



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

Coverage and HoldTight® 102

Since HoldTight® 102 is not a coating, but a cleaner, it cannot be “applied” or painted like the products titled “rust inhibitors” on the market. It does not cover the surface with a film. However, there is still a way to calculate how much 102 to purchase in order to clean the entire surface to be coated.

To determine how much HoldTight® 102 will be required for a given project, take the following steps:

1. Ask yourself: **How much water** will I use when I blast and/or pressure wash a specific area, given:
 - the equipment I am using – specifically, **water consumption in a given amount of time** (typically, 1-3 gallons per minute)
 - the project size – specifically, **total surface area** to be covered in a given amount of time (square feet; amount varies)
 - the **production rate** – specifically, surface area to be covered in a given amount of time (typically, 500-1000 square feet per hour)
2. Once you know the amount of water you will use, divide this amount by the “water” amount of the appropriate dilution ratio (water to HoldTight® 102) based on the type of blasting. Please note that **adjusting** the water pressure (psi) or dilution rate for unique circumstances can lead to a successful HoldTight® 102 job.

- Wet Abrasive Blasting

Application	Dilution Ratio
Blast Cycle - Normal	50:1 to 100:1
Wash Down Cycle - Normal	50:1 to 100:1
Degreasing During Wash Down Cycle - Heavy to Light Deposits	25:1 to 50:1

- Ultra High Pressure (UHP) Water Jetting

Application	Dilution Ratio
Jetting Cycle - preferred for best results (only if the Pump Manufacturer approves using HoldTight in the jetting water)	50:1 to 200:1
Wash Down Cycle - (if HoldTight® 102 not used in Jetting cycle) - >500 Psi/34 Bar - 8 L/min (2 gal/min)	50:1 to 100:1

- Wet Abrasive Blasting

Application	Dilution Ratio
Wash Down Cycle after Dry Blasting - 1500 Psi / 102 Bar (Recommended)	50:1 to 100:1
Pressure Washing - Prior To Re-Coating Decks and Bulkheads	50:1 to 100:1
Hydrotest Water For Pressure Vessels	50:1 to 100:1



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Other Things to Keep in Mind

- In general, the more contaminated the substrate, the higher the concentration of HoldTight® 102 must be used. Except in special cases (degreasing and/or high contaminant levels), do not concentrate more than 50 to one, but allow more time for 102 to evaporate. NEVER concentrate more than 25 to one to avoid any possibility that 102 will remain on the surface before painting.
- **102**-treated water applied at flow rates of less than 1 gpm under less than 500 psi at the surface is not sufficient to remove all abrasive dust, shattered corrosion products, and tiny paint particles.
- Washing down with an on-board wash down cycle on certain **water and vapor blast systems** can be sufficient at 100-150 psi. If the surface is very contaminated and/or deeply pitted these low pressure (100-150 psi) wash downs will not be sufficient to remove all contaminants and prevent flash rust. On less problematic surfaces they will often result in shorter periods of no flash rust UNLESS the washing is done slowly to increase the amount of 102-treated water doing the washing. Only larger projects, using a separate pressure washer with at least 500 psi of pressure (preferably 1500 psi or above) will be much more effective and efficient.
- The **recommended pressure and flow rate** for 102-treated water is: **at least 500 psi at 1-3 gpm**. In most cases, 2 gpm. at 1,500 ps., or higher, will achieve the best results.
- At these recommended flow rates and pressures, operator productivity is simply not a critical factor. A slow-moving operator of blast equipment will use more HoldTight® 102, and a quick moving operator will use less, but **both** will achieve **the same clean result**.
- Operators tend to clean or blast 500 to 1,000 square feet per hour.
- If the water does not contain **HoldTight®102** in the recommended ratio, the surfaces **will flash rust**.
- If the water is extremely hard, the surfaces might flash rust, even with 102 or any other additive. In such cases, **pre-treating the water** and/or increasing the 102-to-water ratio will be necessary.
- When using UHP water jetting equipment, **check with equipment manufacturer** about using additive in water. Also ask about type of water recommended to be used (i.e. potable, deionized, etc.)