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.

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 Enhancers:
- SET1600 Hardener
  - For a faster cure and tougher finish
- SET1600 Accelerator
  - 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).

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

**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

**Optional Hardeners:**
- SET1600
  - Provides a faster cure and tougher finish
- SET1600 Accelerator
  - For use when temperature is below 60°F (16°C)
- SET1600 Retarder
  - For use 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.

**Curing Schedule @ 77°F (25°C):**

<table>
<thead>
<tr>
<th></th>
<th>Without Hardener</th>
<th>With SET1600 Hardener</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Tack Free</strong></td>
<td>2.5 hours</td>
<td>3 hours</td>
</tr>
<tr>
<td><strong>Drying Time</strong></td>
<td>8.5 hours</td>
<td>7 hours</td>
</tr>
<tr>
<td><strong>Curing Time</strong></td>
<td>7 days</td>
<td>3 days</td>
</tr>
<tr>
<td><strong>Recoat</strong></td>
<td>30 minutes minimum</td>
<td>30 minutes minimum</td>
</tr>
<tr>
<td></td>
<td>No maximum (degloss and recoat)</td>
<td>No maximum (degloss and recoat)</td>
</tr>
</tbody>
</table>

**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 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 HLVP, 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

**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.

PHYSICAL PROPERTIES

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

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.

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.

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.

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