



# TECHNICAL DATA SHEET

## SYN-GLO SYNTHETIC ENAMEL TOPCOAT

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
- ◆ Wide assortment of factory packaged colors
- ◆ Easy to apply
- ◆ Good gloss retention and color holdout

### COATING TYPE:

Synthetic Enamel Topcoat (single-stage)

### PRODUCT CODES:

SA Prefix

### HARDENERS:

K-1605PT S/E Hardener (pint)

K-1605G S/E Hardener (gallon)

### REDUCERS:

R-8250 (Fast)

R-8253 (Medium)

R-8256 (Slow)

### WEIGHT PER GALLON:

Varies by color

### PACKAGE MEASURE:

1 US Gallon / 128 fl. oz. / 3.785 Liters

### RTS VOC:

Varies by color (will not exceed 5.0 lbs/gallon)

### RTS Viscosity:

20-22 seconds, #2 Zahn cup

### SUITABLE SUBSTRATES:

Black Diamond Low-VOC 2K Urethane Primer Surfacer

PERFECT PRIME 2K Urethane Primer Surfacer

RAPID PRIME 2K Urethane Primer Surfacer

DIRECT PRIME DTM 2K Urethane Primer Surfacer

ENDURO PRIME DTM Epoxy Primer Surfacer

Properly prepared, OE finishes and other fully cured automotive-grade primers may also be suitable.



### 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 also be applied "wet on wet," over certain freshly applied undercoats including Kirker's DIRECT PRIME, PERFECT Prime and RAPID Prime 2K Urethane Primer Surfacer after approximately 30 minutes flash time; or ENDURO PRIME DTM Epoxy Primer after 30-45 minutes flash. Be sure to mask all adjacent panels to prevent dry overspray.

### COLOR

Please note that while every attempt for color consistency is made, there may be some difference in shade from one batch to the next. If using multiple cans of the same color for the same job, be sure to check for a common batch code before starting. This can be identified by the five-digit number marked either on the lid or face of the can. If batches are not the same, all materials should be blended prior to use to ensure color consistency.

# SYN-GLO ACRYLIC ENAMEL TOPCOAT

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### MIXING

Mix ratio: 4:1 by volume. Thoroughly mix four (4) parts ACRYL-GLO Color with one (1) part of the appropriate Acrylic Enamel Reducer (R-8250, R-8253, R-8256) pending on shop temperature and other conditions). Additional reduction may be necessary to improve flow and leveling.

BELOW 70°	70-80°	ABOVE 80°
FAST	MEDIUM	SLOW
R-8250	R-8253	R-8256

Though not required, it is highly recommended that Kirker's Synthetic Enamel Hardener (K-1605) be used. The addition of a hardener will speed up the dry time, increase the gloss in the finished film and extend the durability of the synthetic enamel paint. One (1) pint (16 oz) of Hardener 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 will be needed to complete the immediate job.

TOMIX	11 oz	22 oz	33 oz
S/E COLOR	8 oz	16 oz	24 oz
REDUCER	2 oz	4 oz	6 oz
HARDENER	1 oz	2 oz	3 oz

### POT LIFE

Approximately two hours at 70°F.

Mix only as much material as is needed to complete the immediate job.

### GUN SETTINGS

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

GUN TYPE	TIP SIZE	AIR PRESSURE
Conventional Siphon	1.4-1.8 mm	50-60 psi
Conventional Gravity	1.4-1.6 mm	50-60 psi
HVLP	1.2-1.4 mm	8-10 psi

### APPLICATION

Apply non-metallic SYN-GLO colors with a medium tack coat. After allowing paint to flash, apply in full wet coats. With metallic SYN-GLO colors, the process should be reversed; a full wet coat followed by a lighter coat once the first has sufficiently flashed (coat will still be 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 be required, but take care not to overload the surface, which may lead to runs, sags, soft paint film and/or wrinkling.

### DRY TIMES

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

	WITH HARDENER	WITHOUT HARDENER
Dust Free:	1 hour	1 hour
Tack Free:	2 hours	2 hours
Tape:	24 hours	1 week +
Polish:	36-48 hours	1 month
Deliver:	24 hours	1 week

### RECOAT

SYN-GLO should only 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, allow paint to dry at least two weeks before recoating. Be sure to properly abrade surface (with 600-800 grit) to promote adhesion prior to recoating a dried paint film.

### 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.

### CLEANUP

Close all containers tightly after each use. Clean gun and spray equipment with Kirker's VOC Compliant Gun Wash (670) or other appropriate solvent products immediately after application to prevent damage.

### HEALTH / SAFETY

THIS PRODUCT IS INTENDED FOR USE BY PROFESSIONALS ONLY. 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 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.

### CONTACT FOR MORE INFO

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