

technical data

AXEL

PLASTICS RESEARCH LABORATORIES, INC.
MOLD RELEASES & INTERNAL LUBRICANTS

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MOLD WIZ INT-EP-545SL

General: A process aid additive with anti-static properties which is incorporated directly into the resin or rubber eliminating the need for an external mold release agent. FRP molds require a surface coating to seal the porosity and maintain the gloss. An effective addition of process aid additive will not have any adverse affect on the cured resin. Thermoplastic molded parts will be stress-free and thermoset parts may have improved Barcol hardness. The complex polymeric nature of the process aid additive will not interfere with secondary operations such as decorating, silk screen, painting, bonding or plating.

Use: Polyester, Epoxy and Glass Fiber Processing.

Recommended for solventless thin aliphatic amine cured systems

Recommended for water-based polyester and epoxies cured with aliphatic polyamines, polyaminoamides and polyamides. Readily water soluble/dilutable

Composition: Proprietary synergistic blend of organic fatty acids, and esters combined with neutralizing agent.

TYPICAL PROPERTIES:

EFFECTIVE INGREDIENTS:	100%
COLOR:	Pale straw / Slightly hazy
SPECIFIC GRAVITY:	1.06 @ 25°C
VISCOSITY:	300 cps @ 25°C
pH:	10.0
FLASH POINT:	Non Flammable
SHELF LIFE:	Minimum of one year

Application Instructions:

General: For best results, laboratory tests or pre-production trials should determine the optimum addition level. MOLD WIZ Process Aid Additives are effective within a range of 1 to 10 parts per 1000 resin or rubber by weight, excluding reinforcements, pigments and fillers. A high amount of filler may require a higher percentage of process aid additive than the indicated maximum. Always start an evaluation at 5 parts per 1000 (0.5%). Too much additive may retard the cure. Reduce the level of additive or slightly increase the catalyzing.

Mixing: For two-part thermoset resins, mix the process aid additive in the less viscous or less reactive side before catalyzing.

Glass Fiber Processing: For optimum results evaluate experimentally in water solution(seizing) in the range of 0.5 – 10 %.

Veil Processing for release properties: Add 1% by resin weight that will be saturated on the veil.

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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