

## technical data



PLASTICS RESEARCH LABORATORIES, INC.  
MOLD RELEASES & INTERNAL LUBRICANTS

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# MOLD WIZ INT-VMC-400

**General:** A non-silicone process aid additive for use in all types of rubber processing which eliminates the need for any external release minimizing mold and machine cleaning time. Facilitates processing by increasing the flow characteristics and lubricating qualities of the rubber formulation without affecting its mechanical properties. The cured product can be readily glued, bonded, coated, etc. and there is no exudation or deterioration after prolonged storage. There is an increase in elongation percentage and tensile strength with many formulations.

**Use:** VAMAC EVA SBR-Natural  
Natural and Synthetic Rubbers

**Composition:** Proprietary synergistic blend of organic fatty acids, esters and glycerides combined with polyolefins and wetting agents.

### TYPICAL PROPERTIES:

<b>EFFECTIVE INGREDIENTS:</b>	<b>100%</b>
<b>SOLIDS:</b>	<b>100%</b>
<b>COLOR:</b>	<b>White</b>
<b>SPECIFIC GRAVITY:</b>	<b>0.840 @220°F</b>
<b>VISCOSITY:</b>	<b>Solid brick form</b>
<b>DROPPING POINT:</b>	<b>219°F / 104°C</b>
<b>FLASH POINT:</b>	<b>&gt;400°F / &gt;204°C (C.O.C.)</b>
<b>SHELF LIFE:</b>	<b>Minimum of one year</b>

### Application Instructions:

**General:** Beginning with a clean mold will provide accurate results. It is recommended to remove mold release and rubber residue with CLEAN WIZ.

0.2-1.0 phr will be effective in most rubber compounds (2-10 parts per 1000 parts rubber). Begin testing with 0.25 and 0.5 phr to determine the optimum level of usage in a particular rubber recipe. Process aid additive may be Banbury mixed or milled in the rubber recipe. If the process aid additive can be milled with the rubber first, it will promote faster mixing of fillers and additives, also reducing tack on the mill. In molding operations, rubber viscosity will be reduced allowing better fill at lower temperature and pressure.

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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