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HONEY WAX® 100 Non-Silicone Mold Release Paste Wax

PRODUCT DESCRIPTION

Honey Wax® 100 is a pure, carnauba paste wax containing no silicones, paraffin, or fillers. It is designed for the fiberglass molder 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.

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, residue 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® 100** 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® 100** 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 solvent carriers 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® 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).
5. Once a part is pulled, apply two more coats of **Honey Wax® 100** 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 2.0** which will provide superior smoothness and effectively seals the surface of the tooling mold before applying the **Honey Wax® 100**. The use of **KantStik® Sealer 2.0** to new molds and plugs during the break-in period will also serve to protect wax coatings from being attacked by styrene migration.

AVAILABILITY: **Honey Wax® 100** is available in 14-ounce cans, 12 cans per case

STORAGE: Reseal the lid tightly when not in use to avoid solvent evaporation and loss in performance. For more information, please refer to our Material Safety Data Sheet.