



PLASTICS RESEARCH LABORATORIES, INC.  
MOLD RELEASES & PROCESS ADDITIVES

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## Technical Data Sheet

# MoldWiz®

## INT-1859

### Internal Mold Release Process Aid Additive

#### 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 of organic fatty amines, esters and acids.

#### Handling

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

#### Uses

General purpose Internal mold release for various epoxy resin systems including Bisphenol A or F, and cures including: acid/anhydride, imidazole, aliphatic and aromatic amines and polyamines.

May also be used in vinyl ester and phenolic resins.

Suitable for processes including resin and BMC formulation; winding, laminating, casting, etc.

#### Typical Properties

Color	Amber
Specific Gravity	0.98
Flash Point	300°F / 149°C (C.O.C)
Refractive Index	1.46
Viscosity	ca. 1300 cps @ 25°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. Typical addition level in epoxy resin formulations ranges from 5 – 15 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.

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.

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