



Metalok[®] 230S[™] Adhesion Promoter



GENERAL

DESCRIPTION

A water-reducible, low VOC, easy to apply adhesion promoter that eliminates the need for a conversion coating, or sanding and etching of aluminum and hard to work with metal substrates.

SUGGESTED USES

Aluminum, stainless steel, galvanized steel and cold rolled steel. A substrate panel test is recommended to ensure compatibility with substrate and optimize the metal preparations to insure maximum adhesion.

NOT RECOMMENDED FOR

Substrates that have not been thoroughly cleaned of contaminants such as grease, dirt and oil.

COMPATIBILITY COATINGS

Compatible with all Axalta Transportation epoxy or polyurethane primers and topcoats.

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



MIXING

MIX RATIO

Combine components and mix thoroughly.

Component

Metalok[®] 230S[™]
Deionized water

Volume

2
98

POT LIFE AND INDUCTION TIME

Allow a 15-minute induction time. Mixed product should be stored in non-ferrous containers. Product stored in plastic containers can be used up to 1 month after mixing. Do not exceed this time period.



APPLICATION

APPLICATION CONDITIONS

The substrate should be free of contaminants (dirt, oil, grease, etc.) prior to application. Not all soap and water cleaners are effective for removing grease and oil. 225S[™] Aluminum Conditioner, AquaPrep (Parker-Amchem) and Alsteam (Chemcoa) have proven to be effective cleaners.

ADDITIONAL COMMENTS

- Mix and store Metalok[®] 230S[™] in plastic containers only.
- Substrate can be sanded prior to application of Metalok[®] 230S[™]. Follow the recommended cleaning procedures. A properly cleaned substrate will allow Metalok[®] 230S[™] to form a consistent layer over the substrate. Areas not properly cleaned will run off the substrate in a non-uniform pattern.
- Wipe, spray or dip the substrate in Metalok[®] 230S[™] solution.
- Do not allow Metalok[®] 230S[™] to dry without rinsing with deionized water. Rinse off Metalok[®] 230S[™] within 15 minutes of application using deionized water or water that has



- been analyzed and approved for use. Do not discharge Metalok® 230S™ solution to drain without contacting your local wastewater treatment facility to check BOD and COD limits.
- Prime within 48 hours after application (within 24 hrs. is preferred). Sooner is desirable so that airborne debris doesn't contaminate the substrate. Wiping with a clean tack rag prior to priming is recommended. The substrate should be stored indoors.

APPLICATION

- Metalok® 230S™ can be applied by spraying, wiping, or dipping the substrate.
- For spray application a wide fan pattern with low fluid delivery is best.
- Rinse the substrate with deionized water within 15 minutes of applying Metalok® 230S™.

APPLICATION EQUIPMENT

Recommend using a pressure washer capable of siphoning from a container.



DRY TIMES

77°F (25°C) & 50% RH at Recommended Film Thickness

The substrate must be completely dry and free from water before primer is applied. Metalok® dries at approximately the same speed as water. It can be force dried with ambient or hot air.



PHYSICAL PROPERTIES

Maximum Service Temperature	200°F (92°C) in continuous service 200°F (92°C) in intermittent heat
Weight Per Gallon (component only)	7.21 lbs.
Weight Per Liter (component only)	864 grams
Suggested Dry Film Thickness	Not Applicable
Gloss	Not Applicable
Color	Not Applicable
Flash Point (Closed Cup)	See MSDS/SDS
Shelf Life	12 months minimum

RTS mixed 2:98 with:

	DI Water
Gallon Weight pounds per gallon	8.33
Gallon Weight grams per liter	998
VOC AP pounds per gallon	0.1
VOC AP grams per liter	8
VOC LE pounds per gallon	2.8
VOC LE grams per liter	332
Weight Solids	0.9%
Volume Solids	1.0%
Weight Volatiles	99.1%
Weight Water	98.3%
Volume Water	97.6%
Weight Exempt Solvents	0.0%
Volume Exempt Solvents	0.0%
Theoretical Coverage per RTS Gallon at 1 mil DFT	N/A

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/SDS 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.

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