



PLASTICS RESEARCH LABORATORIES, INC.
MOLD RELEASES & PROCESS ADDITIVES

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Technical Data Sheet

MoldWiz®

INT-619

Process Aid Additive

Product Description

A process aid, resin additive that will improve flow properties while maintaining MFI.

Will also enhance dispersion of other resin additives (reinforcements, fillers, pigments, etc.); increase through-put; reduce cycle time; permit effective processing/molding at lower temperatures and pressures.

May be used to improve the surface appearance and scratch resistance of molded parts.

An effective addition of process aid additive will not have any adverse effect on the cured resin or interfere with secondary operations such as printing, painting or bonding.

Composition

Proprietary synergistic blend of modified polymers and waxes.

Handling

Keep container closed when not in use.
Store above freezing and below 100°F / 38°C.

Uses

Especially recommended for polycarbonate, polycarbonate blends and PP resins including clarified PP. Not recommended for clear polycarbonate – use INT-619C.

Recommended for improving scratch and mar resistance in polycarbonate, polycarbonate blends, polyolefins and other engineering resins

Typical Properties

Effective Ingredients:	100%
Solids:	100%
Color:	White
Dropping Point:	153°F/67°C
Flash Point:	Non-flammable (C.O.C)
Shelf life	Minimum of one year
Availability:	Powder or Pellet form

Instructions for Use

For best results, laboratory tests or pre-production trials should determine the optimum addition level. Addition level ranges from 1 – 30 parts /1000 by weight, excluding reinforcements, pigments and fillers. Loading at the higher end of this range may apply when there are compounding; using high loadings of filler; or where improved scratch resistance is desired.

For molding, begin evaluations at 5 parts per 1000 (0.5%). If screw slippage occurs, reduce the addition level of the additive and/or reduce temperature.

Mixing: The process aid additive may be dry blended; dispensed with an additive feeder; introduced directly into the resin stream; or compounded into the resin to create a masterbatch.

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