



Mold Release Agents & Process Aid Additives

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Technical Data Sheet

MoldWiz®

INT-1944NRR

Process Aid Additive

MoldWiz® INT-1944NRR

General: A process aid additive primarily for providing internal release. Processes include, RTM, infusion, pultrusion, or casting. INT-1944NRR is specifically designed to have minimum effect on resin gel times or cure times. INT-1944NRR can be used for pultrusion when no delay in gel time is required. For pultrusion, line speeds can be maximized with excellent surface profiles while reducing pull force and die wear. Improved wet out of fiber, fillers and resin is evidenced by retained or improved physical properties of the profile. The complex polymeric nature of the process aid additive will not interfere with secondary operations, such as: painting or bonding.

Use: Epoxy, Polyurethane, In Mold Coatings RTM, Infusion, Pultrusion, and Casting.

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

TYPICAL PROPERTIES:

EFFECTIVE INGREDIENTS:	100%
COLOR:	Light Amber
SPECIFIC GRAVITY:	0.930 @ 25°C
VISCOSITY	225 cps @ 25 °C
FLASH POINT:	Non-Flammable
SHELF LIFE:	Minimum of one year

Application Instructions:

General: For best results, laboratory tests or pre-production trials should determine the optimum addition level.

For polyurethane systems, add to the polyol/resin component and mix thoroughly to ensure uniform dispersion prior to combining with isocyanate. Evaluation should start at 2-3 parts per 100 parts of reactive isocyanate and resin components combined. Depending on the nature of the fillers and reinforcements incorporated into the system, even higher levels may be required. INT-1944NRR is typically added to the polyol.

For Epoxy systems evaluations should start at 1-3 parts per 100 parts resin and curatives by weight combined.

For In-Mold Coatings 0.25-3.0% can be evaluated. A starting addition rate of between 0.5%-1.0% is recommended. All addition should be done by weight

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.