HOLDTIGHT
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HT 365®
Application Guide

Spray Application

- Application should be conducted in a cool, well ventilated area away from sources of ignition or heat sources and applied while wearing proper PPE. Please refer to product SDS, Product Data Sheet and product label for additional information.
- Verify that HT 365® is in its original liquid state and viscosity is a free-flowing liquid. Make sure that the coating is in full suspension by stirring or shaking container and observe consistent color throughout coating.
- Surface preparation of the item to be coated is not required, but will improve functionality of the coating. Suggested methods of surface preparation can range from solvent wiping, machining surfaces to blasting. At a minimum, it is recommended that loose corrosion or mill scale that is not tightly adhered be removed by wire brushing. In addition, removal of corrosion and surface contaminants (such as chlorides) will improve the effectiveness and protection provided by the HT 365®.
- If able, attempt to suspend the piece to be protected on wire or other device to completely coat all surfaces. If not able to suspend, position item in most convenient location to effectively apply coating to all surfaces to be protected.
- Spray area should be in an area where cross drafts are minimized as best as possible to prevent overspray and loss of coating. Spray application should be done in a manner to contain all overspray to prevent environmental contamination.
- Spray equipment can range from simple garden style pump spray units to commercial hand held, electric spray guns. For large industrial applications, conventional or airless spray equipment can be used. Please consult with manufacturer for further information with this type of application.
- Spray the piece in such a way to achieve complete coverage and a uniform thin film of desired thickness.
- Check for complete coverage. Typically, coating will be cured (still oily, but solvent will have flashed) within 5 minutes.
- After inspection, store item or ready it for shipping and begin the process again for next piece.
- Once spray coating activity is completed, completely seal coating container to reduce solvent emission and preserve the HT 365®. IT IS IMPORTANT TO MINIMIZE AND PREVENT IF POSSIBLE ANY WATER FROM ENTERING THE HT 365® CONTAINER. INTRODUCTION OF WATER WILL CAUSE THE PRODUCT TO GEL, THUS LOOSING ITS EFFECTIVENESS.
- Storage of HT 365® after usage is best maintained indoors in a cool, well ventilated area away from heat sources.

Brush Application

- Application should be conducted in a cool, well ventilated area away from sources of ignition or heat sources and applied while wearing proper PPE. Please refer to product SDS, Product Data Sheet and product label for additional information.
- Verify that HT 365® is in its original liquid state and viscosity is a free-flowing liquid. Make sure that the HT 365® coating is in full suspension by stirring or shaking container and observe consistent color throughout coating.
- Surface preparation of the item to be coated is not required, but will improve functionality of the coating. Suggested methods of surface preparation can range from solvent wiping, machining surfaces to blasting. At a minimum, it is recommended that loose corrosion or mill scale that is not tightly adhered be removed by wire brushing. In addition, removal of corrosion and surface contaminants (such as chlorides) will improve the effectiveness and protection provided by HT 365®.
- If desired, attempt to suspend the piece to be protected on wire or other device to completely coat all surfaces. If not suitable to suspend, position piece in such a way to be able to brush coat all surfaces desired to be protected.
- Area where coating to occur should have minimal cross drafts to prevent contamination of applied coating before curing. Containment should be provided where brush application is to be done to contain all coating loss and prevent environmental contamination.
- Brush the piece with a nylon/polyester or natural bristle brush. Do in such a way to completely cover the item with a consistent, even film of coating on all surfaces to be protected. Check for complete coverage. Typically, coating will be cured (still oily, but solvent will have flashed) within 5 minutes.
- After inspection, store item or ready it for shipping and begin the process again for next piece.
- Once brush coating activity is finished, completely seal coating container to reduce solvent emission and preserve the HT 365® product. IT IS IMPORTANT TO MINIMIZE AND PREVENT IF POSSIBLE ANY WATER FROM ENTERING THE HT 365® CONTAINER. INTRODUCTION OF WATER WILL CAUSE THE PRODUCT TO GEL, THUS LOOSING ITS EFFECTIVENESS.
- Storage of HT 365® after usage is best done indoors in a cool, well ventilated area away from heat sources.

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Dip Application

- Application should be conducted in a cool, well ventilated area away from sources of ignition or heat sources and applied while wearing proper PPE. Please refer to product SDS, Product Data Sheet and product label for additional information. Provide proper containment to prevent environmental contamination. Additionally, confirm that dipping station is properly grounded before usage.
- Prepare dipping station by ensuring that HT 365® is in full suspension by stirring and observing consistent color throughout coating.
- Verify that HT 365® is in its original liquid state and viscosity is a free-flowing liquid.
- Surface preparation of the item to be coated is not required, but will improve functionality of the coating. Suggested methods of surface preparation can range from solvent wiping, machining surfaces to blasting. At a minimum, it is recommended that loose corrosion or mill scale that is not tightly adhered be removed by wire brushing. In addition, removal of corrosion and surface contaminants (such as chlorides) will improve the effectiveness and protection provided by HT 365®.
- Attempt to suspend the piece to be protected on wire or other device to completely coat all surfaces.
- Dip the piece into the bath and allow complete coverage. Allow to remain in bath at a minimum of 5-10 seconds or long enough for all surfaces to come in contact with the HT 365®. If possible, it is recommended to gently shake piece while immersed to ensure good coverage and remove any surface bubbles.
- Raise piece out of bath and allow drip-drying to remove any excess HT 365® coating. Check for complete coverage. Coating will be cured (still oily, but solvent will have flashed) within 5 minutes.
- After inspection, store item or ready it for shipping and begin the process again for next piece.
- Once dip coating activity is completed, completely seal coating vat to reduce solvent emission and preserve the HT 365®. IT IS IMPORTANT TO MINIMIZE AND PREVENT IF POSSIBLE ANY WATER FROM ENTERING THE VAT WHILE IT CONTAINS HT 365®. INTRODUCTION OF WATER WILL CAUSE THE PRODUCT TO GEL, THUS LOOSING ITS EFFECTIVENESS.
- Storage of the vat containing HT 365® after usage is best maintained indoors in a cool, well ventilated area away from heat sources.

Aerosol Application

- Application should be conducted in a cool, well ventilated area away from sources of ignition or heat sources and applied while wearing proper PPE. Please refer to product SDS, Product Data Sheet and product label for additional information.
- Verify that HT 365® Aerosol is in its original liquid state and can be sprayed as a free-flowing liquid. Make sure that the coating is in full suspension by shaking can vigorously.
- Surface preparation of the item to be coated is not required, but will improve functionality of the coating. Suggested methods of surface preparation can range from solvent wiping, machining surfaces to blasting. At a minimum, it is recommended that loose corrosion or mill scale that is not tightly adhered be removed by wire brushing. In addition, removal of corrosion and surface contaminants (such as chlorides) will improve the effectiveness and protection provided by the HT 365® Aerosol.
- If able, attempt to suspend the piece to be protected on wire or other device to completely coat all surfaces. If not able to suspend, position item in most convenient location to effectively apply coating to all surfaces to be protected.
- Spray area should be in an area where cross drafts are minimized as best as possible to prevent overspray and loss of coating. Spray application should be done in a manner to contain all overspray to prevent environmental contamination.
- Spray the piece in such a way to achieve complete coverage and a uniform thin film of desired thickness. Typically, the HT 365® can should be approximately 6 to 12 inches from surface to be protected. This will vary depending on piecing being coated.
- Check for complete coverage. Typically, coating will be cured (still oily, but solvent will have flashed) within 5 minutes.
- After inspection, store item or ready it for shipping and begin the process again for next piece.
- Once spray coating activity is completed, completely seal coating aerosol can to reduce solvent emission and preserve the HT 365® Aerosol. IT IS IMPORTANT TO MINIMIZE AND PREVENT IF POSSIBLE ANY WATER FROM ENTERING THE HT 365® AEROSOL CONTAINER. INTRODUCTION OF WATER WILL CAUSE THE PRODUCT TO GEL, THUS LOOSING ITS EFFECTIVENESS.
- Storage of HT 365® Aerosol after usage is best maintained indoors in a cool, well ventilated area away from heat sources.

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HT 365®
Removal

Removal of HT 365®

HT 365® is easily removed. It is best removed with a thorough high-pressure water wash (1,500 psi or greater) with HoldTight® 102 at a dilution rate of 50-100:1 (water to HoldTight® 102) and a water flow rate of 1-3 gallons per minute. Completely rinse the entire area to ensure complete removal. If desired, HT 365® can also be removed by solvent wipe.

Procedure for Checking for Cleanliness after HT 365® removal

- An Ultraviolet light (365 nanometer ultraviolet [UV] light is recommended, but 300 - 400 nanometer UV light is acceptable) can be used to verify the removal of HT 365® after a thorough high-pressure water wash (1,500 psi or greater) with HoldTight® 102 at a dilution of 50-100:1 (water to HoldTight® 102) and a water flow rate of 1-3 gallons per minute. HT 365® is hydrocarbon-based and will fluoresce under UV light, thus highlighting areas that need to be cleaned again. Clean bare metal has no reaction under UV light.
- If using cleaning solvents to remove HT 365®, some hydrocarbon based cleaning solvents may leave a residue and will fluoresce under UV light, either highlighting the residual cleaning solvent or areas that were not completely cleaned. As a result, it is recommended that a high-pressure wash with HoldTight® 102 be used to remove HT 365®.
- Fluorescence may not be obvious in bright light and best seen in reduced or low light. For best results, light should meet minimum specifications for NDT testing which is 15w/cm^2 at 15 inches.