



DuPont OEM/Fleet Finishes

TECHNICAL MANUAL

TYPE

A water reducible, organic ester mixture with 3.2 lbs/gal VOC as packaged.

DESCRIPTION

230S is a low VOC metal adhesion system designed for aluminum and other hard-to-work-with metal substrates. METALOK may eliminate conversion coating, sanding or etching, and provides outstanding adhesion. METALOK 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.

SUGGESTED USES

- Aluminum

METALOK can be used on other metal substrates such as Stainless Steel, Galvanized Steel and Cold Rolled Steel. 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 insure maximum adhesion.

COMPATIBILITY WITH OTHER PRIMERS

The following primers have been tested with METALOK and are highly recommended:

- 1220S Urethane Primer (3.5 lbs/gal VOC)
- 952S Corlar® Epoxy Primer (2.8 lbs/gal VOC)
- 934S Corlar® Waterborne Epoxy Sealer (3.5 lbs/gal VOC)

Note: Primer should be applied within 48 hours after application of METALOK. The substrate should be stored indoors.

COMPATIBILITY WITH OTHER TOPCOATS

The following topcoats have been tested with the METALOK system and are highly recommended:

- Imron® 6000 Basecoat/Clearcoat
- Imron® 5000
- Centari® 5000

VOC CONTENT

- 3.2 lbs/gal as packaged.
- The ready-to-spray VOC is extremely low when mixed 2% with water.

ACTIVATION

- Mix 2% by volume with deionized water and stir the mixture before using.

INDUCTION TIME

- Allow a 15-minute induction time.

POT LIFE

- 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.)

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. The following types of products have proven to be effective:
 - Metal Conditioner 225S
 - AQAPREP (Parker-Amchem)
 - ALSTEAM (Chemcoa)

APPLICATION

- METALOK 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. water within 15 minutes after application of METALOK.

DRY TIME

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

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.

ADDITIONAL COMMENTS

DO'S

- Mix and store METALOK in plastic containers only.
- Allow at least a 15-minute induction time after mixing 230S with water before application.
- Sand if you desire. Follow the recommended cleaning procedures. A properly cleaned substrate will allow 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 solution.
- Rinse off METALOK within 15 minutes of application. Use deionized water or water that has been analyzed and approve for use.
- If METALOK solution is going to drain, contact your local waste water treatment to check BOD and COD limits. Do this 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 insure that the intended prep system is adequate to provide good adhesion.

DON'TS

- Allow to dry without rinsing with deionized or approved water.
- Sand after application of METALOK.
- Use tap water to mix or rinse without analysis.
- Prime after 48 hours of METALOK application. Within 24 hours is recommended the same day is preferred.
- Discharge water without proper notification to your local waste water treatment facility.
- Store substrate outside after application of METALOK.
- Do not use METALOK/water mixture that is older than one month.

FOR VOC REGULATED AREAS

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

SAFETY AND HANDLING

DuPont 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 DuPont products before handling or using. These products are for industrial use by trained professional painters only.

