



STONER Release System for Epoxy Wind Blades



Product Description

The Stoner release system for epoxy wind blades incorporates a choice of sealers (solvent or water-based) and an ambient temperature cure water-based semi-permanent release agent that provides multiple releases with minimal transfer.

Stoner Release System Advantages using G600 Sealer & G610 Release Agent

- Non-Flammable
- VOC free
- Minimal transfer to the part
- Multiple releases
- Excellent adhesion to mold surfaces
- Stable resin emulsion – 1 year shelf life

Stoner Release System Advantages using KantStik Sealer and G610 Release Agent

- **KantStik Solvent Sealer** cures at ambient temperature
- **G610 Release Agent** is nonflammable, VOC free, and cures at ambient temperature
- 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 either 4 coats of **KantStik Solvent Sealer**, **OR** 4 coats of **G600 Water Based Sealer**. Apply each coat and allow to dry for 15 minutes. **DO NOT** wipe or buff off any coat. Repeat 3 more times.
3. If using **KantStik Solvent Sealer**, wait 30 minutes after the 4th coat before applying **G610**.
4. If using **G600 Water Based Sealer**, after the 4th coat bake the sealer for 1 hour @ 80°C. Cool to room temperature before applying **G610**.
5. **G610 Semi-Permanent Release Agent** only requires 2 coats. Apply the 1st coat and wait 15 minutes before applying the 2nd coat. **DO NOT** wipe or buff off either coat.
6. 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**. **DO NOT** wipe or buff off and allow to cure for 30 minutes before returning the mold to production.

Storage and Handling

Stoner G600 & G610 should be stored in a cool, dry, well-ventilated area. Do not expose to freezing temperatures. **KantStik Mold Sealer** is moisture sensitive. Reseal the lid immediately after each use. This product contains flammable solvents.

Packaging

All products are available in 1-gallon containers.

- **KantStik Solvent Sealer** Part # P59101GLXXX3
- **G600 WB Sealer** Part # G600GLSTON01
- **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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