



**MOULEX®  
FOR WOOD PANEL, LAMINATING PRESS,  
PAPER IMPREGNATION**

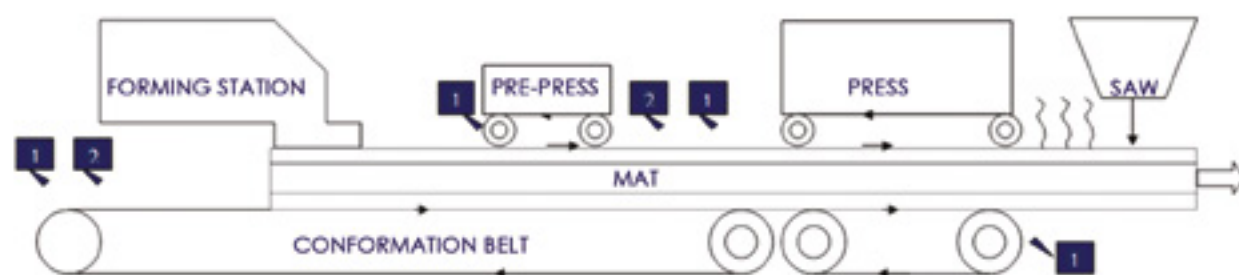
[www.additek.net](http://www.additek.net)

**RELEASE AGENTS  
& PROCESSING BOOSTERS**

# ADDITIVES TO GO OVER THE LIMIT OF MECHANICAL OPTIMISATION

## MOULEX® PROCESSING BOOSTER

### WHERE MOULEX® SHOULD BE SPRAYED



### SPECIFICATIONS :

#### MOULEX® WE02B

Form : liquid  
Color : transparent Yellow  
Density 25°C : 0.98 – 1.00  
Dry contains : 4.0 – 6.0%  
pH : 6 – 8  
Acid value : 0 – 10.0 mg/KOH/g  
Viscosity 25°C : 25 cSt  
Freezing point : < 3°C  
Shelf life : 1 year

#### MOULEX® WE07B

Form : liquid  
Color : transparent yellow  
Density : 0.98 – 1.00  
Dry contains : 18.0 – 20.0%  
pH : 6 – 8  
Acid value : 14 – 24 mg/KOH / g  
Viscosity 25°C : 79 cSt  
Freezing point : < 3°C  
Shelf life : 1 year

#### MOULEX® WE07BSP

Form : liquid  
Color : transparent Yellow  
Density : 0.98 – 1.01  
Dry contains : 15.0 – 18.0%  
pH : 6.2 – 7.5  
Acid value : 15 – 20 mg/KOH / g  
Viscosity 25°C : 42 cSt  
Freezing point : < 3°C  
Shelf life : 1 year

Moulex® WE02B, Moulex® WE07BSP and Moulex® WE07B are frost resistant, the stability and the performances of the products do not change after repeated freeze-thaw cycles.

## IT'S TIME TO DO SOMETHING DIFFERENT







## FOR WOOD PANEL

### MOULEX® WE02B

External Release agent

TO SPRAY : 1g/m<sup>2</sup>.mm (thickness)  
DILUTION : 3% to 10% into soft water

- ✓ ON THE MAT
- ✓ ON STEEL BELT
- ✓ ON CONFORMATION BELT

#### BENEFITS :

- ✓ TO AVOID STICK ON THE BELT
- ✓ TO REDUCE DIRT BUILD UP

### MOULEX® WE07B - WE07BSP

External & Internal Release agent, processing booster

#### EXTERNAL USED TO BE SPRAYED :

TO SPRAY : 1g/m<sup>2</sup>.mm (thickness)  
DILUTION : 3 to 5% into soft water

- ✓ ON THE MAT
- ✓ ON STEEL BELT
- ✓ ON CONFORMATION BELT

#### BENEFITS :

- ✓ TO AVOID STICK ON THE BELT
- ✓ TO REDUCE DIRT BUILD UP
- ✓ TO REDUCE STATIC EFFECT
- ✓ TO CLEAN UP THE BELTS
- ✓ TO IMPROVE SPRAY SYSTEM PERFORMANCES
- ✓ TO IMPROVE WATER WETTABILITY
- ✓ TO REDUCE POROSITIES
- ✓ TO REDUCE PAINT CONSUMPTION
- ✓ TO IMPROVE DENSITY PROFILE
- ✓ TO REDUCE SANDING
- ✓ TO INCREASE SPEED OF THE LINE

#### INTERNAL USED TO BE ADDED INTO THE GLUE :

TO ADD 0.1% - 0.3% TO LIQUID GLUE

#### BENEFITS :

- ✓ TO REDUCE DIRT BUILD UP INTO THE FORMING STATION, THE MIXER, TANK, PIPES, PUMP, ETC...
- ✓ TO IMPROVE WETTABILITY OF THE GLUE AND PARAFIN EMULSION WHICH CAN REDUCE THEIR DOSAGE LEVEL.
- ✓ TO REDUCE DIRT BUILD UP, ESPECIALLY WITH FIRE RETARDANT AND WATER RESISTANCE FORMULATIONS (HIGH LEVEL OF GLUE - ADDITIVES ...)

## MOULEX® WE 20R NEW GENERATION OF RELEASE AGENT

For MDI and isocyanate derivatives

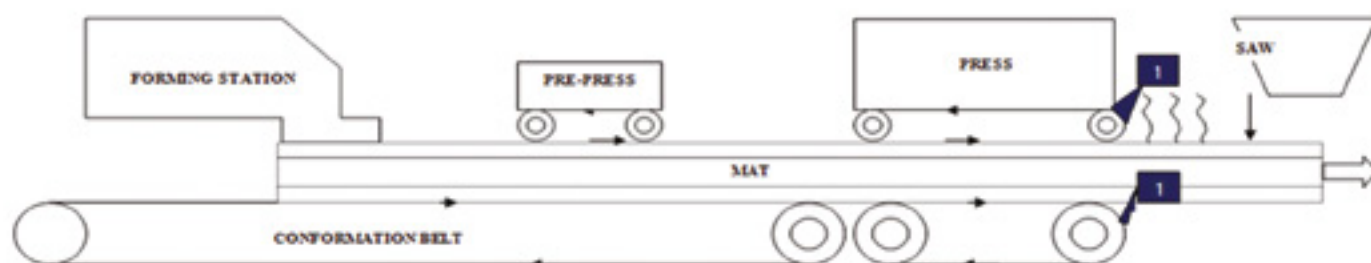


### DESCRIPTION

MOULEX® WE 20R is an external release agent based on high molecular weight synthetic polymers combined with strong surfactants.

MOULEX® WE 20R is chemically inert and has an excellent film forming properties which result in a very efficient chemical barrier coating to avoid sticking to the press belt or plate. Its high efficiency allows very low dosage reducing consumption and costs significantly.

Efficiency is also directly relative to quality and method of application. A system of application with good distribution, regular flow and good dosing control is recommended to succeed the tests.







## FOR WOOD PANEL



### **MOULEX® WE20R**

Analysis	Method	Specifications
Form	Visual	Liquid
Color	Visual	White
Dry contains	ADDM/004	13-16
Density	ADDM/005	0.98 – 1.00
pH	ADDM/009	9.5 - 11
Viscosity cSt / 25°C	ADDM/007	31
Freezing point °C	ADDM/015	<-6°C
Shelf life	-	1 year
Packaging	-	IBC 1000KG

Moulex® WE20R is frost resistant, the stability and the performances of the product do not change after repeated freeze-thaw cycles.



## MOULEX® ISOFACE X WOOD PANEL SEALER & PAINT REDUCER

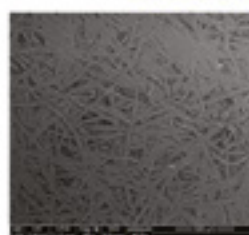
MOULEX® ISOFACE X is used for non-sanding and painted wood panels' production lines. It is sprayed on the mat before the press. It reduces porosities and paint absorption of the finish board.

More than a release agent which normally reduces porosities thanks to the steam shock, MOULEX® ISOFACE X is a sealer coating, formulated with selected resins without formaldehyde.

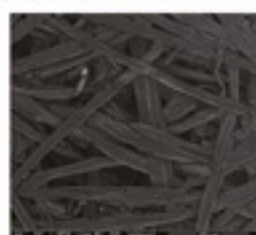
### BENEFITS :

- ✓ PAINT SAVING
- ✓ REGULAR COLORATION
- ✓ BETTER QUALITY

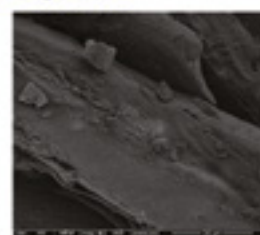
### HAVE A LOOK ON YOUR MDF BOARD?



Pressure MDF (x400)



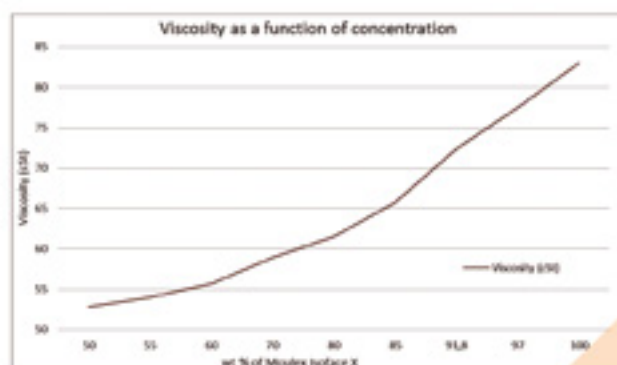
Pressure MDF (x2000)



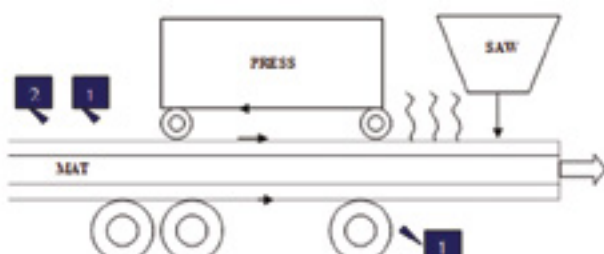
Pressure MDF (x2000)

### PHYSICAL CHARACTERISTICS

Form :	Liquid
Color :	Brown
Dry contains :	27%
Density :	1.09
pH :	3.6
Viscosity cSt 25°C :	95
Stability :	Stable with a slight stirring or recirculating.
Shelf life :	6 month
Packaging :	IBC 1000L



### WHERE MOULEX® ISOFACE X HAVE TO BE SPRAYED ON?



**1** - MOULEX® WE07BSP or WE02B:  
Release agent & processing booster

**2** - MOULEX® ISOFACE X: Paint reducer  
Dilution: 50% in water - Flow: 20 g/m²





## MOULEX® WE LP1 HIGH GLOSS SOLUTION FOR LAMINATING PRESS

MOULEX® WE LP1 is a sealer & release coating used on laminating plates to promote a high gloss finished aspect of furniture's, floors ...It is sprayed directly on the plates with a spray gun.

- ✓ NO DILUTION :ready to use
- ✓ APPLICATION : 2 – 3 cross layers with a spray gun
- ✓ CURE : 2 to 5 minutes at 200°C.

To be 100% efficient our product should be applied with a good set up (nozzles, pressure, and flow)  
Do not hesitate to contact us for more recommendations and technical support.

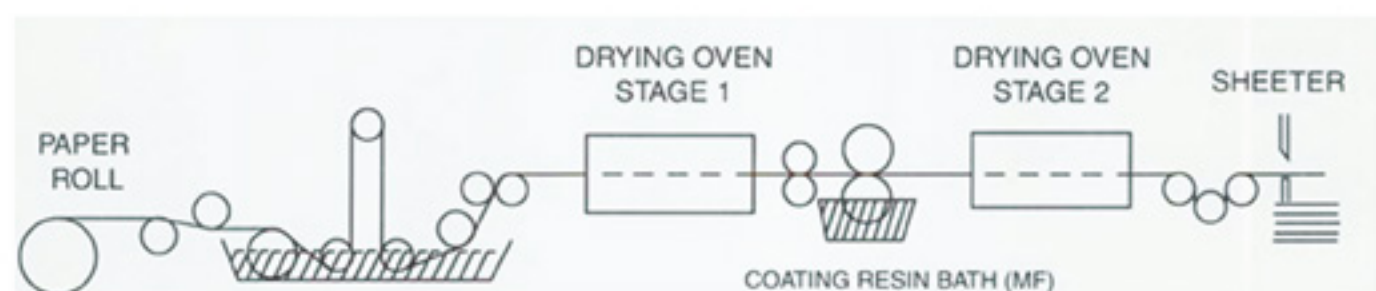
### BENEFITS :

- ✓ TO GET HIGH TOP GLOSS, ON LAMINATING PLATES PRESS
- ✓ TO REDUCE DIRT BUILD UP ON THE PRESS (especially for complex shapes)
- ✓ TO REDUCE MICRO-POROSITIES AND DIRT BUILD UP ON THE PRESS PLATES
- ✓ TO IMPROVE FINISH ASPECT OF DECORATIVE PAPERS

Analysis	Method	Specifications
Form	Visual	Liquid
Color	Visual	White
Density at 25 °C	ADDM/005	0.98 – 1.00
Dry contains	ADDM/004	3.0% – 4.0%
pH	ADDM/009	9.6 – 10.4
Freezing point	ADDM/015	< 0 °C
Viscosity at 25 °C	ADDM/007	23 cSt
shelf life		1 year
Packaging		25 Kg, 220 Kg



## ADDITIVES FOR DECORATIVE PAPER A FULL RANGE TO REACH THE RIGHT BALANCE



### STANDARD RANGE

MOULEX®	FUNCTION	DOSAGE bath 1	DOSAGE bath 2
WE05I	Release – antistatic (colorless grade)	0.1% - 0.2%	0.2% - 0.3%
WE07I	Release, antistatic & wetting agent	0.1% - 0.2%	0.2% - 0.4%
WE09	Wetting agent	0.2% - 0.4%	0.1% - 0.3%
WE04A	Anti-blocking	0%	0.2% - 0.5%
AF04	Anti-foaming	0.01% - 0.1%	0.01 - 0.1%
AP-01	Anti-dust	0	0.1 - 0.3%

Except Moulex® WE04A, all our additives for paper impregnation are frost resistant: products stability and performances do not change after repeated freeze-thaw cycles.







## FOR PAPER IMPREGNATION

### MOULEX® WE05I

Internal Release & antistatic additive *(high quality transparent formulation)*

LEVEL DOSAGE: 0.1 - 0.4%

#### BENEFITS

Avoids sticking into the laminating press.  
Reduces dirt build up on the press plates.  
Improves antistatic effect  
No effect on color.

#### SPECIFICATIONS

Form 20°C : liquid  
Color : transparent colorless to slight yellow  
Density at 25°C : 1 - 1.03  
Dry content : 17.5% - 21.5%  
pH : 6 - 8  
Acid value : 3 - 13 mg KOH / g

#### PACKAGING

1000KG IBC  
Freezing point : < 3°C  
Shelf life : 1 year

### MOULEX® WE07I

Internal release, antistatic and wetting agent

LEVEL DOSAGE: 0.1 - 0.5%

#### BENEFITS

Avoids sticking into laminating press.  
Reduces dirt build up on the plates press.  
Improves antistatic effect  
No effect on color.  
Improves glue wettability.  
Improves glue penetration into the paper.

#### SPECIFICATIONS

Form 20°C : liquid  
Color : transparent yellow  
Density at 25°C : 0.99 - 1.00  
Dry content : 17% - 22%  
pH : 6 - 8  
Acid value : 17 - 27 mg KOH / g

#### PACKAGING

1000KG IBC  
Freezing point : < 3°C  
Shelf life : 1 year

### MOULEX® WE09

Wetting agent

LEVEL DOSAGE: 0.1 - 0.3%

#### BENEFITS

Improves glue wettability.  
Improves glue penetration into the paper.  
Improves air degassing.

#### SPECIFICATIONS

Form 20°C : liquid  
Color : transparent colorless  
Density at 25°C : 1.01 - 1.03  
Dry content : 26% - 30%  
pH : 6 - 8  
Acid value : 0 - 2 mg KOH / g

#### PACKAGING

1000KG IBC  
Freezing point : < 3°C  
Shelf life : 1 year

## FOR PAPER IMPREGNATION

### MOULEX® WE04A

Anti-blocking agent

LEVEL DOSAGE : 0.1 - 0.5% only in the second bath

#### BENEFITS

Anti-blocking  
Avoids sheet sticking during storage  
in extreme conditions of humidity and  
temperature

#### SPECIFICATIONS

Form 20°C : liquid  
Color : white to yellow  
Density at 25°C : 0.98 - 1.00  
Dry content : 22% - 28%  
pH : 7 - 9  
Acid value : 0.5 - 4 mg KOH / g

#### PACKAGING

1000KG IBC  
Freezing point : < 3°C  
Shelf life : 1 year

### MOULEX® AF04

Anti-foaming agent

LEVEL DOSAGE : 0.01 - 0.1%

#### BENEFITS

Avoids foam forming into impregnation  
bathes.  
Improves glue distribution and  
thickness average.

#### SPECIFICATIONS

Form 20°C : liquid  
Color : yellow  
Density at 25°C : 0.86 - 0.90  
Dry content : 99% - 100%  
pH : 7- 10  
Viscosity, 25°C : 1000 - 3000 cSt

#### PACKAGING

850KG IBC, 180kg and 60kg drums  
Freezing point : < 5 °C  
Shelf life : 2 years

### MOULEX® AP- 01

Anti-dust

LEVEL DOSAGE : 0.1 - 0.3%

#### BENEFITS

Avoids melamine dust forming,  
(on the rolls, in the oven and paper surface).  
Improves air degasing.

#### SPECIFICATIONS

Form 20°C : liquid  
Color: amber  
Density at 25°C : 0.99 - 1.03  
Dry content : 99% - 100%  
pH : 8.5-9.5  
Acid value : max 5  
Viscosity, 25°C : 140 cSt (typical)

#### PACKAGING

1000L IBC or 204kg drums  
Freezing point : < 5 °C  
Shelf life : 1 year





## SHARING EXPERIENCES

**MOULEX®**  
**PROCESSING BOOSTER**  
Not only a release agent...

### A PARTNERSHIP

**Sharing technical knowledge will be profitable for all of us.**

ADDITEK always works for you, on new solutions.  
The most important is not to be the only one, but the first one.

**GB = 3 GP<sup>2</sup>**

**Good Business, Good Partners, Good Products, Good Prices**



## HIGHER SPRAY FLOW, BETTER ADVANTAGES

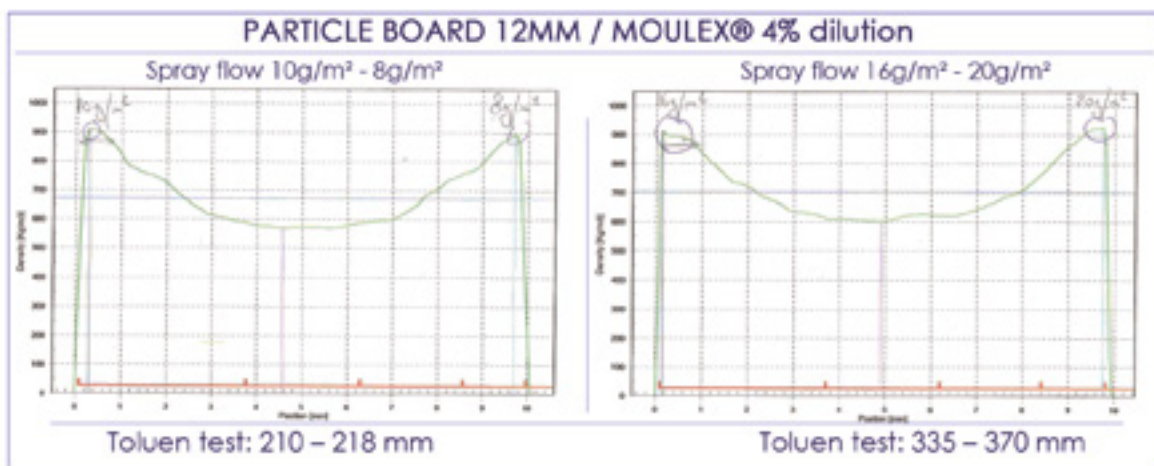
### SHARING EXPERIENCE 1



### HIGHER SPRAY FLOW, BETTER ADVANTAGES

It is well-known and proved that spraying water on the mat and the forming belt, helps to improve surface density and steam chock. The highest spray flow, the best results.

- ✓ Better surface density will increase mechanical characteristics, reduce sanding and porosity surface.
- ✓ Stronger steam chock will improve heat transfer and consequently allow to play with parameters of the line : increasing speed, reducing temperature of the press and so on...



### THE FLOW LIMIT

When spraying too much, the film is too thick. Then, mat sticks to the surface, not because of glue adhesion, but due to capilarity effect, especially on the forming belt. This limit reduces significantly the benefits of spraying.

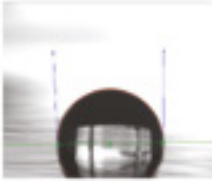
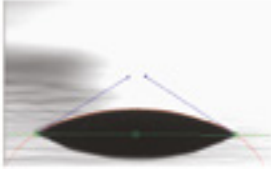
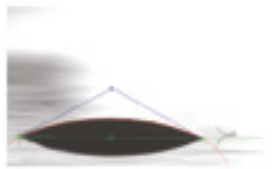


## OVER THE SPRAY FLOW LIMIT

### SHARING EXPERIENCE 2

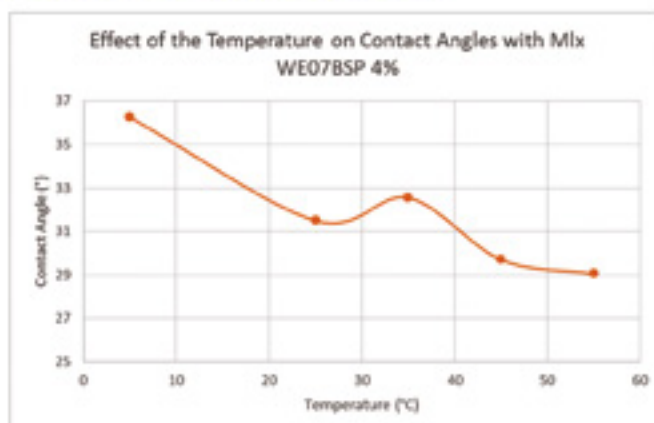
#### OVER THE SPRAY FLOW LIMIT

Using MOULEX®, water film thickness on the mat and on the forming belt, will be extremely thin and well distributed due to MOULEX® very strong powerful wetting effect. Consequently, with MOULEX®, you will be able to work with the highest spray flow, over the limit you usually work, using water only or others competitors traditional release agents.

CONTACT ANGLE ON A FORMING BELT		
TAPE WATER	COMPETITION 25% Dilution	MOULEX® 4% Dilution
		

#### TEMPERATURE INFLUENCE ON CONTACT ANGLE

Temperature of the MOULEX® sprayed is important to reduce contact angle especially on the forming belt. Best results were obtained at 55°C.





## OUR ENVIRONMENTAL ORIENTATION

### Dear Customers

Since more than 15 years, ADDITEK feels concerned by environmental rules, staff and customers health care.

Therefore, we manage to:

- Measure and control waste production.
- Improve our process to limit production of waste.
- Ensure waste destruction cycle traceability.
- Improve our process to decrease energy consumption
- Strongly focus in formulating our water based products in total compliance with REACH regulation and health care for final users.



P. MAHIEU  
Managing Director





## REACH



Dear Customers,

One of the aims of REACH is to ensure a high level of protection of human health and the environment from the risks that can be posed by chemicals.

These chemicals could be under authorization or interdiction.  
First step is to create a list (SVHC List) of those chemical substances.

We hereby certify that the **MOULEX® WE02B, WE07B, WE07BSP, WE20R, ISOFACE X, WE LP1, WE05I, WE07I, WE09, WE04A, WE AF04, AP01**, do not contain any of the SVHC listed substances. All the substances in the recipes are registered or pre-registered.

Mr. Jacques DELFORGE  
Quality Manager of ADDITEK SAS

## ISO 9001

Management system as per  
**EN ISO 9001 : 2008**



In accordance with TÜV NORD CERT procedures, it is hereby certified that

**ADDITEK S.A.S.**  
Z.I. Route de Thennes  
80110 MOREUIL  
France



applies a management system in line with the above standard for the following scope

**Design, production, sales and trade of mould release agents and processing aids used in the rubber, thermoplastics, composites, wood and paper impregnation industries**

Certificate Registration No. 04 100 051274  
Audit Report No. 3510 1968

Valid until 2015-08-02

*C. Brüntigam*  
Certification Body  
at TÜV NORD CERT GmbH

Essen, 2012-08-03

This certification was conducted in accordance with the TÜV NORD CERT auditing and certification procedures and is subject to regular surveillance audits.

TÜV NORD CERT GmbH

Langemarckstrasse 20

45141 Essen

[www.tuev-nord-cert.com](http://www.tuev-nord-cert.com)



TGA-ZM-07-06-00



ADDITEK SAS, Production plant ZI Route de Thennes, 80110 Moreuil, France,  
TVA n° FR 58 418 609 400

Tel: + 33 (0)3 22 09 90 28 - Fax: + 33 (0)3 22 09 03 70

**contact@additek.net**

**www.additek.net**