

# Stoner

## Honey Plus Wax

Premium Mold Release Paste Wax for High Temp Resins



### Product Description

**Honey Plus Wax** is a high gloss paste wax for use in open molding by a composite fabricator that requires a wax mold release agent that can perform in both normal and high-exotherm molding temperatures.

**Honey Plus Wax** is an excellent release agent where reproducibility, hi gloss, non-staining, and a hard releasing film are important. It is easier to apply than our other wax release agents and the residual film is durable and resistant to abrasion. In addition, **Honey Plus Wax** withstands higher temperatures than most processed waxes, which can be critical in some molding processes.

### 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 Plus Wax** 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 Plus Wax**. 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 Plus Wax**.
7. For the third part, a single application will suffice. From this point on, multiple pulls can be achieved.
8. 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 Plus Wax** 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 Plus Wax®** available in:

- 14-ounce cans, 12 cans per case Part # P52115REAXX2

### 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.

**Stoner Molding Solutions**  
You Mold It, We Release It.™

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