

## technical data

# AXEL

PLASTICS RESEARCH LABORATORIES, INC.  
MOLD RELEASES & INTERNAL LUBRICANTS

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## MOLD WIZ INT-DLP-22E

**General:** A process aid additive designed especially for MEKP cured resin. An effective addition of process aid additive will not have any adverse effect on the cured resin. Thermoset molded 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: Polyester Vinyl Ester  
RTM, Hand lay-up/spray and  
Filament winding Resin.**

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

### TYPICAL PROPERTIES:

<b>EFFECTIVE INGREDIENTS:</b>	<b>100%</b>
<b>COLOR:</b>	<b>Amber.</b>
<b>SPECIFIC GRAVITY:</b>	<b>0.930 @ 25°C</b>
<b>VISCOSITY:</b>	<b>50 - 150 cps @25°C</b>
<b>Solubility in water:</b>	<b>Insoluble</b>
<b>FLASH POINT:</b>	<b>Non Flammable (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 0.25 to 2.0 parts per 100 resin by weight, excluding reinforcements, pigments and fillers. Always start an evaluation at 5 part per 1000 (0.5%). High amount of filler may require a higher percentage of process aid additive. Too much additive may retard the cure. Reduce the level of process aid additive or slightly increase the catalyst

**Mixing:** Mix into resin prior to addition of catalyst, fillers, and other resin additives.

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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