



SPECIALTY PRODUCTS

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HONEY WAX[®] Premium Paste Mold Release Agent

PRODUCT DESCRIPTION

Honey Wax[®] is a unique, high gloss paste wax for use by the reinforced fiberglass molder as a mold release agent. It is compounded with the purest grade carnauba wax, plus special binders and spreading agents. Honey Wax creates a durable wax surface that remains intact for multiple pulls.

Honey Wax[®] reduces man hours due to its exceptional ease of application and buffing. It is an excellent mold release agent providing reproducibility, glossiness, non-staining and a hard releasing film which are important to the fabricator. It is easier to apply than other processed waxes; the residual film is also more durable and resistant to abrasion.

MOLD PREPARATION

It is essential that the mold surface be thoroughly cleaned so that all traces of previous waxes used and/or other release agents or any foreign materials are removed. KantStik[®] Mold Cleaner will remove waxes and wax residue. It should be noted, however, that the KantStik[®] Mold Cleaner breaks down the wax and, therefore, must be removed from the mold surface. A clean cloth should be used for this purpose to ensure that the dissolved wax is completely removed and not merely being spread.

Continue the process until the surface is completely clean. To test the surface for cleanliness, use a piece of masking tape on various points on the mold surface. Good adhesion to the mold should be observed when removing tape. If not, further cleaning is necessary.

APPLICATION

Once the mold surface has been thoroughly cleaned, Honey Wax[®] can be applied using a soft cotton cloth, being careful not to scratch the fiberglass mold surface.

1. Apply a thin, even film of Honey Wax[®] using circular motions and making sure there is complete uniform coverage.
2. The coating should be left to haze completely. This process should take approximately 15 minutes depending upon ambient temperatures and humidity. Hazing is an important step, as all the carriers (mineral spirits) should evaporate completely before buffing. The wax film should be totally dry.
3. Buff the surface to a luster using a fresh, clean absorbent cloth.
4. Wait approximately 10 to 15 minutes before applying another coat of Honey 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).
5. Once a part is pulled, apply two more coats of Honey Wax[®] following Steps 1, 2 and 3.
6. For the third part, a single application will suffice. From this point on, multiple pulls can be achieved.

NOTE: In high humidity conditions, it may be necessary to give the mold a final wiping with a clean, dry cloth to remove any haze that develops from unreleased solvents. In order to avoid contamination, a clean cloth should always be used when applying and buffing this product.

Also recommended, is the use of our KantStik[®] Sealer as a sealer. This will provide superior smoothness and effectively seal the surface of the tooling mold before applying the Honey Wax[®]. The use of the KantStik[®] Sealer to new molds and plugs during the break-in period will protect the Honey Wax[®] coating from being attacked by styrene migration.