



Honey Wax® 100

Non-Silicone Mold Release Paste Wax



Product Description

Honey Wax® 100 is a pure, carnauba paste wax containing no silicones or fillers. It is designed for the composite fabricator who requires a very high quality paste wax mold release agent.

Honey Wax® 100 is an excellent mold release where purity, non-staining and a hard releasing film are important. Although application is somewhat more exacting than for processed waxes, the residual film is more durable and resistant to abrasion. It will readily accept PVA without fish-eyeing. **Honey Wax® 100** will also withstand higher temperatures than most processed waxes which can be critical for high exotherm resins. Due to the nature of its components and its ability to provide a hard, durable, waxy film, **Honey Wax® 100** is highly recommended when breaking in new molds or plugs.

Uses

For New Or Reconditioned Tooling Surfaces.

Direction for Use

Recommended Procedure

1. The mold surface should be thoroughly cleaned of all contaminants such as oils, grease, wax, dirt, or previous release agents by hand buffing with **BuffAway™ 2000** polish followed by **KantStik® Mold Cleaner**. The cleaned surface should be completely dry. Then apply 2 coats of **KantStik® Sealer 1.0** to seal surface porosity.
2. Apply a thin, even film of **Honey Wax® 100** using circular motions and making sure there is complete uniform coverage. Use the applicator sponge or a clean, dry rag.
3. The coating should be left to haze completely. This process should take approximately 2-15 minutes depending upon ambient temperatures and humidity. Hazing is an important step, as all the solvents should evaporate completely before buffing. The wax film should be totally dry.
4. Buff the surface to a luster using a fresh, clean absorbent cloth or micro fiber towel as soon as the wax film is totally dry.

5. Wait approximately 10 to 15 minutes before applying another coat of **Honey Wax® 100**. Five to seven applications initially will effectively fill the pores and coat the mold surface (The number of coats depends upon the porosity of the mold).
6. Once a part is pulled, apply two more coats of **Honey Wax® 100**.
7. For the third part, a single application will suffice. From this point on, multiple pulls can be achieved. If a new mold is being put into service and molding is done with a polyester resin, it is recommended that PVA be used over the 5-7 coats of **Honey Wax® 100** for the first 2 molding cycles. This is not necessary if the mold is seasoned and being reconditioned.

Storage and Handling

This product contains flammable solvents. Reseal the lid after each use. Store in a cool, dry place. Use in a well-ventilated area. Consult MSDS prior to use. Shelf life is 12 months from date of manufacture.

Packaging

Honey Wax® 100 is available in:

- 14-ounce cans, 12 cans per case Part # P54016REAXX2
- 5-gallon - 30 LB Part # P54005PLXXX2

Technical Assistance

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

Email: TimeSaver@StonerSolutions.com

Visit: StonerSolutions.com

The information contained in this TDS is believed to be accurate and reliable. It is recommended that each user test the material and procedures prior to initial use. Nothing stated in this TDS is to be construed as a warranty either expressed or implied.