



p.o. box: 27907 Houston, TX USA 77227.7907
phone: 800.319.8802 / 713.266.9339
fax: 800.728.8861 / 713.266.1022
email: info@holdtight.com

Product Data

Description

HoldTight® 102 is an additive that prevents flash rusting of wet abrasive- and water-blasted iron and steel surfaces and of dry-blasted surfaces in a pressurized wash down. It also removes chlorides and other salts and contaminants very effectively. It is approved by most major coating suppliers for use with most coatings: contact HoldTight Solutions Inc., for details and references.

Principal Characteristics

Soluble in water — Non-hazardous — Biodegradable — Phosphate free — Non-flammable. With no rain, temperature above 40°F, rusting will be prevented for about 48 hours, often longer — Raises pH of blasting water to help compensate for acidic sand — Colorless — Leaves no residue — Surface salts, including chlorides, undetectable after use — Product chemistry approved by the FDA for food grade service under 21 Code of Federal Regulations 178.3400.

Basic Data

Mass Density Approximately 62.43 lb/cu.ft. (1g/cm³) — Minimum Time before coating Priming should be done as soon as possible, before flash rust appears and after the surface is dry. Some primers can be applied even when the surface is still damp, provided it is free from visible droplets or running water, but a dry substrate is always preferred. — Typical Time before coating (“the window”) 48 hours, or longer with favorable weather conditions — no rain, temperature above 40°F — Shelf Life 1 year stored in cool & dry place. Do not store below 24°F to avoid freezing.

Instructions for Use

HoldTight® 102 is typically used in both blast water and wash down water. (See note on water below.) It is diluted with water 50 to 250 to one, depending on the application, humidity, and level of surface contamination. It is rarely necessary to dilute it less than 50 to one and frequently possible to dilute it much more. (See: “Getting the Most Out of HoldTight® 102” and “FAQ1: mix ratios”). In some cases it may be used only in the wash down: after ultra high pressure (UHP) water blasting or after dry blasting. (See our separate document on UHP water jetting.) UHP users should always consult their equipment manufacturer concerning the use of HoldTight® 102 or any other additives in their equipment.

In high humidity environments with highly contaminated substrates (e.g., steel plate used in ocean service or exposed to “dirty” air), 50 to one may be necessary for both cycles. With low humidity and a relatively clean surface, 100 to 250 to one dilution on the blast cycle and 100 to one on the wash down should be satisfactory. Until a job begins, assume an average of 100 to one for all the water you plan to use. If testing various dilutions of HoldTight® 102 is not practical, 50 to one is the “fail safe” dilution for both cycles. In wash downs: always use HoldTight® 102; never dilute more than 100 to one (more for some UHP uses); and use HoldTight® 102-treated water at 1-3 gpm (3.8-11.4 Lpm), at no less than 500 psi (34 bars).

NOTE: Water that contains a high concentration of salts, carbonates and bicarbonates (i.e., “hard water”), or other contaminants may interfere with the performance of HoldTight® 102. Hard water may also be a problem for some equipment. Consult the manufacturer. Industrial or plant water is often a problem, so should be avoided. In a few areas, even potable (“drinking”) water may also be a problem. In most cases “bad” water can be corrected easily and inexpensively. Call our technical service staff if you have any concerns or questions about water.



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If you follow these instructions and HoldTight® 102 is not working as you expect, it is probable that you have a water problem: Call our staff immediately.

To avoid "pooling" of inhibitor-treated water, for example on flat areas, excess water should be blown away with oil-free compressed air.

Though you will usually have a 48-hour or larger window, it is good practice to prime as soon as possible after the surface is dry and before flash rust appears.

Safety Precautions

Wear eye protection when handling this or similar products. In case inhibitor gets into eyes, flush with water for 5-10 minutes. See a doctor if irritation persists. Inhalation of vapor of undiluted inhibitor may be harmful to some individuals.

This information is, to the best of our knowledge, correct at the date of printing. Always consults HoldTight Solutions Inc., for the latest changes. Since conditions of application and service, including equipment used, are beyond our control, we accept no liability on the basis of the information and suggestions here or elsewhere.