



STONER Release System for Cast Polymer Manufacturing



Product Description

The Stoner release system for cast polymer manufacturing incorporates a solvent sealer and an ambient temperature cure water-based semi-permanent release agent that provides multiple releases with minimal transfer.

Stoner Release System Advantages using KantStik Sealer 1.0 and G610 Release Agent

- **KantStik Sealer 1.0** cures at ambient temperature
- **G610 Release Agent** is nonflammable, VOC free, and cures at ambient temperature
- Multiple Releases
- Used for vanities, custom, hat molds, flat stock
- Excellent adhesion to mold surfaces

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 1.0** using a reinforced paper towel and applying a thin film in

a linear pattern. Apply subsequent coats 90° from the direction of the previous coat and allow to dry for 15 minutes. **DO NOT** wipe or buff off any coat. Repeat 3 more times.

3. Wait 30 minutes after the 4th coat of **KantStik Sealer 1.0** before applying **G610**.
4. **G610 Semi-Permanent Release Agent** only requires 2 coats. Apply the 1st coat in a thin film using a reinforced paper towel. Wait 15 minutes before applying the 2nd coat and apply in a direction 90° from the direction of the 1st coat. **DO NOT** wipe or buff off either coat.
5. Wait 30 minutes after the 2nd coat for complete cure before proceeding with molding.
6. When it is apparent that the ease of release is impacted, apply one more coat of **G610**. **DO NOT** wipe or buff off and allow to cure for 30 minutes before returning the mold to production.
7. 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. **KantStik Sealer 1.0** is moisture sensitive and contains flammable solvents. Reseal the lid immediately after each use.

Packaging

All products are available in 1-gallon containers.

- **KantStik Sealer 1.0** Part # P59101GLXXX3
- **G610 Release Agent** Part # G610GLSTON01

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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