

T1F1 Combination Press Pads for Presses & Heavy Equipment

The performance of a press is greatly affected by how it is installed. Without proper support, a multitude of problems can occur from unwanted vibrations to premature wear of press components and tooling.

Due to the higher cost of mounts, pad materials are often used where critical leveling and alignment is not required. Problems can occur however, when the combined weight / force of the press exceeds the capacity of these conventional materials. Careful selection is necessary to ensure that the pad accommodates the difference between the static and dynamic forces and other factors such as off-load conditions.

**T1F1 COMBINATION PADS ARE
NOW AVAILABLE TO MEET
THE SPECIFIC
REQUIREMENTS OF EACH
PRESS APPLICATION**

COMBINED PERFORMANCE

UNISORB™ Red-Line™ Anchor Pads have been used to isolate presses for over 50 years, and provide excellent vibration control and damping. UNISORB™ Titan™ Shock Pads also provide excellent damping, especially under extreme loads and high shock applications.

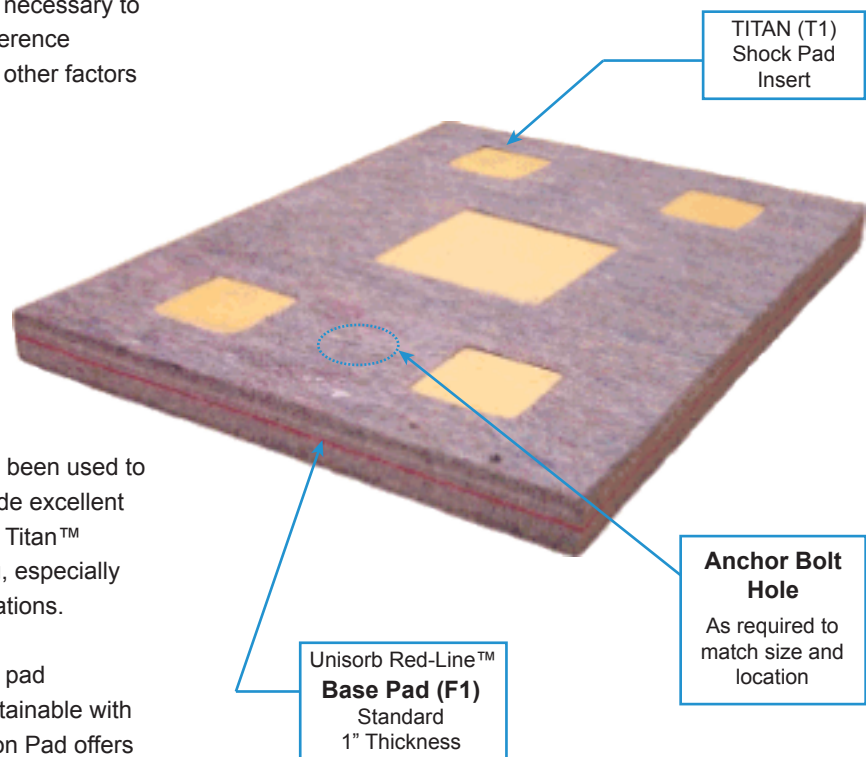
When used together, these well engineered pad materials reach a level of performance unattainable with stand alone products. The T1F1 Combination Pad offers static support, frictional contact and the capacity to handle impact forces with a wide safety margin.

Advantages...

- High damping and vibration isolation performance.
- Controls misalignment and excessive gib wear by accommodating unknown uneven load conditions.
- Constant thickness (1") prevents excessive deflection and dipping & crushing associated with conventional pad materials - Mandatory for quick change die carts and rolling bolsters.
- 100% coverage of manufacturer's originally designed press foot.
- Very long life - no deterioration of pad materials.
- Reuse pads - when relocating equipment.
- Less cost than mounts on the market.

BASIC CONFIGURATION

UNISORB™ Titan™ Shock Pads are inserted into the Red-Line™ material which acts as a frame for secondary support. Full contact is obtained with sizes matching each press foot. By varying the size and number of inserts, it ensures that the combination pads are working within optimum load ranges. This inter-dependent system allows the pads to be fine-tuned to the individual support requirements of the press.

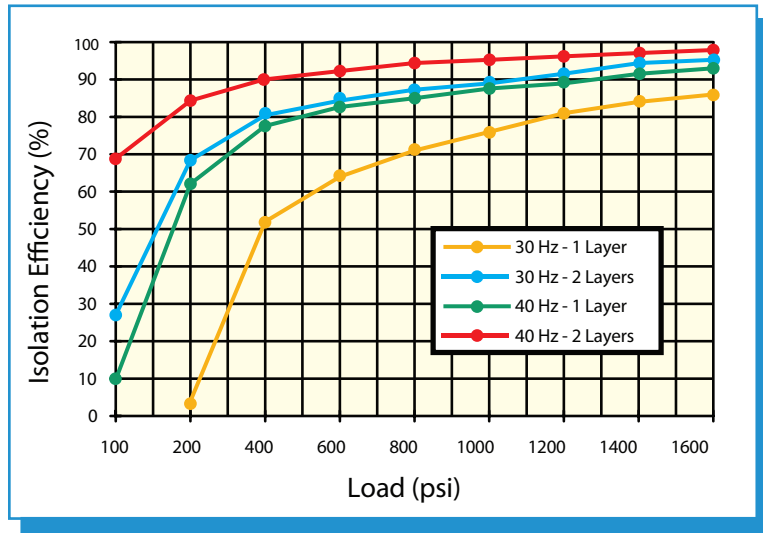


TECHNICAL DATA

PERFORMANCE AND OPTIMUM LOADS

The optimum load range for the T1F1 Combination Pads with Titan™ Shock Pad inserts is between 800 and 1000 psi. This places the material in a favorable compressive work range for maximum pad life. Calculations are made to determine the appropriate configuration for each pad set.

Most presses exhibit an interfering frequency in the 30 to 50 Hz range. This graph shows the attainable isolation values (30 and 40 Hz plotted) based on the deflection characteristics of the combination pads with the Titan inserts. Further isolation can be achieved by increasing the deflection with additional layers of the pads.



T1F1 COMBINATION PADS UNDER PRESSES

As a press blow is struck, the entire press frame including its foundation is set into motion. This motion is essentially a free oscillation. Extremely high loads can be induced into the internal press frame components and foundation area. The T1F1 Combination Pad sharply reduces these forces through energy absorption. Due to a high coefficient of damping, it quickly dampens out this free oscillation and limits the number of shock pulses being transmitted. This also insures that the press frame and foundation will be completely at rest before the next blow is struck.

INSTALLATION

For installations where anchoring is required, the pads can include a bolt through configuration. Titan inserts are positioned in the base material to accept virtually any hole pattern. Symmetrical spacing ensures even distribution of weight under the press foot. Additional measures include placing a pad washer under the anchor bolt nut. This will eliminate the possibility of transmitting shock and vibration into the foundation through the anchor bolt.

A special "Friction-Kote" can be applied to the pads on the top and bottom surfaces to prevent the press from 'creeping' or 'walking' on shop floors.

Mastic Adhesives are recommended on uncoated pad surfaces for permanent installations and presses with more active movement. All contact areas on shop floors under the press feet should be free of dirt, oil and grease.

When required, metal shims matching the size of the pads can be used for leveling the press. Adhesive should be used to prevent shifting.

