

## technical data

# AXEL

PLASTICS RESEARCH LABORATORIES, INC.  
MOLD RELEASES & INTERNAL LUBRICANTS

Mailing Address: Box 77 0855, Woodside, NY 11377  
Shipping Address: 58-20 Broadway, Woodside, NY 11377  
Tel: 718-672-8300 • Fax: 718-565-7447  
E-mail: [info@axelplastics.com](mailto:info@axelplastics.com)

## MOLD WIZ INT-1846N2

**General:** A process aid additive and mold release with anti-static properties which is incorporated directly into the resin eliminating the need for an external mold release agent. Improves resin flow and line speeds. 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**  
**Especially recommended for**  
**Aliphatic amine cured systems**

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

### TYPICAL PROPERTIES:

<b>SOLIDS:</b>	<b>100%</b>
<b>EFFECTIVE INGREDIENTS:</b>	<b>100%</b>
<b>COLOR:</b>	<b>Amber</b>
<b>SPECIFIC GRAVITY:</b>	<b>1.005 @ 25°C</b>
<b>VISCOSITY:</b>	<b>400 - 1200 cps @25°C</b>
<b>pH:</b>	<b>5.25 – 7.25</b>
<b>FLASH POINT:</b>	<b>&gt;325°F / &gt;163°C (C.O.C.)</b>
<b>SHELF LIFE:</b>	<b>Minimum of one year</b>

### 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 additives than the indicated maximum. Always start an evaluation at 5 parts per 1000 (0.5%). In thermosets, too much additive may retard the cure. \*Reduce the level of additive or slightly increase the catalyst. 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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