

technical data

AXEL

PLASTICS RESEARCH LABORATORIES, INC.
MOLD RELEASES & INTERNAL LUBRICANTS

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MOLD WIZ INT-DLP30RH

General: A process aid additive/mold release with anti-static properties, which is incorporated directly into the resin. Provides release, improves resin flow, and improves dispersion of other resin additives (reinforcements, fillers, and pigments). An effective addition of process aid additive will not have any adverse effect on physical properties or secondary operations such as decorating, or printing for thermoplastics, and painting or bonding for thermosets.

Use:

Thermoplastic: PVC Vinyl Plastisol

Thermoset: Polyester Resin.

Composition: Proprietary synergistic blend of organic fatty acids, esters and amine combined with wetting agents.

TYPICAL PROPERTIES:

EFFECTIVE INGREDIENTS:	100%
SOLIDS:	100%
GARDNER COLOR:	12 max.
SPECIFIC GRAVITY:	0.926 @25°C
VISCOSITY:	43 cps @25°C
FLASH POINT:	>250°F / >121°C
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 excluding reinforcements, pigments and fillers. A high amount of filler may require a higher percentage of process aid additive.

Thermoplastic: We recommend a starting addition rate at 5 parts per 1000 (0.5%).

Thermoset: We recommend a starting addition rate of between 1.0-1.5% by resin weight. A total range of 0.5%-3.0% is not uncommon.

Mixing: For thermosets, we recommend the DLP30RH be added after all other components except the catalyst or catalysts.

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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