



PLASTICS RESEARCH LABORATORIES, INC.  
MOLD RELEASES & PROCESS ADDITIVES

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Technical Data Sheet

**MoldWiz®**

**INT-1851**

**Internal Mold Releases  
Process Aid Additives**

**Product Description**

A liquid internal mold release/process aid additive which is incorporated directly into the resin eliminating, or significantly reducing the need for an external mold release agent.

Internal mold release / process aids can also improve the wetting of reinforcements and fillers and enhance the surface appearance of molded parts.

An effective addition of process aid additive will not have any adverse effect on the cured resin or interfere with secondary operations such as printing, painting or bonding.

**Composition**

Proprietary synergistic blend comprising organic fatty acids, esters with amine neutralizing agent.

**Handling**

Keep container closed when not in use.  
Store above freezing and below 100°F / 38°C.  
DO NOT DILUTE

**Uses**

Epoxy, phenolic, vinyl ester and furan resin systems.  
Pultrusion and compression molding.

**Typical Properties**

Color	Light Amber
Specific Gravity	1.05
Flash Point	>250°F / > 121°C (C.O.C)
Viscosity	ca. < 1000
pH	ca.5
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. Typical addition level in resin formulations ranges from 10 – 35 parts /1000 by weight, excluding reinforcements, pigments and fillers. High amounts of filler and/or different processing conditions may require a higher or lower loading of the process aid additive. Axel recommends a starting addition level of 2.0 pph based on the total system weight (not including fillers).

Additional information on conducting pre-production trials is available in AXEL’s Technical Guide: Testing IMRs in Thermoset Resins.

**Mixing:** For two-part thermoset resins, mix the process aid additive in the less viscous or less reactive side of the resin system. Always fully mix in any other additives or fillers PRIOR to adding the AXEL INT-1851.

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