mix. Watch the pot life. If material or ambient air is greater than 77°F (25°C) or if mixing more than a gallon of product at one time, pot life is dramatically shortened. No thinning required.

Mixing:	SET6100 (A) / 1 : SET6100 (B) catalyst / 1

CURE SCHEDULE @ 77°F (25°C):

Tack Free	4 hours 15 minutes
Drying Time	7 hours
Curing Time	48 hours
Recoat	4–5 hours minimum depending on temperature
	12 hours maximum

MECHANICAL PROPERTY	TEST METHOD	RESULT
Abrasion Resistance CS 17 Wheel, 1 kg Load, 1 000 Cycles	ASTM D4060	100mg of loss
Cyclic Salt Fog/UV Exposure	ASTM D5894	2,000 hours
Scribe	ASTM D1654	10
Blister	ASTM D714	10
Salt Fog Resistance (5,000 Hours) Applied Over Primer	ASTM B117	Very Good
Accelerated Weathering (3,000 Hours)	ASTM D4587	Very Good

Product Limitations:

- Surface and temp. must be 41°F (5°C)
- Humidity and temp. will affect the drying time
- Thinner can be added depending on local VOC and air quality regulations
- Surface temp. must be at 5°F (3°C) above dew point during application

STORAGE CONDITIONS:

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

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CHEMICAL RESISTANCE

Although SET6100 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
OILS
ANIMAL FATS

PHYSICAL PROPERTIES

PROPERTY	VALUE*
Finish	High Gloss
% Solids by Volume	89% ± 2%
% Solids by Weight	91% ± 2%
Theoretical Coverage @ 1 mil	1428 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)	80 KU
VOC Actual	83.6 g/L / 0.70 lbs./gal.
VOC Regulatory	85.3 g/L / 0.71 lbs./gal.
Flash Point	Part A: 180°F (82°C) / Part B: 191°F (88°C)
Weight of Volatiles	8.4% ± 2%
Weight of Exempt	1.5% ± 2%
Volume of Exempt	2.0% ± 2%
Shelf Life (when kept at the recommended storage conditions and in original, unopened containers)	12 months @ 77°F (25°C)
Pigment Type	Chemical Resistant
Solvent Type	Ketone/Aromatic
Vehicle Type	Polyaspartic/Aliphatic Polyisocyanate

Values listed will be color dependent
Values blended 1A: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.*