

SYN-GLO

Synthetic Enamel Topcoat



TECHNICAL DATA SHEET

SYN-GLO synthetic enamel paints are easy to apply and offer a durable, beautiful finish designed to stand up to the everyday wear endured by commercial fleet vehicles. More than anything else, Kirker's SYN-GLO single-stage paint system provides exceptional value. This economical topcoat system is available in 18 stock, pre-mixed factory-packaged colors that cover the spectrum for fleet and light industrial vehicles.

Designed to be used in a single-stage application with or without a hardener.

- National Rule Compliant
- Excellent economic value
- 18 stock color choices
- Easy to apply
- Good gloss retention and color holdout

COATING TYPE:

Synthetic Enamel Paint (Single-stage)

PRODUCT CODE:

"SA" prefix; Factory-pack colors (see color chart)

HARDENER:

K-1605 Synthetic Enamel Hardener

REDUCERS:

R-8250 – Fast (Less than 65° F)
R-8253 – Medium (Between 65° - 80° F)
R-8256 – Slow (Above 85° F)
UE-8000 – Universal VOC-Exempt Reducer



PHYSICALS:

Appearance:	Paint (color varies)
Weight per Gallon:	Varies with color
Package Measure:	1 U.S. gallon / 128 fl. oz. (3.785 liters)
RTS VOC:	Maximum VOC of 5.0 lbs/gallon

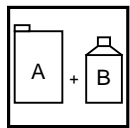


SURFACE PREP:

Remove all traces of wax, grease, silicone, oil and other contaminants with detergent wash, followed with a solvent wash (such as Kirker's 650 Wax & Grease Remover). Abrade substrate with 600-800 grit to ensure sufficient adhesion. Re-clean with final wash cleaner (such as Kirker's 600 Surface Wash).

SYN-GLO may be applied "wet on wet," over certain freshly applied undercoats including Kirker's PERFECT Prime (2K urethane primer surfacer – overall), RAPID Prime (Kirker's 2K urethane primer surfacer – spot/panel) and SUPER RUST STOP (Kirker's non-sanding primer) after approximately 30 minutes flash time; or ENDURO Prime (Kirker's 2-part epoxy primer) after 30-45 minutes flash.

Be sure to mask all adjacent panels to prevent dry overspray.



MIXING:

Mix ratio: 4:1 by volume. Thoroughly mix four (4) parts SYN-GLO color with at least one (1) part of the appropriate Synthetic Enamel Reducer (R-8250, R-8253 or R-8256), depending on air flow and shop temperatures.

Temperature range	Less than 65° F	Between 65° F - 80° F	More than 80° F
Reducer	R-8250 (fast)	R-8253 (medium)	R-8256 (slow)

Additional reduction may be required to improve flow and leveling. Use one of Kirker's Synthetic Enamel Reducers (R-8250, R-8253 or R-8256), depending on shop temperature, or Universal Zero-V.O.C. Reducer, UE-8000. WARNING: With further reduction beyond the recommended 4:1 mix ratio, SYN-GLO may no longer be VOC compliant for your area. Using UE-8000 will not increase the VOC.

Caution: Mix only as much material as you will need to complete the immediate job.

WITHOUT HARDENER:

4:1

SA Color	4oz	12 oz.	20 oz.	28 oz.
Synthetic Enamel Reducer	1 oz.	3 oz.	5 oz.	7 oz.
TOTAL MIXTURE	5 oz.	15 oz.	25 oz.	35 oz.

Though not required, it is highly recommended that Kirker's Synthetic Enamel Hardener (K-1605) be used. The use of a hardener will significantly speed the dry time, increase gloss in the finished film and extend the durability of the synthetic enamel paint job. One (1) pint (16 oz.) of hardner should be mixed with each gallon of synthetic enamel paint and quart of synthetic enamel reducer, resulting in an 8:2:1 mix ratio (8 parts paint: 2 parts reducer: 1 part hardener).

Caution: Mix only as much material as you will need to complete the immediate job.

WITH HARDENER:

8:2:1

SA Color	4oz	8 oz.	16 oz.	24 oz.
Synthetic Enamel Reducer	1 oz.	2 oz.	4 oz.	6 oz.
Synthetic Enamel Hardener	½ oz.	1 oz.	2 oz.	3 oz.
TOTAL MIXTURE	5.5 oz.	11 oz.	22 oz.	33 oz.



POT LIFE:

Approximately 3 hours at 70°F

Caution: Pot life is significantly shorter at elevated temperatures and in humid conditions. These environmental factors also may affect flow and leveling during the application process.



GUN SETTINGS:

<u>GUN TYPE</u>	<u>TIP SIZE</u>	<u>AIR PRESSURE</u>
Conventional Siphon Feed:	1.4 mm – 1.8mm	50-60 psi at the gun
Conventional Gravity Feed:	1.4 mm – 1.6 mm	50-60 psi at the gun
HVLP	1.2 mm – 1.4 mm	8-10 psi at the tip

Always refer to gun manufacturer's recommendations for additional details on suggested tip size, air pressure and other adjustments.



APPLICATION:

Apply non-metallic SYN-GLO colors with a medium tack coat. After allowing paint to flash, apply paint in a full wet coat. With metallic SYN-GLO colors, the process should be reverse; a full wet coat followed by a lighter coat once the first coat has dried tacky. Too much time passed between coats could result in poor flow, which may lead to orange peel. Two coats should be sufficient to achieve a dry film thickness of 2 mils. Additional coats may induce runs, sags, soft paint film and / or wrinkling.



DRY TIMES:

	<u>WITH HARDENER</u>	<u>WITHOUT HARDENER</u>
Dust free:	1 hour	2 hours
Tack free:	2 hours	3 hours
Tape:	24 hours	1 week +
Polish:	36 hours	1 month
Deliver:	24 hours	1 week

Air-dry times may vary slightly depending on shop temperatures, airflow and total film thickness. All dry times listed are approximate, at 70° - 75°F



CLEANUP:

Close all containers tightly after each use. Clean gun and spray equipment with gun wash or other appropriate solvent products immediately after application to prevent damage.

Shelf life of K-1605 Synthetic Enamel Hardener is limited once can has been opened. This product is extremely susceptible to oxygenation and exposure to moisture. Therefore, containers should be closed tightly after each use, with a clean seal, as quickly as possible. Also, activators should be stored at a consistent temperature to prevent the formation of potentially damaging condensation inside of the can.

**RECOAT WINDOW:**

SYN-GLO should be recoated while the previous coat is still tacky. After paint has dried hand-slick, wait at least four (4) hours to recoat, as long as Synthetic Enamel Hardener was used. If no hardener was used, wait at least two weeks before recoating SYN-GLO, but only after surface has first been abraded with 600-800 grit to promote sufficient adhesion.

**POLISH:**

In single-stage applications when a Synthetic Enamel Hardener is used, SYN-GLO may be polished after 24 to 48 hours. Start by sanding finish with 1500 grit or finer to abrade surface and / or remove dust nibs and other surface imperfections such as orange peel, then finish sand with 2000 grit or finer to remove all 1500-grit sand scratches.

Use a wool pad or foam pad in combination with a high-quality finishing compound, following material manufacturer's instructions. Follow with a high-quality finishing glaze applied either by hand, or variable-speed buffer.

When no hardener is used, SYN-GLO should not be buffed for at least one month.

**HEALTH / SAFETY PRECAUTIONS:**

THIS PRODUCT IS INTENDED FOR USE BY PROFESSIONALS ONLY.

USE THIS PRODUCT ONLY WITH ADEQUATE VENTILATION: Wear appropriate, properly fitted fresh-air-supplied NIOSH/MSHA-approved respirator (TC-19C or equivalent) as directed by the manufacturer. Protect hands with impervious nitrile gloves. Always wear eye and face protection. Individuals with lung or breathing problems should neither use nor be exposed to this product, its vapors or spray mist. READ ALL WARNINGS ON ALL LABELS BEFORE USING.

This product is designed to be mixed with other components. Mixture will have hazards of all components. Before opening the packages, read all warning labels. Follow all precautions. See Material Safety Data Sheet for additional health and safety information.

WARRANTY:

All recommendations for the use of Kirker products are based on tests and experience believed to be reliable. Since the methods of use, conditions of application, and the application itself are beyond our control, product warranty is restricted to replacement of material only. No other warranty, written or oral, is expressed or implied.

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