



Mold Release Agents & Process Aid Additives

50 Cambridge Drive  
Monroe, Connecticut 06468 USA  
203.590.2000 | 800.332.2935  
www.axelplastics.com

## Technical Data Sheet

# MoldWiz®

INT-PUL24

Internal Mold Release

Process Aid Additive

## MoldWiz® INT-PUL24

**General:** A process aid additive designed specifically for pultrusion. The benefit is to optimize line speed while reducing both pull force and die wear. Improves wet out of fiber, fillers and resin flow while reducing viscosity. Physical properties of the profile are retained or improved. The complex polymeric nature of the process aid additive will not interfere with secondary operations, such as: painting, bonding, or powder coating.

**Use: Polyester, Vinyl-Ester, & DAP Resins**

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

### TYPICAL PROPERTIES:

<b>EFFECTIVE INGREDIENTS:</b>	<b>100%</b>
<b>GARDNER COLOR:</b>	<b>3 max.</b>
<b>SPECIFIC GRAVITY:</b>	<b>0.962 @ 25°C</b>
<b>VISCOSITY:</b>	<b>100 - 180 cps @25°C</b>
<b>pH:</b>	<b>4.3</b>
<b>FLASH POINT:</b>	<b>305°F / 152°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 0.75 to 3.0 parts per 100 parts resin by weight, excluding reinforcements, pigments and fillers. We recommend a starting evaluation at 1.5 parts per 100. High amount of filler may require a higher percentage of process aid additive.

**Mixing:** Mix INT-PUL24 in to the resin *after* the addition of all fillers and low-profile additives.