

## technical data

# AXEL

PLASTICS RESEARCH LABORATORIES, INC.  
MOLD RELEASES & INTERNAL LUBRICANTS

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## MOLD WIZ INT-RF-16

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**General:** A process aid additive with anti-static properties which is incorporated directly into the resin. Eliminating the need for an external mold release agent. Additional advantages include better resin flow, improved dispersion of other resin additives, faster cycle times, reduced temperatures and pressures of molding machines, and elimination of weld/knit lines. The complex polymeric nature of the process aid additive will not interfere with secondary operations such as printing, bonding, or hot foil stamping.

**Use:** Urethane Elastomers  
Polyurethane Foam

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

### TYPICAL PROPERTIES:

<b>EFFECTIVE INGREDIENTS:</b>	<b>100%</b>
<b>SOLIDS:</b>	<b>75%</b>
<b>COLOR:</b>	<b>Pale Yellow</b>
<b>SPECIFIC GRAVITY:</b>	<b>0.904 @ 25°C</b>
<b>VISCOSITY:</b>	<b>500 – 900 cps @ 25°C</b>
<b>REFRACTIVE INDEX:</b>	<b>1.4885</b>
<b>pH:</b>	<b>8.0 – 10.0</b>
<b>FLASH POINT:</b>	<b>158°F / 70°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. MOLD WIZ process aid additives are effective within a range of 1 to 10 parts per 1000 resin excluding reinforcements, pigments and fillers. A high amount of filler may require a higher percentage of process aid additive than the indicated maximum. Always start an evaluation at 5 parts per 1000 (0.5%). The process aid additive may increase the MFI. Reduce the level of additive or reduce the process temperature to raise the resin viscosity and to eliminate screw slippage.

**Mixing:** For two part thermoset resins, mix the process aid additive in the less viscous or less reactive side before catalyzing. For thermoplastics, dry blend the process aid additive by tumbling, or use an additive dispenser to meter directly into the resin stream. Process aid additives may be compounded into the resin to make a masterbatch.

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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