

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

# G600 Water Based Sealer



## Product Description

**Stoner® G600 Water Based Sealer** is a unique water-based sealer that bonds to the mold surface creating a hard and chemically resistant barrier.

New or reconditioned tooling surfaces have micro porosity and irregularities. **G600** is used to seal surface porosity and provide an inert surface that allows superior bonding of semi-permanent release agents.

### Stoner® G600 ADVANTAGES:

- Non-Flammable.
- VOC free.
- 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® G600** is designed to be used with **Stoner's G610 Water Based Semi-Permanent Release Agent** as a sealer and bonding agent.

## Direction for Use

### Recommended Procedure

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. **G600 Water Based Sealer** can be applied by spray, roller, or wiping on. Regardless only a very thin film is required. If wiping on, a clean 100% cotton towel or reinforced paper towel is recommended.
3. Apply to an area of approximately 3-4 square feet, let sit for 2 minutes, then buff off with a clean microfiber towel. Continue with 3-4 square foot sections of the mold until 100% of the mold surface has been sealed and wiped off.
4. After the mold has been completely sealed, repeat Step-3 three more times, waiting 15 minutes between coats. After 4 Sealer coats have been applied, insert the mold into an oven at 80°C and cure for 1 hour.
5. After the Sealer has cured for 1 hour, remove from the oven and cool to room temperature. Then the **Stoner® G610 Semi-permanent Release Agent** can be applied.

## Storage and Handling

**Stoner® G600** should be stored in a cool, dry, well-ventilated area. Do not expose to freezing temperatures.

## Packaging

**Stoner® G600 Water Based Sealer** is available in:

- 1-gallon plastic bottle      Part # G600GLSTON01
- 5-gallon plastic pail      Part # G600PLSTON01

## Technical Assistance

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

Email: [CustomerService@StonerMolding.com](mailto:CustomerService@StonerMolding.com)

Visit: [StonerMolding.com](http://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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