**Product Description**
A liquid internal mold release/process aid additive which is incorporated directly into the resin eliminating, or significantly reducing the need for an external mold release agent.

Internal mold release / process aids can also improve the wetting of reinforcements and fillers and enhance the surface appearance of molded parts.

An effective addition of process aid additive will not have any adverse effect on the cured resin or interfere with secondary operations such as printing, painting or bonding.

**Composition**
Proprietary synergistic blend comprising organic fatty acid derivatives with surface active agents.

**Handling**
Keep container closed when not in use. Preferable to store above freezing and below 100ºF / 38ºC. DO NOT DILUTE

**Uses**
Particularly designed for use with DICY (dicyandiamide) and anhydride epoxy systems. Also compatible with tertiary amine curing agents. Polyurethane Systems.

**Typical Properties**

<table>
<thead>
<tr>
<th>Property</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Color</td>
<td>Amber</td>
</tr>
<tr>
<td>Specific Gravity</td>
<td>0.94</td>
</tr>
<tr>
<td>Flash Point</td>
<td>&gt;240ºF, &gt;116ºC (C.O.C)</td>
</tr>
<tr>
<td>Viscosity</td>
<td>ca. 350-400 cps @25ºC</td>
</tr>
<tr>
<td>Shelf Life</td>
<td>1 yr. minimum in original closed container</td>
</tr>
</tbody>
</table>

**Instructions for Use**
For best results, laboratory tests or pre-production trials should determine the optimum addition level. Typical addition level in epoxy resin formulations ranges from 0.5 – 3.5 % by weight, excluding reinforcements, pigments and fillers. High amounts of filler and/or different processing conditions may require a higher or lower loading of the process aid additive. Axel recommends a starting addition level of 2% based on the total system weight (not including fillers).

Additional information on conducting pre-production trials is available in AXEL’s Technical Guide: Testing IMRs in Thermoset Resins.

**Mixing:** For two-part thermoset resins, mix the process aid additive in the less viscous or less reactive side of the resin system. Always fully mix in any other additives or fillers PRIOR to adding the AXEL INT-1324B whenever possible.

**XTEND, MoldWiz & PasteWiz** are registered trademarks of Axel Plastics Research Laboratories.

This information is supplied for technically skilled professionals working at their own risk. AXEL believes the information to be accurate, although the Company assumes no liability in the validity of this information for any specific process or application. Moreover, AXEL will assume no liability from any direct and/or consequential damages of any kind that may arise from the use or non use of AXEL products or information supplied by the Company or its appointed representatives.

02-02-2015