

## Technical data

# AXEL

PLASTICS RESEARCH LABORATORIES, INC.  
MOLD RELEASES & INTERNAL LUBRICANTS

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## MOLD WIZ

### INT-35PHT Pellet/Powder (100% Active)

**General:** A process aid which is incorporated directly into the resin. Improves resin flow/fill; imparts easy release of molded polymers; , improves Scratch & Mar properties and dispersion of other resin (reinforcements, fillers, and pigments); shortens cycle times; reduces temperatures and pressures of molding machines; reduces or eliminates weld/knit lines; and improves the surface appearance of molded parts. An effective addition of process aid additive will not have any adverse effect on physical properties or secondary operations such as decorating, printing, bonding, or plating.

**Use:** Especially recommended for improving molding, processing, and Scratch & Mar of engineering resins such PC/PBT and others.

**Composition:** Proprietary synergistic blend of modified polymers, organic fatty amides and glycerides.

#### TYPICAL PROPERTIES:

<b>EFFECTIVE INGREDIENTS:</b>	<b>100%</b>
<b>SOLIDS:</b>	<b>100%</b>
<b>COLOR:</b>	<b>Off White</b>
<b>DROPPING POINT:</b>	<b>243°F / 117°C</b>
<b>SHELF LIFE:</b>	<b>Minimum of one year</b>
<b>AVAILABILITY:</b>	<b>Powder or Pellet form</b>

#### Application Instructions:

**General:** For best results, laboratory tests or pre-production trials should determine the optimum addition level. Mold Wiz® process aid additives are generally effective within a range of 3-10 parts per 1000 resin excluding reinforcements, pigments and fillers. A high amount of filler may require a higher percentage of process aid additive than the indicated maximum. Processing requirements will determine the optimum loading level for this additive. Extrusion and compounding operations should begin evaluations at 1% loading, while injection molding or when improved release is the primary requirement, may benefit from starting evaluation at 0.5% or less. If screw slippage occurs, reduce the level of additive, and/or reduce the process temperature to increase resin viscosity.

**Mixing:** Dry blend the process aid additive by tumbling or use an additive dispenser to meter directly into the resin stream. Process aid additives may be compounded into the resin to make a master-batch.