

technical data



PLASTICS RESEARCH LABORATORIES, INC.
MOLD RELEASES & INTERNAL LUBRICANTS

50 Cambridge Drive, Monroe, CT 06468

Tel: 718-672-8300 • Fax: 718-565-7447

E-mail: info@axelplastics.com

MOLD WIZ INT-1209

A process aid additive with anti-static properties which is incorporated directly into the resin eliminating the need for an external mold release agent. Improves resin flow and line speeds. An effective addition of process aid additive will not have any adverse effect on the cured resin. 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: Polyester Vinyl Ester SMC/BMC

Composition: Proprietary complex mixture of organic acid phosphate esters.

TYPICAL PROPERTIES:

EFFECTIVE INGREDIENTS:	100%
COLOR:	Clear
SPECIFIC GRAVITY:	1.045 @25°C
pH:	2.29
VISCOSITY:	705 cps @ 25°C
REFRACTIVE INDEX:	1.4605
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 by weight, excluding reinforcements, pigments and fillers. High amounts 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 catalyst.

Mixing: Mix into resin prior to addition of catalyst, fillers, and other resin additives.

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.

(060403)