

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

STONER Release System for Resin Transfer Molding (RTM)



Product Description

The Stoner release system for Resin Transfer Molding incorporates a solvent-based Sealer and a choice of a solvent or water-based semi-permanent release agent that provides multiple releases with minimal transfer.

Stoner Release System Advantages using KantStik Sealer & G495 Release Agent

- Slightly lower slip for the “A” mold
- Fast cure for both the Sealer and Release Agent
- Minimal transfer to the part
- Multiple releases
- Excellent adhesion to mold surfaces

Stoner Release System Advantages using KantStik Sealer and G610 Release Agent

- **Extreme slip** for the “B” Mold with **G610**
- **G610** can be used on the “A” Mold
- **KantStik Solvent Sealer** cures at ambient temperature
- **G610 Release Agent** is nonflammable, VOC free, and cures at ambient temperature
- **G610 Release Agent** is more forgiving to apply than solvent release agents
- Minimal transfer to the part
- Multiple Releases
- 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 Solvent Sealer** using a reinforced paper towel. Apply each coat in a thin film. For the “A” mold surface, lightly buff the **KantStik Sealer** while still wet to prevent streaking. **DO NOT** wipe or buff off any coat on the “B” mold. Allow to cure for 15 minutes before applying another coat. Repeat 3 more times.
3. Wait 30 minutes after the 4th coat of **KantStik Sealer** before applying either **G610** or **G495**.
4. **G610 Semi-Permanent Release Agent** or **G495** only requires 2 coats. Apply the 1st coat in a thin film using a reinforced paper towel. For the “A” mold surface, lightly buff the **G495** while still wet to prevent streaking. Wait 15 minutes before applying the 2nd coat. If using **G610** on the “A” mold, allow the water to evaporate for 4 minutes and lightly buff the surface. For the “B” mold surface, **“DO NOT”** wipe or buff off either coat.
5. Wait 30 minutes after the last 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 either **G610** or **G495**. Allow to cure for 30 minutes before returning the mold to production.

Storage and Handling

Stoner G610 should be stored in a cool, dry, well-ventilated area. Do not expose to freezing temperatures. **G495** and **KantStik Mold Sealer** are moisture sensitive. Reseal the lid immediately after each use. **G495** and **KantStik Mold Sealer** contain flammable solvents.

Packaging

All products are available in 1-gallon containers.

- **KantStik Solvent Sealer** Part # P59101GLXXX3
- **G495 Release Agent** Part # G495GLSTON01
- **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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