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Technical Data Sheet

MoldWiz® INT-DLP-60RS Internal Mold Release

Product Description: A process aid additive/internal mold release designed for MEKP cured resins, especially DCPD. Provides greatly reduced mold build-up (scumming) and ease of release. INT-DLP-60RS will reduce demold times and reduce application of external release agents. Does not affect inter-laminar bond of gelcoat and resin. Synergistic effect maximizes fiber wet-out, while improving adhesion of paints and adhesives when used at 2%*.

Use: For use with Polyester, Vinyl Ester, DCPD, PET and other blends

Composition: Balanced blend of inert natural oils and waxes

Handling: Please be sure to read the SDS and follow all precautions including appropriate PPE necessary to handle this product safely.

This product will freeze in cold temperatures. If frozen, warm up and remix to ensure a homogenous solution.

Keep tightly sealed while not in use.

Instructions for Use:

MoldWiz® Process Aid Additives are effective within a range of 0.5 to 2.5 parts per 100 resin by weight, excluding reinforcements, pigments and fillers. For starting evaluations, 1.0 part per 100 parts of resin (1.0%) are recommended. Typically, Low Profile Additives are counted towards resin weight, whereas fillers are not. High amounts of filler may require a higher percentage of process aid additive. Too much additive may affect the cure or physical properties (>4%).

Prior to use in production, the following tests are suggested to determine if there is any impact (changes) on the resin system:

- Gel Time
- Gel to Peak Time
- Peak Exotherm
- Barcol or Shore Hardness testing

Usually, there are no adverse effects to properties or molding cycles.

For improved adhesion, INT-DLP-60RS should be added at 2% by weight to the resin. This will improve adhesion for paints and adhesives while in most cases eliminating non-value-added steps, such as sanding.

Mixing:

It is suggested to incorporate fillers and any other additives prior to adding the INT-DLP-60RS.

Note: INT-DLP-60RS is highly effective for promotion of paint adhesion and adhesive properties. A loading level up to 2% is typical and in most cases will not affect physical properties of the polymer. As with all additives, validation testing should be conducted to ensure proper inter-laminar strength. The INT-DLP-60RS will typically have no impact on laminar strength as well as the gel coat when added to the resin (B) side.

Review SDS before use.

FEATURES:

Dramatically reduces mold build-up	Reduces external mold release usage
Improves release	Eventual build-up cleans up easily
Maximizes fiber wet-out	Does not affect gel time
Improves performance of paint and adhesives	

TYPICAL PROPERTIES:

COLOR:	Hazy yellow
SPECIFIC GRAVITY:	0.84 @ 25°C
VISCOSITY:	80 cps @ 25°C
pH:	4-6
FLASH POINT:	113°C
SHELF LIFE:	One year from the date of manufacture