

Gloss Alkyd Enamel

INDUSTRIAL MAINTENANCE

SET821 is an excellent gloss finish ready-to-spray coating for miscellaneous metal parts and mobile equipment in industrial environments.

Recommended For:

- Miscellaneous Metals
- Industrial Equipment Market
- Equipment Manufacturers

Features:

- VOC Compliant
- High Hiding
- Ready-to-Spray
- Outstanding Flow and Leveling

FOR INDUSTRIAL USE ONLY

Surface Preparation: Surface should be clean and free of all surface contamination, using SET500 or similar cleaner. Treat aluminum with a commercial etching solution. For light rust, treat with SET400, a rust convertor. For heavily rusted areas, use abrasive blasting. For previously painted surfaces, sand using 320 grit (dry) or 400 grit (wet).

Recommended Primers:

Ferrous metals:
Use SET70, SET73 or SET7500
Nonferrous metals:
Use SET7300.

Apply SET821 to properly cured primers only.

Colors:

Made-to-order custom batches available.

Shipping Weight:

(approximate due to color, fill level and pigment)

SET821: 1 Gal–10 lbs. / 5 Gal–50 lbs.

APPLICATION DATA

Optional Enhancers:
Not applicable

Wet Film Thickness:
2–6 wet mils per coat

Dry Film Thickness:
1.75–2.5 mils per coat

Pot Life @ 77°F (25°C):
Not applicable unless using SET800 series hardener (with hardener 90 minutes)

EQUIPMENT:

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

HVLP:
10 psi at the gun
1.4 mm or equivalent

AA Airless:
60 psi Air / 30 psi Material
Recommended liquid pressure is from 900–3300 psi with a tip size from 411–515.

Roller:
Not recommended

Brush:
Not recommended

MIXING AND THINNING:

Mixing:	Ready to Spray	With 800 Hardener If using hardener always thin after adding hardener. Thin up to 5% depending on application and temperature, with SET 601 or SET602 (exempt solvents).
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CURE SCHEDULE @ 77°F (25°C):

Tack Free	1 hour 30 minutes
Drying Time	4 hours 30 minutes
Curing Time	3 days
Recoat	6 hours minimum no maximum (degloss and recoat)

STORAGE CONDITIONS:

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

CHEMICAL RESISTANCE

Although SET821 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

SOLVENTS

PHYSICAL PROPERTIES

PROPERTY	VALUE*
Finish	Gloss
% Solids by Volume	42% ± 2%
% Solids by Weight	59% ± 2%
Theoretical Coverage @ 1 mil	690 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)	22–24 Zahn 2
VOC Actual	171 g/L / 1.4 lbs./gal.
VOC Regulatory	340 g/L / 2.3 lbs./gal. (w/ 800 hardener 315 g/L)
Flash Point	41°F (5°C)
Weight of Volatiles	41.4% ± 2%
Weight of Exempt	27.0% ± 2%
Volume of Exempt	37.9% ± 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	Modified Alkyd Resin

* 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.

