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HoldTight®102 Application Guide

This document is to be used in conjunction with the **HoldTight® 102** Product Data Sheet and Safety Data Sheet for proper usage of this additive to help remove all soluble salts and contaminants and prevent flash rusting.

Water Recommendation: Potable water is recommended while plant water or well water are not. Hard water (high concentration of carbonates) should also be avoided. This is the case for all types of blasting where water is included and specifically for each type listed below. (For more information see our Water Specification Sheet.) Please contact a HoldTight® representative with any questions.

Dry Abrasive Blasting: **HoldTight® 102**, properly diluted, is used in the wash down water through a pressure washer immediately after the dry blast. The pressure wash should cover all surfaces typically at a dilution rate of 50-250:1 of water to **HoldTight® 102** most often 50:1. Dilution rate depends on method of application, humidity and degree of cleanliness. Should the humidity be low or substrates relatively free of contaminants, a dilution rate of 100:1 is recommended. Typically, application is at 1-3 gpm (3.8-11.4 Lpm) and at no less than 500 psi (34 bars).

Avoid “pooling” of **HoldTight® 102** treated water on flat surfaces during any type of application by blow drying with oil-free compressed air. Pooling may result in staining that many inspectors will reject or that may be out of compliance with the specification.

Wet Abrasive Blasting using a water ring or WIN® nozzle: **HoldTight® 102** should be added to the blast water typically at a 100:1 dilution rate of water to **HoldTight® 102**. Should the humidity be high or substrates highly contaminated, a dilution rate of 50:1 is recommended.

Vapor/Wet Abrasive Blasting: **HoldTight® 102** should be added to the blast water typically at a 100:1 dilution rate of water to **HoldTight® 102**. Should the humidity be high or substrates highly contaminated, a dilution rate of 50:1 is recommended. The blast water typically is then added to the blast pot as directed by the blast equipment manufacturer.

Ultra High Pressure Blasting (UHP): **HoldTight® 102** should be added to the blast water typically at a 100:1 dilution rate of water to **HoldTight® 102**. Should the humidity be high or substrates highly contaminated, a dilution rate of 50:1 is recommended. **Note:** Please contact UHP equipment manufacturer to determine if **HoldTight® 102** or any additive can be used in their equipment. If an additive is not recommended in the UHP equipment, then pressure wash as directed in the [Dry Abrasive Blasting](#) section above. Users of UHP equipment have reported good results with no equipment issues when De-ionized (“DI” or de-mineralized) water is used.

Wash Down after blasting: It is recommended that after any of the above blast procedures to wash down the blasted area with **HoldTight® 102** diluted water (100:1) without abrasive to remove residue from the blast. A separate pressure washer is recommended at 500 psi or above for speed and efficiency, though lower pressures are acceptable if the washing action is slow and thorough.

Degreasing: For typical degreasing applications, dilute wash water at a 50:1 water to **HoldTight® 102** using a pressure washer. Should contamination be heavy, 25:1 dilution rate is recommended. The dwell time can also be increased while slowly washing the surface to remove heavy grease deposits.

When to Prime: Typically there will be a 48 hour or longer rust-free window, however it is good practice to prime the surface as soon as practical after the surface is dry and before flash rust appears.