

## technical data



PLASTICS RESEARCH LABORATORIES, INC.  
MOLD RELEASES & INTERNAL LUBRICANTS

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-820

**General:** A Process Aid Additive designed specifically for pultrusion. Benefits include excellent release, providing optimized line speeds while reducing both pull force and die wear; improved wet out of fiber, fillers and resin. Physical properties of the profile are retained or improved. Tight controls in the manufacture of this product ensure that potential adverse effects from moisture on polyurethane resins are minimized. Secondary operations on PU composites using this product, such as painting, bonding, or plating, are not impaired.

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

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

### TYPICAL PROPERTIES:

<b>EFFECTIVE INGREDIENTS:</b>	<b>100%</b>
<b>SOLIDS:</b>	<b>100%</b>
<b>COLOR:</b>	<b>Pale Yellow</b>
<b>SPECIFIC GRAVITY:</b>	<b>1.00 @ 25°C</b>
<b>VISCOSITY:</b>	<b>590 cps @ 25°C</b>
<b>pH:</b>	<b>7 – 9</b>
<b>FLASH POINT:</b>	<b>&gt;295°F / &gt;146°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. 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.

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.