

## Application Guide

### HS-940 Mold Tool Release Coat

#### Nano-Ceramic Clear (wipe-on)

“No Free Silicones - Zero transfer”

HS-940 is a high performance • single component • wipe-on • ambient air cured product  
HS-940 creates a covalent bond to the substrate giving it an intrinsic bond to the mold tool  
HS-940 is an inert (benign) material containing no “Free Silicones”  
HS-940 has excellent release properties with the all curing temperature resins\*  
(\*examples; Epoxies, BMIs, Polyimides and similar high temperature cured resin systems)



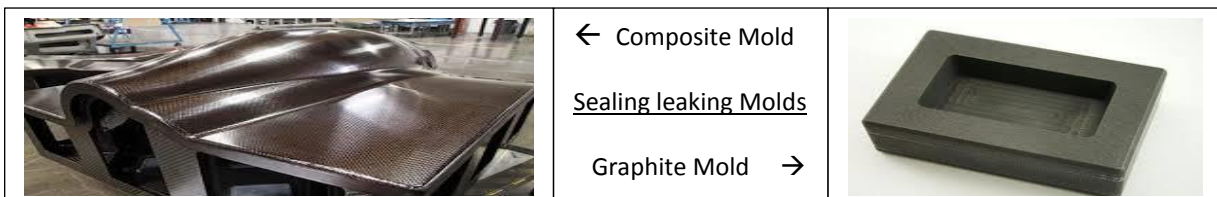
HS-940 Mold Tool Release was formulated for simple application & high performance results.

**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 lay-up of pre-preg materials or similar.
  - ✓ **Do not** put parts in an oven to cure – prior to 20 minutes or achieving the “Dry to Touch”.
  - ✓ If the mold surface is green and needs to be sealed, apply 1<sup>st</sup> coat – oven cure at 350°F for 30 minutes (part temperature) allow to cool – apply a 2<sup>nd</sup> coat per instructions above.

**General Notes: 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”**



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