

## SYNTHETIC 3000

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**SYNTHETIC 3000** is a high gloss alkyd enamel, designed for wood and steel surfaces, suitable for all interior and exterior applications. **SYNTHETIC 3000** is high gloss and fast dry synthetic enamel has good hiding power and good weather resistance. It also fast dry, easy to apply and has excellent flow so does not leave brush mark.

### PRODUCT SPECIFICATION

Type	: One component alkyd enamel
Appearance	: Colored liquid
Color	: As shown in the color card
Finish	: Glossy
Solid content (NV, w/w)	: 50 ± 5 %
Specific Gravity	: 1.00 ± 0.04 g/cc
Coverage	: 3 - 4 m <sup>2</sup> /kg (40 micron)
Flash Point	: 27°C
Drying time	: Touch dry : 2 hours (30°C) Hard dry : 4 hours (30°C)
Packing	: 20 kg in steel pail

### APPLICATION

Thinner	: THAK-71500 PT		
Application method	: Airless Spray	Air Spray	Brush / Roll
Thinning ratio by weight	: 5%	35%	15%
Viscosity of mixture (Din cup 4)	: 80 sec	15 sec	25 sec
Wet film thickness	: 90 microns or 3.6 mils		
Dry film thickness	: 40 microns or 1.6 mils		
Recommended dry film thickness	: 2 x 40 microns 2 x 1.6 mils		
Recoating interval	: Minimum 12 hours (30°C), when the first film already dry		
	: Maximum -		
Cleaning	: Wash all equipment immediately after use with thinner		

### SURFACE PREPARATION

1. The surface must be clean, dry, and free from rust, dust, oil, grease and other contaminants with appropriate method (wire brush, sand paper, rust converter).
2. For optimal use on steel where good resistant to corrosion is needed, it is recommended to apply appropriate primer before applying this coating.

### APPLICATION CONDITION

Temperature	: Minimum 10°C Maximum 50°C
Humidity maximum	: 80% RH

Provide adequate ventilation during application and drying

## RECOMMENDED COATING STEP

### A. ON WOOD

No.	PROCESS FINISHING	PRODUCT	MIXING RATIO	VISCOSITY	APPLICATION	COATING AMOUNT	DRYING TIME
1	Base Coat	IMPRA WF-115	-	25.000 cps	Scrap	-	1 hour
2	Top coat	<b>SYNTHETIC 3000</b>	Max 35%	14 - 15 sec	Spray	100	2 hours

### B. ON METAL

No.	PROCESS FINISHING	PRODUCT	MIXING RATIO	VISCOSITY	APPLICATION	COATING AMOUNT	DRYING TIME
1	Base Coat	AP-291 ZINC PHOSPHATE / ZINC CHROMATE	Max 40%	14 - 15 sec	Spray	100	3 hours
2	Top coat	<b>SYNTHETIC 3000</b>	Max 35%	14 - 15 sec	Spray	100	2 hours

## SAFETY PRECAUTION

Avoid contact with the skin and eyes. Wear suitable protective clothing such as overalls, goggles, dust masks, and solvent resistance gloves. Use barrier cream.

This product is flammable. Subject to spontaneous heating. Do not smoke. Use only explosion proof equipment. Do not breathe the vapor of spray. Ensure adequate ventilation and fresh air entry during application and drying. If there are experiences eye watering, headaches, dizziness or difficulty breathing, leave the area to obtain fresh air or respiratory protection.

### FIRST AID:

- Eye contact : Rinse immediately with plenty of water for at least 15 minutes; seek medical advice
- Skin contact : Wash with soap and water. If irritation occurs, seek medical advice
- Ingestion : Provide symptomatic treatment and seek medical advice
- Inhalation : Remove person to fresh air. Keep patient rested and give artificial respiration