

## 230S

12.12.2014

**METALOK™**

### DESCRIPTION

METALOK™ 230S is a low VOC metal adhesion system designed for aluminium and other hard-to-work-with metal substrates. METALOK™ 230S may eliminate conversion coating, sanding or etching, and provides outstanding adhesion. METALOK™ 230S is easy to apply; mix 2% by volume with deionized water and stir the mixture before using. Allow a 15-minute induction time and spray, wipe or dip the substrate. Disposal is easy. A water reducible, organic ester mixture with 385 g/L VOC as packaged.

### PRODUCT

230S      Metalok™

### SUBSTRATES

METALOK™ 230S can be used on Aluminium, Stainless Steel, Galvanized Steel and Cold Rolled Steel and Glass. It is recommended a customer substrate panel testing program take place prior to commercialization. This testing helps define the differences in substrates and optimizes the metal preparation to ensure maximum adhesion.

### PRODUCT ADVANTAGES

Can eliminate the need for sanding.

- Can eliminate the need for exotic metal preparation.
- Very easy to apply by spray, wipe or dip.
- Ultra-low VOC ready-to-spray. Easy waste disposal.

### ACTIVATION

- Mix 2% by volume with deionized water and stir the mixture before using. Allow a 15-minute induction time.
- Mixed product should be stored in non-ferrous containers. (The product bonds with metal and becomes less, or not effective over time.)
- Product stored in plastic containers can be used up to 1 month after mixing. (Do not exceed this time period.)

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### 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.

### 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. An excellent spray method is one using a pressure washer that can siphon from containers. The substrate should be rinsed with deionized or R.O. (Reverse Osmosis) water within 15 minutes after application of METALOK™ 230S.

### DRYING

- The substrate must be completely dry and free from water before an Axalta epoxy primer is applied. METALOK™ 230S dries quickly, approximately the same speed as water. It can be forced dried with ambient or hot air.

### ADDITIONAL COMMENTS

#### DO's:

- Mix and store METALOK™ 230S in plastic containers only.
- Allow at least a 15-minute induction time after mixing METALOK™ 230S with water before application.
- Sand if you desire. Follow the recommended cleaning procedures. A properly cleaned substrate will allow METALOK™ 230S to uniformly "sheet" off the substrate. Areas of the substrate not properly cleaned will run off the substrate in a non-uniform pattern.
- Wipe, spray or dip substrate in METALOK™ 230S solution.
- Rinse off METALOK™ 230S within 15 minutes of application. Use deionized water or water that has been analysed and approved for use.
- If METALOK™ 230S solution is going to drain, contact your local waste water treatment facility to check BOD and COD limits prior to disposing.
- Prime within 48 hours after application. Sooner is desirable, so that airborne contaminants do not contaminate the substrate. Wiping with a clean tack rag prior to priming is recommended.
- It is highly recommended that a panel testing program is conducted prior to startup with this product. Panels prepared, primed and painted on line will be tested for humidity and salt spray adhesion. The purpose of this test is to ensure that the intended preparatory system is adequate to provide good adhesion.

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### ADDITIONAL COMMENTS CONT.

#### **DON'Ts:**

- Allow to dry without rinsing with deionized or approved water.
- Sand after application of METALOK™ 230S.
- Use tap water to mix or rinse without analysis.
- Prime after 48 hours of METALOK™ 230S application. Within 24 hours is recommended the same day is preferred.
- Discharge water without proper notification to your local waste water treatment facility.
- Store treated substrates outside after application of METALOK™ 230S.
- Use METALOK™ 230S/water mixture that is older than one month.

### SAFETY AND HANDLING

- For safety directions please refer Safety Data Sheet for each product.
- VOC: 385g/L as packaged. The ready-to-spray VOC is extremely low when mixed 2% with water.

Axalta Coating Systems is committed to helping you develop and maintain a safe working environment. Carefully read the specific warnings and precautions printed on the labels of all Axalta products before handling or using. Refer to Safety Data Sheets (SDS) for all products used. These products are for industrial use by trained professionals only.

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