



PLASTICS RESEARCH LABORATORIES, INC.
MOLD RELEASES & PROCESS ADDITIVES

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Technical Data Sheet

MoldWiz®

INT-1881B

Internal Mold Release Process Aid Additive

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 of organic fatty amines, esters and acids.

Handling

Keep container closed when not in use.
Store above freezing and below 100°F / 38°C.
DO NOT DILUTE

Uses

Especially recommended for epoxy pultrusion; offering excellent processing while maintaining stable bath viscosity; high Tg and uncompromised physical properties in molded profiles.

Internal mold release suitable for various epoxy resin systems including Bisphenol A or F, and cures including: acid/anhydride, imidazole, aliphatic and aromatic amines and polyamines.

Typical Properties

Color	Amber
Specific Gravity	0.92
Flash Point	300°F / 149°C (C.O.C)
Refractive Index	TBD
Viscosity	ca. 100 cps @ 25°C
Shelf Life	1 yr. minimum in original closed container

Instructions for Use

For best results, laboratory tests or pre-production trials should determine the optimum addition level. Typical addition level in epoxy pultrusion is 15 parts /1000 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.

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.

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