

## technical data

# AXEL

PLASTICS RESEARCH LABORATORIES, INC.  
MOLD RELEASES & INTERNAL LUBRICANTS

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## Mold Wiz INT-1681/OG

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**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. 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, printing, bonding, or plating.

**Use:** Polyurea based Polyurethane Systems

**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>COLOR:</b>	<b>Water Clear</b>
<b>SPECIFIC GRAVITY:</b>	<b>1.01 @ 25°C</b>
<b>VISCOSITY:</b>	<b>&lt; 100 cps @ 25°C</b>
<b>FLASH POINT:</b>	<b>230°F / 110° C (C.O.C.)</b>
<b>pH:</b>	<b>7.5</b>
<b>REFRACTIVE INDEX:</b>	<b>1.4940</b>
<b>SHELF LIFE:</b>	<b>Minimum of 1 year, the water-clear appearance may be shortened by storage above 25°C/77°F temperatures</b>

### Application Instructions:

**General:** For best results, laboratory tests or pre-production trials should determine the optimum addition level. MoldWiz® process aid additives are often effective within a range of 5 to 10 parts per 1000 resin by weight. An evaluation starting at 5 parts per 1000 (0.5%) is suggested. Too much additive may retard the cure. Reduce the level of additive or slightly increase the catalyst.

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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