



Mold Release Agents & Process Aid Additives

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## Technical Data Sheet

# MoldWiz®

## INT-DLP-22E

Internal Mold Release

Process Aid Additive

## MoldWiz® INT-DLP-22E

**General:** A process aid additive designed for MEKP cured resins, especially DCPD. Provides greatly reduced mold build-up (scumming) and ease of release. Reduced demold times. Reduced application of external release agents. Does not affect inter-laminar bond of gel-coat and resin. Improves fiber wet-out. Improves adhesion of paints, and adhesives when used at 2%.

**Use:** Polyester (DCPD), Vinyl Ester

**RTM, Hand lay-up/spray up and Filament winding.**

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

### TYPICAL PROPERTIES:

<b>EFFECTIVE INGREDIENTS:</b>	<b>100%</b>
<b>COLOR:</b>	<b>Amber.</b>
<b>SPECIFIC GRAVITY:</b>	<b>0.930 @ 25°C</b>
<b>VISCOSITY:</b>	<b>50 - 150 cps @25°C</b>
<b>Solubility in water:</b>	<b>Insoluble</b>
<b>FLASH POINT:</b>	<b>Non Flammable (C.O.C.)</b>
<b>SHELF LIFE:</b>	<b>Minimum of one year</b>

### Application Instructions:

**General:** 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%). A gel time test should be done to determine the effect on gel time. High amounts of filler may require a higher percentage of process aid additive. Too much additive may affect the cure or physical properties (>4%). For improved adhesion, DLP-22E should be added at 2% by weight to the resin. This will improve adhesion for paints and adhesives while in most cases eliminating non-value-added steps, such as: sanding.

**Mixing:** Always incorporate the DLP-22E in to the mix after any fillers. The addition of microthene should be avoided when looking for improved adhesion.

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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