

## technical data

# AXEL

PLASTICS RESEARCH LABORATORIES, INC.  
MOLD RELEASES & INTERNAL LUBRICANTS

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## MOLD WIZ INT-1850HT

**General:** A process aid additive and mold release with anti-static properties which is incorporated directly into the resin eliminating the need for an external mold release agent. Improves resin flow and line speeds. 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:** Epoxy:  
Aliphatic amine cured high temp(350°F)  
Phenolic, Vinyl ester  
Pultrusion  
Compression

**Composition:** Proprietary synergistic blend of organic fatty acids, esters, alkanes and alkanols.

### TYPICAL PROPERTIES:

<b>EFFECTIVE INGREDIENTS:</b>	<b>100%</b>
<b>SOLIDS:</b>	<b>100%</b>
<b>*COLOR:</b>	<b>Amber</b>
<b>SPECIFIC GRAVITY:</b>	<b>1.02 @25°C</b>
<b>VISCOSITY:</b>	<b>250 – 450 cps</b>
<b>pH (10% in water):</b>	<b>1.0 – 3.0</b>
<b>REFRACTIVE INDEX:</b>	<b>1.455 – 1.475</b>
<b>FLASH POINT:</b>	<b>415°F / 212°C</b>
<b>SHELF LIFE:</b>	<b>Minimum of one year</b>

\*The color may change over time from light to dark amber without affecting product performance

### 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. High amount of filler may require a higher percentage of Process Aid additives than the indicated maximum. Always start an evaluation at 5 parts per 1000 (0.5%). Too much internal may retard the cure. Reduce the level of internal 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.

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