



Mold Release Agents & Process Aid Additives

50 Cambridge Drive
Monroe, Connecticut 06468 USA
203.590.2000 | 800.332.2935
www.axelplastics.com

Technical Data Sheet

MoldWiz®

INT-33LSER

Internal Mold Release

Process Aid Additive

MoldWiz®

INT-33LSER

General: A process aid for lowering coefficient of friction and provide mold release. Improves resin flow/fill, improves dispersion of other resin additives, such as: reinforcements, fillers, and pigments. Shortens cycle times, allows for reduction in temperatures and pressures of molding machines, and reduces or eliminates weld/knit lines. Eliminates the need for an external mold release agent. Provides anti-static properties to the molded part. Remains clear at low to moderate loading levels. An effective addition of process aid additive will not have any adverse effect on physical properties or secondary operations such as printing, bonding, labeling, or plating.

Use: All PE, PP including TPO, TPE, TPV & TPU, PA, PPA, as well as other engineered thermoplastics.

Composition: Proprietary synergistic blend of organic fatty acids, esters and amides.

TYPICAL PROPERTIES:

EFFECTIVE INGREDIENTS:	100%
SOLIDS:	100%
COLOR:	Off White
SHELF LIFE:	Minimum of one year
AVAILABILITY:	Powder or Pellet form

Application Instructions:

General: For best results, laboratory tests or pre-production trials should determine the optimum addition level. MoldWiz® 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 3 to 5 parts per thousand (0.3%-0.5%). The additive may increase the MFI. For clear applications the INT-33LSER should be added at 1-2 parts per thousand.

Mixing: 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 or included in a master-batch. For polymers that are dried prior to molding, the INT-33LSER can handle high heat, so it can be added prior to the drying cycle in pellet form.