

technical data



PLASTICS RESEARCH LABORATORIES, INC.
MOLD RELEASES & INTERNAL LUBRICANTS

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MOLD WIZ INT-390A

General: An internal lubricant and mold release with ant-static properties which is incorporated directly into the resin or gel coat 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 internal lubricant will not have any adverse effect on the cured resin. Thermoplastic molded parts will be stress-free and thermoset parts may have improved Barcol hardness. The complex polymeric nature of the internal will not interfere with secondary operations such as decorating, silk screen printing, painting, bonding or plating

**Use: Polyester resin & Gelcoat
Thermoplastic polyester**

Composition: Proprietary condensation product of synthetic resins, glycerides & organic acid derivatives in an intimate combination with otherwise modified fatty acids.

TYPICAL PROPERTIES:

EFFECTIVE INGREDIENTS:	100%
SOLIDS:	100%
COLOR:	Light Amber
SPECIFIC GRAVITY:	0.896 @ 25°C
VISCOSITY:	<150 cps @ 25°C
FLASH POINT:	Non Flammable
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 internal lubricants are effective within a range of 1 to 10 parts per 1000 resin or rubber by weight, excluding reinforcements, pigments and fillers. High amount of filler may require a higher percentage of internal lubricant than the indicated maximum. Always start an evaluation at 5 parts per 1000 (0.5%). In thermosets, too much internal may retard the cure. Reduce the level of internal or slightly increase the catalyst. In the thermoplastics, the internal may increase the MFI. Reduce the level of internal, or reduce the process temperature to raise the resin viscosity and to eliminate screw slippage. For additional information, refer to Internal Mold Release – Testing Procedures.

Mixing: For two-part thermoset resins, mix the internal in the less viscous or less reactive side before catalyzing. For thermoplastics, dry blend the internal by tumbling, or use an additive dispenser to meter directly into the resin stream. Internals may be compounded into the resin to make a masterbatch.

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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