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## **Glo-Mold, Inc.**

Manufacturers and Distributors of Glo-Mold® mold cleaning compound.

### **Using Glo-Mold**

Preventative maintenance: cleaning the mold before it gets too dirty or built up with foul.

#### **How to achieve preventative maintenance:**

Before using Glo-Mold, first establish how long it takes for the mold to get dirty or fouled. This is the point where the mold SHOULD be pulled and cleaned. When the mold starts to yield scrap parts, due to a large volume of foul material, or when the parts show surface imperfections, the mold should be maintained. (In some cases, this might happen every shift. In other molds, it may be every month.)

Once we determine this cleaning point, we must try to establish a procedure for running the Glo-Mold in half that time. For example, if the point to pull and clean should be every shift, then we need to use the Glo-Mold half-way through the shift (maybe lunch time?) If the mold gets dirty every month, we need to try to clean every two weeks. The reason for this more frequent cleaning is the mold fowl grows at an exponential rate. For example, if the mold is running in a press for half a shift, it will accumulate one micron of fowl. In the next four hours, the fowl layer will not be two microns, it will be four to eight microns. At that point (eight hours) it will take four cleanings in a row to get the mold as clean as one cleaning every four hours.

#### **Easy steps to cleaner molds:**

Now that we know when to use Glo-Mold, we must now explain how to use it. We refer to the Glo-Mold product selection and curing guide which is available online at [www.valleyrubber.com](http://www.valleyrubber.com).

1. Check actual mold temperature. We recommend using a pyrometer and checking the temperature inside the mold as soon as the mold is open.
2. Product selection. Match the temperature you obtain with the Glo-Mold color-coded product. If you do not have the specific color product for the temperature you have determined, simply use any color product you have available and cure for the number of minutes indicated at that temperature. All Glo-Mold products will clean at any temperature. We have found colors used at the temperatures indicated on the guide yield the best results.
3. Insert Glo-Mold in the usual fashion.  
This includes running through the entire injection system in an injection mold. The overwhelming majority of Glo-Mold we sell is run through an injection system. Glo-Mold has excellent flow characteristics, so it is easy to purge through almost any press with decent tolerances. Run the Glo-Mold the number of minutes indicated on the temperature chart, but make sure the vacuum is turned off. After running the Glo-Mold in an injection press, we have to purge the Glo-Mold with your regular molding compound. We have found if a customer completely fills and empties the barrel two times, we don't get the residual Glo-Mold at this point. Make sure when you are running your regular compound through the injection system, you keep the press open so the purge material does not encounter any resistance. We recommend laying a piece of cardboard in the open mold to catch the purge material.

If an injection press has enough pressure to close the mold with Glo-Mold laid in the cavity, Glo-Mold can be run compression style in an injection press. Keep in mind, Glo-Mold has to completely fill the mold cavity or it will not clean.

In a compression press, we recommend you overload the cavity by 10%. This will increase the likelihood of filling the part and any residual material will clean the lan area. If the part is rubber-to-metal bonded, we recommend using your insert. If your insert is used with the Glo-mold, you will have the same distribution of pressure as a regular heat and you will use less Glo-Mold compound. It is best to use an insert that is not coated with bonding agent (this insert can be reused for future cleanings).

In a transfer mold, a 10% larger shot size is recommended to insure proper cavity filling to clean the pot thoroughly.

4. Cure Time. On the first trial, cure the Glo-Mold about 75% of the time the curing guide recommends. This will insure there is no reversion of the Glo-Mold material and you will have the greatest hot tear strength for removal. The longer you cure the Glo-Mold, the more it will break up the foul material, but it will also become more brittle. So after the first heat, evaluate the ease of removing the Glo-Mold part.
5. DO NOT BUMP or turn off the vacuum. We cannot stress this enough. Glo-Mold works by releasing a vapor that breaks up the cross links of the foul material, it then absorbs the broken foul material on its surface. If you have a bump or a vacuum, the vapor will escape, thus reducing cleaning effectiveness.

NOTE: After running Glo-Mold, try to put the Glo-Molded parts into a sealed container or a bucket of water. The product only loses about 50% of the cleaning agent during the curing cycle. If the Glo-Mold is placed in a sealed container or water, the smell generated will be cut in half.