

## ■ dichtol HTR #0977

### Product description

dichtol HTR is a specially developed, heat-resistant polymer-based impregnation system. With dichtol HTR smallest pores up to 0.1mm can be sealed. This enables a very high pressure tightness of components, even in difficult object structures. In the case of locally known leaks, punctual impregnation ensures an efficient use of materials.



### Characteristics

- Very high pressure tightness
- Resistant to corrosion and weathering
- Heat resistant up to 500°C
- Diverse application possibilities: dipping, brushing, injecting, spraying

### Typical applications

- Impregnation of metals, impregnation of castings
- Sealing of thermally sprayed coatings (sealers for APS, HVOF, LDS, flame spraying)
- Infiltration of 3D printed components, additive manufacturing, generative manufacturing

### Pack sizes

Article	Description
M04 1 litre	1 litre can with resealable HZ-closure

Custom sizes on request.

### Product data condition of delivery

Hue component A (resin)	transparent
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Storability	5 years at (5°C-+20°C)
Density	0.89 g/cm <sup>3</sup>
Viscosity	too thin
Mixing ratio	1-component product, mixing is unnecessary

### Productdata mixed

Curing Surface drying at +20°C (h) load-bearing capacity	45 minutes at 20°C
up to 5mm wall thickness	1 hour after applying, temper at +200°C for 1 h
5-10mm wall thickness	1 hour after applying, temper at +200°C for 1 h
10-15mm wall thickness	1 hour after applying, temper at +200°C for 1 h
>15mm wall thickness	1 hour after applying, temper at +200°C for 1 h
Processing temperature	+10 °C to +40 °C

### Product data (outreacted product)

Temperature resistance (permanent)	500 °C
Temperature resistance (briefly)	550 °C
color	transparent
pore size	0 - 0,1 mm

### Storage / Shelf life

Store in original, unopened container in a dry, cool and frost-free place (+5°C to +20°C). Shelf life 5 years.

## Processing / Preparation

Dirt residues, foreign bodies, grease and other substances must be completely removed from the pores to be sealed. For this purpose we recommend the use of DIAMANT Cleaner #1417.

## Application

The object temperature should not exceed 40°C, otherwise the penetration of the polymer cannot be guaranteed 100%.

## Brush & Spray

apply sealant in 4 stages at intervals of about 1 minute and keep damp on the surface for at least 5 minutes. This allows dichtol to penetrate deep into the pores.

## Inject

dichtol into the space to be sealed (e.g. blind hole, threaded hole, cooling channel, etc.) and allow to react for at least 5 minutes. Then, if necessary, vacuum/drain off excess material.

## Dipping

Dip the component to be treated completely in dichtol. Remove the component after a working time of at least 5 minutes.

## Curing

dichtol HTR must be cured for 1 hour at a temperature of 200°C for full cure.

## Disposal

Do not empty into drains or water courses. Waste and containers must be disposed of in a secure manner. Disposal according to Directive 2008/98/EC on waste and hazardous waste. Proposal list for waste codes/waste designations according to EAKV 080111\* Waste paints and varnishes containing organic solvents or other hazardous substances \*Hazardous waste according to Directive 2008/98/EC (Waste Framework Directive). Non-contaminated and empty packaging can be recycled. Containers that are not emptied properly are hazardous waste.

## Safety Data Sheet

Please read the appropriate safety data sheet before processing the product. Material Safety Data Sheets are available on a daily basis upon request via [info@diamant-polymer.de](mailto:info@diamant-polymer.de) or by phone +49-2166-98360. DIAMANT guarantees the product properties as long as they are stored and used according to the specifications listed here. DIAMANT does not assume any responsibility for the processing of the material. Our technicians will be happy to answer any further questions you may have.

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