**How to Select Suitable Rubber Pads**

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| **Shapes & Sizes of the Pads** | |
| 1. | Normally, we select the pads basing on the sizes of the printed pattern. |
| 2. | If there are many fine lines, we use sharper and harder pads. |
| 3. | Use bigger/softer/flater pads for bigger printed patterns. |
| 4. | If there is combination of the patterns, use combinative pads. |
| 5. | When pressing the pad to a certain level, the pressing angle is not good for |
|  | exhaustion. Therefore, do not choose too small pads when basing on printed size. |
| 6. | When using harder pad, the pressing speed must exceed ink-floating speed. |
|  | Otherwise, the underflow-ink might occur. |
| 7. | When the ink contains too many bubbles, a harder pad can sometimes discharge |
|  | the air out of the ink. |
| 8. | When the printed area is curved, the deformation occurs |
|  | when you press the pad too fast. |
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| **Silicone Colors** | |
| 1. | Generally, we use different colors to distinguish pads’materials. |
| 2. | Find Cause Pads – Different colors for different pad characters. |
|  | |  |  | | --- | --- | | Red: | High Hardness;  Good Ink-Absorption; | |  | Suitable for bad-exaust and etching patterns. | | White: | Softer Pads; High-Ductility; | |  | Used to cover irregular pattern and not easy to break. | | Blue: | Good Anti-Solvent Resistance; Used for massive printing; | |  | Enhance the life of the pads. | |  |  | |
| **Hardness of the Pads** | |
| 1. | Some silcone are soft and suitable fpr soft pads. |
|  | However, some silcone are only suitable for hard pads . |
|  | If making it into soft pads, it will reduce the life of the pads. |
| 2. | Normally, the sharper/harder the pads are, the better exhaustion they are. |
|  | Therefore, we use sharper/harder pads for thinner lines and patterns. |
| 3. | Hard pads are with better exhaustion but it is also easier to cause underflow-ink. |
| 4. | For bigger area printing, use softer pads to avoid uneven shades. |
| 5. | The harder the pads are, the greater that the pads can hold when printing. |
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| **Ink Absorption for Pads** | |
| 1. | Better anti-solvent pads, the ink absorption is worse. |
| 2. | Old pads’ ink absorption is better than new pads. |
| 3. | Printing in advance to test the concentrated dilutions of the ink. If the evaporation |
|  | is ok but the pad still can't absorb the inks, use the cloth to clean up the pad. |
| 4. | Clean the pad surface can enhance the ink absorption; however, |
|  | it can reduce its deinking as well. |
| 5. | Try not to pause too long when sticking the ink. Do not stop the machine and |
|  | expose the content on the steel plate. These may cause the incompleted ink-sticking. |
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| **Deinking of the Pads** | |
| 1. | The longer the pads are used, the deinking is worse because of the solvent |
|  | corrosion to the pads and friction between pads and printed objects. |
| 2. | The faster the ink evaporating speed, the better the deinking is. |
| 3. | When pressing the pad before touching the object, you can stop for 0.3-1.5 |
|  | second (to make the ink a bit more dry) and then press down. |
|  | This is helpful for deinking. It especially works better using the dryer. |
|  | (Using dryer in winter helps the ink evaporation) |
| 4. | The deinking effect is the best when the pad ink is at semi-dry state. |
|  | The deinking process can be done successfully more than 10,000 times per day. |
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| **Life of the Pads** | |
| 1. | Normally, a pad can be used 10K – 50K times. |
| 2. | Factors affecting the pad lives: |
| 3. | A. Squeezing Variant |
|  | B. Solvent Corrosion |
|  | C. Oxidation |
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|  | This product is suitable for softer/flater pad.   |  |  | | --- | --- | | 1. | FC-06 Pad; Red Silcone; Hardness: 20%. | | 2. | Ink: RUCO180 +30% Clear Coat | | 3. | Solvent: Fine Cause Extra Fast Evaporating Solvent | | 4. | Steel Plate Depth: 33u-36u | | 5. | Machine: FC-252 2-Color Pad-Printer | | 6. | Printed Object Material: Nylon | | 7. | Use dryer to assist deinking | | 8. | Stop before sticking ink: 0 second | |  | Stop after sticking ink: 0.3 second | |  | Stop before printing: 0.7 second | |  | Stop after printing: 0.5 second | |
|  | This product is suitable for sharper/harder pad.   |  |  | | --- | --- | | 1. | FC-120 Pad; Red Silcone; Hardness: 0% | | 2. | Ink: SEIKO-VIC Series | | 3. | Solvent: Fine Cause Extra Fast Evaporating Solvent | | 4. | Steel Plate Depth: 20u-22u | | 5. | Machine: FC-125 Single Color Pad-Printer + Auto Sliding Rail | | 6. | Printed Object Material: Nylon | | 7. | Use dryer to assist deinking | | 8. | Stop before sticking ink: 0 second | |  | Stop after sticking ink: 0.3 second | |  | Stop before printing: 0.3 second | |  | Stop after printing: 0.3 second | |