

Stoner

Honey Wax® 250

Premium Mold Release Paste Wax



Product Description

Honey Wax® 250 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 Wax® 250 reduces cycle times due to its exceptional ease of application and buffing. It is an excellent mold release agent providing reproducibility, high gloss, and a non-staining, hard releasing film which are important to the fabricator. **Honey Wax® 250** is our easiest to apply and remove paste wax.

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 **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.
2. Apply a thin, even film of **Honey Wax® 250** using circular motions and making sure there is complete uniform coverage. Use the applicator sponge or a clean, dry rag.
3. The coating should be left to haze completely. This process should take approximately 2-15 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.
4. 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.
5. Wait approximately 10 to 15 minutes before applying

another coat of **Honey Wax® 250**. 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).

6. Once a part is pulled, apply two more coats of **Honey Wax® 250**.
7. For the third part, a single application will suffice. From this point on, multiple pulls can be achieved.
8. 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 Wax® 250** 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 MSDS prior to use. Shelf life is 12 months from date of manufacture.

Packaging

Honey Wax® 250 is available in:

- 11-ounce cans, 12 cans per case Part # P52111EAXXX2
- 1 kg cans, 12 cans per case Part # P51540EAXXX2

Technical Assistance

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

Email: TimeSaver@StonerSolutions.com

Visit: StonerSolutions.com

The information contained in this TDS is believed to be accurate and reliable. It is recommended that each user test the material and procedures prior to initial use. Nothing stated in this TDS is to be construed as a warranty either expressed or implied.

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

© Stoner Inc.



SPC® is a registered trademark of Stoner, Inc.