

Technical data

AXEL

PLASTICS RESEARCH LABORATORIES, INC.
MOLD RELEASES & INTERNAL LUBRICANTS

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MOLD WIZ

INT-704S

Pellet/Powder (100% Active)

General: A process aid, which is incorporated directly into the resin. Improves resin flow/fill, 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. End properties such as slip and Scratch & Mar are also enhanced, depending on loading. 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: Processing all polyolefins especially TPO, TPE, TPV & TPU. Also for other resins where improved lubricity of the molded part, or reduced coefficient of friction is required. Especially recommended for improving processing of Polycarbonate blends such as PC/PBT and PC/ABS and related polymers.

Composition: Proprietary synergistic blend of modified polymers, organic fatty amides and waxes.

TYPICAL PROPERTIES:

EFFECTIVE INGREDIENTS:	100%
SOLIDS:	100%
COLOR:	Off White
DROPPING POINT:	243°F / 117°C
SHELF LIFE:	Minimum of one year
AVAILABILITY:	Powder or Pellet form

Application Instructions:

General: For best results, laboratory tests or pre-production trials should determine the optimum addition level. Mold Wiz® process aid additives are typically effective within a range of 1 to 10 parts per 1000 resin excluding reinforcements, pigments and fillers. A high amount of filler may require a higher percentage of process aid additives than the indicated maximum. For release and flow, start an evaluation from 1 part per 1000 (0.1%). Reduce the level of additive or reduce the process temperature to raise the resin viscosity and to eliminate screw slippage. Otherwise increase the level of additive if the loading was not sufficient for other target end properties. To emphasize alternative end properties such as Scratch and Mar, start the evaluation from 10 parts per 1000 (1.0%) and increase to pass associated tests if necessary.

Mixing: 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 master-batch.

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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