

technical data



PLASTICS RESEARCH LABORATORIES, INC.
MOLD RELEASES & INTERNAL LUBRICANTS

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MOLD WIZ INT-PUL-7

General: An internal lubricant and mold release with anti-static which is incorporated directly into the resin eliminating the need for an external mold release agent. Improves resin flow and line speeds. An effective addition of internal lubricant will not have any adverse effect on the cured resin. The complex polymeric nature of the internal 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 complex mixture of primary, secondary fatty amines with copolymers of organic phosphate esters and fatty acids.

TYPICAL PROPERTIES:

EFFECTIVE INGREDIENTS:	100%
GARDNER COLOR:	2
SPECIFIC GRAVITY:	0.974 @ 25°C
VISCOSITY:	250 - 350 cps @25°C
pH:	6.0 – 7.0
REFRACTIVE INDEX:	1.457
FLASH POINT:	300°F / 149°C (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. MoldWiz® internal lubricants are effective within a range of 0.75 to 2.0 parts per 100 resin by weight, excluding reinforcements, pigments and fillers. Always start an evaluation at 1 part per 100. High amount of filler may require a higher percentage of internal lubricant. Too much internal may retard the cure. Reduce the level of internal or slightly increase the catalyst

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

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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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