



# Metalok<sup>®</sup> 250S<sup>™</sup> Pretreatment



## GENERAL

### DESCRIPTION

A two-component, non-sanding, 5.0 lb/gal (600 g/l) VOC, chrome containing pretreatment formulated to provide maximum adhesion and corrosion resistance.

### SUGGESTED USES

As a pretreatment for aluminum, stainless steel, steel and fiberglass substrates.

### NOT RECOMMENDED FOR

Immersion service  
Use where EPA Rule 6H compounds are not desired.

### COMPATIBLE COATINGS

Compatible with all Axalta Transportation primer and sealer systems

### DRY FILM CHARACTERISTICS

Chemical Resistance	EXCELLENT
Weather-ability	VERY GOOD
Humidity Resistance	EXCELLENT
Flexibility, Impact and Chip	VERY GOOD
Durability	VERY GOOD

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



## MIXING

### MIX RATIO

Thoroughly mix prior to activation. The use of a Cyclone<sup>®</sup> shaker is recommended. Combine components and mix thoroughly. Filter material prior to spray application.

Component	Volume
Metalok <sup>®</sup> 250S <sup>™</sup> Pretreatment	1
Metalok <sup>®</sup> 255S <sup>™</sup> Activator	1

### INITIAL APPLICATION VISCOSITY

9-13 seconds with #3 Zahn Cup.

### POT LIFE

8 hours at 70°F (21°C)

### INDUCTION TIME

Not required



## APPLICATION

### ADDITIONAL COMMENTS

Allow 30 minutes flash prior to applying primer. Product must be sanded if left to dry for more than 48 hours. Sand with 400 grit or less.

### APPLICATION CONDITIONS

Do not apply if material, substrate or ambient temperature is less than 50°F (10°C) or above 110°F. The substrate must be at least 5°F (3°C) above the dew point. Relative humidity



should be below 90%.

**APPLICATION EQUIPMENT**

Refer to spray equipment documentation for setting recommendations.

- Pressure Pot (recommended)
- Gravity
- Suction Spray
- Airless Spray
- Air Assisted Airless

**APPLICATION SOLVENTS**

Ready-to-spray below 5.0 lb/gal (600 g/l) VOC upon activation. Further reduction may result in greater than 5.0 lb/gal (600 g/l) VOC.

**APPLICATION**

Apply one quick cross coat to achieve 0.6-0.8 dry film over properly prepared substrates. The cross coat should be applied about six inches from the substrate to allow proper wetting of the pretreatment to the substrate.

**CLEANUP SOLVENTS**

- 3602S™ Lacquer Thinner
- 106™ Lacquer Thinner
- 107™ Low VOC Gun Cleaner
- 108™ Low HAPS Cleaning Solvent



**DRY TIMES**

**AIR DRY**

77°F (25°C) & 50% RH at recommended film thickness

- Dry to touch: 10 minutes
- Dry to prime: 30 minutes

**FORCE DRY**

Product may be force dried 15 min at 140°F (60°C). Allow to flash 10 minutes before bake.



**PHYSICAL PROPERTIES**

Maximum Service Temperature	200°F (92°C) in continuous service 200°F (92°C) in intermittent heat
Weight Per Gallon (component only)	11.60 lbs.
Weight Per Liter (component only)	1390 grams
Suggested Dry Film Thickness	0.6-0.8 mils
Gloss	Matte
Color	Yellow
Flash Point (Closed Cup)	See MSDS/SDS
Shelf Life	12 months minimum

<b>RTS mixed 1:1 with:</b>	<b>255S</b>
Gallon Weight pounds per gallon	9.24
Gallon Weight grams per liter	1107
VOC AP pounds per gallon	5.0
VOC AP grams per liter	595
VOC LE pounds. per gallon	5.0
VOC LE grams per liter	595
Weight Solids	46.2%
Volume Solids	27.2%
Weight Volatiles	53.8%
Weight Water	0.1%
Volume Water	0.1%



Weight Exempt Solvents	0.0%
Volume Exempt Solvents	0.0%
Theoretical Coverage per RTS Gallon at 1 mil DFT	436 ft <sup>2</sup> (40.5 m <sup>2</sup> )

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### **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.

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### **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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In the United States:  
**1.855.6.AXALTA**  
**axalta.us**

In Canada:  
**1.800.668.6945**  
**axalta.ca**

