



# DuPont OEM/Fleet Finishes

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## TECHNICAL MANUAL

METALOK®-CVP 235S™ 3.5 VOC

NON-SANDING EPOXY PRETREATMENT

### TYPE

Non-sanding pretreatment

### DESCRIPTION

MetaLok®-CVP 235S™ 3.5 VOC is a non-sanding epoxy pretreatment especially formulated for maximum adhesion and corrosion resistance.

### SUGGESTED USES

- As a pretreatment coating, to provide outstanding anti-corrosive and adhesion properties on aluminum and metal substrates. Also provides excellent adhesion on fiberglass.

### NOT RECOMMENDED FOR

- Immersion service

### COMPATIBILITY WITH OTHER COATINGS

- Compatible with all DuPont OEM/Fleet Primer/Sealer systems

### DRY FILM CHARACTERISTICS

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

### MAXIMUM SERVICE TEMPERATURE

- 200°F (93°C) in continuous or intermittent service

### VOLUME SOLIDS

- 42.36% unactivated
- 33.75% RTS mixed 3:1 with MetaLok®-CVP 236S™ Activator

### WEIGHT SOLIDS

- 62.87% unactivated
- 52.93% RTS mixed 3:1 with MetaLok®-CVP 236S™

### WEIGHT PER GALLON

- 10.73 lbs/gal unactivated

### SUGGESTED FILM THICKNESS

- 0.6-0.8 mils dry film thickness as pretreatment coating

### THEORETICAL COVERAGE PER GALLON

- 541 sq. ft./gal @1mil DFT mixed 3:1 with MetaLok®-CVP 236S™

### GLOSS

- Matte

### COLOR

- Yellow

### FLASH POINT (CLOSED CUP)

- 55°F (13°C)

### SHELF LIFE

- 12 months minimum

### APPLICATION SOLVENTS

- None required

### CLEANUP SOLVENTS

- DuPont 3602S™ Thinner

### ACTIVATION (MIX RATIO)

- Mix three parts MetaLok®-CVP 235S™ Pretreatment with one part MetaLok®-CVP 236S™ Activator and mix thoroughly

### INDUCTION TIME

- None required

### POT LIFE

- 8 hrs at 70°F (21°C)

**ADDITIONAL COMMENTS**

- Allow 30 minutes flash prior to applying primer.
- This product is Rule 66 compliant.
- MetaLok®-CVP 235S™ 3.5 VOC is a non-sanding pretreatment. However, if left to dry for 48 hours or more, sanding is required. 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**

- Mechanically agitate 3.5 VOC MetaLok®-CVP 235S™ Pretreatment component thoroughly prior to use.
- Mix three parts MetaLok®-CVP 235S™ Pretreatment with one part MetaLok®-CVP 236S™ Activator and mix thoroughly.
- 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.
- Product when mixed should be approximately 9 – 13 seconds in a Zahn #3 cup.

**CURE TIME AT RECOMMENDED THICKNESS – 77°F (25°C) & 50% RH**

- Dry to touch 10 min
  - Dry to prime 30 min
- Product may be force dried for 15 minutes @ 140°F (60°C).  
Allow 10 minute flash before bake.

**APPLICATION EQUIPMENT**

- Pressure Pot (recommended) 1.1-1.4 tip
- Airless Spray
- Air Assisted Airless
- Gravity 1.1- 1.4 tip
- Suction Spray 1.4 tip
- HVLP 1.4 tip

**ENVIRONMENTAL**

| VOC content (lbs/gal)          | <u>LE</u> | <u>AP</u> |
|--------------------------------|-----------|-----------|
| MetaLok®-CVP 235S™ unactivated | 2.2       | 1.4       |
| Mixed 3:1 w/MetaLok®-CVP 236S™ | 3.5       | 2.4       |

**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.

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