



Metalok[®] 235S[™] Pretreatment



GENERAL

DESCRIPTION

A two-component, non-sanding, 3.5 lb/gal (420 g/l) VOC, non-sanding, chrome free pretreatment formulated to provide maximum adhesion and excellent corrosion resistance.

SUGGESTED USES

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

NOT RECOMMENDED FOR

Immersion service

COMPATIBLE COATINGS

Compatible with all Axalta Transportation primer and sealer systems

DRY FILM CHARACTERISTICS

Chemical resistance	EXCELLENT
Weatherability	VERY GOOD
Humidity resistance	EXCELLENT
Flexibility, impact and chip resistance	VERY GOOD
Durability	VERY GOOD

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



MIXING

COMPONENTS

Thoroughly mix prior to activation. The use of a Cyclone[®] shaker is recommended. Combine components and mix thoroughly. Filter material prior to spray application.

Component	Volume
Metalok [®] 235S [™] Pretreatment	4
Metalok [®] 236S [™] Activator	1

INITIAL APPLICATION VISCOSITY

9-13 seconds with Zahn #3.

POT LIFE AND INDUCTION TIME

No induction time is required. Pot life is 8 hours at 70°F (21°C)



APPLICATION

Tips for Success

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
- Gravity
- Suction Spray
- Airless Spray
- Air Assisted Airless

APPLICATION

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

APPLICATION SOLVENTS

Ready-to-spray below 3.5 lb/gal (420 g/l) VOC upon activation. Further reduction may result in greater than 3.5 lb/gal (420 g/l) VOC.

CLEANUP SOLVENTS

- 130™ Acetone
- 105™ 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

15 minutes 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)	10.51 lbs.
Weight Per Liter (component only)	1260 grams
Suggested Dry Film Thickness	0.6-0.8 mils
Gloss	Matte
Color	Yellow
Flash Point (Closed Cup)	See MSDS/SDS

RTS mixed 4:1 with:	236S
Gallon Weight pounds per gallon	9.86
Gallon Weight grams per liter	11.82
VOC AP pounds per gallon	2.1
VOC AP grams per liter	253
VOC LE pounds. per gallon	3.1
VOC LE grams per liter	375
Weight Solids	56.6%
Volume Solids	37.2%
Weight Volatiles	34.4%
Weight Water	0.1%
Volume Water	0.1%
Weight Exempt Solvents	21.7%
Volume Exempt Solvents	62.5%



Theoretical Coverage per RTS gal at 1 mil DFT 596 ft² (50.3 m²)

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.

Revised: November 2021

In the United States:
1.855.6.AXALTA
axalta.us

In Canada:
1.800.668.6945
axalta.ca

