Operational Manual

We had applied best-grade rubber material and formula in the research and development of the molding rubber for jewelries. Our GREDIA molding rubber can meet the highest requirements of thorough vulcanization, high tension, and strong repeated memory. We are grateful for your choice of GREDIA molding rubber as the material for your jewelry molding production.

A. Press Molding Frames and Molds

(1) Aluminum frames that have good thermal conductivity are recommended for the Press molding frames. Press molding frames must be kept flat and inline. Poor quality press molding frames should not be used. Those with V-shape grooves to help release of air are the best choice.

(2) Molds must be kept clean. Please clean them thoroughly before applying.

B. Filling rubber

(1) Too much or too little rubber during the press molding is inadequate. The thickness of the press molding frame should be determined before the job. The best total thickness of the press molding rubber is about 1~2mm higher than the press molding frame. To achieve best result at the minute and complicated portions of the rubber mold, proper size of press mold should be cut to assure rubber be filled in the minute and complicated portions.

(2) Place mold at the center of the molding frame. Use as many molds on top and lower levels.

(3) Dirty environment and sweats or oils on hands will pollute the rubber, resulting in defective rubber molds. Use pliers and other tools to perform the press molding.

C. Heated vulcanization

(1) Standard heating temperature for vulcanization is 155◦C. The base time for heating 15mm molding frame is 30 minutes, for each additional 1mm on the frame, the heating time needs to be increased 2 minutes. It is suggested that the frame does not exceed 30mm.

(2) Before vulcanization, the molding press must be heated to a set temperature 155◦C. During the vulcanization, place the mold under the mold press to be pressed lightly for about one minute. When the rubber surface is softened, then start the pressing operation, and counting the pressing time.

(3) Some thermometer on the press is not very accurate. When purchasing the molding press, measure the actual temperature of the molding press with a thermometer. This will ensure the best vulcanizing effect.

D. Cooling

Both natural and water cooling can achieve the same result, though the time is shorter with water cooling. The rubber mold is still moldable before complete cooling. Do not begin mold generation until it is completely cold

E. Mold Generation

Using mold generation tools can produce better rubber molds. Mold generation tooling must be kept sharp. Dull tooling will make mold cutting very difficult and result in poor molding tools. It could increase the chances of accidents to the molding technicians.

F. Preservation

Rubber should be kept in a cool place. The best ambient temperature of the store is between 15~30° C .

G. Notes:

New rubber is best of its quality in the first 3 months. Rubber without vulcanization will gradually lower its rubber characteristics and use limit with the rising ambient temperature. The vulcanization under high ambient temperature will result in the scrap of the rubber. The rubber should be used in turn with the storing dates. When stored under good environment, the rubber characteristics could be as good as new even over a year.

Under low temperature, the rubber may harden temporarily. Normally it can recover when changing back to normal temperature. On the other hand, stored under high temperature will speed aging of vulcanized rubber and shorten its life.

Weight: 50-lb (22.7kg) Size: 467mm X 73mm X 3.6mm

NO：C100-G1 (A-38 Front with white refractory lining, back with red dustproof adhesive paper)

NO：C100-G2 (A-40 Front with white refractory lining, back with blue dustproof adhesive paper)

For detailed description of GREDIA, please visit our website: http://www.gredia.com e-mail:hsiang@gredia.com