

## technical data

# AXEL

PLASTICS RESEARCH LABORATORIES, INC.  
MOLD RELEASES & INTERNAL LUBRICANTS

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## MOLD WIZ INT-44/3PV powder

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**General:** Process aid additive which is incorporated directly into the resin. Improves resin flow/fill, improves dispersion of other resin additives (reinforcements, fillers, and pigments), shortens cycle times, reduces temperatures and pressures of molding machines, and reduces or eliminates weld/knit lines. Eliminates the need for an external mold release agent. An effective addition of process aid additive will not have any adverse effect on physical properties or secondary operations such as decorating, printing, bonding, or plating.

**Use:** Fluoroelastomers VITON KRATON  
TPR SBR-NR EPDM Nitrile

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

### TYPICAL PROPERTIES:

<b>EFFECTIVE INGREDIENTS:</b>	<b>100%</b>
<b>SOLIDS:</b>	<b>100%</b>
<b>COLOR:</b>	<b>Off white</b>
<b>BULK DENSITY;</b>	<b>5.30 lb/gal</b>
<b>DROPPING POINT:</b>	<b>230 – 270°F / 110 – 132°C</b>
<b>FLASH POINT:</b>	<b>Non-Flammable (C.O.C.)</b>
<b>SHELF LIFE:</b>	<b>Minimum of one year</b>
<b>AVAILABILITY:</b>	<b>Powder or Pellet form</b>

### Application Instructions:

**General:** Beginning with a clean mold will provide accurate results.

**Mixing:** 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. Additives 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 other additives, also reducing tack on the mill, In molding operations, rubber viscosity will be reduced allowing better fill at lower temperature and pressure.

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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