Axalta 13238S™
Epoxy Pre-Treatment

GENERAL

DESCRIPTION
A strontium-chromate based epoxy pre-treatment designed to provide adhesion and corrosion resistance for aluminum, aluminum alloy, and metal substrates.

RECOMMENDED USES
13238S is recommended for use as a metal pre-treatment/conversion coating in lieu of a chromic-acid conversion coating. It is compatible with most epoxy primers and is recommended for use with Corlar® 13550S™ or 13580S™ as part of a complete pre-treatment and primer system.

The products referenced herein may not be sold in your market. Please consult your distributor for product availability.

MIXING

COMPONENTS
13238S Epoxy Pre-Treatment
13138S™ Pre-Treatment Activator

MIX RATIO
Thoroughly mix 13238S prior to activation. Filter activated material prior to spray application.

Component	Parts by Volume
13238S Epoxy Pre-Treatment	1
13138S Pre-Treatment Activator	1

VISCOSITY
9-11 seconds in a Zahn #3 cup.

INDUCTION TIME
No induction time is required.

POT LIFE
8 hours at 70°F (21°C).

ADDITIVES
None recommended.

APPLICATION

ENVIRONMENTAL CONDITIONS
Substrate and ambient temperature must be between 50°F (10°C) and 110°F (43°C). The substrate must be at least 5°F (3°C) above the dew point. Relative humidity should be below 90%.

SUBSTRATES AND SURFACE PREPARATION
- Substrate must be properly prepared for application. As a minimum, aluminum surfaces should be scrubbed/scuffed with Scotch-Brite™ 7447 pads (or coarser) using an alkaline aviation cleaner.
- Work area should be kept wet and rinsed with clean water, not allowing detergent to dry on the clean surface. Surface must be “water break free”, meaning water sheets out

completely over the metal surface. Any beading up or breaks indicate surface contamination where cleaning must be repeated.
- Surface must be dry prior to application of 13238S.

GUN SETUP
13238S can be applied with conventional, HVLP, and electrostatic spray equipment using pressure or gravity fluid delivery.

Conventional Fluid Tip

Pressure Pot	1.2 mm-1.5 mm (.047”-.059”)
Gravity Feed	1.3 mm-1.6 mm (.051”-.063”)

HVLP

Pressure Pot	1.0 mm-1.4 mm (.039”-.055”)
Gravity Feed	1.2 mm-1.5 mm (.047”-.059”)

FLUID DELIVERY

Conventional	8-10 oz./min
HVLP	8-10 oz./min

AIR PRESSURE

Conventional	50-60 psi atomizing air
HVLP	25-30 psi atomizing air

APPLICATION
Apply using a single medium-wet coat to achieve 0.6-0.8 mils dry film thickness (approximately 1.8-2.4 mils wet).

CLEANUP SOLVENTS
Axalta 107™ Low VOC Gun & Equipment Cleaner
Axalta 105™ Gun & Equipment Cleaner

DRY TIMES

AIR DRY AT 70°F (21°C)

Dry to Touch	10 minutes
Dry to Prime	30 minutes

FORCE DRY AT 130°F (54°C)

Flash Before Force Dry	10 minutes
Dry to Prime	15 minutes

RECOAT
Recoat window is 48 hours for 13238S which has been air dried.

PHYSICAL PROPERTIES

VOC	Less Exempts (LE)	As Packaged (AP)
13238S	3.8 lbs./gal	3.8 lbs./gal
Ready-to-Spray 13238S	5.0 lbs./gal	5.0 lbs./gal

FACTORY-PACKAGED PRIMER

Color	Yellow-Green
Closed Cup Flash Point	20°F - 73°F
Shelf Life	2 years (Unopened at 50°-110°F)

READY-TO-SPRAY

Theoretical Coverage	430 ft²/gal at 1 mil dry film thickness
Weight Solids	46%
Volume Solids	27%

Gallon Weight	9.2 lbs./gal

DRY FILM

Gloss	Satin
Recommended Film Thickness	0.6-0.8 mils

COATING PERFORMANCE

Corrosion Resistance	Very Good
Adhesion	Excellent
Chemical and Solvent Resistance	Very Good
Humidity Resistance	Excellent
Flexibility	Very Good

VOC REGULATED AREAS

These directions refer to the use of products which may be restricted or require special mixing instructions in VOC regulated areas. Follow mixing usage and recommendations in the VOC Compliant Products Chart for your area.

SAFETY AND HANDLING

For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and MSDS precautions. If mixed with other components, mixture will have hazards of all components.

Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.

Revised: January 2015