

## technical data

# AXEL

PLASTICS RESEARCH LABORATORIES, INC.  
MOLD RELEASES & INTERNAL LUBRICANTS

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## MOLD WIZ INT-PUL-14

**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  
Phenolic**

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

### TYPICAL PROPERTIES:

<b>EFFECTIVE INGREDIENTS:</b>	<b>100%</b>
<b>COLOR:</b>	<b>Amber</b>
<b>SPECIFIC GRAVITY:</b>	<b>0.964 @ 25°C</b>
<b>VISCOSITY:</b>	<b>280 - 480 cps @25°C</b>
<b>pH:</b>	<b>4.5</b>
<b>FLASH POINT:</b>	<b>370°F / 189°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 additive or slightly increase the catalyst

**Mixing:** To minimize air entrapment and assure easiest most through mixing, Axel recommends incorporating the filler with the resin, followed by addition of the process aid additive, catalyst, initiators and other materials.

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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