

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	Monthly Glo-Mold Cost (USD)	Monthly Blast Material Cost
Average Monthly Salary (MXP)	\$4,120.59	\$412.50
Average Man Hour (MXP)	Glo-Mold Cleaning	Current Cleaning Process
\$7,000.00	a) Man Hour Material Preparation	a) Cleaning Man Hours
Average Man Hour (MXP)	Hours for preparation per Cleaning	Cleans per Month
\$29.17	0.25	214.29
Exchange Rate	Monthly Man Hours of Preparation	Mold Cleaning Hours
\$19.50	143.75	5.00
Man Hour Cost (USD)	Man Hour Cost	Monthly Man Hours
\$1.50	\$1.50	1,071.43
Total Monthly Glo-Mold Cost (USD)	Monthly Man Hour Cost	Man Hour Cost
\$29,463.10	\$215.01	\$1.50
Current Average Cost of Cleaning (USD) \$43,901.92	b) Machine dead time	Monthly Man Hour Cost
Monthly Savings (USD) \$14,438.82	Mold Cleaning hours	\$1,602.56
	0.25	
	Machine dead time	b) Machine dead time
	143.75	Mold Cleaning hours
	Dead time hour cost	5.00
	\$2.00	Monthly Machine dead time (Hrs.)
	Monthly Machine Dead Time Cost	1,071.43
	\$287.50	Dead time hour cost
		\$2.00
	c) Scrap parts	Monthly Machine Dead Time Cost
	Scrap average rate	\$2,142.86
	0.50%	
	Monthly Scrap Parts	c) Scrap parts
	1,656.0	Scrap average rate
	Average Part Cost	0.80%
	\$15.00	Monthly Scrap Parts
	Monthly Scrap Cost	2,649.6
	\$24,840.10	Average Part Cost
	Monthly Glo-Mold Cleaning Cost	\$15.00
	\$29,463.10	Monthly Scrap Cost
		\$39,744.00
		Current Monthly Mold Cleaning Cost
		\$43,901.92

For More Information:

Chris Poirier, General Manager
HEXPOL Silicone/Performance Additives NA
Chris.Poirier@hexpol.com