

PRODUCT DESCRIPTION

Non-toxic soluble salt and flash rust remover, field applied pickling agent

INTENDED USES

HoldTight® SP8 Gel is a revolutionary two step surface decontamination process, comprised of two products (HoldTight® SP8 Gel and HoldTight® SP8 Rinse) that clean at the microscopic level to remove surface contaminants including, but not limited to:

- ▶ **Water-Soluble Contaminants**
 - ▶ Chlorides
 - ▶ Sulfates
 - ▶ Nitrates
- ▶ **Non Water-Soluble Contaminants**
 - ▶ Sulfides
 - ▶ Flash rust
 - ▶ Blast Media

HoldTight® SP8 Gel process can be used after surface preparation and prior to protective coating applications. The process is for use wherever a protective coating will be applied to a metal substrate and extended coating surface life is desired.

Coatings applied over the HoldTight® SP8 Gel cleaned process can significantly outperform coatings applied over substrates prepared by conventional surface preparation standards.

HoldTight® SP8 Gel is “coating-neutral.” It is not a film-former and does not leave any residue on the substrate. It can be used with any coating system and can be used before and after welding. HoldTight® SP8 Gel improves weld strength by removing contaminants that negatively affect puddling and weld porosity and can clean weld flame residue and other surface contaminations after welds have cooled.

Physical Data

HoldTight® SP8 Gel is supplied as a gel and packaged in a 5-Gallon pail.

Color

Clear / White Gel. Product may appear white in color due to the air being inducted during the mixing process. This is normal.

Typical WFT

12 to 16 mils wet film thickness

Theoretical WFT

133 sq. ft / US gallon at 12 mils WFT and 100 sq. ft. / US gallon at 16 mils WFT. Allow for normal loss factors during mixing, handling and application when estimating practical coverage.

Mix Ratio

Each 5-Gallon pail of HoldTight® SP8 Gel contains 5 gallons of gel.

Mixing

Use a drill with clean mixing head to stir at low to medium speed. After mixing, clean the mixing shaft and blade with clean water, or rinse with HoldTight® SP8 Rinse. *Always ensure the mixing blade is clean prior to each usage.*

Working Pot Life 12-24 hours at 85° F. or as long as HoldTight® SP8 Gel material remains gelled. Mix only as much HoldTight® SP8 Gel as required for one day's project application.

Equipment HoldTight® SP8 Gel may be applied by brush, roller, airless or conventional spray, using clean equipment suitable for mild acid product. If spray equipment, hoses and gun have been used previously for applying paint, flush with strong solvent, then with potable water. When possible, use new or dedicated fluid hose. For airless spray, use the minimum pressure required to produce a working fan; tip sizes may range from .021 to .031, depending on size and complexity of surfaces to be coated. Fan sizes are dependent upon the contractor and the project. For conventional spray, use a plastic pot liner whenever possible. Use a gun, needle and tip combination suitable to properly atomize the gel. Use a sufficient pot pressure and atomization pressure to produce a uniform fan.

Surface Preparation All surfaces to be treated with HoldTight® SP8 Gel should be clean, dry and free from interference materials. HoldTight® SP8 Gel will work over any surface profile although higher profiles will require more product per square foot.

Prior to applying HoldTight® SP8 Gel to substrates:

1. Oil, grease, and other contaminants must be removed from the substrate surface in accordance with SSPC-SP1 solvent cleaning standards.
2. Substrates to be treated with HoldTight® SP8 Gel should be prepared by means of mechanical abrasion cleaning, abrasive blasting, vapor abrasive blasting or ultra-high-pressure-water blasting to remove all visible interference materials. The minimum requirement for abrasive blasted surfaces is SSPC-SP6, NACE 3, or a Sa 2.5. The cleanliness standards for any project are to be determined by the owner.

Note: *HoldTight® SP8 Gel may be applied before or after flash rusting of the steel following the blasting process.*

Application	HoldTight® SP8 Gel should be applied and rinsed from top to bottom. The preferred method to apply the gel is by airless or conventional spray. The gel may be applied by brush or medium nap paint roller, however, care must be taken to ensure that the required minimum wet film thickness is consistently achieved. If the gel has dried on the surface, and does not rinse off, it is possible to quickly put more gel on the area, let sit for ten minutes and rinse off with the HoldTight® SP8 Rinse. For typical applications, apply 12 to 16 mils of HoldTight® SP8 Gel. Use a wet film thickness gauge to check proper application. Do not apply to excessive thicknesses due to possibility of sagging. Brush or roller application may be used for small areas or where spray application is not allowed. Use rollers and brushes suitable for waterborne paint application. Be careful to maintain the recommended wet film thickness. HoldTight® SP8 Gel may be applied after flash rusting occurs caused by wet abrasive blasting. This method allows the applicator to blast a complete area without the need to paint out on the same day.
Dwell Time	“Dwell Time” is the length of time required after application for HoldTight® SP8 Gel to clean and passivate the surface. Minimum Dwell Time at 70° F. (21° C.) is approximately 1/2 hour. Additional dwell time may be required and is recommended for badly contaminated surfaces, or for very deep anchor profiles. Chlor*Rid™ SP8 should not be allowed to completely dry on surfaces. Application to hot substrates may dry in less than ½ hour. Use extra precaution to prevent this from occurring. In the event this does occur simply wash the gel off the substrate and apply another coat. Washing: To complete the process, HoldTight® SP8 Gel must be pressure washed off prepared surfaces, using property mixed HoldTight® SP8 Rinse. Optimal rinsing pressure should be 3500 psi with nozzle 4 inches from the surface. Turbo nozzles that clean the substrate evenly, without leaving circular marks, work excellent. Do not wash surfaces prepared with HoldTight® SP8 Gel with tap water. Only use HoldTight® SP8 Rinse preferably prepared with deionized water or clean filtered water. Do not coat surfaces prepared with HoldTight® SP8 Gel which have not been properly washed with the HoldTight® SP8 Rinse.
Clean Up	Thoroughly flush all equipment with clean water and store according to the manufacturer’s recommendation. Dispose of cleanup waste in accordance with all local ordinances.
