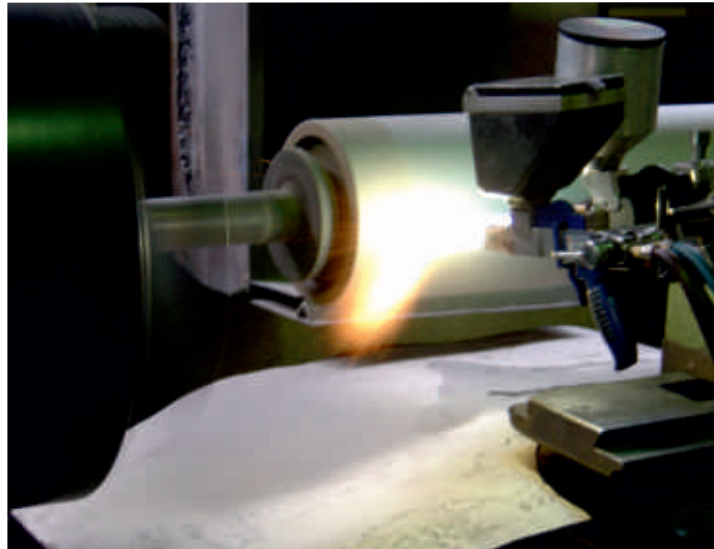


## The Capillary Sealer to Impregnate THERMAL SPRAY COATINGS

**dichtol** is the proven sealer for thermal spray coatings with outstanding product properties.



**dichtol** reliably seals cracks and finest pores. The high-performing polymers penetrate deep into the coating and protect the metallic surface against corrosion.



### Product benefits

- ◆ Deepest possible penetration
- ◆ Perform on-the-spot repairs, in-house
- ◆ Versatile application of the capillary-active sealing through
  - Dipping
  - Brushing
  - Spraying
- ◆ Increased solid contents (up to 40%)
- ◆ Transparent, invisible
- ◆ Resistant against chemical, thermal and physical loads
  - Pressure-resistance up to 600 bar (8700 psi)
  - Heat-resistance up to 500°C (932°F)
- ◆ Drinking water and food approved
- ◆ Significantly increases the machinability of the coating

### Our products

#### WFT #1532

For the reliable impregnation of micropores and hairline cracks from approx. 0 to 1/10 mm (0,004 inch) without vacuum or pressure for any kind of alloy.

#### WFT Macro #1546

For the reliable impregnation of micropores and hairline cracks from nearly 1/10 mm (0,004 inch) to 5/10 mm (0,02 inch).

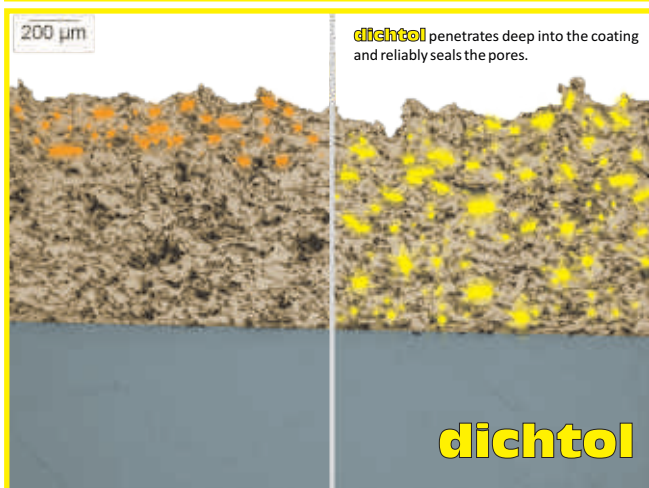
#### HTR #0977


For the reliable impregnation of micropores and hairline cracks and temperature resistant up to 500°C (932°F) continuously, also available in spray form.

Approx. 1 hour after application, **dichtol HTR** will have to be heat cured at approx. 250°C (482°F) for approx. 3 hours for full cure.

### Thinners

**dichtol** may change viscosity after a longer period of use, losing penetrating and impregnating properties. Ideal viscosity can be controlled by **dichtol Viscometer**; viscosity loss can be compensated by adding the appropriate thinner.



 www.hyg.de **dichtol** has been tested for the reliable use in contact with food and drinking water - underlining the exceptional product properties.



## The Capillary Sealer to Impregnate THERMAL SPRAY COATINGS

	WFT FL #1532	WFT Macro FL #1546	HTR FL #0977
<b>Application Data</b>			
dipping	X	X	X
brushing	X	X	X
filling	X	X	X
spray can	X	-	-
spraying chamber	X	-	X
<b>Surface Drying</b> [approx. time in min.]	1	3	-
<b>Surface Layer Thickness</b> [µm (inch)]	3 (0,0001)	10 (0,0004)	4 (0,0002)
<b>Cure Time at 20°C</b> [hours] (load)	light (full)	light (full)	1 hour after dipping anneal at 250°C for 3 hours
up to 5 mm (0,2 inch) wall thickness	4 (24)	6 (24)	
5 - 10 mm (0,2 - 0,4 inch)	8 (24)	10 (24)	
10 - 15 mm (0,4 - 0,6 inch)	13 (48)	15 (48)	
> 15 mm (0,6 inch)	24 (48)	24 (48)	
<b>Technical Data</b>			
Porosity sizes [mm (inch)]	-1/10 (-0,004)	1/10 - 5/10 (0,004 - 0,02)	-1/10 (0,004)
Continuous temp. load [°C (°F)]	-170 / +250 (-274 / +482)	-170 / +250 (-274 / +482)	-170 / +500 (-274 / +932)
Max. short term temp. load [°C (°F)]	-170 / +450 (-274 / +842)	-170 / +350 (-274 / +662)	-170 / +650 (-274 / +1202)
Compressive strength [bar (psi)]	~600 (8700)	~600 (8700)	~600 (8700)
Viscosity at 20°C (68°F) approx. 4mm (0,16 inch) nozzle	14-16 sec.	20-22 sec.	12-14 sec.
dichtol - 1 ltr, 5 ltr, 10 ltr and 200 ltr	X	X	X
Thinner - 0,5 ltr and 1 ltr	X	-	X

All material values are average values and vary due to mixing ratio, material quantity and environmental conditions. The mentioned material values are based on normal conditions (STP) of 20°C (273K / 31,73°F) and 1013mbar (1013hPa).

### Preparation

Areas to be impregnated must be clean and dry (surface cleaned mechanically and chemically, then heat treated to remove all remaining materials inside the pores so **dichtol** can penetrate area).

### Application

Applicable by  
 - dipping into **dichtol** (e. g. in a container with a tight cover) for 30 minutes  
 - brushing 3 to 4 times within a short period with a soft brush  
 - by spraying 3 to 4 times crosswise within a short time period.

Cures at ambient temperature for 1 hour per mm wall thickness (i.e. 8 hours cure time for 8 mm (0,3 inch) wall thickness).

### Resistant

ethyl alcohol 96%, ethyl alcohol 50%, ethyl ether, ethyl silicate, 2 ethyl hexanol, ethylene glycol, ammonia conc. 5%, gasoline, butanol, butyl glycol, n-butyl ether, carbitol, chlorine lime sol., diesel oil, diethylene glycol, dipropylene glycol, natural gas, acetic acid conc., acetic acid 10%, frigene, glycol, hexanol, heptadecanol, isopropylene techn., isopropylene ether, isopropylene alcohol, potash lye 10%, potash lye 40%, sodium chloride sol. 10%, lubricating oil, seawater, methanol, methyl amyl alcohol, methyl carbitole, lactic acid conc., lactic acid 10%, soda lye 20%, soda lye 40%, paraffin oil, phenol sol. 10%, phosphoric acid conc., hydrochloride acid 10%, oxygen, sulphuric acid conc., sulphuric acid 30%, sulphuric acid 10%, soap sud, soda lye, tetradecanole, tetra ethylene glycol, triethylene glycol, undecanole.

### Limitedly resistant

formic acid conc., formic acid 40%, benzene, carbon tetrachloride, toluene, xylene

### Non resistant

acetone, ester, cetone, methylene chloride

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**Authorized**  
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