

CELEBRATING

**85**  
YEARS  
1941 - 2026

**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                                                                     |
|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------|----------------------------------------------------------------------------------------------------|
| <b>MEKP</b><br>Ketone Peroxide                                                                                                                                                                | MoldWiz® INT-DLP-22E  | Improved release, minimizes build up. For resins and gel coats.                                    |
|                                                                                                                                                                                               | MoldWiz® INT-DLP-60RS | Improved release, minimizes build up. For resins and gel coats. Non-reactive, highest performance. |
|                                                                                                                                                                                               | MoldWiz® INT-15TBT    | For clear or white gel coats; resin infusion.                                                      |
| <b>Perkadox® 16 (Akzo)</b><br>Peroxydicarbonate<br><b>TBPB Tertiary Butyl Perbenzoate</b><br>Peroxyesters<br><b>Triganox® C (Akzo)</b><br>Two Tier Cures<br>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.                                                                 |
| <b>BPO</b><br>Diacyl Peroxide                                                                                                                                                                 | MoldWiz® INT-54       |                                                                                                    |
|                                                                                                                                                                                               | MoldWiz® INT-542WT    |                                                                                                    |
|                                                                                                                                                                                               | MoldWiz® INT-1854     |                                                                                                    |
| <b>AAP</b>                                                                                                                                                                                    | MoldWiz® INT-DLP-22E  |                                                                                                    |
|                                                                                                                                                                                               | MoldWiz® INT-DLP-60RS |                                                                                                    |
| <b>2, 4-Pentanedione</b><br>Ketone Peroxide                                                                                                                                                   | MoldWiz® INT-15TBT    |                                                                                                    |
| <b>Dicumyl Peroxide</b><br>Dialkyl Peroxides                                                                                                                                                  | MoldWiz® INT-PUL24    |                                                                                                    |
| <b>Cumene Hydroperoxide</b><br>Hydroperoxide                                                                                                                                                  | MoldWiz® INT-DLP-22E  | Often used with thick-sectioned parts of vinyl ester resins.                                       |
| <b>Lupersol® 231 (Atofina)</b><br>Peroxyketals                                                                                                                                                | MoldWiz® INT-EQ6      | Rapid molding and prolonged shelf life. For SMC and BMC.                                           |



## 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                                                                                       |
|--------------------------------------------------------------------------------------------------|---------------------|----------------------------------------------------------------------------------------------------------------------|
| <b>Aliphatic amines<br/>(Example: DETA)</b>                                                      | MoldWiz® INT-1846N2 | High performance. Works for most epoxies. Minimal to no impact on gel time.                                          |
|                                                                                                  | MoldWiz® INT-1888LE | High performance. Works for most epoxies. Neutralized to prevent acceleration of cure.                               |
|                                                                                                  | MoldWiz® INT-1850HT | For high temperature processing >350°F/167°C.                                                                        |
| <b>Cycloaliphatic amines<br/>(Example: PACM)</b>                                                 | MoldWiz® INT-1846N2 | For quick curing; filament winding.                                                                                  |
|                                                                                                  | MoldWiz® INT-1850HT |                                                                                                                      |
| <b>Aromatic amines, MDA &amp; non-MDA based</b>                                                  | MoldWiz® INT-1888LE | High performance. Works for most epoxies. Neutralized to prevent acceleration of cure.                               |
| <b>Acid anhydride<br/>(Example: phthalic anhydride OR w/ tertiary amine or imidazole; MTHPA)</b> | MoldWiz® INT-1888LE | High performance. Works for most epoxies. Neutralized to prevent acceleration of cure.                               |
|                                                                                                  | 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. First choice for epoxy wind spar production. |
|                                                                                                  | MoldWiz® INT-1888LS | For high Tg requirements.                                                                                            |
| <b>DICY with other amines</b>                                                                    | MoldWiz® INT-1324B  | Excellent for balance of Tg, short beam shear, line speed, surface cosmetics, etc.                                   |
|                                                                                                  | MoldWiz® INT-1888LE | High performance. Works for most epoxies. Neutralized to prevent acceleration of cure.                               |



# solutions for composites: internals

## Phenolics

| Resin Type                     | Product Name        | Typical Application / Features |
|--------------------------------|---------------------|--------------------------------|
| <b>Novolac or Resol Liquid</b> | MoldWiz® INT-1850HT | Pultrusion.                    |

## Polyurethanes

| Product Name                                 | Typical Application / Features                                                                                                                    |
|----------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------|
| 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<br>MoldWiz® INT-1968RAC | Release for PU pultrusion of aromatic and aliphatic systems.                                                                                      |
| MoldWiz® INT-1944NRR                         | 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. |

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. © 2026, Axel Plastics Research Laboratories, Inc. All Rights Reserved. Rev Feb 2026.

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



www.axelplastics.com  
800.332.AXEL