

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

Honey Plus Wax®

Premium Mold Release Paste Wax

High Temp!



Product Description

Honey Plus Wax® Mold Release is a unique, high temperature version of Honey Wax, formulated to work with higher exotherm resins up to 116 C° (240°F). It is a unique, high gloss paste wax for use by composite fabricators as a mold release agent. It is compounded with the purest grade carnauba wax, plus special binders and spreading agents.

Honey Plus Wax® reduces man hours due to its exceptional ease of application and buffing. It is an excellent mold release agent providing reproducibility, glossiness, and a non-staining, hard releasing film which are important to the fabricator. It is easier to apply and remove than other processed waxes and the residual film is resistant to abrasion.

Honey Plus Wax® creates a durable wax surface that remains intact for multiple pulls.

Uses

For New Or Reconditioned Tooling Surfaces.

Direction for Use

Recommended Procedure

1. 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 **Granudan Sealer** to seal surface porosity.

1. Apply a thin, even film of **Honey Plus Wax®**. using circular motions and making sure there is complete uniform coverage. Use the applicator sponge or a clean, dry rag.
2. The coating should be left to haze completely. This process should take approximately 1-10 minutes depending upon ambient temperatures and humidity.
3. Buff the surface to a luster using a fresh, clean absorbent cloth or microfiber towel as soon as the wax film is totally dry.
4. Wait approximately 10 to 15 minutes before applying another coat of **Honey Plus Wax®**. Five to seven applications initially will effectively fill the pores and coat the mold surface (The number of coats depends upon the porosity of the mold). Once a part is pulled, apply two more coats of **Honey Plus Wax®**.
5. For the third part, a single application will suffice. From this point on, multiple pulls can be achieved.
6. 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 5-7 coats of **Honey Plus Wax®**. for the first 2 molding cycles. This is not necessary if the mold is seasoned and being reconditioned.

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. 5 year shelf life from date of manufacture when container is sealed and stored out of direct sunlight.

Packaging

Honey Plus Wax®. is available in:

- 397 gr. can (14-ounce), 12 cans per case

Technical Assistance

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