technical data

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MOLD RELEASES & INTERNAL LUBRICANTS
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MOLD WIZ
INT-PUL-421

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. 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 painting, bonding, or plating.

Use: Polyurethane (isocyanate & polyol) Pultrusion systems – Tin catalyzed

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

TYPICAL PROPERTIES:

EFFECTIVE INGREDIENTS:	**100%**
SOLIDS:	**100%**
COLOR:	**Pale Yellow**
SPECIFIC GRAVITY:	**1.00 @ 25ºC**
VISCOSITY:	**470 cps @ 25°C**
pH:	**7 – 9**
FLASH POINT:	**>295ºF / >146ºC (C.O.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. Always start an evaluation by determining the effect of the process aid additive on gel time and adjust catalyst package to meet cure schedule requirements. Add to the polyol/resin component and mix thoroughly to ensure uniform dispersion prior to combining with isocyanate.

Evaluation in polyurethane systems should start at 2 parts per 100 parts of reactive isocyanate and resin components combined. Depending on the nature of the fillers and reinforcements incorporated into the system, even higher levels may be required. For example, complex profiles or those containing at least 60% glass rovings by volume typically use 3 parts of internal lubricant.