

## technical data



PLASTICS RESEARCH LABORATORIES, INC.  
MOLD RELEASES & INTERNAL LUBRICANTS

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# MOLD WIZ

## INT-PS-140

**General:** A process aid additive designed specifically for pultrusion. The benefit is to optimize line speed while reducing both pull force and die wear. Improves wet out of fiber, fillers and resin flow while reducing viscosity. Physical properties of the profile are retained or improved. The complex polymeric nature of the process aid additive will not interfere with secondary operations such as decorating, silk screen printing, painting, bonding, or plating.

**Use: Polyester Vinyl Ester Modar™**  
**Pultrusion Hot Press Molding**  
**Resin Transfer Molding**

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

### TYPICAL PROPERTIES:

<b>EFFECTIVE INGREDIENTS:</b>	<b>100%</b>
<b>COLOR:</b>	<b>Amber</b>
<b>SPECIFIC GRAVITY:</b>	<b>0.988 @ 25°C</b>
<b>VISCOSITY:</b>	<b>1000 - 1300 cps @25°C</b>
<b>pH:</b>	<b>6.5</b>
<b>REFRACTIVE INDEX:</b>	<b>1.465</b>
<b>FLASH POINT:</b>	<b>380°F / 193°C (C.O.C.)</b>
<b>SHELF LIFE:</b>	<b>Minimum of one year</b>

### Application Instructions:

**General:** For best results, laboratory tests or pre-production trials should determine the optimum addition level. MoldWiz® process aid additives are effective within a range of 1 to 10 parts per 1000 resin 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%). Too much additive may retard the cure. Reduce the level of additive or slightly increase the catalyst.

**Mixing:** Mix into resin prior to addition of catalyst, fillers, and other resin additives.

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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