



AXEL

solutions for composites

internal mold releases

Manufacturers of advanced composite products understand the importance of delivering finished goods with superior structural and surface quality. When you need the best, AXEL internal mold releases deliver unparalleled results.

Polyester & Vinyl Ester

Peroxide Type / Group Classification	Product Name	Typical Application / Features
MEKP Ketone Peroxide	MoldWiz® INT-DLP-22E	Improved release, minimizes build up. For resins and gel coats.
	MoldWiz® INT-1515TBT	For clear or white gel coats; resin infusion.
Perkadox® 16 (Akzo) Peroxydicarbonate TBPP Tertiary Butyl Perbenzoate Peroxyesters Triganox® C (Akzo) Two Tier Cures Peroxydicarbonates + Peroxyesters	MoldWiz® INT-PUL24	High performance internal release for most applications.
	MoldWiz® INT-PUL34	Recommended for highly-filled ATH applications >40 or 50 phr.
	MoldWiz® INT-PS125	Excellent for aramid in combination with VE resins
	MoldWiz® INT-PUL524M	Low cost alternative to INT-PUL24.
BPO Diacyl Peroxide	MoldWiz® INT-54	
	MoldWiz® INT-542WT	
	MoldWiz® INT-1854	
AAP	MoldWiz® INT-DLP-22E	
	MoldWiz® INT-1838P	
2, 4-Pentanedione Ketone Peroxide	MoldWiz® INT-15TBT	
	MoldWiz® INT-389A	
Dicumyl Peroxide Dialkyl Peroxides	MoldWiz® INT-PUL24	
Cumene Hydroperoxide Hydroperoxide	MoldWiz® INT-DLP-22E	Often used with thick-sectioned parts of vinyl ester resins.
Lupersol® 231 (Atofina) Peroxyketals	MoldWiz® INT-626HT	Rapid molding and prolonged shelf life. For SMC and BMC.
	MoldWiz® INT-EQ6	

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Epoxy

Typical loading level of MoldWiz® internal mold release in epoxy resin is 0.5% - 1.5% based on resin weight, and depending on the type of molding process. Resin formulations with higher filler loading generally require higher loadings of internal release.

Cure Type / Group Classification	Product Name	Typical Application / Features
Aliphatic amines (Example: DETA)	MoldWiz® INT-1846N2	High performance. Works for most epoxies. Minimal to no impact on gel time.
	MoldWiz® INT-1888LE	Neutralized to prevent acceleration of cure.
	MoldWiz® INT-1850HT	For high temperature processing >350°F/167°C.
Acid Anhydride & some aromatic & aliphatic amines	MoldWiz® INT-1888LS	For high Tg requirements.
Cycloaliphatic amines (Example: PACM)	MoldWiz® INT-1846N2	For quick curing; filament winding.
	MoldWiz® INT-1850HT	
Aromatic amines, MDA & non-MDA based	MoldWiz® INT-1857DC	High temperature cures >450°F/230°C.
	MoldWiz® INT-1888LE	
Acid anhydride (Example: phthalic anhydride OR w/ tertiary amine or imidazole; MTHPA)	MoldWiz® INT-1888LE	High performance for anhydrides.
	MoldWiz® INT-1324B	Excellent for balance of Tg, short beam shear, line speed, surface cosmetics, etc.
	MoldWiz® INT-1846N2	General purpose for anhydrides.
	MoldWiz® INT-1890M	Classic internal for anhydrides. Not for high temperature applications.
Water-dispersable amines or polyamides	MoldWiz® INT-EP545(SL)	Good dispersion for epoxy emulsions; suitable for treating surface veils.
DICY (imidazole accelerated)	MoldWiz® INT-1324	Pre-preg or wet systems.
DICY with other amines	MoldWiz® INT-1324B	
	MoldWiz® INT-1888LE	



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800.332.AXEL

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Phenolics

Resin Type	Product Name	Typical Application / Features
Novolac Powdered, Hexa-cured	MoldWiz® INT-326PWD	Compression molding.
Novolac or Resol Liquid	MoldWiz® INT-1850HT	Pultrusion.
	MoldWiz® INT-PUL14	
Resol Alcohol-based	MoldWiz® INT-12	Phenolic laminates.
	MoldWiz® INT-1312MS	
Resol Aqueous-based	MoldWiz® INT-1E-11S Series	Phenolic laminates.

Polyurethanes

Product Name	Typical Application / Features
MoldWiz® INT-1230	General purpose release for foam or elastomers and non-aqueous in-mold coatings.
MoldWiz® INT-120IMC	Release additive for in-mold coatings and polyureas.
MoldWiz® INT-EPH19	Release additive for water-borne polyureas.
MoldWiz® INT-1681OG	release for optical grade cast PU.
MoldWiz® INT-1948MCH MoldWiz® INT-1968RAC	Release for PU pultrusion, primarily aromatic systems.
MoldWiz® INT-1960MCH	Release for PU pultrusion, primarily aliphatic systems.
MoldWiz® INT-1940RTM	Release additive for RTM, infusion, or other closed molded PU processes. Can also be used in pultrusion when no extension of gel time is desired.

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50 Cambridge Drive | Monroe, Connecticut 06468 US
800.332.AXEL | info@axelplastics.com | axelplastics.com



www.axelplastics.com
800.332.AXEL