

technical data

AXEL

PLASTICS RESEARCH LABORATORIES, INC.
MOLD RELEASES & INTERNAL LUBRICANTS

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MOLD WIZ INT-12

General: A Process Aid Additive with anti-static properties which is incorporated directly into the resin or gel coat eliminating the need for an external mold release agent. An effective addition of Process Aid Additive 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

Composition: Proprietary synergistic blend of organic fatty acids, esters and amine combined with wetting agents.

TYPICAL PROPERTIES:

EFFECTIVE INGREDIENTS:	100%
SOLIDS:	100%
COLOR GARDNER:	13 max.
SPECIFIC GRAVITY:	0.940 @ 25°C
VISCOSITY:	1000 – 3000 cps @ 25°C
REFRACTIVE INDEX:	1.475
FLASH POINT:	280°F / 138°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 or rubber by weight, excluding reinforcements, pigments and fillers. A high amount of filler may require a higher percentage of process aid additive 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.

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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