



Huntington Specialty Materials

Application Guide

HS-965 (single component)

Polysilazane Chromate-free Primer Coating

The HS-965 is a high performance, ambient curable and/or oven cured primer product. The HS-965 coating is designed for uses where corrosion protection is of utmost importance, regardless of environmental conditions; from extreme heat or cold or chemical attack.

HS-965 Chromate-free Primer was designed for simple application and high performance use.

Note! Surface cleanliness is of utmost importance, free from oils and other contaminants.

- It is always best to create a blast profile by a 120 grit aluminum oxide, garnet or equal, on all of the surfaces that will be coated..
- **(Do not use Glass or natural Sand as this will impede the adhesion or the coating to the surface).**
- **(Do not handle blasted parts with bare hands, as salts/acids will contaminate the surface and possibly cause a loss of adhesion in those areas once the part sees extreme heat).**
- Mix contents well before applying to ensure that no solids are in the bottom of the container.
- With clean dry air blow off any dust from the surfaces, preventing contaminating the coating.
- **Interior of tubular parts coating:**
If normal spray operations cannot be performed because of size constraints
 - ✓ Plug all of the openings at both ends of the tube shaped part
 - ✓ Remove one plug, to allow a modest amount of coating to be poured into the part.
 - ✓ Replace this plug and gently rotate the part to ensure that all surfaces are coated.
 - ✓ Now remove the plug and pour out any excess coating* into a container (*may be re-used)
 - ✓ Now hang the part so that it allows for continued draining of excess coating and ease of spraying the exterior surfaces.

➤ **Exterior coating of HS-965 Chromate-free primer:**

- ✓ **With a HLVP or similar spray gun fitted with a fine tip (i.e. 0.08);**
 - A finer spray mist is better, enabling the product to flow out easier and help control the products thickness.
- ✓ **Now start to spray all of the hardest areas to coat, first;**
 - Then start to spray the remaining areas until the entire surface is coated with an approximate dry film thickness of .5 to 1 mil.
- ✓ **It is very important not to build the coating to thick; (more is not better),**
- ✓ **As “to thick” will inhibit the coatings flexibility and adhesion during thermal cycles – it must be a thin coating to work as designed.**
- ✓ *** only re-use excess interior coating • for other interior surfaces, unless filtered.**

➤ **Curing the HS-965 Primer:**

- ✓ **The product can completely cure under ambient conditions in approximately 5 days, though useable or careful handling properties can happen in as little as 2 hrs.**
- ✓ **Oven curing; The coating must be “Dry to the Touch” before it is exposed to elevated oven temperatures, (normal cure cycle – ramp up-to 350°F for 45 minutes Part temperature).**

➤ **Recoat or touch-up of the HS-965 Primer;**

To attain proper intra-coat adhesion to the HS-965 chromate-free primer, HS-520 primer must be used before top-coating.

- ✓ **Be sure the area to be re-coated has been cleaned free of oils or other contaminants**
- ✓ **Apply (per HS-520 application instructions) a thin 2-3 micron coat of HS-520 Intra-coat primer onto the intended surface; now apply the needed top-coat, within 3-5 minutes or as a “wet on wet” application.**
- ✓ **Follow standard curing instructions for the top-coat.**

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