

## technical data

# AXEL

PLASTICS RESEARCH LABORATORIES, INC.  
MOLD RELEASES & INTERNAL LUBRICANTS

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## MOLD WIZ INT-EQ6

**General:** A non-silicone internal release and lubricating agent for use in all types of rubber processing which eliminates the need for any external release agent minimizing mold and machine cleaning time. Facilitates processing by increasing the flow characteristics and lubricating qualities of the rubber formulation without affecting its mechanical properties. The cured product can be readily glued, bonded, coated, etc. and there is no exudation or deterioration after prolonged storage. There is an increase in elongation percentage and tensile strength with many formulations.

**Use: Thermoplastics:**

PBT PET TPU PP PE PS

**Thermosets:**

Polyester Vinyl ester

**Especially for MEK cured resin in RTM and hand lay-up/ spray-up process.**

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

### TYPICAL PROPERTIES:

<b>EFFECTIVE INGREDIENTS:</b>	<b>100%</b>
<b>SOLIDS:</b>	<b>100%</b>
<b>COLOR GARDNER:</b>	<b>10 max.</b>
<b>SPECIFIC GRAVITY:</b>	<b>0.930 @ 25°C</b>
<b>VISCOSITY:</b>	<b>100 –160 cps @ 25°C</b>
<b>pH:</b>	<b>6.0 – 7.0</b>
<b>REFRACTIVE INDEX:</b>	<b>1.460</b>
<b>FLASH POINT:</b>	<b>280°F / 137°C</b>
<b>SHELF LIFE:</b>	<b>Minimum of one year</b>

### Application Instructions:

**General:** Beginning with a clean mold will provide accurate results. It is recommended to remove mold release and rubber residue with CLEAN WIZ.

0.2-1.0 phr will be effective in most rubber compounds. (2-10 parts per 1000 parts rubber). Begin testing with 0.25 and 0.5 phr to determine the optimum level of usage in a particular rubber recipe. Process aid additive may be Banbury mixed or milled in the rubber recipe. If the process aid additive can be milled with the rubber first, it will promote faster mixing of fillers and additives, also reducing tack on the mill. In molding operations, rubber viscosity will be reduced allowing better fill at lower temperature and pressure.

**Material may thicken at lower temperatures. Store at room temperature or apply equivalent heat to restore flow properties.**

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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