

## technical data



50 Cambridge Drive, Monroe, CT 06468

Tel: 718-672-8300 • Fax: 718-565-7447

E-mail: [info@axelplastics.com](mailto:info@axelplastics.com)

# MOLD WIZ INT-PUL-75

**General:** A cost effective Process Aid Additive designed specifically for pultrusion applications, targeting higher pulling speeds consistent with reduced pull loads, lower addition levels of PAA and die wear. Improves wet out of fiber, fillers and resin flow. 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, silkscreen printing, painting, bonding, or plating.

**Use: Unsaturated Polyester Resins for Pultrusion Applications**

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

### **TYPICAL PROPERTIES:**

<b>EFFECTIVE INGREDIENTS:</b>	<b>100%</b>
<b>GARDNER COLOR:</b>	<b>5 max.</b>
<b>SPECIFIC GRAVITY:</b>	<b>0.96 @ 25°C</b>
<b>VISCOSITY:</b>	<b>230 cps @25°C</b>
<b>pH:</b>	<b>3.5</b>
<b>FLASH POINT:</b>	<b>297°F / 147°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. It is recommended that the contact surfaces of the die and the dry rovings are first primed with the INT-PUL-75 prior to start up with the fully formulated resin system. INT-PUL-75 is in most cases effective at lower addition levels compared with other brand name or generic release aids. Always start an evaluation at 1 part INT-PUL-75 per 100 parts resin – 1 phr (by weight) - before reducing to typical 0.75 phr loading level. Further reductions may be possible depending on the prevailing pull loads of the line operation. Filler loadings higher than 25 phr or especially difficult profiles may demand increased additions of INT-PUL-75.

**Mixing:** Mix into resin after addition of pigments, fillers, and other resin additives to avoid air entrainment in the formulated resin mix.

**Storage:** Prevent INT-PUL-75 from exposure to cold and freezing temperatures. Store at minimum of 60F/15C. It will separate if stored below 60°F/15°C but may still be used if thoroughly re-dispersed for 10 minutes at low shear. INT-PUL-75 will solidify if stored below 40°F/5°C and will require warming to at least 60F/15C with re-dispersion before use. Frozen or separated INT-PUL-75 may be readily restored to its original liquid condition following gentle warming overnight at 104°F/40°C and will remain liquid at 60°F/15°C. Do not use below 60°F/15°C.