

DTM HIGH BUILD FLEET ENAMEL

Direct-to-metal (DTM) two-component coating for fleet, mobile, industrial and construction equipment. SET2300 has excellent adhesion and requires minimal prep time while maintaining excellent gloss retention.

Recommended For:

- Refinish Market
- Trailer and Fleet
- Equipment Manufacturers
- Structural and Maintenance

Features:

- High Build
- Outstanding Exterior Durability
- Excellent Gloss and Color Retention
- Outstanding Flow and Leveling
- VOC Compliant
- 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 for use on nonferrous metal, prime with SET7300 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 SET2300 to properly cured primers only.

Colors:

Tintable bases, custom matches available upon request.

Shipping Weight:

(approximate due to color, fill level and pigment)

SET2300 Gal Kit: (A) 11.1lbs. / (B) 2.63bs.
SET2300 5 Gal Kit:(A) 44.4 lbs.
(B) 10.52lbs.

APPLICATION DATA

Optional Enhancers:

Liquid Lightning Accelerator
Will significantly decrease pot life.

Wet Film Thickness:

6-8 wet mils per coat

Dry Film Thickness:

4-6 mils per coat

Pot Life @ 77°F (25°C):

1.5 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:

Two-component packaging. If necessary, depending on application and temperature, thin up to 15% with SET601 or SET602 (exempt solvent). Always thin after adding catalyst.

Mixing:

$\frac{\text{SET2300 (A)}}{4}$: $\frac{\text{SET2300 (B) Catalyst}}{1}$: $\frac{\text{SET Reducer}}{0.75}$

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	2 hours
Drying Time	5 hours
Curing Time	5 days
Recoat	5 hours minimum/7 days maximum (degloss and recoat)

STORAGE CONDITIONS:

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

CHEMICAL RESISTANCE

Although SET2300 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

ACIDS

PHYSICAL PROPERTIES

PROPERTY	VALUE*
Finish	High Gloss
% Solids by Volume	64% ± 2%
% Solids by Weight	72% ± 2%
Theoretical Coverage @ 1 mil	1028 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)	64 KU
VOC Actual	290.8 g/L / 2.43lbs./gal.
VOC Regulatory	306 g/L / 2.56 lbs./gal.
Flash Point	Part A: 77°F (25°C) / Part B: 122°F (50°C)
Weight of Volatiles	27.33% ± 2%
Weight of Exempt	3.3% ± 2%
Volume of Exempt	5.07% ± 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	Acetone / Aromatic
Vehicle Type	Acrylic Urethane
	* Values listed will be color dependent Values blended 4A: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.

