technical data

PLASTICS RESEARCH LABORATORIES, INC.
MOLD RELEASES & INTERNAL LUBRICANTS
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MOLD WIZ
INT-937

General: A process aid additive 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. Thermoplastic molded parts will be stress-free and thermoset parts may have improved Barcol hardness. 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: **THERMOSETS:**
Polyester resins, Gelcoats & MMA Modified resins
THERMOPLASTICS:
Acetal Polyethylene, Polystyrene, Polypropylene, Noryl and TPU

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

TYPICAL PROPERTIES:

EFFECTIVE INGREDIENTS:	**100%**
SOLIDS:	**100%**
***COLOR:**	**Amber**
SPECIFIC GRAVITY:	**0.890 @ 25ºC**
VISCOSITY:	**210 cps @ 25°C**
REFRACTIVE INDEX:	**1.466**
FLASH POINT:	**360ºF / 176ºC**
SHELF LIFE:	**Minimum of one year**

* The color may change over time from light to dark amber without effecting product performance.

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. A 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%). In thermosets, too much process aid additive may retard the cure. *Reduce the level of additive or slightly increase the catalyst. In thermoplastics, the process aid additive may increase the MFI. Reduce the level of additive, or reduce the process temperature to raise the resin viscosity and to eliminate screw slippage.

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

* For additional information, refer to Internal Mold Release / Thermoset Resin – Testing Procedures.

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