

## technical data

# AXEL

PLASTICS RESEARCH LABORATORIES, INC.  
MOLD RELEASES & INTERNAL LUBRICANTS

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## MOLD WIZ

## INT-310IMC

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**General:** A process aid additive with mold release and antistatic properties, specifically designed for incorporation into amine neutralized **polyurethane dispersions (PUD's)** and emulsions. Its use does not affect the shelf life of the in-mold coating. It eliminates the use of external mold release agents on steel and aluminum tools. Composite molds require a mold release agent to seal the porosity and maintain the gloss of the molds. This process aid additive will not interfere with secondary operations such as bonding.

**Use:** **Water-based In-Mold Coatings, Polyurethane dispersions (PUD's)**

**Composition:**

Proprietary synergistic blend of organic fatty acids, esters and amine neutralizing agent in a hydrocarbon carrier

**TYPICAL PROPERTIES:**

<b>COLOR:</b>	<b>Amber</b>
<b>SPECIFIC GRAVITY:</b>	<b>0.950 @ 25°C</b>
<b>VISCOSITY:</b>	<b>50 – 250 cps @ 25°C</b>
<b>pH:</b>	<b>10.5</b>
<b>FLASH POINT:</b>	<b>215°F /102°C (C.O.C.)</b>
<b>SHELF LIFE:</b>	<b>Minimum of one year</b>

**Application Instructions:**

**General:** For best results, laboratory tests or pre-production trials should determine the optimum addition level. Recommended addition level of process aid additive should range within 5-15 parts lubricant per 1000 parts in-mold coating by weight.

**Incorporation:** INT-310IMC should be added to the in-mold coating or PUD under high shear mixing **until** it is evenly dispersed throughout the product.

All information given by us about our products is based upon our tests and experience. It is intended for use by persons having technical skill at their own discretion and risk, and we assume no liability in connection with their use.

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