



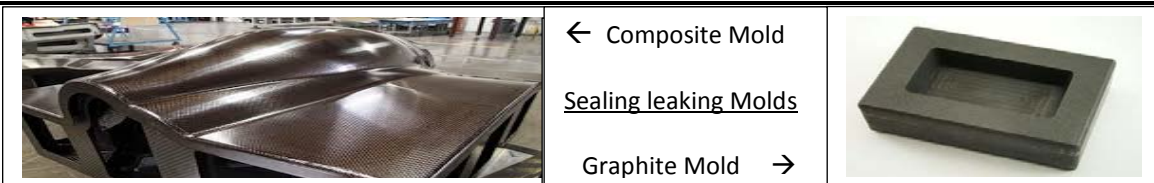
Huntington Specialty Materials

Application Guide

HS-920 Mold Tooling Sealer Coat

Nano-Ceramic Clear (wipe-on) ----- “No Free Silicones - Zero transfer”

HS-920 is a high performance • single component • wipe-on • ambient air cured product
HS-920 creates a covalent bond to the substrate giving it an intrinsic bond to the mold tool
HS-920 is an inert (benign) material containing no “Free Silicones” • No dimensional change
HS-920 soaks into the micro pores & micro-cracks sealing them permanently, from the face side
HS-920 saves expensive leaking Graphite, Composite and all types of Metal molds and tooling,
(*examples; Epoxies, BMIs, Polyimides and similar high temperature cured resin systems)

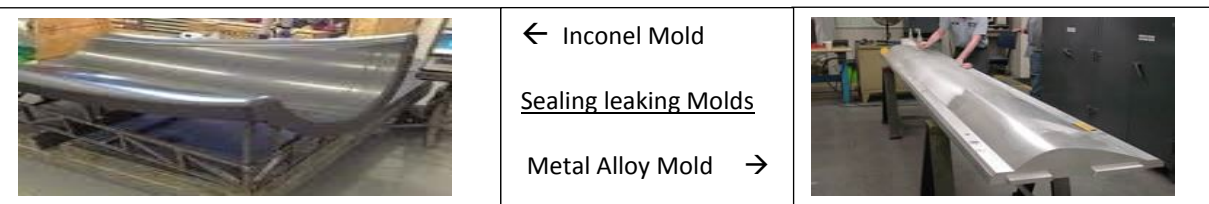


HS-920 Mold Tool Sealer was formulated for simple application & high performance results.

Note! Surfaces must be free from oils and other contaminants before starting the coating process.

Application on Metal, Graphite or Composites Molds & Tooling;

- Mix contents gently before applying to ensure that is no separation of the resin system.
- With clean dry air blow off any dust from the surfaces, preventing contaminating the coating.
- **Coating the face side of the Mold Tool:**
 - ✓ Apply a modest amount of the coating on the surface or on a lint free pad or cloth
 - ✓ In a circular motion work the release coating into the surface of the mold tool
 - ✓ Once the absorption seems to stop, gently glide the wetted applicator over the surface to ensure that there is a complete coverage with a semi-wet 2-5 micron of the coating on the entire surface of the mold tool.
 - ✓ Let the coated surface, ambient dry to a “Dry to the Touch” film, a warm 110°F/43°C (max) air flow will speed this up.
 - ✓ Allow the coated surface to cross-link for 2-3 hrs or longer, it is now ready to be heated or put into a convection oven or autoclave at (350°F - 30 min part temp) to cure further cure the resins that are within the mold tools Nano-porous face.
 - ✓ **Do not** put parts in an oven to cure – prior to the 2-3 hrs or the solvents will expand and potentially create minute pin-holes within the embedded coating during this cure.
 - ✓ **Allow the part to cool – before applying a coating of the HS-940 Release coating**



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