

Printing pads



Silicone qualities
Pad shapes and hardnesses
Pad holders

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General information

The printing pad is one of the deciding factors for producing excellent print results. Teca-Print manufactures high-quality printing pads tailored to the needs of pad printers and backed by a qualified team for support. With a commitment to excellence, silicone qualities and pad shapes are continuously evaluated and improved.

Printing pads are made of silicone and are available in different qualities, shapes and hardnesses.

Pad families, silicone qualities and hardnesses (i.e. durometer)

The pad's ink transfer performance varies depending on the properties of the silicone.

There is a wide range of silicone types to choose from in order to find the ideal pad for each application and to optimize the print quality.

The hardness of the pads is measured in Shore. Teca-Print uses the scale according to the system 00 Si. The production tolerance is ± 2 Shore 00 Si. Generally speaking, pad durometers range from 39 Shore 00 Si (very soft) to 68 Shore 00 Si (very hard). In addition to the quality of the surface and shape of the part to be printed, the printing force of the machine and the size of the print image must also be taken into consideration when choosing the proper pad durometer.

Cleaning

The dust and ink residue left on the pad surface should be cleaned with adhesive tape only.

Activation

New printing pads must be de-oiled before using them for the first time, so that the pad is activated for printing. Great care is required during the activation. Use soft paper towels, soaked with ink thinner (e.g. VD, VM) to wash down the pad surface. Important: dry rubbing or scrubbing can create an eraser effect and damage the pad surface. Once the surface is matt and the thinner evaporated, the pad can be used to print.

Storage

Store pads in an area without sunlight and keep them away from direct contact with other parts (including other pads).

Pad bases and fastening

Both wood and aluminum are used as pad bases. All Teca-Print printing pads with a wooden base have a M6 thread in the middle (if size and form allow). Printing pads with this pad base can easily be mounted to the corresponding pad holder containing a M6 threaded pin.

You can find an overview on pages 32 and 33.

The golden rule of pad selection

The rule below should be followed when choosing a printing pad:

Always choose the hardest, most pointed and largest pad possible.

The hardness of the pad helps to print sharp contours and ensures perfect prints on structured surfaces.

The steeper the pad is, the better the air can escape (i.e. during ink pick up and transfer).

The largest pad volume possible minimizes image distortion, as larger pads deform less.

Printing pad qualities



universal application

widest range of shapes

excellent fine-image transfer

very good resistance to mechanical abrasion

Standard

Our "Standard" silicone range of printing pads covers a very broad spectrum of applications. They are available in a large variety of shapes and three different hardnesses.

Best transfer properties enable the printing of very fine detailed images. The silicone has a high level of resistance to mechanical abrasion and is therefore universal in application, even when used over a longer period the swell resistance is excellent. The good anti-static properties round off the benefits of the "Standard" pads.

In general we recommend our standard pads in the hardness "red" (medium-hard, 54 Shore 00 Si) as the first test option for a large variety of applications as long as no special silicone properties are required. This universal printing pad has an excellent price-performance ratio.

For special applications several shapes of the quality "Standard" are available with a cavity or with a net.



transfer of pad printing ink as well as watchmaker's ink

relief prints possible

best fine-image transfer

Blue

Printing pads of the quality "Blue" have a hardness of 64 Shore 00 Si and are suitable for the transfer of conventional pad printing ink as well as the special inks used by watchmakers.

Thanks to these possibilities and in combination with an excellent fine-image transfer, the "Blue" printing pads are very often found in the watch industry. The very finest print images can be transferred reliably and at the same time relief effects can be created.

The high resistance to mechanical abrasion, as well as the high resistance to swelling, supplement the positive properties of the "Blue" printing pads. Thanks to the increased hardness the printing pads of the quality "Blue" offer additional benefits to the "Standard" printing pads especially when printing on a textured or metallic surface.

Printing pad qualities



excellent anti-static properties

high resistance to mechanical abrasion

swell resistant and easy to clean

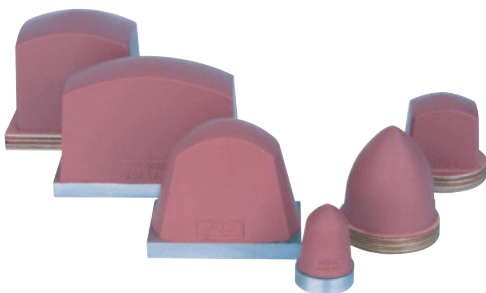
long lifetime

StarX

The high-performance printing pads "StarX" are ideal for a large variety of applications. They are available in different hardnesses from 39 - 64 Shore and can be ordered in various shapes. The field of application ranges from single-colour line prints to multi-colour halftone printing.

Only a very short activation time is required for new StarX pads compared to standard silicones. The anti-static properties of this unique silicone offer unrivalled and splash free ink transfer.

The extremely high swell resistance of "StarX" printing pads can be used continuously even with alternating print images. Resistance to mechanical abrasion is also very high. Where pads may be over-compressed around curves or have continual contact with a tooling fixture, StarX pads will outlast standard silicones in the most demanding production situations.



superdry

no marks on glossy surfaces

highly tear-resistant

very good mechanical abrasion properties

BriX

"BriX" printing pads contain only encapsulated oil which makes them "superdry". Due to this encapsulation the printing pads quality "BriX" stand out from all other silicone qualities. No unwanted marks remain on the printing surface, not even on glossy substrates.

Thanks to the special components used in "BriX" printing pads the mechanical resistance and hardness are especially high. They score excellently in terms of abrasion and anti-swelling.

"BriX" printing pads are available in various shapes and two different hardnesses (medium hard and hard). After a short activation time they are ready to use.

Printing pad qualities



transfer of pad printing ink
as well as watchmaker's ink

relief-effect possible

best fine-image transfer



ideal for full-surface prints

long lifetime

very good anti-swelling properties



"FDA"-conform

supplied with a certification

particularly suitable for medical
technology sectors

Dual

The quality "Dual" combines two different silicone types and offers exceptional printing pads for special applications. Best fine-image transfer and the possibility to transmit not only pad printing inks but also other media such as watchmaker's ink, make the printing pads "Dual" so special. In the watch industry "Dual" printing pads combined with watchmaker's ink demonstrate the desired relief-effect particularly well.

"Dual" printing pads are limited to smaller, mostly round pad shapes and are available with coloured anodized aluminum bases. They are produced in durometer 64 Shore 00 Si (hard).

Long-Life

Printing pads quality "Long-Life" are produced in a great shape diversity and in two hardnesses (soft and medium hard).

Apart from their good resistance to mechanical abrasion the printing pads "Long-Life" are ideal for full-surface prints. The printed ink film of full-surface prints shows outstanding homogeneity.

These printing pads are also often used in the watch industry.

FDA

"FDA" printing pads meet the stringent requirements of the American Food- and Drug Administration. Due to its characteristics "FDA" printing pads are mainly used in the sector medical technology and in the food industry.

The printing pads quality "FDA" always have an aluminum base and an airtight packaging.

"FDA" printing pads are available in two hardnesses (medium hard and hard) and convince with a high mechanical resistance.

Overview printing pad qualities

silicone type	durometer	description	appearance	example
Standard	39 Shore 00 Si	W	white	
	44 Shore 00 Si	G	green	
	54 Shore 00 Si	R	red	
Blue	64 Shore 00 Si	B	blue	
StarX	39 Shore 00 Si	-39	grey	
	44 Shore 00 Si	-44		
	54 Shore 00 Si	-54		
	64 Shore 00 Si	-64		
BriX	54-58 Shore 00 Si	D-M	brick red	
	64-68 Shore 00 Si	D-H		
Dual	64 Shore 00 Si	-DL64	transparent/ grey	
Long-Life	44 Shore 00 Si	O	white	
	54 Shore 00 Si	M		
FDA	54 Shore 00 Si	-54-MT-FDA	brick red	
	64 Shore 00 Si	-64-MT-FDA		

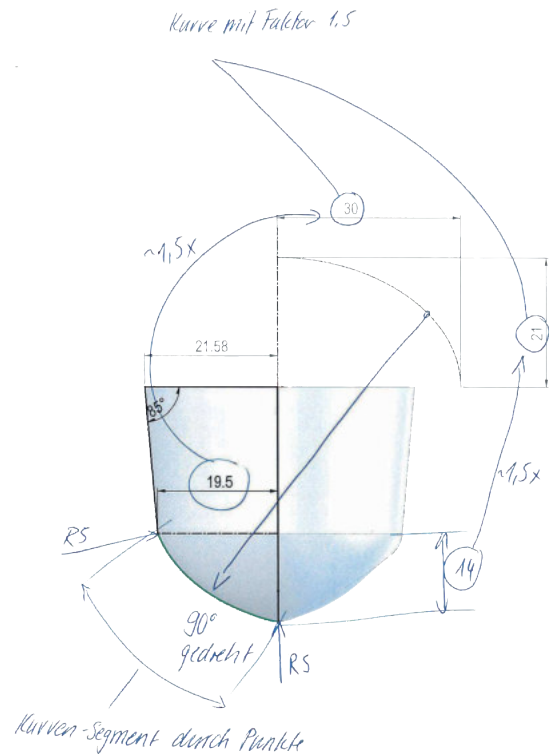
The perfect pad shape

Apart from the silicone that is used to make the pad, the shape is the decisive factor for optimal printing results. Nature provides the geometry to calculate the ideal pad shapes. The surface structures of the OrbiX printing pads are derived from shapes, similar to that of a parabola, which are often found in nature.

This unique combination of experience and inspiration from nature provides the basis of design for the perfect printing pad. With all printing pads of the OrbiX series this formula has been applied to the surface structure. The special pad surface design provides even pad compression during the ink transfer, which results in the visible improvement of print quality.

The results include:

- even pad pressure
- optimized unroll properties
- significant improvement in ink transfer
- improved print accuracy



green
44 Shore 00



blue
64 Shore 00



StarX
39 Shore 00
44 Shore 00
54 Shore 00
64 Shore 00



red
54 Shore 00




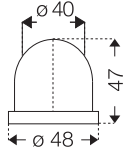
Long-Life
44 Shore 00
54 Shore 00



BriX
54-58 Shore 00
54-68 Shore 00


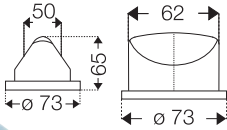
OrbiX - shapes

T8001
round


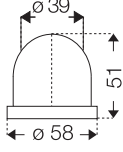
61 g
M6

T8002
rectangular


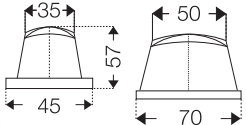
213 g
M6

T8003
round


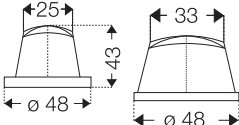
86 g
M6

T8004
rectangular


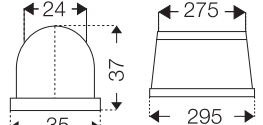
129 g
M6

T8005
rectangular


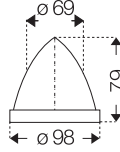
55 g
M6

T8006
rectangular


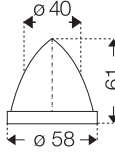
287 g
M6

T8007
round


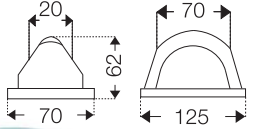
389 g
M6

T8008
round


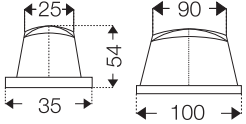
103 g
M6

T8009
rectangular


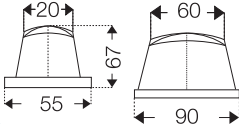
287 g
M6

T8010
rectangular


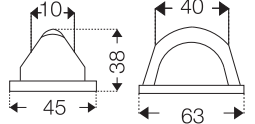
158 g
M6

T8011
rectangular


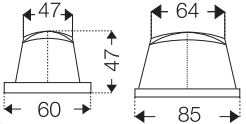
187 g
M6

T8012
rectangular


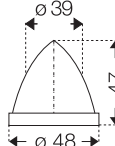
57 g
M6

T8013
rectangular

159 g
M6

T8014
round

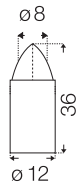



64 g
M6

The print surfaces of these pads can be found in a separate brochure.

ROUND conical

T0368

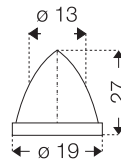


7 g

M6

aluminum base

T0405

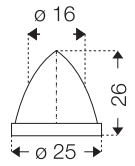


11 g

M6

aluminum base

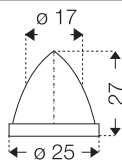
T1179



8 g

M6

T0198

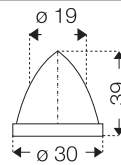


18 g

M6

aluminum base

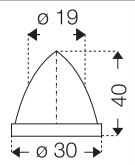
T0545



30 g

M6

T1325

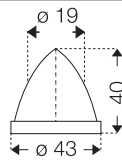


30 g

M6

aluminum base

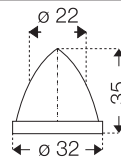
T0093



23 g

M6

T0199

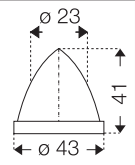


35 g

M6

aluminum base

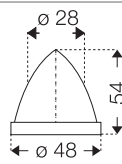
T0092



30 g

M6

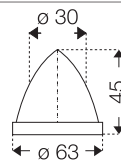
T0548



63 g

M6

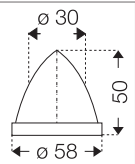
T1542



85 g

M6

T1120



87 g

M6


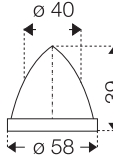
ROUND conical

T1466




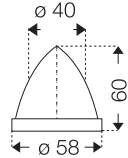

110 g
M6

T1700


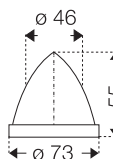
55 g
M6

T0011

103 g
M6

T0159


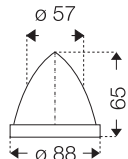
124 g
M6

T0098




220 g
M6

T0722

224 g
M6

T0328




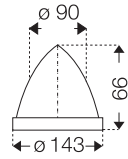

378 g
M6

T0027




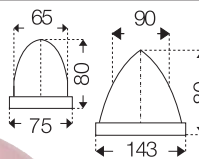

389 g
M6

T0628


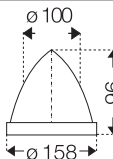
555 g
M6

T0637


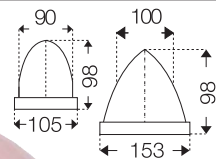
610 g
M6

T0090

1095 g
M6

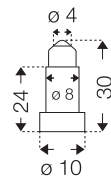
T0636

1007 g
M6

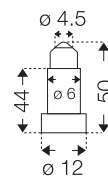
ROUND cylindrical with conical print surface

T0426



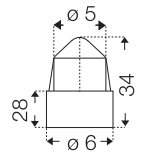
3 g
M6
aluminum base

T0383



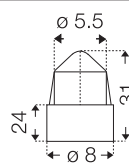
6 g
M6
aluminum base

T1189



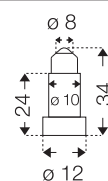
2 g
M4
aluminum base

T0363



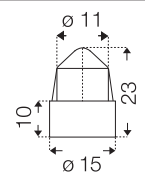
3 g
M6
aluminum base

T0522



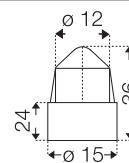
6 g
M6
aluminum base

T0605



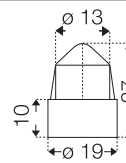
6 g
M6
aluminum base

T0539



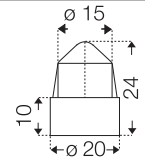
12 g
M6
aluminum base

T0415



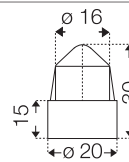
11 g
M6
aluminum base

T1213



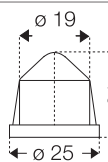
12 g
M6
aluminum base

T0525



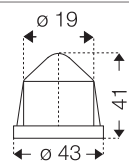
14 g
M10
aluminum base

T0458



12 g
M6


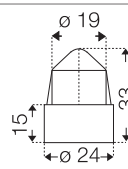
T0095



27 g
M6


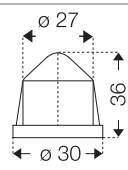
ROUND cylindrical with conical print surface

T0526


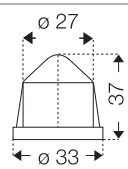
23 g
M10
aluminum base

T0431


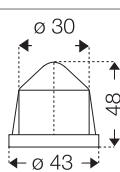
25 g
M6

T0600

40 g
M6
aluminum base

T1144


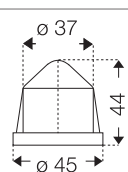
58 g
M6

T0999




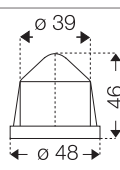

154 g
hollow

T0723


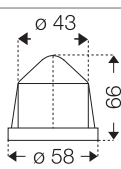
77 g
M6
aluminum base

T0010


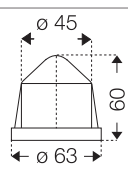
64 g
M6

T0003


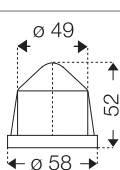
133 g
M6

T1086


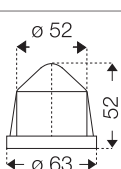
175 g
2x M4
hollow
aluminum base

T0002


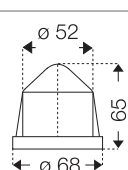
120 g
M6

T0120

124 g
M6

T0042

179 g
M6

ROUND cylindrical with conical print surface

T0009

122 g
M6

T0058

249 g
M6

T0047

306 g
M6

T0060

302 g
M6

T0065

396 g
M6

T0055

550 g
M6

T0063

492 g
M6

T0025

614 g
M6

T1209

450 g
hollow

T0026

1023 g
M6

T0450

848 g
hollow

T0781

1230 g
M6
hollow

ROUND spherical

T0004




51 g
M6

T0005




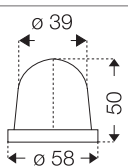

69 g
M6

T0001




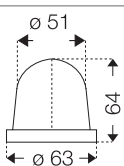

57 g
M6

T0007

86 g
M6

T0008

157 g
M6


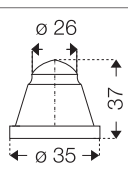
T0105




244 g
M6


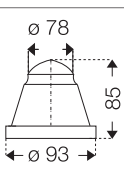
ROUND with a lip

T1005


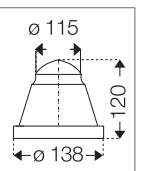
35 g
M6
aluminum base

T1344

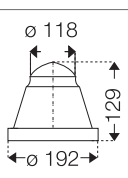
485 g
hollow

T0834


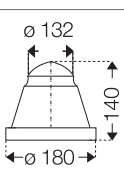
1724 g
M6
aluminum base

T1205


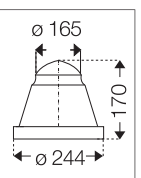
2095 g
hollow

T1406

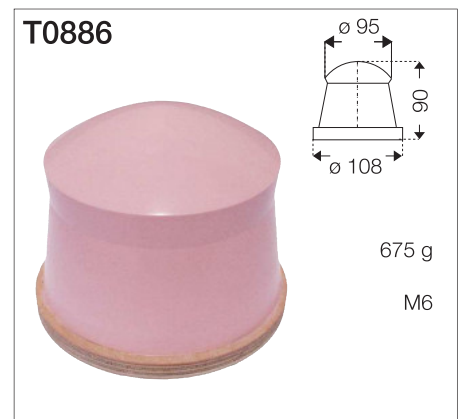
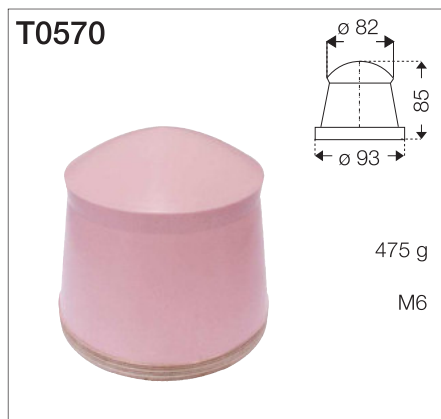
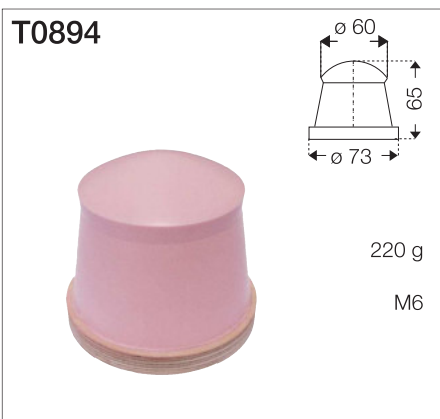
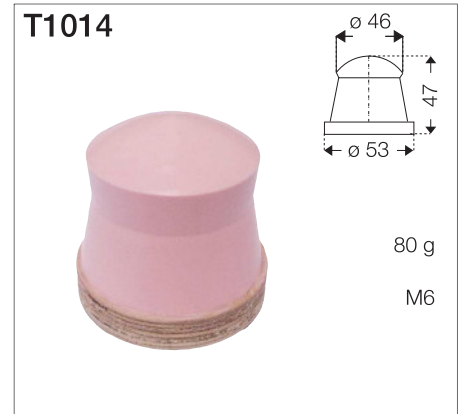
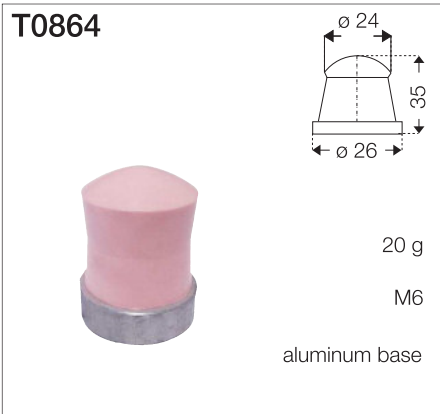
2840 g
3x M4
hollow
aluminum base

T1389

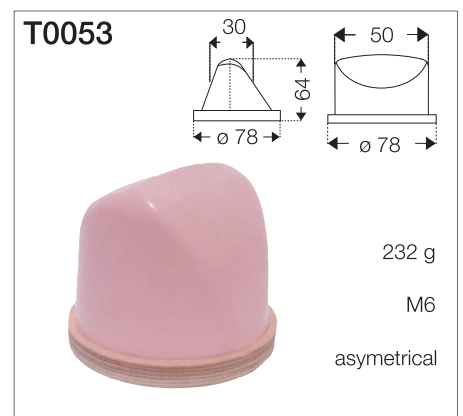
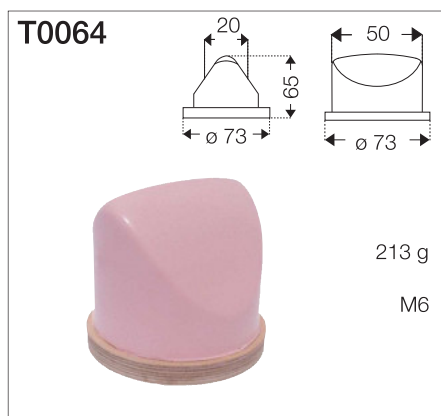
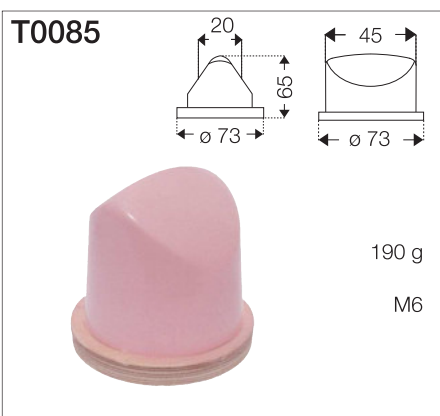



5600 g
6x M4
hollow
aluminum base

ROUND with a waist



RECTANGULAR saddle



RECTANGULAR roofed

T0407

14 g
2xM6
aluminum base

T0020

39 g
M6

T0406

18 g
2xM6
aluminum base

T0212

20 g
M6

T0388

15 g
M6

T0501

39 g
M5
asymmetrical
aluminum base

T0213

24 g
M6

T0070

44 g
M6

T0109

62 g
M6

T0745

88 g
M6

T0091

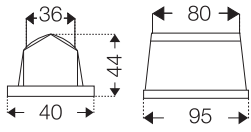
195 g
M6

T0770

33 g
M6

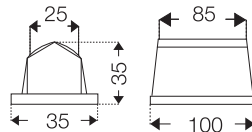
RECTANGULAR roofed

T0457



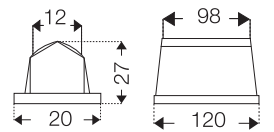
160 g
M6

T0087



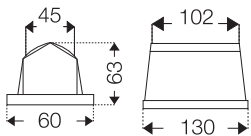
93 g
M6

T0118



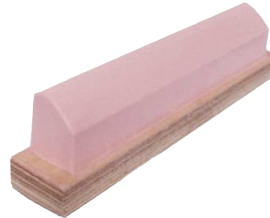
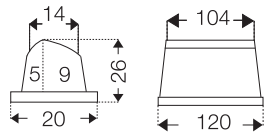
46 g
M6

T0542



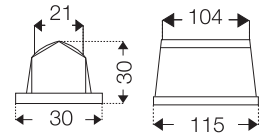
430 g
M6

T0416



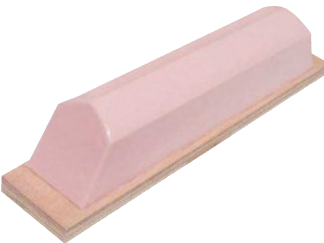
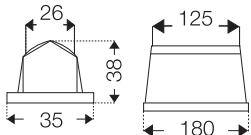
44 g
M6
asymmetrical

T0074



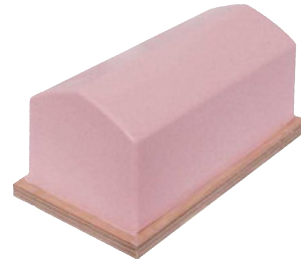
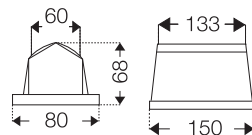
77 g
M6

T0918



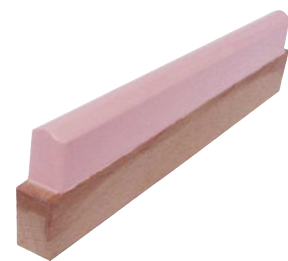
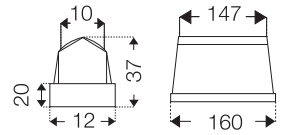
170 g
M6

T0044



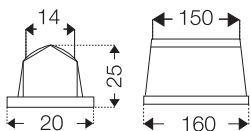
672 g
M6

T0401



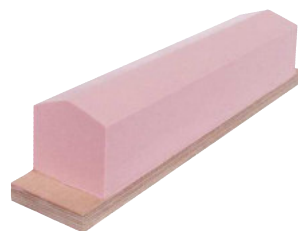
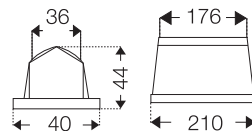
59 g

T0021



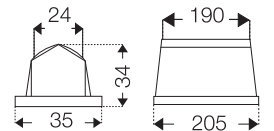
63 g
M6

T0326



332 g
M6

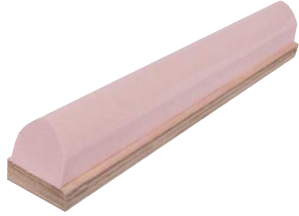
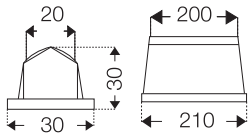
T0646



203 g
M6

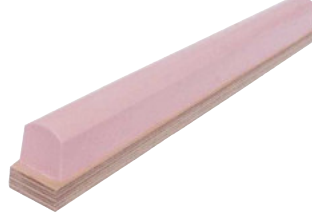
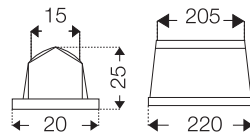
RECTANGULAR roofed

T0610



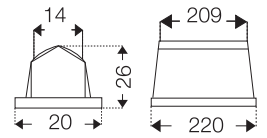
146 g
M6

T0579



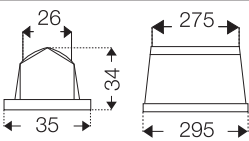
90 g
M6

T0069



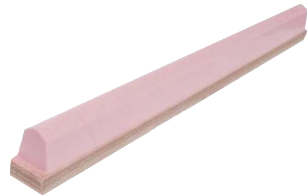
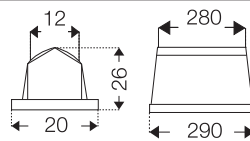
93 g
M6

T0088



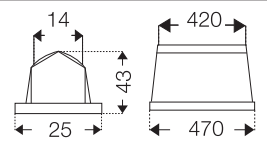
287 g
M6

T0081



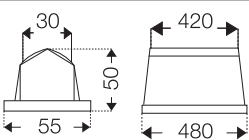
119 g
M6

T0097



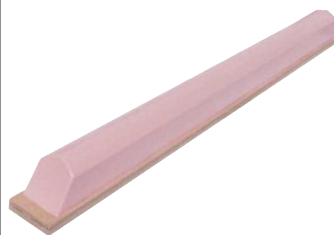
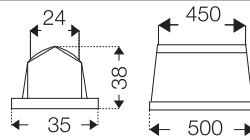
346 g
M6

T0141



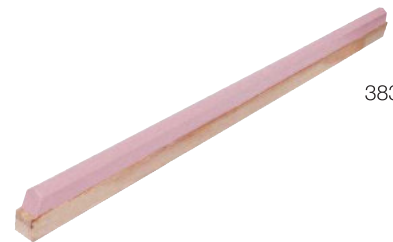
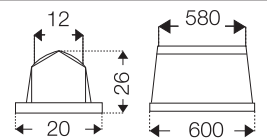
1030 g
3xM6
with a net

T0111



554 g
M6

T0774



383 g

RECTANGULAR curved roof ridge

T1416

90 g
2xM4 / 1xM6
aluminum base

T1299

80 g
2xM4
aluminum base

T1431

133 g
2xM4 / 1xM6

T1309

700 g

T1422

575 g

T1307

1690 g

T1311

1255 g

T1278

1470 g

T1332

420 g

T1292

7425 g
hollow

T1290

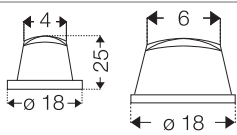
3800 g

T1277

8140 g
hollow

RECTANGULAR standard

T1426

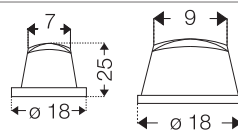


8 g

M6

aluminum base

T1156

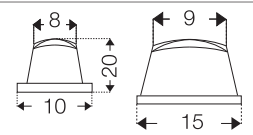


10 g

M6

aluminum base

T1272

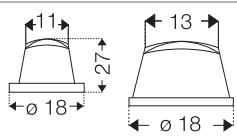


5 g

M5

aluminum base

T0767

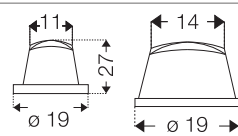


10 g

M6

aluminum base

T0459

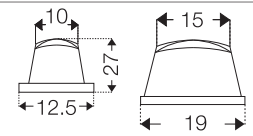


12 g

M6

aluminum base

T0274

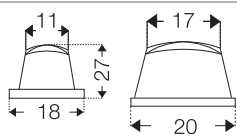


12 g

M5

aluminum base

T0253

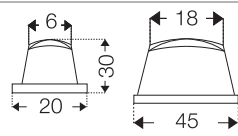


13 g

M6

aluminum base

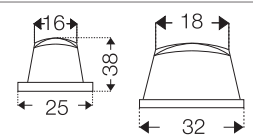
T0132



11 g

M6

T0801

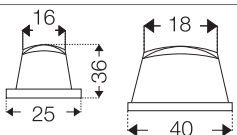


35 g

M5

aluminum base

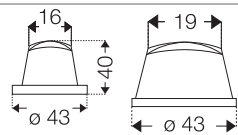
T0410



17 g

M6

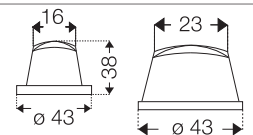
T0084



25 g

M6

T0189



28 g

M6

RECTANGULAR standard



T0885

38 g
M5
aluminum base

T0254

20 g
M6
aluminum base

T0040

39 g
M6

T0633

14 g
M6

T0844

25 g
M5
aluminum base

T0765

38 g
M6
aluminum base

T0156

25 g
M6

T1031

48 g
M6
aluminum base

T0346

140 g
M6

T0078

55 g
M6

T0072

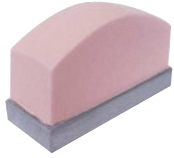
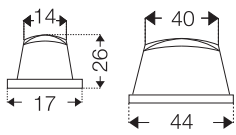
45 g
M6

T0196

43 g
M6

RECTANGULAR standard

T1234

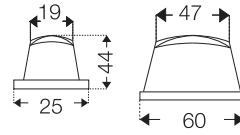


25 g

M5

aluminum base

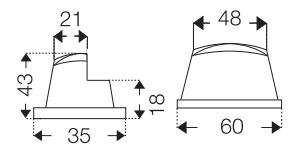
T0395



53 g

M6

T0752

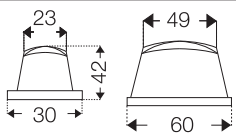


61 g

M6

with nose, depth 18mm

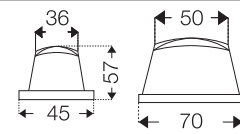
T0403



58 g

M6

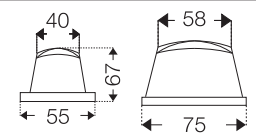
T0077



129 g

M6

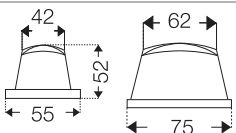
T0071



208 g

M6

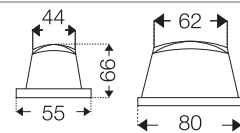
T0119



161 g

M6

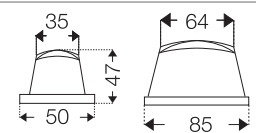
T0017



230 g

M6

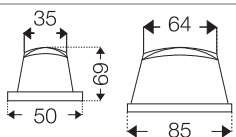
T0303



145 g

M6

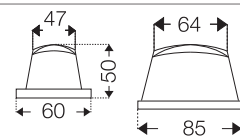
T0048



236 g

M6

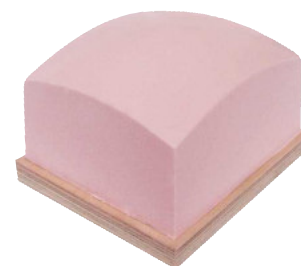
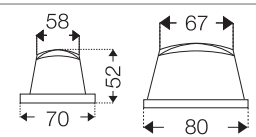
T0137



159 g

M6

T0409



242 g

M6



T0162

134 g
M6

T0365

158 g
M6

T0082

197 g
M6

T0190

139 g
M6

T0056

260 g
M6

T0115

265 g
M6

T0151

375 g
M6

T0360

388 g
M6

T0700

212 g
M6

T0762

318 g
M6

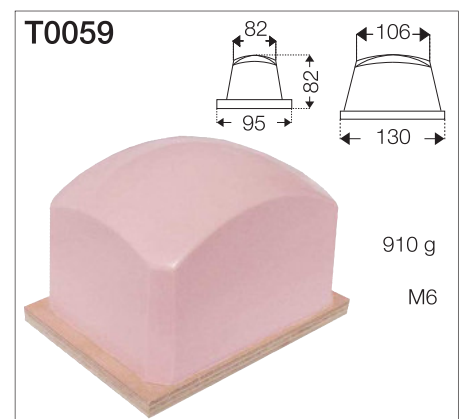
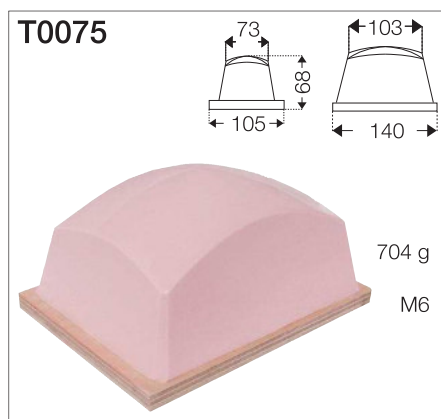
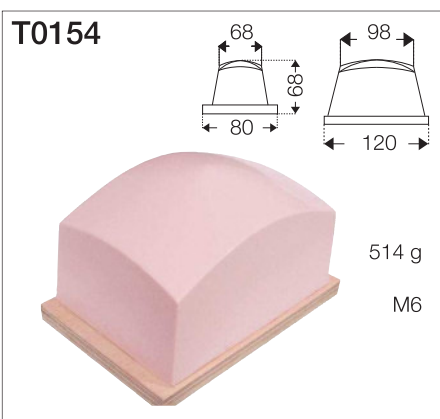
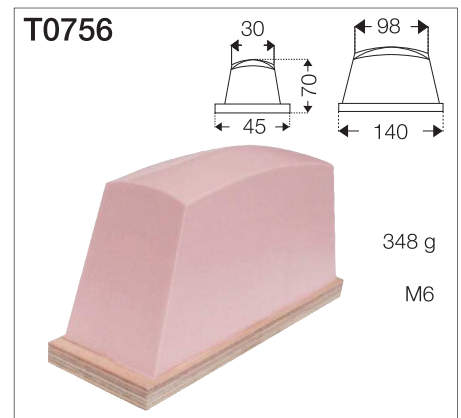
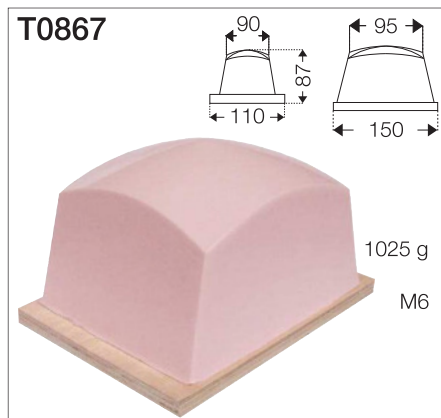
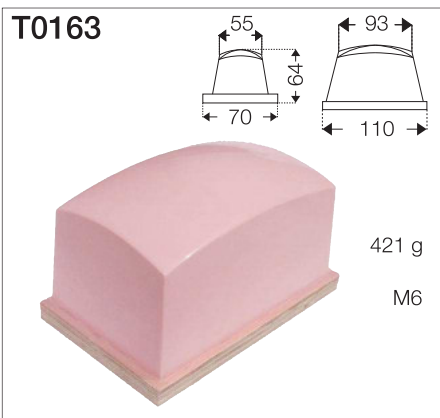
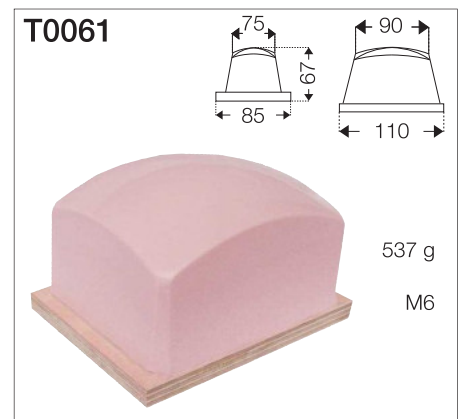
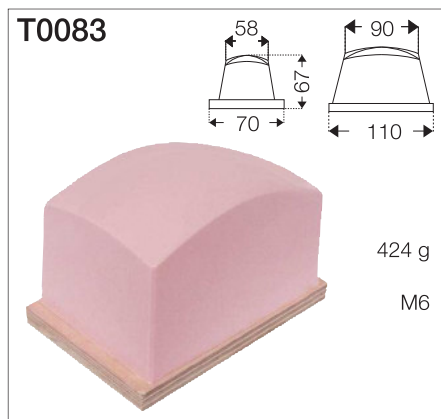
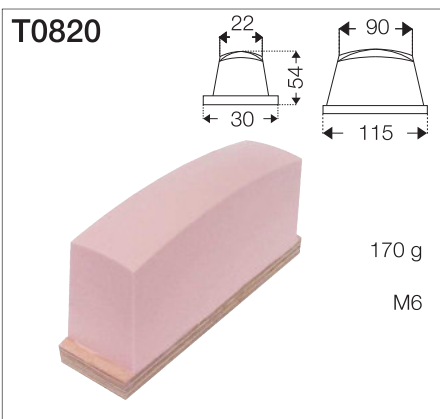
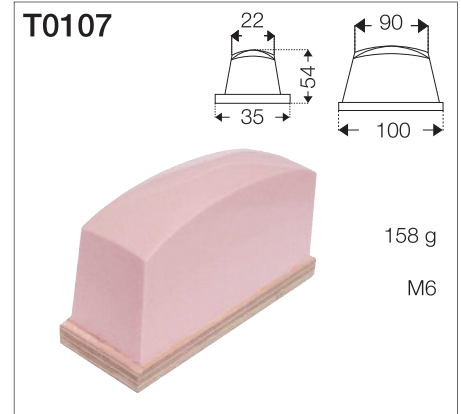
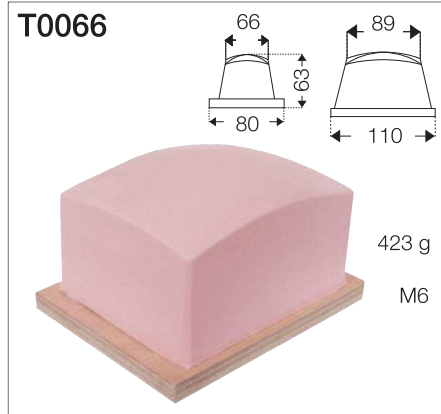
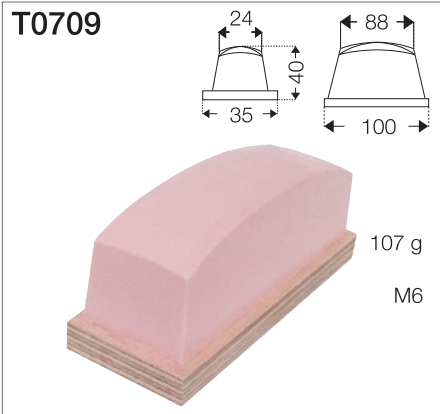
T0166

348 g
M6

T0140

420 g
M6

RECTANGULAR standard



RECTANGULAR standard



T0024

534 g
M6

T0939

930 g
M6

T0738

389 g
M6

T0030

400 g
M6

T0742

940 g
M6

T0437

390 g
M6

T0073

1225 g
M6

T0108

1010 g
M6

T0699

408 g
M6

T0880

1345 g
M6

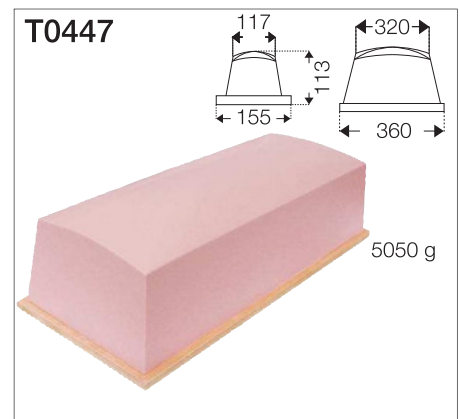
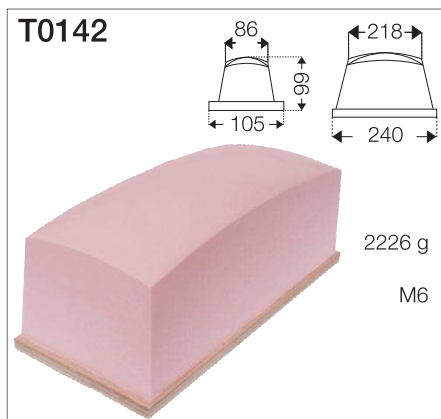
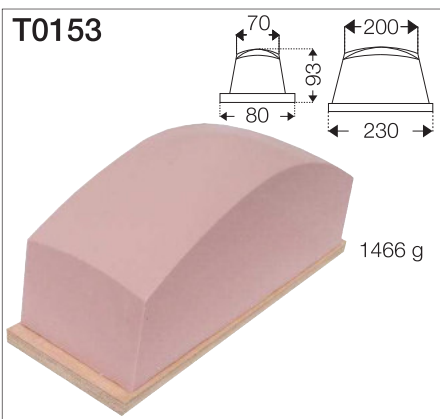
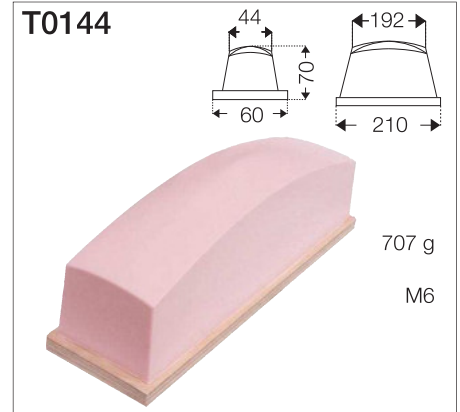
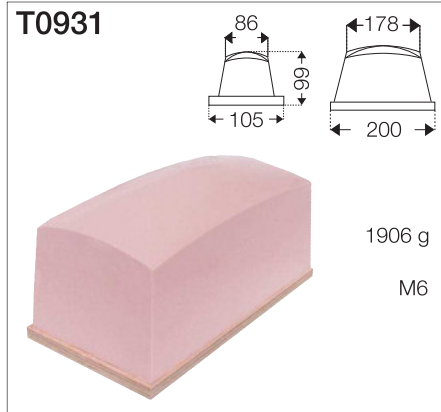
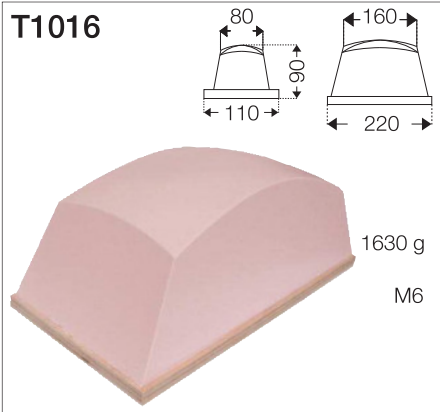
T0558

1800 g

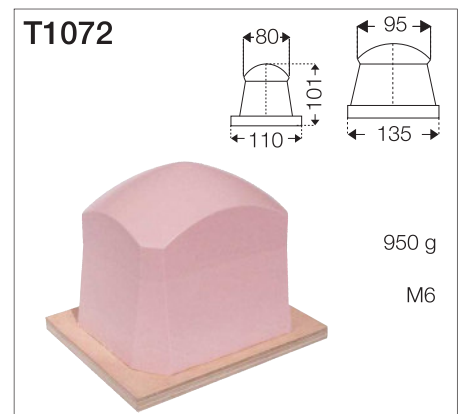
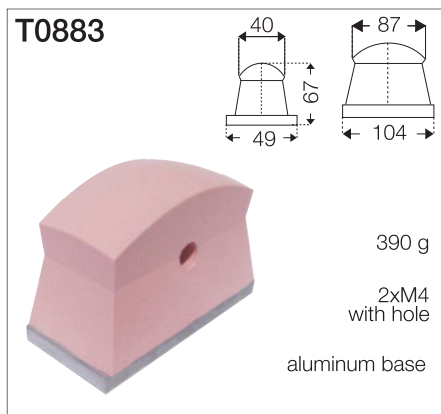
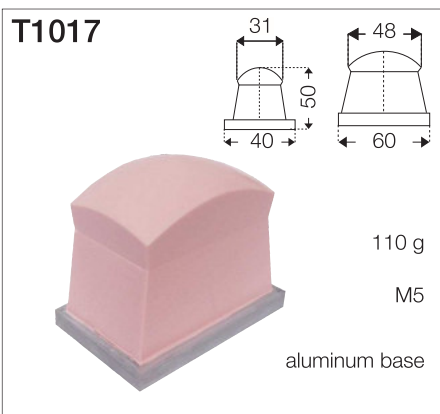
T0971

1290 g
M6

RECTANGULAR standard



RECTANGULAR with a waist



RECTANGULAR fish belly

T0134

37 g
M6

T0135

44 g
M6

T1479

102 g
M6
aluminum base

T0183

57 g
M6

T0184

118 g
M6

T0532

105 g
M6

T0136

114 g
M6

T0185

286 g
M6

T1034

480 g
M6

RECTANGULAR with domed print surface

T1129

35 g
M6
aluminum base

T1060

48 g
M6
aluminum base

T1140

56 g
M6
aluminum base

T0023

55 g
M6

T1012

330 g
hollow

T0086

187 g
M6

T1335

205 g
hollow

T0986

514 g
hollow

T0114

426 g
M6

T1313

2850 g

T1099

5600 g

T1004

6200 g
hollow

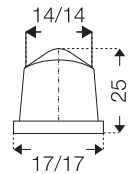

SQUARE

T1242



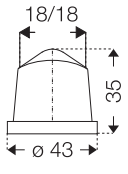


17 g
M6
aluminum base

T0842

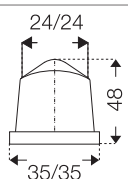

15 g
M5
aluminum base

T0045

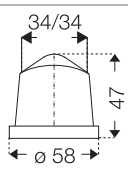

19 g
M6

T0506

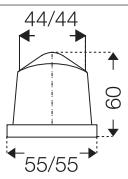

75 g
M5
aluminum base

T0062

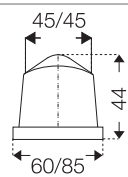

90 g
M6

T0390

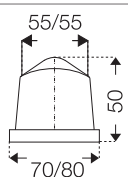

147 g
M6

T0763

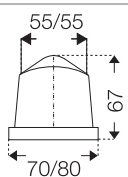

121 g
M6

T0307

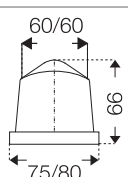
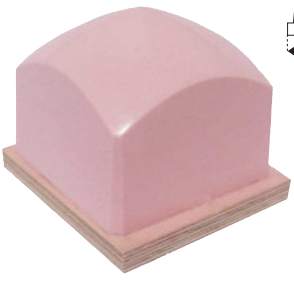
190 g
M6

T0051

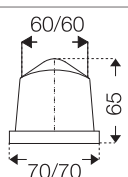

297 g
M6

T0022

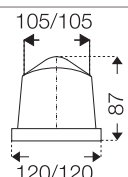

300 g
M6

T0101

283 g
M6

T0028

1016 g
M6

SPECIAL PADS



Some applications place special demands to the printing pad. Different factors are responsible for this: e.g. the form of the to be printed part and the location for the print image. An uneven surface near the print image usually calls for a specially designed printing pad. Also the clustering of smaller pads to a pad combination can be useful.

For the development of special pads printing trials must be done in close collaboration between the application engineers, the film office and the construction team.

If none of the more than 2'000 available printing pads fits your needs, we are happy to develop, test and produce a pad specially for your application.



Pad holders slide supports, clamps, pad cones



Slide supports



25 10 68
w = 58 mm
l = 100 mm



35 10 68
w = 75 mm
l = 100 mm

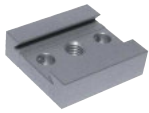


25 20 68
w = 58 mm
l = 90 mm

Clamps



13 05 63
w = 50 mm
M10



13 05 62
w = 50 mm / M10
for TVV 50 00 17



35 05 63
w = 50 mm
M16x1,5



35 12 63
w = 48 mm
M16x1,5

Stop clamps



700 035 342
w = 10 mm



13 05 61
w = 15 mm

Pad cones



70 00 61
M10
pluggable pad holder

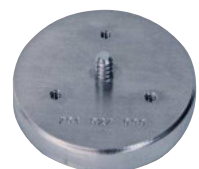


35 01 61
M16x1,5
nut threaded, screw-on

Intermediary disc



701 927 038
ø = 45 mm
M6



701 927 039
ø = 60 mm
M6

Pad holders pluggable or with thread

Pad holder extra small



70 45 67
h = 45 mm
M10



70 45 65
h = 45 mm
M6



70 60 64
h = 60 mm
M10



70 60 65
h = 60 mm
M6

Pad holders narrow with thread



35 50 63
h = 50 mm



35 70 63
h = 70 mm

Pad holder central with thread



35 25 62
h = 26 mm



35 30 62
h = 30 mm



35 40 62
h = 40 mm
M6



35 50 62
h = 50 mm
M6



35 60 62
h = 60 mm
M6

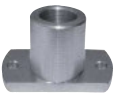


35 70 62
h = 70 mm
M6



35 25 63
h = 26 mm
ø = 100 mm

Pad holder narrow



70 27 63
h = 27 mm



70 45 63
h = 45 mm



70 60 63
h = 60 mm

Pad holder central



70 27 61
h = 27 mm



70 45 61
h = 45 mm
M6



70 60 61
h = 60 mm
M6

Pad holder eccentric



70 27 62
h = 27 mm

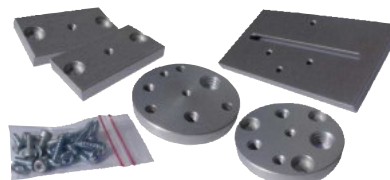


70 45 62
h = 45 mm
M6



70 60 62
h = 60 mm
M6

Double pad holder



70 75 65
for TVV 70 00 22 for 2-colour printing



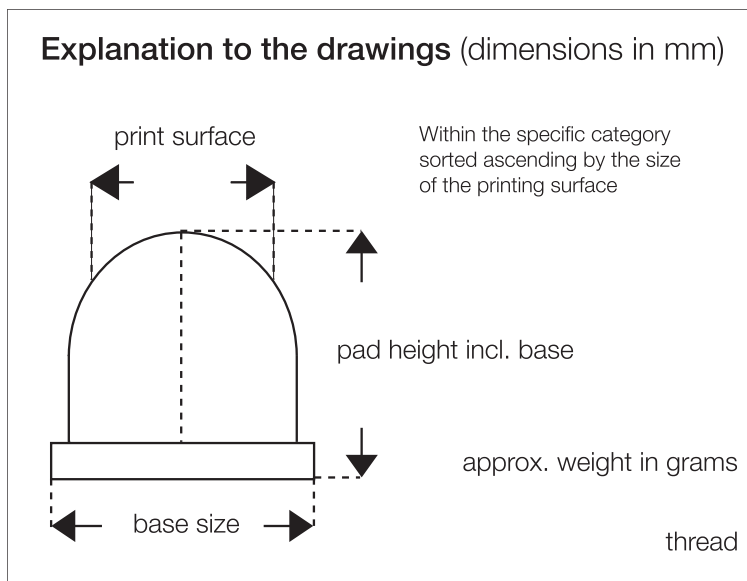
View from below a
M6 thread

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0007	15	0082	24	0189	21
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