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Technical Data Sheet

MoldWiz® INT-33LCA Internal Mold Release

Product Description:

Easy to use pellet or powder that helps release parts from the mold. Eliminates mold release spraying to automate the process. Smoother, glossier parts. Reduces coefficient of friction for easy assembly and for closures to open easier.

This lubricant will aid in flow. It will provide easier fill, with less pressure and lower process temperatures. These reductions will help reduce knit lines and flashing. Especially helpful for dispersion in filled resins. Will not affect secondary operations such as decorating, printing, bonding, labeling, in mold graphics, or plating.

Composition:

Proprietary synergistic blend of organic fatty acids, esters, and amides. Pellets and powder are 100% active.

Each component in this formulation has been certified by our raw material suppliers as having direct USFDA approval for indirect food contact.

Use:

PE, PP, TPO, TPE, TPR, TPV, TPU, ABS, PS, HIPS, CPS, PVC, SAN, SBS

For water clear resins consider INT-33UDS

Can be added at any stage of the process.

From resin manufacturing, compounding or directly pellet fed into the hopper.

Handling:

Please be sure to read the SDS and follow all precautions including appropriate PPE necessary to handle this product safely. Keep tightly sealed while not in use.

TYPICAL PROPERTIES:

DROP MELT POINT:	77.8°C – 90.0°C / 172.0°F – 194.0°F
COLOR:	Off-white
SHELF LIFE:	Two years from date of manufacture
AVAILABILITY:	Powder or Pellet form

Application Instructions:

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

General Use: MoldWiz process aid additives are effective within a range:

- 1-3/1000 (0.10% to 0.30%) help for flow and dispersion
- 3-10 /1000 (0.30% to 1.0%) Greatly improves release
- 10-20/1000 (1.0 - 2.0%) Reduces coefficient of friction: Easy removal of lids and caps and improves scratch and mar resistance.

Always start an evaluation at the lower range to prevent slipping on the screw.

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 to make a master-batch.

Review SDS before use.

FEATURES

Eliminates mold release spraying	Wider resin processing window ie. lower temps/ pressures.
Smoother, glossier parts	PFAS-free