

Huntington Specialty Materials

Application Guide

HS-930 Mold Tool Release Coat

Nano-Ceramic Clear (wipe-on)

"No Free Silicones - Zero transfer"

HS-930 is a high performance • single component • wipe-on • ambient air cured product
HS-930 creates a covalent bond to the substrate giving it an intrinsic bond to the mold tool
HS-930 is an inert (benign) material containing no "Free Silicones"
HS-930 has excellent release properties with Gel-coat and other surface coatings



HS-930 Mold Tool Release 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 Mold Tools;

- 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 any absorption seems to stop, gently glide the wetted applicator over the surface to ensure that there is a complete coverage at 2-3 microns (dry film thickness) 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(max) air flow will speed this up.
 - ✓ Allow the coated surface to cross-link for 20 minutes or longer, it is now ready for the Gel-coat type materials to be applied.
 - ✓ HS-930V contains a UV visible tracer, to help ensure the entire surface has been treated.

General Notes: if using Vacuum infusion or similar processes --- for leaking Mold Tools use; HS-920 to seal them from the face side-with no dimensional change. Seals the micro-pores & micro-cracks with a covalent bonding high temperature Nano-Ceramic & "no free silicones"



← Composite Mold

Sealing leaking Molds

Mold- Plug →



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