



glo·mold, inc

In-place mold cleaning compound.



Valley Rubber Mixing, a wholly owned subsidiary of Glo-Mold, Inc., is a supplier of custom-mixed rubber compounds and calendered goods.

Custom Mixing

Valley Rubber Mixing has the flexibility of mixing your compounds with our open mills or with one of our two internal mixers for larger volume runs.

We have a dedicated black line and a separate dedicated color line where we mix all polymers except silicone.

By mixing on the open mill, we are able to give you compounds with optimum dispersion, better physicals and better heat control. This also gives us the ability to match the batch size to the customer's needs.

We can provide mixed compounds for virtually any application from our extensive recipe files or will mix to customer's recipes and specifications.

To be more competitive on large orders, **Valley Rubber** also mixes with internal mixers. We have a #3 Farrell (130 lbs.) on our black line and a #4 Kobe Side Dump (180 lbs.) on our color line.

Small batch or large run, make **Valley Rubber Mixing** your compound source.

Calendering

Valley Rubber Mixing also has custom calendering capabilities. Our 48" variable speed, three roll vertical calender, equipped with chilled water take-off equipment, provides exceptional dimensional control in both width and gauge.



Along with calendering our mixed compounds, we can also reprocess your leftover trim, which will help reduce or eliminate waste.

Give **Valley Rubber Mixing** a call for any of your calendering needs.

Laboratory Research and Development

Valley Rubber Mixing maintains a full-scale computerized laboratory for formula development, compound scale-up, quality checks on incoming raw materials, and outbound customer shipments.

Compounds are routinely developed for ASTM call-outs, military specification, or per specific customer requests. We also work with several of our raw material suppliers when exact color match of a compound is necessary.

As a small to medium size custom mixer, we look forward to working with our customers in developing new compounds or improving existing compounds. Our lab staff can supply you with trial batches from 2 – 10 lbs.

If you have that labor intensive job, a compound that others don't like to mix or if you aren't satisfied with your current supplier, give **Valley Rubber Mixing** a call.



CUSTOM COMPOUNDING AND DISPERSIONS



Does Glo-Mold work?

Over 500 molders worldwide now use Glo-Mold!

What can Glo-Mold do for you?

- No downtime for cleaning. Injecting Glo-Mold through the screw on a regular basis eliminates the need for equipment shutdown.
- It is possible to spot-clean molds during the production cycle when a defect shows up due to localized build-up of dirt.
- Eliminate the need for major cleaning equipment associated with mold handling equipment and valuable floor space for each.

Glo-Mold has been proven to be a very beneficial production tool when scheduled routinely.

Glo-Mold is the unique, patented rubber compound for IN PLACE mold cleaning.

Eliminates or reduces typical problems and hidden costs of conventional mold cleaning techniques.

Glo-Mold Advantages

- Minimize press downtime
- Minimize excessive labor in mold handling
- Reduce mold damage or abrasion
- Reduce delays due to scheduling of cleaning equipment
- Reduce number of rejects due to defects or poor surface appearance
- Reduce heat transfer loss

Normal processing techniques are used with Glo-Mold in injection, compression and transfer molding.

Preventative maintenance can be extremely effective when Glo-Mold is used regularly. Molds are kept clean. Costs are reduced. Productivity can be increased 5 – 10%.

Cleaning by diffusion is accomplished by penetration of the reactive ingredients through the “dirt” layer and subsequent absorption onto the surface of the compound. Diffusion can be affected by the nature of the “dirt,” time, temperature and pressure.

Temperature and pressure are critical to ensure maximum cleaning. While higher temperatures increase the diffusion rate, they also reduce the cleaning time. Cavity pressure should be maintained by ensuring adequate charge weight. Do not “bump”.

How Glo-Mold works.

Initial cleaning of very dirty molds may require multiple applications.

Maintenance of clean molds will be accomplished through determination of optimal number of production heats between applications of Glo-Mold.

A variety of products allows the fabricator to select the Glo-Mold formulation that best suits the physical, rheological and processing requirements.

Processing recommendations depending on product selection and application.

- Time: 2 to 20 minutes
- Temperature: 280° F to 450° F
- Pressure: Maximum available

Mold storage can be accomplished using Glo-Mold as the last heat in a production run. Remove the mold in the closed position. The rust inhibitor that is generated by the Glo-Mold will protect for a minimum of six months. The mold will also be clean when returned to production.

Most mold surfaces are efficiently cleaned by Glo-Mold. These include steel, stainless steel, chrome and aluminum. Do not use Glo-Mold with brass or other exotic surfaces.

Preparation of Glo-Mold should be the same as used for the normal compound. Glo-Mold can be pre-formed, cold-milled, calendared, extruded or diced.

Precaution should be taken to avoid skin and eye contact. Adequate ventilation should be provided. At room temperature, Glo-Mold may be handled safely. At elevated temperatures, toxic effects are unknown.

Glo-Mold Product Selection and Curing Guide for all Polymers

At 275 degrees fahrenheit (135 celsius) , the cure time for RED Glo-Mold will be 20 minutes

At 300 degrees fahrenheit (148 celsius), the cure time for RED Glo-Mold will be 17 minutes

At 325 degrees fahrenheit (162 celsius), the cure time for RED Glo-Mold will be 15 minutes

At 340 degrees fahrenheit (171 celsius), the cure time for RED Glo-Mold will be 14 minutes

At 345 degrees fahrenheit (174 celsius), the cure time for YELLOW Glo-Mold will be 13 minutes

At 350 degrees fahrenheit (177 celsius), the cure time for YELLOW Glo-Mold will be 12 minutes

At 365 degrees fahrenheit (185 celsius), the cure time for YELLOW Glo-Mold will be 11 minutes

At 380 degrees fahrenheit (193 celsius), the cure time for YELLOW Glo-Mold will be 8 minutes

At 385 degrees fahrenheit (196 celsius), the cure time for ORANGE Glo-Mold will be 5 minutes

At 410 degrees fahrenheit (210 celsius), the cure time for ORANGE Glo-Mold will be 3 minutes

At 425 degrees fahrenheit (218 celsius), the cure time for ORANGE Glo-Mold will be 2 minutes

At 450 degrees fahrenheit (232 celsius), the cure time for ORANGE Glo-Mold will be 1 minute

GREEN: High hot tear strength - Follow the cure times for Yellow Glo-Mold

BLUE: Low mooney - Follow the cure times for Yellow Glo-Mold

LAVENDER: non-curing (for use as a clean-out in extruders)- No cure time

WHITE - Follow the cure times for Yellow Glo-Mold

Easy steps to cleaner molds

- Check actual mold temperature
- Select product based on this chart
- Insert Glo-Mold in usual fashion
- Do not bump, turn off vacuum



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