

Stoner Molding
Solutions®
You Mold It. We Release It.™

Honey Plus Wax® Liquid

Liquid Release Agent



Product Description

Honey Wax® Liquid is a mold release agent specifically formulated for use in the manufacture of reinforced fiberglass products using polyester resins. Because of its unique solvent carrier, **Honey Wax® Liquid** removes old wax, styrene build-up, polymerized resin, and other surface contaminants while forming a durable wax surface. This cleaning ability, while reducing surface contamination, allows molds to be kept in production longer between cleanings, thus saving valuable man-hours.

Direction for Use

Recommended Procedure

- New or Re-conditioned Molds: The mold surface should be thoroughly cleaned of all contaminants such as oils, grease, wax, dirt, or previous release agents by hand buffing with **BuffAway™ 2000 Polish** followed by **KantStik® Mold Cleaner**. The cleaned surface should be completely dry. Then apply 2 coats of **KantStik® Sealer 1.0** to seal surface porosity.
- Apply at least 5 coats of a paste wax (**Honey Wax®**, **Honey Wax® 100**, **Honey Wax® 250** or **Honey Plus Wax®**) and perform 2 molding cycles before using **Honey Wax® Liquid**. If a new mold is being put into service and molding is done with a polyester resin, it is recommended that PVA be used over the **Honey Wax®** for the first 2 molding cycles. This is not necessary if the mold is seasoned and being reconditioned.

- After the first 2 molding cycles have been completed, begin using **Honey Wax® Liquid**. Shake the can well and saturate a clean, dry cloth with **Honey Wax® Liquid**. Apply a thin, even film using circular motions and making sure there is complete uniform coverage.
- The coating should be left to haze completely. This process should take approximately 1-5 minutes depending upon ambient temperatures and humidity. Hazing is an important step, as all the solvents should evaporate completely before buffing. The wax film should be totally dry.
- Buff the surface to a luster using a fresh, clean absorbent cloth or micro fiber towel as soon as the wax film is totally dry.
- At the first sign of a difficult pull or the observation of a dull mold, repeat Steps 3-5.
- If the mold surface is grained textured or sand-like with a rough texture, it may be advantageous to apply **Honey Wax® Liquid** by brush or spray. This will better facilitate the penetration of **Honey Wax® Liquid** into these small crevices, assuring good surface reproduction and minimizing build-up. Buffing may be done with a cloth or soft bristled brush.
- **Honey Wax® Liquid** can be used as part of a mold maintenance program where paste waxes are used as the primary mold release. Use **Honey Wax® Liquid** on every 5th molding cycle to remove any wax build up or styrene haze.

Storage and Handling

This product contains flammable solvents. Reseal the lid after each use. Store in a cool, dry place. Use in a well-ventilated area. Consult SDS prior to use. Shelf life is 12 months from date of manufacture.

Packaging

Honey Wax® Liquid is available in:

- Cases of 4x1-gallon Part # P51701RGLXX2
- 5-gallon pails Part # P51705RPLXX2
- 55-gallon drum Part # P51755DRXXX2

Technical Assistance

Call: 800-227-5538 or 1 (717) 786-7355

Email: CustomerService@StonerMolding.com

Visit: StonerMolding.com

NO RISK GUARANTEE. Stoner Molding guarantees 100% satisfaction or your money back. If you're ever dissatisfied with any Stoner Molding product, simply return the unused portion for a full refund.



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