

technical data

AXEL

PLASTICS RESEARCH LABORATORIES, INC.
MOLD RELEASES & INTERNAL LUBRICANTS

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MOLD WIZ INT-1838P

General: A process aid additives with anti-static properties, which is incorporated directly into the resin eliminating the need for an external mold release agent. An effective addition of process aid additives will not have any adverse effect on the cured resin. The complex polymeric nature of the process aid additive will not interfere with secondary operations such as decorating, silk screen printing, painting, bonding or plating.

Use: Phenolics / Phenolic Printing Boards
Polyester / Vinyl Ester RTM &
Compression Molding

Composition: Proprietary synergistic blend of organic fatty esters and wetting agents.

TYPICAL PROPERTIES:

EFFECTIVE INGREDIENTS:	100%
SOLIDS:	100%
COLOR:	Pale straw
SPECIFIC GRAVITY:	0.880 @ 25°C
VISCOSITY:	<15 cps @ 25°C
REFRACTIVE INDEX:	1.4525
FLASH POINT:	340°F / 171°C
SHELF LIFE:	Minimum of one year

Application Instructions:

General: For best results, laboratory tests or pre-production trials should determine the optimum addition level. MOLD WIZ process aid additives are effective within a range of 1 to 10 parts per 1000 resin by weight, excluding reinforcements, pigments and fillers. High amount of filler may required a higher percentage of process aid additives than the indicated maximum. Always start an evaluation at 5 parts per 1000 (0.5%). Too much additive may retard the cure. Reduce the level of additive or slightly increase the catalyst.