



PLASTICS RESEARCH LABORATORIES, INC.
MOLD RELEASES & PROCESS ADDITIVES

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Technical Data Sheet

MoldWiz®

INT-PUL-341

Internal Mold Release Process Aid Additive

Product Description

A liquid internal mold release/process aid additive which is incorporated directly into the resin to provide release from the die in pultrusion processing. Will also: improve line speed; reduce pull force; enhance wetting of reinforcements and fillers; and improve the surface appearance of molded profiles.

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 of cured parts.

May also be used as an internal mold release in other processes that utilize polyester, vinyl ester and hybrid thermoset resin systems.

Composition

A proprietary synergistic blend of organic fatty acids, esters and amines.

Handling

Keep container closed when not in use.
Store above freezing and below 100°F / 38°C.
DO NOT DILUTE
MIX WELL JUST BEFORE USE

Uses

For pultrusion of polyester, vinyl ester, and hybrid resin systems including acrylate and urethane modified resins.

Especially suitable for hybrid resins, including Modar® and Crestapol®1212, and for resin systems which incorporate high loadings of fillers, particularly ATH.

Typical Properties

Effective Ingredients	100%
Color	Light Amber
Specific Gravity	0.964
pH	4.8
Viscosity	ca. 350 cps @ 25°C
Shelf Life	1 yr. minimum in original closed container

Instructions for Use

For best results, laboratory tests or pre-production trials should determine the optimum addition level. Typical addition level in polyester or vinyl pultrusion is 10-15 parts/1000 by weight (1% - 1.5%) by resin weight (excluding fillers), although small or simple profiles geometry may be achieved with lower addition.

High amounts of filler and/or hybrid resin systems may require higher addition levels (30 parts/1000 or 3%. Additional information on conducting pre-production trials is available in AXEL's Technical Guide: Testing IMRs in Thermoset Resins.

Mixing: For two-part thermoset resins, mix the process aid additive in the less viscous or less reactive side of the resin system. Add prior to the addition of any catalysts.

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Crestapol is a registered trademark of Scott Bader Ltd..

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