

GloMold Plus™ is your in-process mold conditioning solution

Reduce downtime and material waste for significant cost savings

Dirty molds cost molding operations hundreds of thousands of dollars in downtime, lost productivity and wasted material. Traditional cleaning processes require pulling the mold out of the press and blasting it with cleaning media. This stops production and presents opportunity for damage to the mold.

GloMold Plus is a nitrile polymer compound that is used in-place to keep fouling from building up in compression, injection and transfer rubber molding.



Today's GloMold Plus has been improved to make it:

- Nearly odorless
- Extended shelf life – a minimum of six months
- Zero VOC

How GloMold Plus works

GloMold Plus cleans by diffusion. Maintenance of temperature and pressure cavity are critical. Higher temperatures increase diffusion rate but also reduce cleaning time.

GloMold Plus takes the shape of the mold and then comes out looking like a finished piece.

As GloMold Plus will also remove mold release agents from the mold, they must be reapplied after each application.

Injecting GloMold Plus into your mold after an established number of runs, depending on your production schedule, conditions to keep your molds clean, reducing:

- rejects due to defects or poor surface appearance
- heat transfer loss
- and improper mold fill

GloMold Plus can also protect molds during storage. Simply inject GloMold Plus during the last heat and remove the mold in the closed position. Your mold will be protected from rust for a minimum of six months and remain clean and ready for production—reducing set-up time.



There's a GloMold Plus™ formulation that's ideal for your process

This chart can help you determine which GloMold Plus product is right for your operation. These products are typically provided in slab form, so that customers can cut it to the shape they need.

PRODUCT SELECTION GUIDE

| Product | | Standard | Low Temp | High Temp | High Tear | Low Mooney | Non-Curing |
|------------------|---------|--------------|--------------|-------------|--------------|--------------|------------|
| Color | | Yellow | Red | Orange | Green | Blue | Lavender |
| Temp/Cure Time | Low | 345deg/13min | 275deg/20min | 385deg/5min | 345deg/13min | 345deg/13min | 160deg |
| | High | 380deg/8min | 340deg/14min | 450deg/1min | 380deg/8min | 380deg/8min | 400deg |
| Specific Gravity | g/cm3 | 1.13 | 1.13 | 1.13 | 1.14 | 1.28 | 1.13 |
| Tensile Strength | psi | 1220 | 1220 | 750 | 1290 | 740 | N/A |
| 300% Modulus | psi | 150 | 150 | 670 | 110 | 650 | N/A |
| Elongation | % | 720 | 720 | 270 | 810 | 310 | N/A |
| Hardness | Shore A | 46 | 46 | 55 | 43 | 56 | N/A |
| Tear Strength | ppi | 111 | 111 | 49 | 178 | 69 | N/A |

GloMold Plus can be used in normal processing in aluminum, steel or chrome-plated molds. It is not recommended for use in applications using brass or "exotic" mold coatings, some FKM (ASTM D1418) materials, Dupont™ Diak™ curing agents or liquid silicone (LSI).

GloMold Plus can save molding operations thousands of dollars per month

The chart below shows annual cost savings based on a typical production schedule.

Contact our GloMold Plus sales representative can for an analysis like this to outline how much mold condition with GloMold Plus can annual save your operation.

GLO-MOLD COST-BENEFIT ANALYSIS

| Customer Information | Glo-Mold Information | Media (Sand, Dry Ice) Blast Information |
|---|---------------------------------------|---|
| Number of Machines / Molds | Recommended Cycles for Cleaning | Weekly average cleanings per mold |
| 25 | 900 | 2 |
| Average cycles per shift | Cleaning times per day | Daily average cleanings per mold |
| 12 | 1 | 0.29 |
| Shifts | Lb. used per Cleaning | Monthly average cleanings per mold |
| 3 | 1.10 | 8.57 |
| Cycles per day | Number of Machines / Molds | Number of Machines / Molds |
| 900 | 25 | 25 |
| Average working days | Lb. used per day | Monthly average total cleanings |
| 23 | 27.56 | 214.29 |
| Cycles per month | Lb. used per month | Media Used per Cleaning (Lb.) |
| 20,700 | 633.94 | 7.7175 |
| Average cavities per mold | Unit Price USD (Lb.) | Lb. used per month |
| 16 | \$6.50 | 1653.75 |
| Estimated total produced parts | Monthly Glo-Mold Cost (USD) | Unit Price |
| 331,200 | \$4,120.59 | \$0.25 |
| Man Hour Calculation | Glo-Mold Cleaning | Monthly Blast Material Cost |
| Average Monthly Salary (MXP) | a) Man Hour Material Preparation | \$412.50 |
| \$7,000.00 | Hours for preparation per Cleaning | Current Cleaning Process |
| Average Man Hour (MXP) | 0.25 | a) Cleaning Man Hours |
| \$29.17 | Monthly Man Hours of Preparation | Cleans per Month |
| Exchange Rate | 143.75 | 214.29 |
| \$19.50 | Man Hour Cost | Mold Cleaning Hours |
| \$1.50 | \$1.50 | 5.00 |
| Total Monthly Glo-Mold Cost (USD) | Monthly Man Hour Cost | Monthly Man Hours |
| \$29,463.10 | \$215.01 | 1,071.43 |
| Current Average Cost of Cleaning (USD) | b) Machine dead time | Man Hour Cost |
| \$43,901.92 | Mold Cleaning hours | \$1.50 |
| Monthly Savings (USD) | Machine dead time | Monthly Man Hour Cost |
| \$14,438.82 | 143.75 | \$1,602.56 |
| | Dead time hour cost | b) Machine dead time |
| | \$2.00 | Mold Cleaning hours |
| | Monthly Machine Dead Time Cost | 5.00 |
| | \$287.50 | Monthly Machine dead time (Hrs.) |
| | c) Scrap parts | 1,071.43 |
| | Scrap average rate | Dead time hour cost |
| | 0.50% | \$2.00 |
| | Monthly Scrap Parts | Monthly Machine Dead Time Cost |
| | 1,656.0 | \$2,142.86 |
| | Average Part Cost | c) Scrap parts |
| | \$15.00 | Scrap average rate |
| | Monthly Scrap Cost | 0.80% |
| | \$24,840.10 | Monthly Scrap Parts |
| | Monthly Glo-Mold Cleaning Cost | 2,649.6 |
| | \$29,463.10 | Average Part Cost |
| | | \$15.00 |
| | | Monthly Scrap Cost |
| | | \$39,744.00 |
| | | Current Monthly Mold Cleaning Cost |
| | | \$43,901.92 |

For More Information:
Andrew Bruck, Sales Manager
Andrew.Bruck@hexpol.com