Huntington Specialty Materials

Application Guide
HS-950 for Ambient & High Temperature* Use
Nano-Ceramic Adhesion Promoter

The HS-950; is a high temperature/performance, single component, ambient curable, semi-clear product that gives added adhesion, for those questionable surfaces, such as; (silicones or similar surfaces), when applying any ambient use or high temperature use Huntington Specialty Coatings.

The HS-950 was chemically designed to: create a covalent bond to substrate materials, allow for simple application methods, being applied as a thin film coating resulting in high performance properties. Even so, surface cleanliness is still of the utmost importance.

The surface should be clean, dry and free from oils and other containments.

- On metal & alloy component surfaces it is always preferred to have a light blasted profile on the surface to aid in the coatings physical bond, if it is possible to do so.
  - The HS-950 covalently bonds well to all metal types, (i.e.; aluminum, titanium, stainless, metal oxides, most plastics, etc.).
- On composite substrate surfaces it is also preferred to have a very light abraded profile on the surface to aid in the coatings physical bond, if it is possible to do so.

Slightly mix or shake the HS-950 primer contents before applying: (i.e.; by hand is acceptable)

- Same DFT applies to a wipe-on application. Wet a lint free application cloth, so that when lightly wiped over the substrate surface a very thin, 2-3 micron, film is left behind.
  - If it appears to be too thick, with the same cloth re-wipe and spread the -950 primer over a broader surface area

- If spraying, a fine spay tip (0.08) or similar is best, apply at 2 to 3 microns (dry film thickness)
- Top coat within 3 minutes of application - sooner is better (wet-on-wet is ok) – allowing the top coat to bond well.
  - Please note! (not for use with High Gloss finishes, as the HS-950 primer tends to reduce the surface gloss under certain application processes and/or environments).
- If the primer dries longer than 3 minutes before- top coating, re-apply the HS-950 as above, allowing the surface of the HS-950 to reopen-up again, to allow the top coat to bond well.

<u>The HS-950 primer</u> may be applied directly to substrate surfaces where there concerns of proper adhesion, due to potential contamination, (i.e.; silicones, hard anodizing processes, etc.)

<u>The HS-950 primer</u> may also be used over any of other cured coatings, (tightly bonded), to achieve good intra-coat adhesion, where -- coating due to damage or similar is involved.

As with any new material, always test application and finished properties on a low value test article or panel before working on valuable surfaces.

- * “High Temperature” equates to “high performance exhaust temperatures”