



PLASTICS RESEARCH LABORATORIES, INC.
MOLD RELEASES & PROCESS ADDITIVES

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Technical Data Sheet

MoldWiz®

INT-1329

**Internal Mold Releases
Process Aid Additives**

Product Description

A liquid internal mold release/process aid additive which is incorporated directly into the resin eliminating, or significantly reducing the need for an external mold release agent.

Internal mold release / process aids can also improve the wetting of reinforcements and fillers and enhance the surface appearance of molded parts.

An effective addition of process aid additive will not have any adverse effect on the cured resin or interfere with secondary operations such as printing, painting or bonding.

Composition

Proprietary synergistic blend comprising organic fatty amines, and acid derivatives with surface active agents.

Handling

Keep container closed when not in use.
Store above freezing and below 100°F / 38°C.
DO NOT DILUTE

Uses

Particularly designed for use with non-accelerated DICY (dicyanamide) cured epoxy systems including nano-dicyanamide..

Typical Properties

Color	Amber
Specific Gravity	0.965
Flash Point	>240°F /> 116°C (C.O.C)
Refractive Index	1.4566
Viscosity	Ca. 135 cps @ 25°C
Shelf Life	1 yr. minimum in original closed container

Instructions for Use

For best results, laboratory tests or pre-production trials should determine the optimum addition level. Typical addition level In epoxy resin formulations ranges from 15 – 60 parts /1000 by weight, excluding reinforcements, pigments and fillers. High amounts of filler and/or different processing conditions may require a higher or lower loading of the process aid additive.

Additional information on conducting pre-production trials is available in AXEL’s Technical Guide: Testing IMRs in Thermoset Resins.

Mixing: For two-part thermoset resins, mix the process aid additive in the less viscous or less reactive side of the resin system.

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