

## technical data

# AXEL

PLASTICS RESEARCH LABORATORIES, INC.  
MOLD RELEASES & INTERNAL LUBRICANTS

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## MOLD WIZ INT-DCP-220

**General:** A process aid additive designed especially for MEKP cured resins, including DCPD. An effective addition of process aid additive will not have any adverse effect on the physical properties of the finished part. Thermoset molded parts may have improved Barcol hardness and better fiber wet-out. The complex polymeric nature of the process aid additive will not interfere with secondary operations such as painting or bonding..

**Use:** DCPD, unsaturated polyester,

**Composition:** Proprietary synergistic blend of organic triglyceride of fatty acids combined with surfactants and wetting agents.

### TYPICAL PROPERTIES:

<b>EFFECTIVE INGREDIENTS:</b>	<b>100%</b>
<b>SOLIDS:</b>	<b>100%</b>
<b>*COLOR:</b>	<b>Amber</b>
<b>SPECIFIC GRAVITY:</b>	<b>0.932 @25°C</b>
<b>VISCOSITY:</b>	<b>130 – 170 cps @ 25°C</b>
<b>pH:</b>	<b>3.0 – 5.0</b>
<b>REFRACTIVE INDEX:</b>	<b>1.473</b>
<b>FLASH POINT:</b>	<b>460°F / 238°C (Self Extinguishable)</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. MoldWiz® Process Aid Additives are effective within a range of 0.5 to 2.5 parts per 100 resin by weight, excluding reinforcements, pigments and fillers. Always start an evaluation at a minimum of 1.0 part per 100 parts of resin (1.0%). High amounts of filler may require a higher percentage of process aid additive. Too much additive may affect the cure or physical properties.

**Mixing:** Always incorporate the DCP220 in to the mix after any low profile additives, and fillers. The LPA's and fillers should be completely incorporated prior to adding the DCP220.

discretion and risk, and we assume no liability in connection with their use.

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