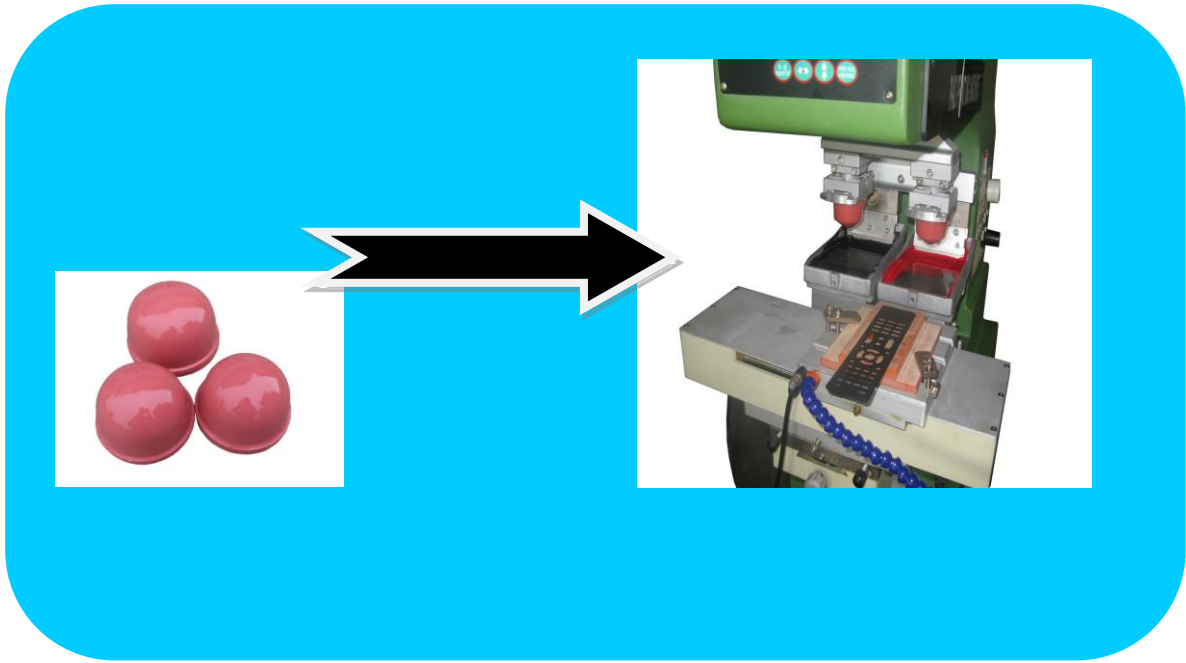


## 移印胶头制作流程

### The procedure of making rubble pad



移印机所用胶头现在普遍采用室温硫化的硅橡胶进行制作,不同厂家生产的硅橡胶材料,参数各有不同,但是制作的工艺相似,下面是我们的过程介绍.



➤ 配方比例: Rate

矽胶: 100 克	Silicon rubber: 100g
矽油: 20—60 克	Silicon oil: 20-60g
固化剂: 3—6.5 克	Curing agent: 3-6.5g



### 制作流程

1. 先取一个干净的塑胶量杯,最好有刻度的,将称好的矽胶、矽油搅拌均匀后静置。  
(想知道每个胶头用料多少,可用胶头模装满水称重即可)。



5.5g  
Plastics gratuity cup

First calculate the percent of silicon rubber and silicon oil, Pour the fixed-rate silicon rubble and silicon oil into a plastics gratuity cup , stir these elements evenly then put the cup aside.

固化剂 2.0—5.5%(夏天)

- 每 100 克矽胶加 20 克矽油内时, 需加 2.0 克固化剂
- 每 100 克矽胶加 30 克矽油时, 需加 2.5 克固化剂
- 每 100 克矽胶加 40 克矽油时, 需加 3.5 克固化剂
- 每 100 克矽胶加 50 克矽油时, 需加 4.5 克固化剂
- 每 100 克矽胶加 60 克矽油时, 需加 5.5 克固化剂

the percentage of curing agent 2.0-5.5 % ( summer)  
Silicon rubber Silicon oil Curing agent 100g 20g 2.0g  
100g 30g 2.5g 100g 40g 3.5g 100g 50g 4.5g 100g 60g

2. 另取一个一次性塑料杯,用电子磅或天平秤好按比例所需的固化剂. 盛放固化剂;  
Weighting some curing agent with electronic scale or balance scale .Prepare a plastic cup for holding

3. 检查胶头模内是否干净及准备好木板  
(将干净 的胶头模排放固定好后), 将固化剂加入胶浆 里面,快速搅拌均匀, 注意桶边及桶底的胶浆与 固化剂要充分搅拌均匀, 然后放进真空机箱内 抽真空 1-3 分钟(注意:不能抽大长时间), 取出 胶料倒入每个胶头模内,然后放木板即可。如果 没有抽真空设备, 可将胶料拉高成一条线状 缓慢倒入胶头模内。



Make sure each Plastics mould or crystal mould of pad is clean before you place it well. and some planks for covering.

Pour the curing agent into the cup containing the silicon rubble and silicon oil , stir quickly till these elements have been stirred evenly . then putting the plastics cup into a vacuum machine About 1-3 minutes later(Note: Do not keep the cup in the vacuum machine too long), you can take the mixing emulsion out and pour it into the mould , covering each mould with the previous prepared plank . Without the vacuum machine , please lifting up the cup full

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of emulsion and pour the emulsion into the mould as a stringy shape so that the air do not hide in mixing liquid.

胶头模可以用透明的不饱和聚酯树脂制作,这叫水晶模,水晶模的表面光洁度非常高,制作出来的 胶头质量比较好. 胶头模也可以用 PET 材料用吸塑的 方法制得, 这样的胶头模成本比较低, 重量很轻. Pad mould made by both unsaturated polyester resin and PET plastics substrates, Resin mould have a very smooth surface than PET plastics substrates. So the quality of pads from resin mould is better than from PET mould.



Plastics Mould



Crystal Mould

4. 固化时无收缩、不膨胀, 固化快慢会受气温的 影响, 环境温度越高固化速度越快,气温越低固化速度越慢(可通过增加固化剂份量),视胶头大小、软硬情 况而定。

During the process of solidifying, the mixing emulsion will not shrink or expand. The solidification is closely related with the temperature, the higher the temperature, the faster the solidification, vice versa. Of course, you can accelerate the speed of solidification by adding the share of curing agent according to the specification and the feature(hard or soft) of the rubble pad.

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5. 移印胶头固化时间约 4-7 小时。如果经过 7 小时后，胶头还没固化好，无法从胶头模内取出，说明固化剂份量未加够，下次需增加份量；如加入固化剂后的胶料才十多分钟，胶料就结团无法倒入胶头模内，这说明固化剂份量加多了，下次需要适当减少固化剂的份量。通常在加入适合份量的固化剂，最少有二十多分钟的操作时间,而且胶料的流动还是很好的！

It's take about 4 to 7 hours to solidify the rubber pad. If it is still can't be solidify 7 hours later, the curing agent should be added more next time. If the rubber be solidify 10 mines later, it means the curing agent should be add much more next time. Usually, the best percent standard of curing agent is that you will have 20 minutes time to treat it and the fluidity of rubber keeps well . if the rubber is beginning solidify within 20 minutes, you will not

6. 胶头模使用一段时间后，如发现胶头比较难以脱模,可在模具表面抹点洗洁精，这样容易起模，也可借助风枪从胶头边缘吹风脱模。(胶头吸塑模具可用自来水冲洗干净,凉干使用，切勿使用任何溶剂 清洁).

When it is difficult to pull the rubber pad from the mould after using for a long time, please coating some liquid detergent on the surface of the mould. You are suggested to use the air pressure gun to blow wind on the edge of the rubber pad for pulling out from the mould ( The vacuum forming mould can be cleaned by water. Don't use any solvent .)



注：移印胶头软硬，可通过添加矽油(硅油)份量来调节，减少矽油份量，胶头变硬；增加矽油 份量，胶头变软，相应要增加固化剂份量。建议矽油份量不要加太多，会降低胶头性能。如胶头要求 很硬，可以不加矽油，视产品需求而定。

Note: The hardness of the rubber pad depends on the percent of silicon oil .The more the silicon oil be add, the harder the rubber pad will be. The percent of silicon oil couldn't be add too much, otherwise the function of the rubber pad would be reduced .Sometimes, if the rubber pad should be very hard, please do not add silicon oil.



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## RM-20BV 抽真空设备说明：



### ● 用途：

在制作移印胶头过程中，混合料(硅橡胶，硅油)会混入大量的空气，如果在交练过程中空气不能及时排出，空气就会混入固化的胶头中引起胶头的寿命下降，RM-20BV 抽真空机就是专门为此目的设计制造的。

### ● 技术参数：

电压：单相 220V /HZ

最大容量：5kg；

真空泵功率：600W.

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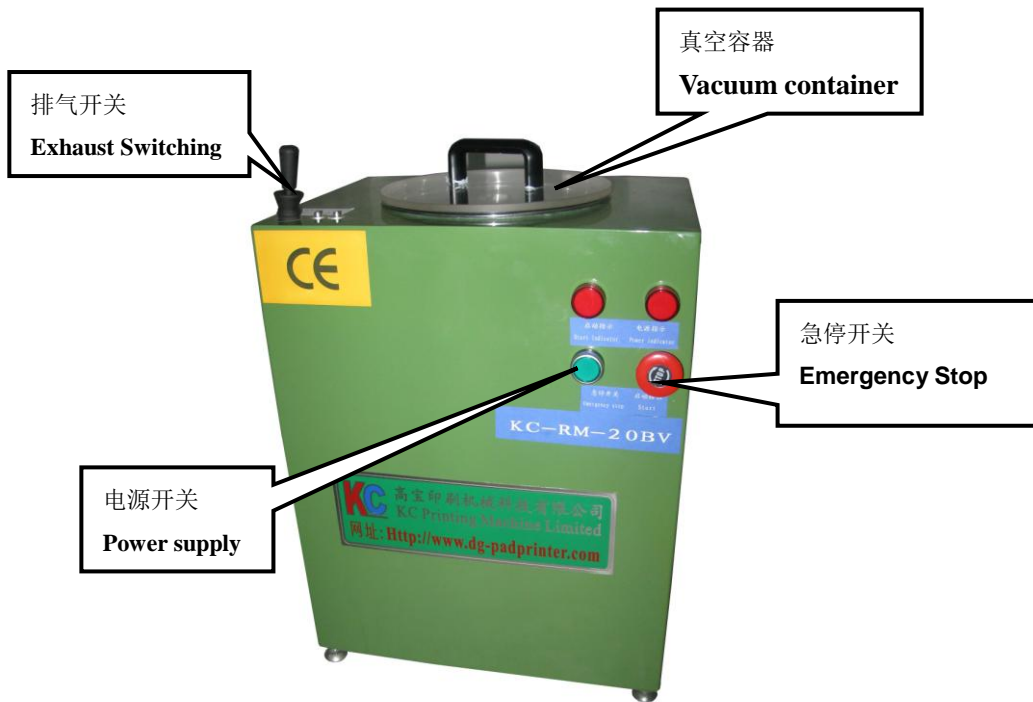
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● **操作程序：**

- 插上电源；
- 启动电源开关；
- 抽真空半个小时后关闭电源；
- 打开排气气阀；
- 取出硅橡胶混合液， 进行浇注作业。

● **结构说明：**



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