



G610 Ambient Cure Water Based Semi-Permanent Mold Release Agent



Product Description

Stoner® G610 Water Based Semi-Permanent Mold Release Agent is a unique, ambient cure water based semi-permanent mold release agent designed to release phenolic, epoxy, isophthalic, orthophthalic, DCPD and vinyl ester resin systems. It combines fast cure with outstanding chemical and abrasion resistance. It gives a smooth, continuous film with unmatched adhesion to the mold.

Stoner® G610 ADVANTAGES:

- Ambient cure. Does not require heat to cure.
- Non-Flammable.
- VOC free.
- Minimal to -0- transfer to the part.
- Application temperature up to 400°C (750°F).
- Tough, abrasion resistant film.
- Excellent adhesion to mold surfaces.
- Stable resin emulsion – 1 year shelf life.

Uses

Stoner® G610 is designed to release phenolic, epoxy, polyester or vinyl ester resins in compression molding, resin transfer molding, vacuum infusing, casting, hand layup, or spray up processes.

Direction for Use

1. Clean mold surfaces to remove any previous waxes, sealers, compounds, or other surface contaminants. A mild polish may be required to remove any previous semi-permanent sealers or release agents. Afterwards use a Stoner Mold Cleaner and perform a tape test to ensure mold is properly cleaned.

2. Apply 4 coats of **KantStik Sealer** per the **KantStik Sealer** application instructions.
3. **G610 Water Base Release Agent** only requires 2 coats. Lightly saturate a 6” X 6” piece of reinforced paper towel and in a linear fashion apply a thin coat. When necessary, rewet the paper towel and keep applying until the entire mold has been covered.
4. Very lightly buff the surface with a clean microfiber towel and wait 15 minutes before applying the second coat.
5. Repeat Step 3 but apply the second coat 90° from the direction of the first coat.
6. Repeat Step 4 and wait 30 minutes after the last coat for complete cure before proceeding with molding.
7. When it is apparent that the ease of release is impacted, apply one more coat of **G610** and allow to cure for at least 30 minutes before returning the mold to production.
8. For non-gel coated surfaces or molds that typically are very difficult to release, **DO NOT** wipe or buff off any of the **KantStik Sealer** or **G610 Release** coats.
9. For molds that are prone to pre-release, buff the **G610 Release** within 45-60 seconds of application.
10. For areas of the mold that may be used with a vacuum sealing tape, wipe just that area of the mold with solvent after the **G610** has been applied.

Storage and Handling

Stoner® G610 should be stored in a cool, dry, well-ventilated area. Do not expose to freezing temperatures.

Packaging

Stoner® G610 Semi-Permanent Mold Release Agent is available in:

- 1-gallon plastic bottle Part # G610GLSTON01
- 5-gallon plastic pail Part # G610PLSTON01
- 55-gallon plastic drum Part # G610DRSTON01

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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