

# Axalta 13238S™ Epoxy Pre-Treatment



## GENERAL

### DESCRIPTION

A strontium-chromate based epoxy pre-treatment designed to provide adhesion and corrosion resistance for aluminum, aluminum alloy, and metal substrates.

### RECOMMENDED USES

13238S™ is recommended for use as a metal pre-treatment/conversion coating in lieu of a chromic-acid conversion coating. It is compatible with most epoxy primers and is recommended for use with Corlar® 13550S™ or 13580S™ as part of a complete pre-treatment and primer system.

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



## MIXING

### COMPONENTS

13238S™ Epoxy Pre-Treatment  
13138S™ Pre-Treatment Activator

### MIX RATIO

Thoroughly mix 13238S prior to activation. Filter activated material prior to spray application.

### Component

### Parts by Volume

13238S™ Epoxy Pre-Treatment	1
13138S™ Pre-Treatment Activator	1

### VISCOSITY

9-11 seconds in a Zahn #3 cup @ 21°C.

### INDUCTION TIME

No induction time is required.

### POT LIFE

8 hours at 21°C.

### ADDITIVES

None recommended.



## APPLICATION

### ENVIRONMENTAL CONDITIONS

Substrate and ambient temperature must be between 10°C and 45°C. The substrate must be at least 3°C above the dew point. Relative humidity should be below 90%.

### SUBSTRATES AND SURFACE PREPARATION

- Substrate must be properly prepared for application. As a minimum, aluminum surfaces should be scrubbed/scuffed with Scotch-Brite™ 7447 pads (or coarser) using an alkaline aviation cleaner.
- Work area should be kept wet and rinsed with clean water, not allowing detergent to dry on the clean surface. Surface must be “water break free”, meaning water sheets out



completely over the metal surface. Any beading up or breaks indicate surface contamination where cleaning must be repeated.

- Surface must be dry prior to application of 13238S™.

**GUN SETUP**

13238S™ can be applied with conventional, HVLP, and electrostatic spray equipment using pressure or gravity fluid delivery.

**Conventional Fluid Tip**

Pressure Pot	1.2 mm-1.5 mm
Gravity Feed	1.3 mm-1.6 mm

**HVLP**

Pressure Pot	1.0 mm-1.4 mm
Gravity Feed	1.2 mm-1.5 mm

**FLUID DELIVERY**

Conventional	240-300mL/min
HVLP	240-300 mL/min

**AIR PRESSURE**

Conventional	3.4-4.1 bar
HVLP	1.7-2.1 bar

**APPLICATION**

Apply using a single medium-wet coat to achieve 15-20 µm dry film thickness (approximately 40-60 µm wet).

**CLEANUP SOLVENT**

Duxone® Gun Wash Solvent



**DRY TIMES**

**AIR DRY AT21°C**

Dry to Touch	10 minutes
Dry to Prime	30 minutes

**FORCE DRY AT55°C**

Flash Before Force Dry	10 minutes
Dry to Prime	15 minutes

**RECOAT**

Recoat window is 48 hours for 13238S™ which has been air dried.



**PHYSICAL PROPERTIES**

**VOC**

	Less Exempts (LE)	As Packaged (AP)
13238S™	456 g/L	456 g/L
Ready-to-Spray 13238S™	600 g/L	600 g/L

**FACTORY-PACKAGED PRIMER**

Colour	Yellow-Green
Closed Cup Flash Point	7°C - 23°C
Shelf Life	2 years (Unopened at 10°-45°C)

**READY-TO-SPRAY**

Theoretical Coverage	10.6 m <sup>2</sup> at 20 µm dry film thickness
Weight Solids	46%
Volume Solids	27%
Specific Gravity	1.10 g/mL



#### DRY FILM

Gloss	Satin
Recommended Film Thickness	15-20 µm

#### COATING PERFORMANCE

Corrosion Resistance	Very Good
Adhesion	Excellent
Chemical and Solvent Resistance	Very Good
Humidity Resistance	Excellent
Flexibility	Very Good

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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 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 an approved air purifying respirator with particulate filters, complying with AS/ANZ 1716:2012 and gloves.