technical data

PLASTICS RESEARCH LABORATORIES, INC.
MOLD RELEASES & INTERNAL LUBRICANTS
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MOLD WIZ
INT-1880

General: A process aid additive and mold release with anti-static properties which is incorporated directly into the resin 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 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: Epoxy- acid/anhydride cure
- imidazole cure

Composition: Proprietary synergistic blend of organic fatty acids, esters and amine combined with wetting agents.

TYPICAL PROPERTIES:

EFFECTIVE INGREDIENTS:	**100%**
SOLIDS:	**100%**
COLOR:	**Amber**
SPECIFIC GRAVITY:	**0.972 @ 25ºC**
VISCOSITY:	**250 - 650 cps @ 25°C**
pH:	**8.5**
FLASH POINT:	**>350ºF / >177ºC (C.O.C.)**
SHELF LIFE:	**Minimum of one year**

Application Instructions:

General: For best results, laboratory tests or pre-production trials should determine the optimum addition level. MoldWiz 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. For additional information, refer to Process Aid Additives / Thermoset Resins – Testing Procedures.

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

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