

## technical data

# AXEL

PLASTICS RESEARCH LABORATORIES, INC.  
MOLD RELEASES & INTERNAL LUBRICANTS

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## MOLD WIZ INT-VP250

**General:** A process aid additive with anti-static properties which is incorporated directly into the resin. Eliminates the need for an external mold release agent. Improves resin flow, 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. 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:** PVC Vinyl Plastisol

**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>GARDNER COLOR:</b>	<b>12 max.</b>
<b>SPECIFIC GRAVITY:</b>	<b>0.968 @25°C</b>
<b>VISCOSITY:</b>	<b>1300 cps @25°C</b>
<b>REFRACTIVE INDEX:</b>	<b>1.465 – 1.485</b>
<b>FLASH POINT:</b>	<b>&gt;250°F / &gt;121°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. MOLD WIZ process aid additives are effective within a range of 1 to 10 parts per 1000 resin excluding reinforcements, pigments and fillers. A high amount of filler may require a higher percentage of process aid additive than the indicated maximum. Always start an evaluation at 5 parts per 1000 (0.5%). The process aid additive may increase the MFI. Reduce the level of additive or reduce the process temperature to raise the resin viscosity and to eliminate screw slippage for injection or extrusion application.

**Mixing:** Dry blend the process aid additive by tumbling or use an additive dispenser to meter directly into the resin stream. Process aid additives may be compounded into the resin to make a masterbatch.

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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