

technical data

AXEL

PLASTICS RESEARCH LABORATORIES, INC.
MOLD RELEASES & INTERNAL LUBRICANTS

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MOLD WIZ INT-1968RAC

General: A Process Aid Additive designed specifically for pultrusion of polyurethane resins. When PU catalyst and lubricant addition levels are optimized, the system can offer long working 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 painting, or bonding.

Use: Polyurethane (isocyanate & polyol). Most effective for polyurethanes with aromatic isocyanate.

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

TYPICAL PROPERTIES:

EFFECTIVE INGREDIENTS:	100%
SOLIDS:	100%
COLOR:	Yellow
SPECIFIC GRAVITY:	0.986 @ 25°C
VISCOSITY:	325 cps @ 25°C
pH:	3.89
FLASH POINT:	>95 C
SHELF LIFE:	Minimum of one year

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 a minimum of 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.

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.

(Aug 11, 2017)