

## technical data



PLASTICS RESEARCH LABORATORIES, INC.  
MOLD RELEASES & INTERNAL LUBRICANTS

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# MOLD WIZ

## INT-2447

**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. Some molds (FRP molds, for instance) may require an external release agent 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 internal will not interfere with secondary operations such as decorating, silk screen printing, painting, bonding or plating.

**Use: Thermosets:**  
**Polyester Vinyl Ester**

**Composition:** Complex mixture of alkoxyated fatty amine, fatty esters and Calcium Sulphonate.

### TYPICAL PROPERTIES:

<b>SOLIDS:</b>	<b>100%</b>
<b>EFFECTIVE INGREDIENTS:</b>	<b>100%</b>
<b>COLOR:</b>	<b>Dark amber</b>
<b>SPECIFIC GRAVITY:</b>	<b>0.970 @ 25°C</b>
<b>VISCOSITY:</b>	<b>1300 cps @ 25°C</b>
<b>pH:</b>	<b>8.0</b>
<b>FLASH POINT:</b>	<b>Non Flammable</b>
<b>SHELF LIFE:</b>	<b>Minimum of one year</b>

### Application Instructions:

**General:** For best results, laboratory tests or pre-production trials should determine the optimum addition level. MoldWiz® process aid additives are effective resoles within a range of 5 to 15 parts per 1000 resin by weight, excluding reinforcements, pigments and fillers. High amounts of filler may require an increased percentage of process aid additive than the indicated maximum. Always start an evaluation at 5 parts per 1000 (0.5%). In thermosets, too much additive may retard the cure. Reduce the level of additive or slightly increase the catalyst.

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.

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