

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

Honey 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 **Farécla Profile 400 polish** followed by **Granudan Mold Cleaner**. The cleaned surface should be completely dry. Then apply 2 coats of **Sealer GP** to seal surface porosity.
- Apply at least 5 coats of a paste wax (**Honey Wax®** or **Honey Wax® 100**), 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 / 4x 3,785 Ltr./can (15,14 ltr./box)
- 5-gallon pails / 18,92 ltr. spand

Technical Assistance

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