

The logo for AXEL, featuring the word "AXEL" in a white, serif font with a blue vertical bar on the right side of the letter "L". The logo is set against a dark blue rectangular background.

AXEL

# solutions for pultrusion

internal & external mold releases

AXEL products are specifically designed for pultrusion applications that require high filler and glass loadings, difficult profiles, and high production demands. Whether you pultrude ladder rail, optical cable, bridge structures, or aerospace components, you can be confident in AXEL quality.

Resin	Product Name	Description
<b>Polyester Vinyl Ester</b>	MoldWiz® INT-PUL24	Enhanced performance for polyesters and vinyl esters; for demanding operations and fast line speeds.
	MoldWiz® INT-PUL34	Enhanced performance for demanding applications; high loading of ATH (>50 phr). Good for most modified MMA hybrid resins.
	MoldWiz® INT-524M	General purpose; low complexity or smaller profiles.
	MoldWiz® INT-542WT	MMA modified polyester and BPO cures.
	MoldWiz® INT-PS125	Industry standard for aramids (Kevlar®). Can be used across the board for polyester and vinyl ester resin.
<b>Epoxy</b>	MoldWiz® INT-1324 MoldWiz® INT-1324B	INT-1324 ideal for DICY systems; INT-1324B ideal for anhydride amines and DICY blends.
	MoldWiz® INT-1857DC MoldWiz® INT-1846	Aromatic amine-cured epoxy.
	MoldWiz® INT-1846N2	Neutralized formulation. Amine or anhydride cures.
	MoldWiz® INT-1888LS MoldWiz® INT-1850HT	Bisphenol A or F epoxy with various cures, especially where high Tg must be maintained.
	MoldWiz® INT-1888LE MoldWiz® INT-1890M	For acid anhydride or imidazole cures.
	MoldWiz® INT-1888LE MoldWiz® INT-1324B MoldWiz® INT-1846N2	For acid anhydride with tertiary amine or imidazole. (Example: MTHPA)
	<b>Phenolic</b>	MoldWiz® INT-1850HT
<b>Polyurethane</b>	MoldWiz® INT-1948MCH MoldWiz® INT-1968RAC	For aromatic polyurethane pultrusion.
	MoldWiz® INT-1960MCH	For aliphatic polyurethane pultrusion.
	MoldWiz® INT-1940RTM	High performance for PU closed mold resins. Processes include infusion, RTM, etc.
	MoldWiz® INT-1944NRR	Suitable for pultrusion, infusion, or RTM when no change to gel time is required.

**Typical Loading Level of MoldWiz Internal Mold Release (based on total resin weight):**  
**0.5% - 2.5% in polyester / vinyl ester resins**  
**0.75% - 3/0% in epoxy resin systems**  
**1.0% - 3.0% in phenolic resin systems**  
**2.0% - 3.5% in polyurethane systems (typically added to the polyol; based on iso/polyol weight)**  
**NOTE: These are guidelines only. Profile size, complexity, filler loading, equipment, and other process requirements may impact these guidelines.**

This information is supplied for technically skilled professionals working at their own risk. AXEL believes the information to be accurate, although the Company assumes no liability in the validity of the information for any specific process or application. Please refer to individual data sheets for further application, safety, and handling information. MoldWiz®, XTEND®, PasteWiz®, and CleanWiz® are registered trademarks of Axel Plastics Research Laboratories, Inc. © 2020, Axel Plastics Research Laboratories, Inc. All Rights Reserved. Rev Jan 2020.

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