

## technical data

# AXEL

PLASTICS RESEARCH LABORATORIES, INC.  
MOLD RELEASES & INTERNAL LUBRICANTS

Mailing Address: Box 77 0855, Woodside, NY 11377  
Shipping Address: 58-20 Broadway, Woodside, NY 11377  
Tel: 718-672-8300 • Fax: 718-565-7447  
E-mail: [info@axelplastics.com](mailto:info@axelplastics.com)

## MOLD WIZ INT-PUL-24

**General:** A process aid additive designed specifically for pultrusion. The benefit is to optimize line speed while reducing both pull force and die wear. Improves wet out of fiber, fillers and resin flow while reducing viscosity. Physical properties of the profile are retained or improved. 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: Polyester Vinyl Ester  
Pultrusion DAP Resin**

**Composition:** Proprietary synergistic blend of organic fatty acids, esters and amine neutralizing agents.

### TYPICAL PROPERTIES:

<b>EFFECTIVE INGREDIENTS:</b>	<b>100%</b>
<b>GARDNER COLOR:</b>	<b>3 max.</b>
<b>SPECIFIC GRAVITY:</b>	<b>0.962 @ 25°C</b>
<b>VISCOSITY:</b>	<b>100 - 180 cps @25°C</b>
<b>pH:</b>	<b>4.3</b>
<b>FLASH POINT:</b>	<b>305°F / 152°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. MoldWiz® Process Aid Additives are effective within a range of 0.75 to 2.0 parts per 100 resin by weight, excluding reinforcements, pigments and fillers. Always start an evaluation at 1 part per 100. High amount of filler may require a higher percentage of process aid additive. Too much additive may retard the cure. Reduce the level of process aid additive or slightly increase the catalyst

**Mixing:** Mix into resin prior to addition of catalyst, fillers, and other resin additives.

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.

(021809)