



PLASTICS RESEARCH LABORATORIES, INC.
MOLD RELEASES & PROCESS ADDITIVES

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Technical Data Sheet

MoldWiz®

INT-1651

**Internal Mold Release
Process Aid Additive**

Product Description

A process aid, which is incorporated directly into the resin. Improves resin flow/fill, improves Scratch & Mar properties, and improves dispersion of other resin additives (reinforcements, fillers, and pigments). Also shortens cycle times by reducing temperatures and pressures of molding machines, and reduces or eliminates weld/knit lines. An effective addition of process aid additive will not have any adverse effect on physical properties or secondary operations such as decorating, printing, bonding, or plating.

Composition

Proprietary synergistic blend of modified polymers, fatty acids and fatty esters.

Handling

Keep container closed when not in use. Store in dry location below 100°F / 38°C.

Uses

Especially recommended for high-temperature engineering plastics such as ULTEM®, Nylon, Polyether ether ketone (PEEK) polyethylenimines (PEI) & polyphenylbenzimidazole (PBI) etc. and their blends/alloys.

Typical Properties

Color	White
Dropping Point	141.8°F / 61°C
Shelf Life	1 yr. minimum in original closed container

Instructions for Use

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 - 20 parts per 1000 resin excluding reinforcements, pigments and fillers. A high amount of filler may require a higher percentage of process aid additive than the indicated maximum. Start an evaluation from 10 per 1000 (1.0%). To eliminate screw slippage, reduce the level of additive or reduce the process temperature to raise the resin viscosity.

Mixing: Dry blend the process aid additive by tumbling or use an additive dispenser to meter directly into the resin stream. Process aid additives may be compounded into the resin to make a master-batch. Avoid adding the INT-1651 prior to drying the resin. INT-1651 should be added after drying.

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