

## technical data

# AXEL

PLASTICS RESEARCH LABORATORIES, INC.  
MOLD RELEASES & INTERNAL LUBRICANTS

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## MOLD WIZ INT-1948MCH

**General:** A Process Aid Additive designed specifically for pultrusion. When PU catalyst and lubricant addition levels are optimized, the system can offer long open resin bath times at ambient yet very rapid cures within the heated die. Line speeds can be maximized with excellent surface profiles while reducing both pull force and die wear. Improved wet-out of fiber, fillers and resin is evidenced by retained or improved physical properties of the profile. The complex polymeric nature of the process aid additive will not interfere with secondary operations such as decorating, silk screen printing, painting, bonding, or plating.

**Use:** Polyurethane (isocyanate & polyol)

**Composition:** Proprietary synergistic blend of organic fatty acids, esters and amine neutralizing agents.

### TYPICAL PROPERTIES:

<b>EFFECTIVE INGREDIENTS:</b>	<b>100%</b>
<b>SOLIDS:</b>	<b>100%</b>
<b>COLOR:</b>	<b>Dark Amber</b>
<b>SPECIFIC GRAVITY:</b>	<b>1.00 @ 25°C</b>
<b>VISCOSITY:</b>	<b>200 cps @ 25°C</b>
<b>pH:</b>	<b>8.5 – 10.5</b>
<b>FLASH POINT:</b>	<b>245°F / 118°C (C.O.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. Always start an evaluation by determining the effect of the process aid additive on gel time and adjust catalyst package to meet cure schedule requirements. Add to the polyol/resin component and mix thoroughly to ensure uniform dispersion prior to combining with isocyanate.

Evaluation in polyurethane systems should start at 2 parts per 100 parts of reactive isocyanate and resin components combined. Depending on the nature of the fillers and reinforcements incorporated into the system, even higher levels may be required. For example, profiles containing at least 60% glass rovings by volume typically use 3 parts of process aid additive.

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.