

technical data



PLASTICS RESEARCH LABORATORIES, INC.
MOLD RELEASES & INTERNAL LUBRICANTS

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MOLD WIZ INT-43GHT

General: A process aid additive which is incorporated directly into resin, and into, or on to filler, reinforcements or pigment. Improves flow and dispersion of other resin additives (reinforcements, fillers, and pigments), shortens cycle times, reduces temperatures and pressures of molding machines, and reduces or eliminates weld/knit lines. Eliminates the need for an external mold release agent. An effective addition of process aid additive will not have any adverse effect on physical properties or secondary operations such as decorating, printing, bonding, or plating.

Use: As a surface treatment, flow enhancer / dispersant for fillers and color. Improves wetting and loading and reduces torque in mixing. Can be used in combination with, or a replacement for, silane treatments.

Also for processing thermoplastic resins, especially those molded at high temperatures (above 500°F/260°C)

Each component in this formulation has been certified by our raw material suppliers as having direct USFDA approval for food contact.

Composition: Proprietary synergistic blend of modified phenyl polymers.

TYPICAL PROPERTIES:

EFFECTIVE INGREDIENTS:	100%
SOLIDS:	100%
COLOR:	Colorless
SPECIFIC GRAVITY:	1.025 @ 25°C
VISCOSITY:	ca. 220 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. MOLD WIZ Process Aid Additives are effective within a range of 1 to 10 parts per 1000 resin or rubber 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%). In thermosets, too much process aid additive may retard the cure. Reduce the level of additive or slightly increase the catalyst. In thermoplastics, the process aid additive may increase the MFI. Reduce the level of additive, or reduce the process temperature to raise the resin viscosity and to eliminate screw slippage.

Mixing: For two-part thermoset resins, mix the process aid additive in the less viscous or less reactive side before catalyzing. For thermoplastics, dry blend the process aid additive by tumbling, or use an additive dispenser to meter directly into the resin stream. Process aid additives 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.

(30/SEP/16)