

## technical data



PLASTICS RESEARCH LABORATORIES, INC.  
MOLD RELEASES & INTERNAL LUBRICANTS

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# Mold Wiz

## INT-420/2C

**General:** A process aid additive with anti-static properties which is incorporated directly into the resin eliminating the need for an external mold release agent. Additional advantages include better resin flow, improved dispersion of other resin additives, faster cycle times, reduced temperatures and pressures of molding machines, and elimination of weld/ knit lines. The complex polymeric nature of the process aid additive will not interfere with secondary operations such as printing, bonding, or hot foil stamping.

**Use: Urethane Elastomers**  
Polyurethane Foam, TPU

**Composition:** Proprietary condensation product of synthetic resins, esters, organic acid derivatives and hydrocarbons in an intimate mixture with modifying and neutralizing agents.

### **TYPICAL PROPERTIES:**

<b>EFFECTIVE INGREDIENTS:</b>	<b>100%</b>
<b>NON-VOLATILES:</b>	<b>100%</b>
<b>COLOR:</b>	<b>Amber-Yellow</b>
<b>SPECIFIC GRAVITY:</b>	<b>0.946 @ 25°C</b>
<b>VISCOSITY:</b>	<b>100 – 200 cps @ 25°C</b>
<b>FLASH POINT:</b>	<b>350°F / 177° C (C.O.C.)</b>
<b>SHELF LIFE:</b>	<b>Minimum of one year</b>
<b>R.I.:</b>	<b>1.4630</b>
<b>pH:</b>	<b>7.0 – 9.0</b>

### **Application Instructions:**

**General:** For best results, laboratory tests or pre-production trials should determine the optimum level.

#### **Thermoset Urethanes:**

When used in polyurethane foam, MoldWiz® process aid additives should be added to the resin (polyol) stream to avoid any potential chemical reaction from occurring prematurely with the isocyanate. Start with an addition level of 1.5% by weight, based on combined isocyanate and resin (polyol) weights. Levels may be increased or decreased to optimize release properties and minimize possible interference with reaction.

#### **Thermoplastic Urethanes (TPU's)**

Start evaluation at 0.5% based on TPU weight.

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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