

technical data

AXEL

PLASTICS RESEARCH LABORATORIES, INC.
MOLD RELEASES & INTERNAL LUBRICANTS

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MOLD WIZ INT-1840

General: A process aid additive and mold release with anti-static properties which is incorporated directly into the resin or gel coat eliminating the need for an external mold release agent. FRP molds require a surface coating to seal the porosity and maintain the gloss. An effective addition of process aid additive will not have any adverse effect on the cured resin. The complex polymeric nature of the process aid additive will not interfere with secondary operations such as decorating, silk screen printing, painting, bonding, or plating.

Use: Epoxy @1.0 – 2.0% by resin weight
Especially recommended for PACM
(Cycloaliphatic amines)cured systems

Composition: Proprietary synergistic blend of organic fatty acids, esters and amine combined with hydrocarbon resin.

TYPICAL PROPERTIES:

EFFECTIVE INGREDIENTS:	100%
SOLIDS:	100%
COLOR:	Amber
SPECIFIC GRAVITY:	1.005 @ 25°C
VISCOSITY:	500 – 900 cps @ 25°C
pH:	2.0 – 4.0
FLASH POINT:	300°F/149°C (C.O.C)
SHELF LIFE:	Minimum of one year

Application Instructions:

General: For best results, laboratory tests or pre-production trials should determine the optimum addition level. MoldWiz Process Aid Additives are effective within a range of 1 to 10 parts per 1000 resin or rubber by weight, excluding reinforcements, pigments and fillers. High amount of filler may require a higher percentage of process aid additive than the indicated maximum. Always start an evaluation at 5 parts per 1000 (0.5%). Too much additive may retard the cure. Reduce the level of additive or slightly increase the catalyst.

Mixing: For two-part thermoset resins, mix the process aid additive in the less viscous or less reactive side before catalyzing.

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.

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