

technical data

AXEL

PLASTICS RESEARCH LABORATORIES, INC.
MOLD RELEASES & INTERNAL LUBRICANTS

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MOLD WIZ INT-DCP-220

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 affect 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: DCPD Resin

Composition: Proprietary synergistic blend of organic triglyceride of fatty acids combined with surfactants and wetting agents.

TYPICAL PROPERTIES:

EFFECTIVE INGREDIENTS:	100%
SOLIDS:	100%
*COLOR:	Amber
SPECIFIC GRAVITY:	0.932 @25°C
VISCOSITY:	130 – 170 cps @ 25°C
pH:	3.0 – 5.0
REFRACTIVE INDEX:	1.473
FLASH POINT:	460°F / 238°C (Self Extinguishable)
SHELF LIFE:	Minimum of one year

Application Instructions:

General: For best results, laboratory tests or pre-production trials should determine the optimum addition level. MOLD WIZ Process Aid Additives are effective within a range of 7.5 to 10 parts per 1000 resin by weight, excluding reinforcements, pigments and fillers. High amount of filler may require a higher percentage of process aid additive than the indicated maximum.

Mold Preparation: Mold should be prepared by applying two coatings of Axel Mold Sealer: **Melax-3F/NC**

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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