

T&T

R&D, Project Management and Consulting

Catalogue

Version 2 10-2018

Contents

Specification of Pusher Fingers.....	2
Sample case: Pusher Fingers specification	3
Accessories	3
Contact materials	5
Overview of Pusher Fingers	8
Accessories and JIGs for Pusher Fingers.....	14

Note: Other catalogues for variables are available on request.

© T&T, Turnov s.r.o.

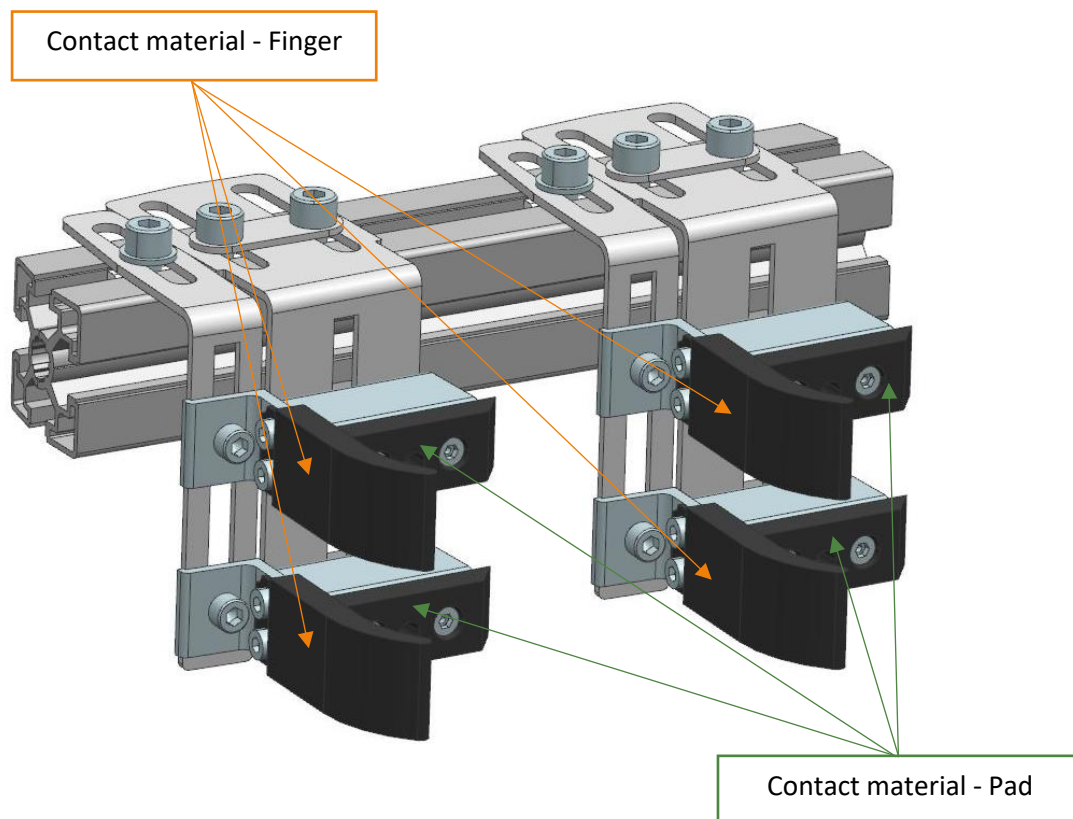
Specification of Pusher Fingers

For optimal use it is necessary to correctly specify the Pusher Fingers, dedicated to customer needs.

In order to specify the right setup, you should use this document.

Also, you will find the various contact material and arrangements of Fingers and Pads. This document provides an overview of the entire spectrum of Pusher Fingers and accessories for the Pusher mechanism.

At first it is now necessary to specify the Pusher Fingers and appropriate contact materials (hereinafter CM).



Information from the customer needed:

- Type of production (Single Gob SG, Double Gob DG, Triple Gob TG, Quad Gob QG)
- Orientation of the machine (L = left, R = right)
- Machine size (4 section, 6,8,10, or 12 section, etc)
- Preferred contact material (Duratemp, Pyrotek PMC, Graphite composite, Stainless fabricated, Ceramic coating, etc)
- Product size and shape (diameter and height of product, product outline, drawing, or sample)
- Production speed (number of products per minute BPM, Belt advance in inch)

The specification we than provide:

- Depending on the type of production, we define a type of Pusher Finger
- Depending on the size and height of the product, we determine the size of the Pusher Finger
- Depending on the assumed range of production and the quantity of ordered types, we determine the remaining properties of Pusher Finger (universality X uniqueness)
- For the Pusher Finger specified, we choose the correct orientation according to the customer's production (R = right, L = left)
- Depending on customer requirements, we define a CM
- Specify the serial number with the appropriate number of pieces entered in the production

Sample case: Pusher Fingers specification

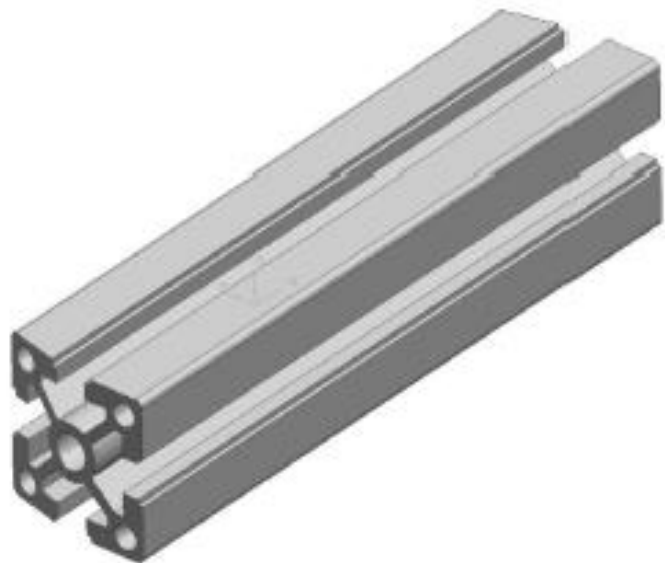
Information obtained from the customer

- IS 10, TG, right-hand production orientation, CM has no preference, product packages for jam, smaller size (Ø40mm, height 80mm), large number of job changes, high production speed (540 BMP, 110mm pitch), the customer wants to produce faster.

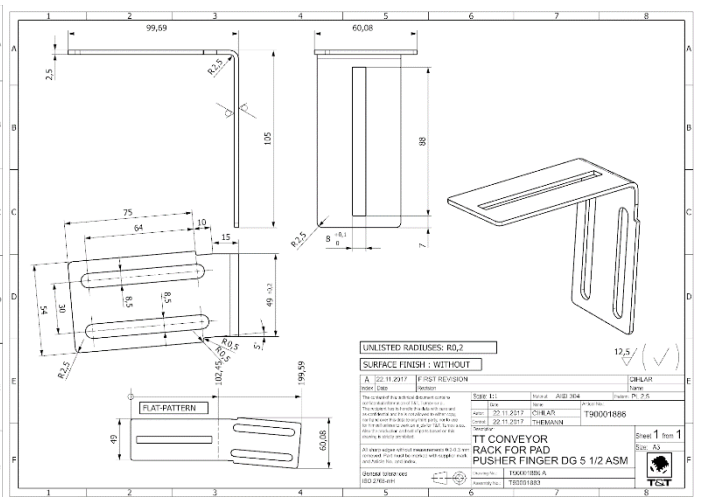
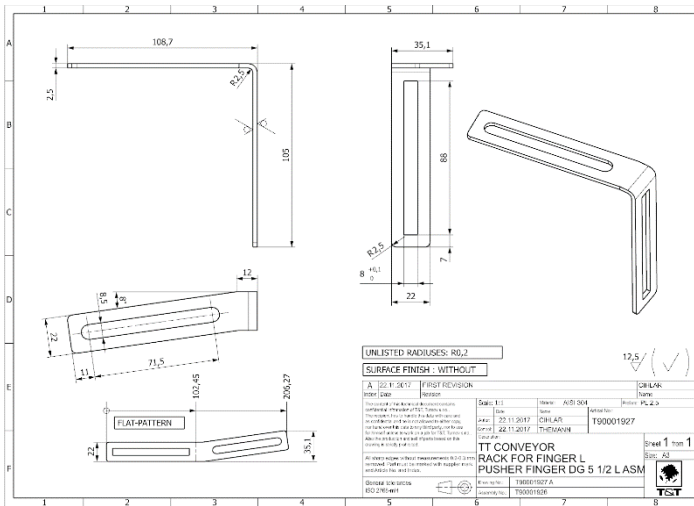
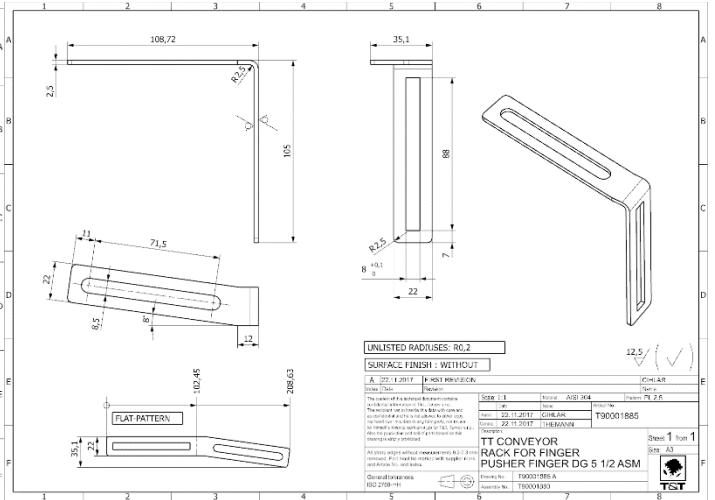
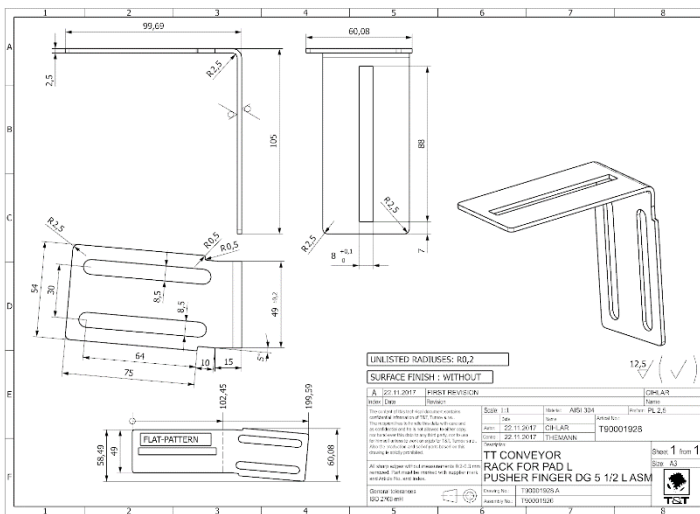
Accessories

AL profile (dimensions):

- 30 x 45 x L
- 45 x 45 x L
- 60 x 45 x L
- 90 x 45 x L



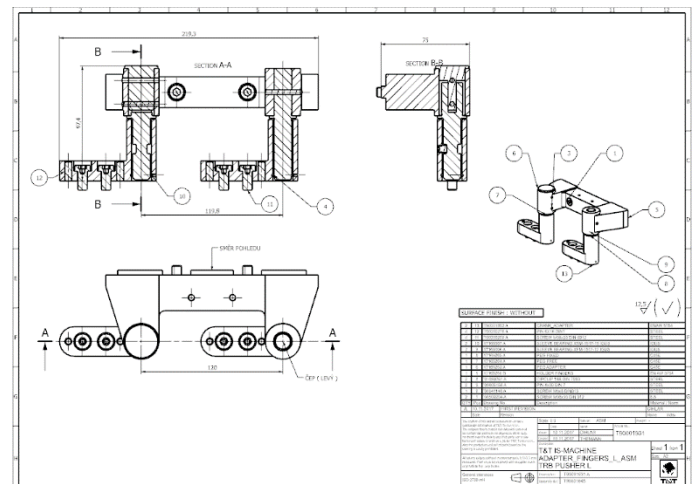
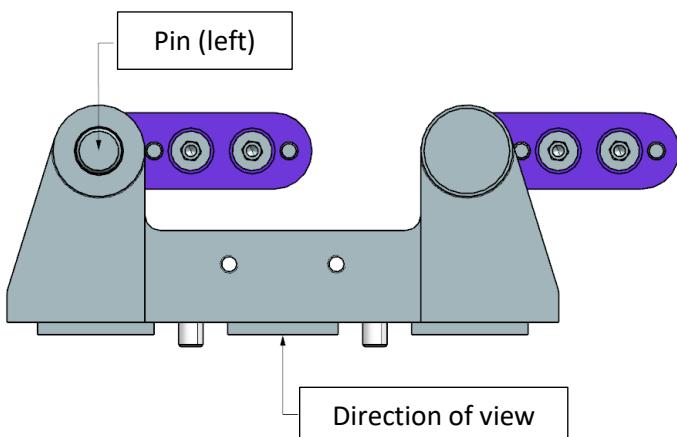
Holder carriers:



Adapter Fingers:

Determination orientation of the Adapter Fingers:

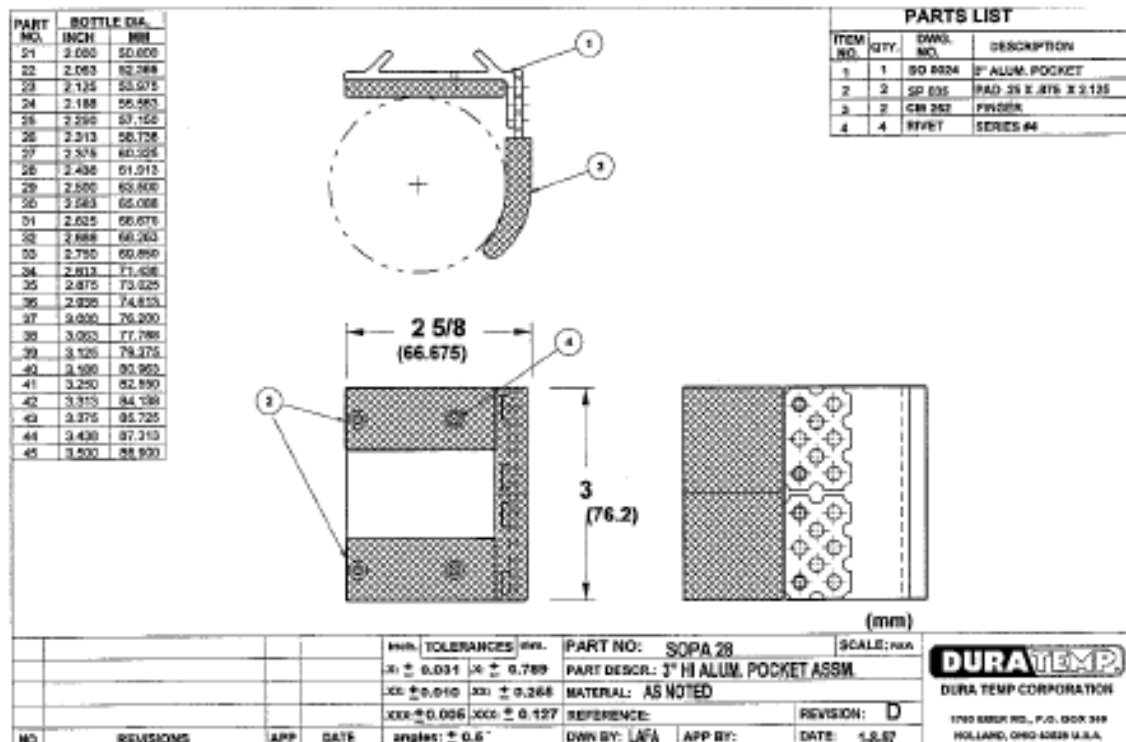
- If looking inside the Pusher Finger, the pin for the left-hand holder is on the left
- If looking inside the Pusher Finger, the pin for the right holder is on the right



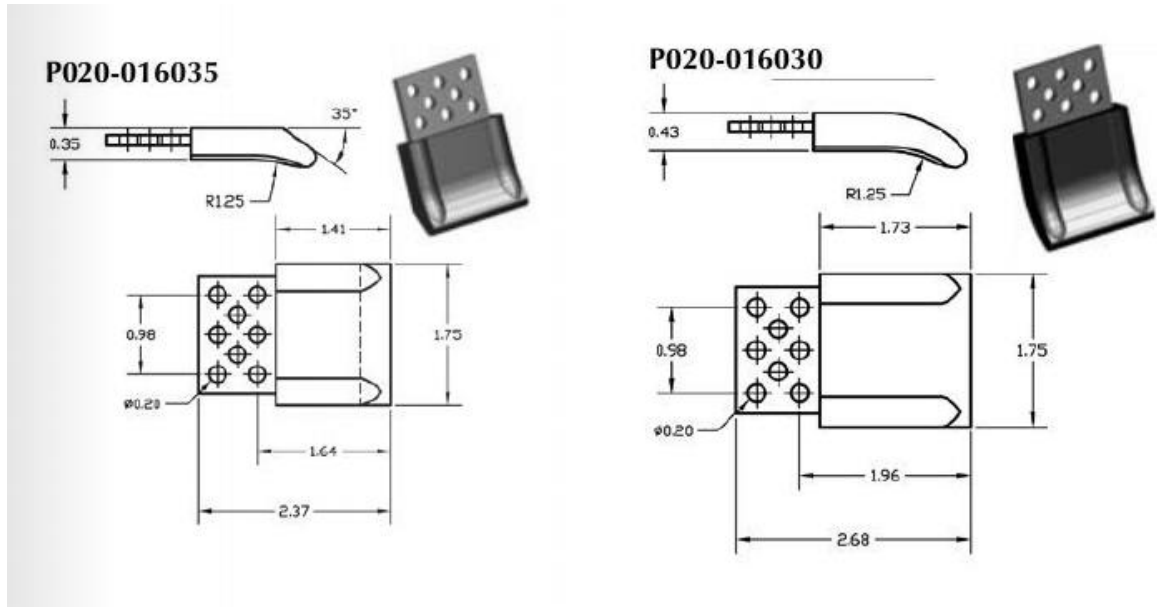
Contact materials

1. **Duratemp** – a graphite silicon thermoset with the addition of non-oriented glass fibers injected into the mold on a metal carrier. Supplied by Pyrotek, Duratemp etc.

+ low price, additional machining, a wide range of products
 - low lifetime, prone to cracking, thick finger - more time to take off on the conveyor belt



1. **Pyrotek PMC** - a graphite-silicone thermoset with the addition of glass fibers injected into a metallic carrier (similar to Duratemp)
 - + low price, additional machining
 - low lifetime, prone to cracking, finger is thicker than Duratemp and it takes longer to get out of the range of products on the conveyor belt



2. **Graphite composite** - graphite composite with oriented carbon fibers in the form of a fabric, the blanks are plate-shaped. Supplied by f. Pyrotek, Duratemp further used on Fingers with air pocket

- + longer lifetime than any previous materials, any shape cut out of the workpiece blank
- fragile, after collision material may split, limitation of plate shape



3. Stainless fabricated –stainless steel wires (rope) are welded to a stainless steel carrier. Supplied by f. Pyrotek, etc.

+ 4x longer lifetime than previous materials, shape can be designed according to customer's requirements

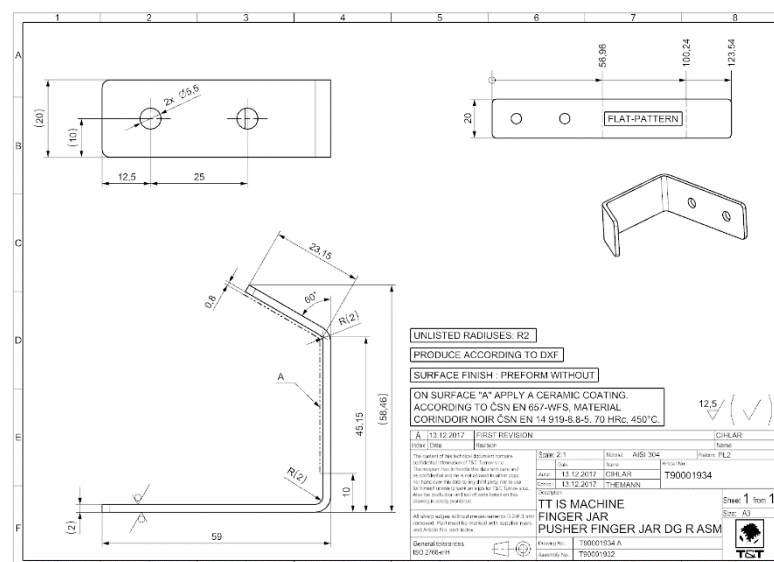
- higher purchase price, finger is thicker than the previous one, and it takes longer to get out of the range of products on the belt



4. Ceramic coating – on the stainless steel carrier is a sprayed ceramic coating up to a maximum thickness of 1 mm

+ flexibility of shape, long lifetime, ceramic coating can be sprayed on optional metal material, possibility of optional shape and thickness (0,2-1mm), ceramic coating can be on optional surface, thin structure allows for quick exit from a range of products on the belt - suitable for fast production

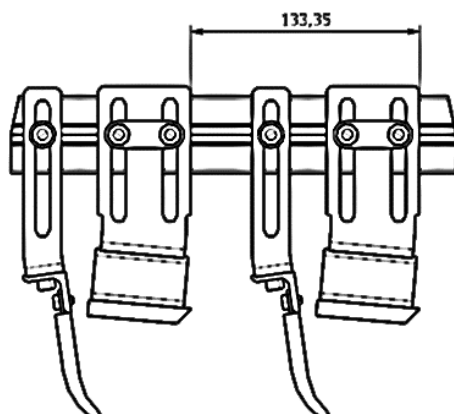
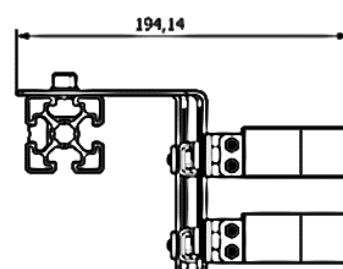
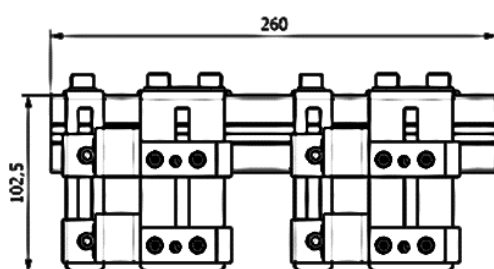
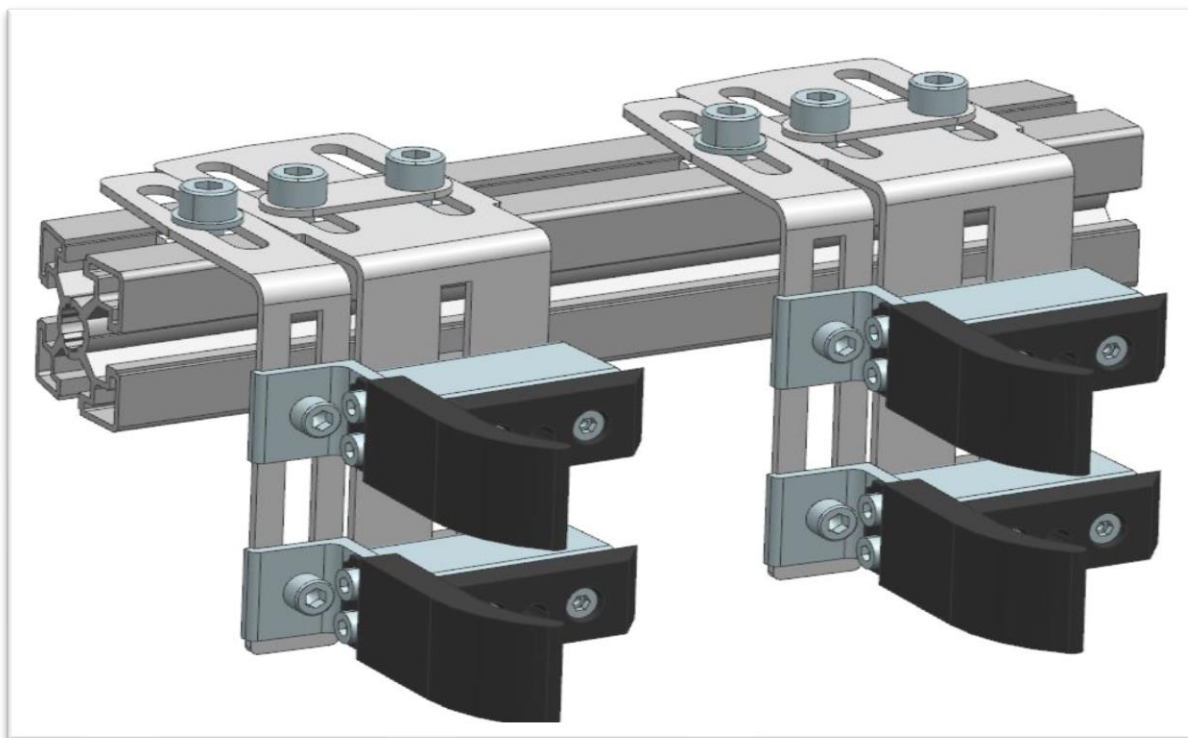
- after spraying, it can no more be additionally shaped and machined (clears ceramic coating), prone to cracking



Overview of Pusher Fingers

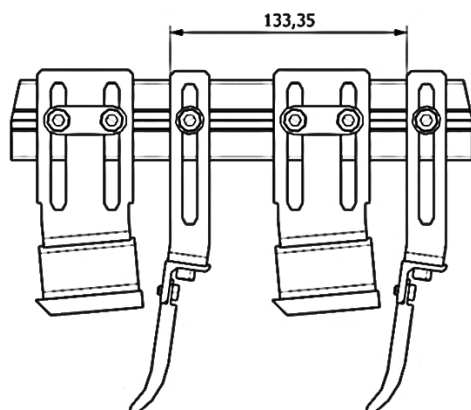
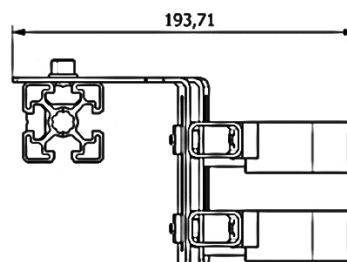
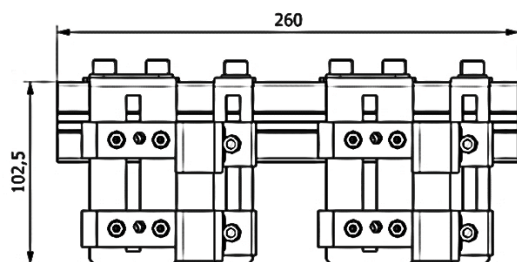
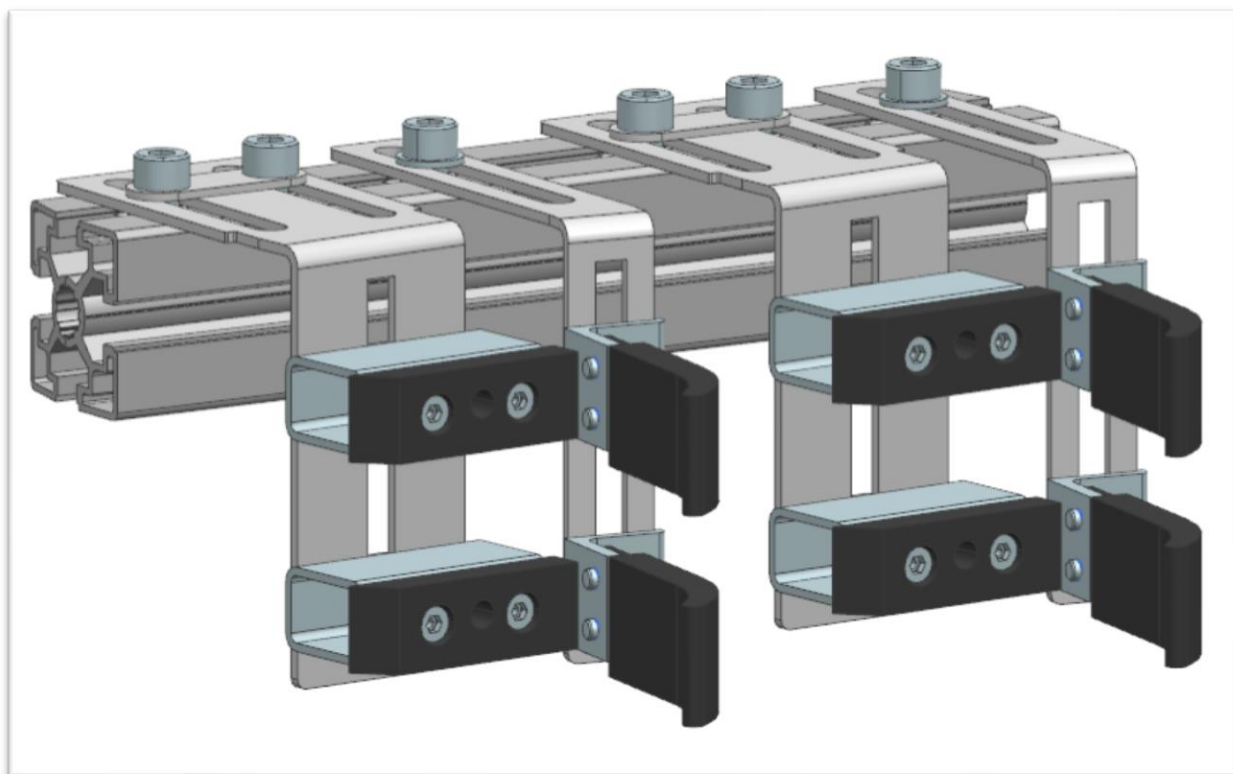
DG 5 1/2'' R - T90001883

- Order number – T90001883
- AL Profile – 45x45x260
- Duratemp Finger and Pad
- For example, the product: Ø 60 mm, Height 113 mm



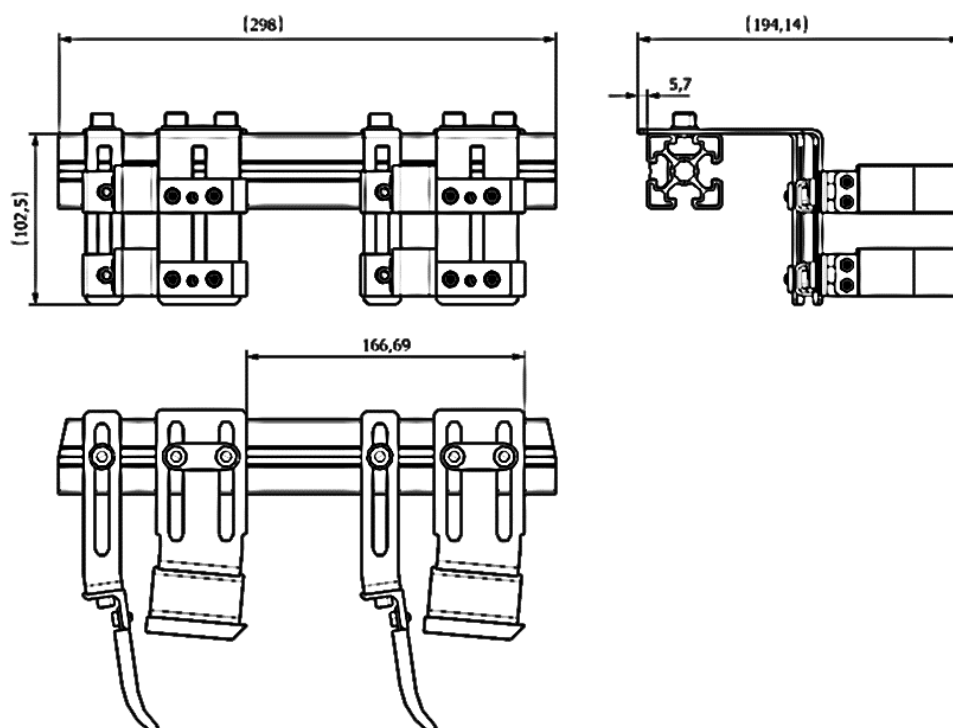
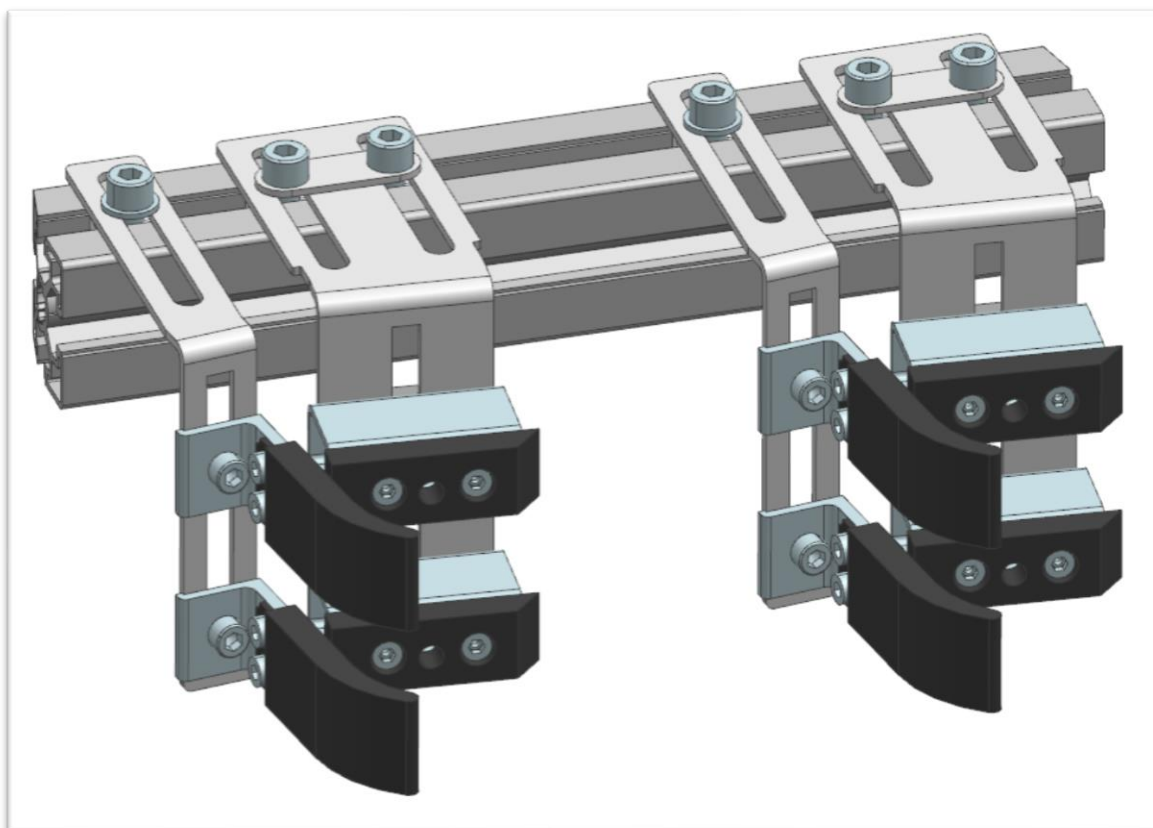
DG 5 1/2" L - T90001926

- Order number – T90001926
- AL Profile – 45x45x260
- Duratemp Finger and Pad
- For example, the product: Ø 60 mm, Height 113 mm



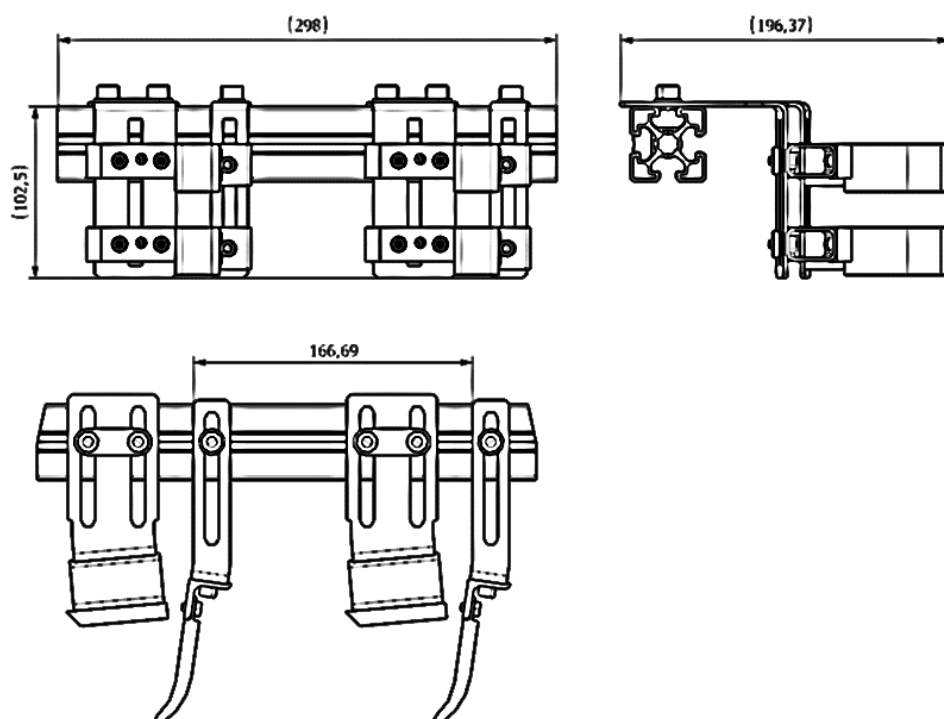
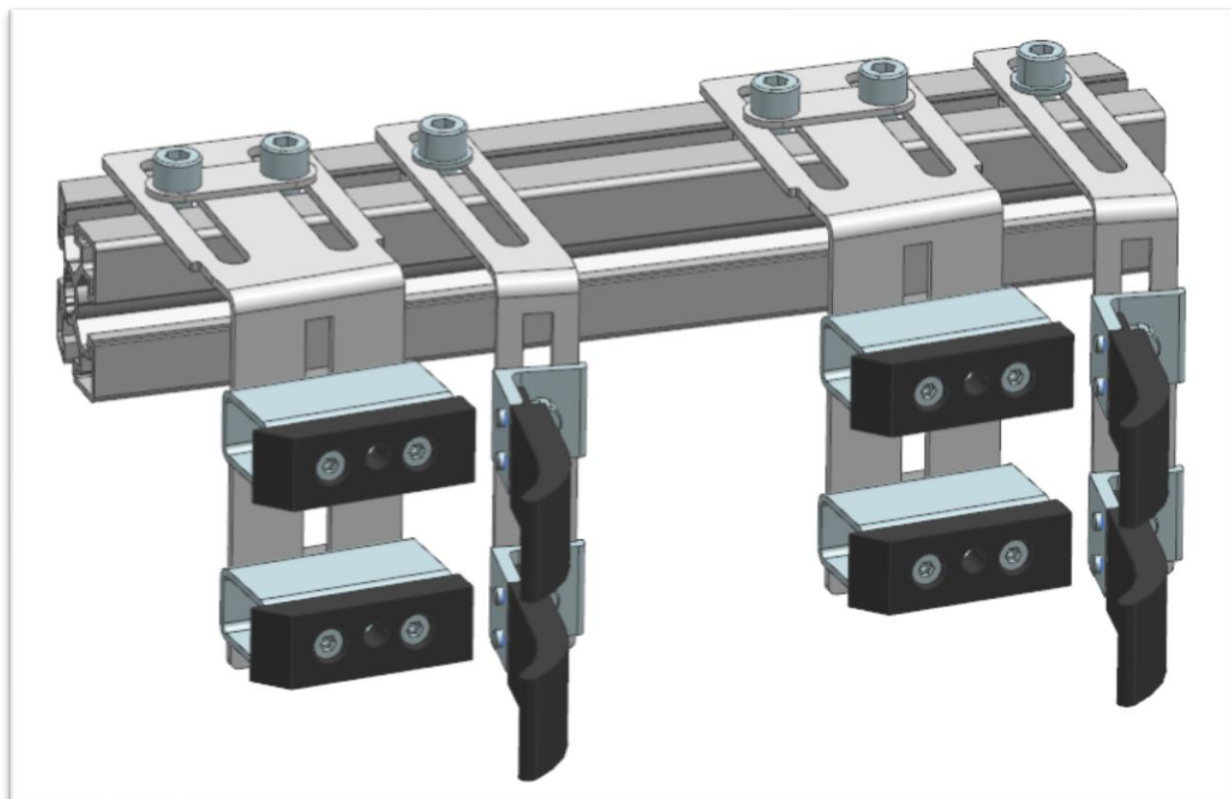
DG 6'' R - T90001936

- Order number – T90001936
- AL Profile – 45x45x298
- Duratemp Finger and Pad
- For example, the product: Ø 77,5 mm, Height 270 mm



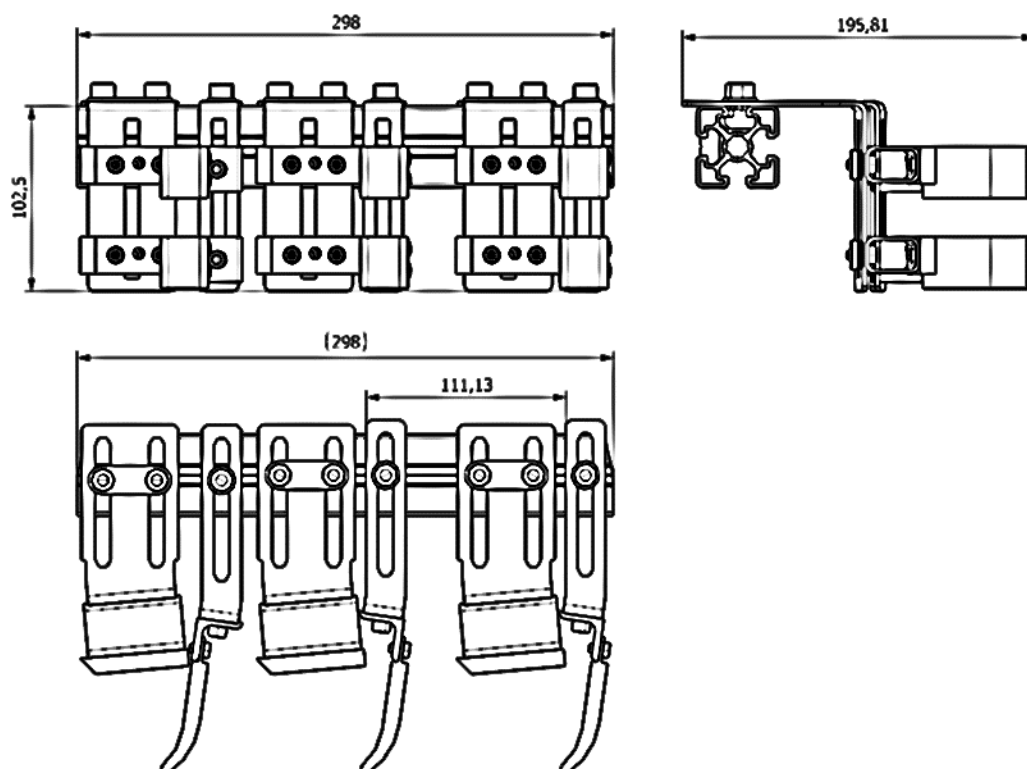
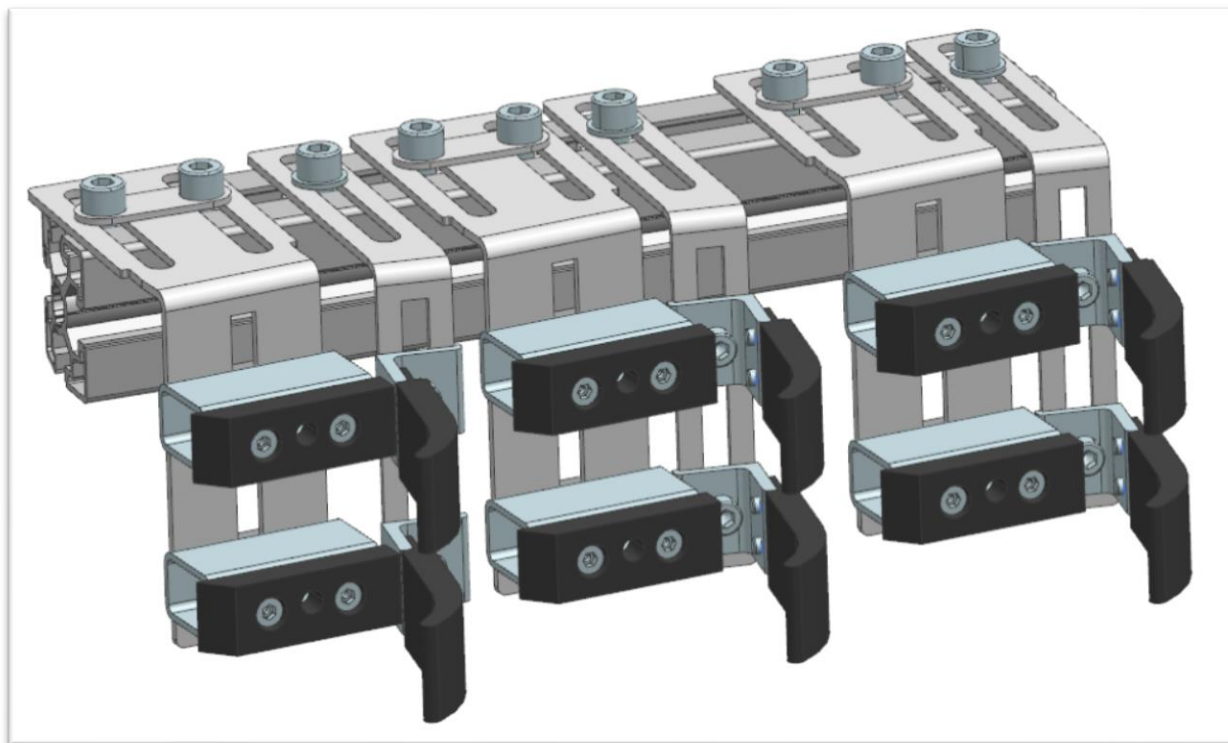
DG 6'' L - T90001935

- Order number – T90001935
- AL Profile – 45x45x298
- Duratemp Finger and Pad
- For example, the product: Ø 77,5 mm, Height 270 mm



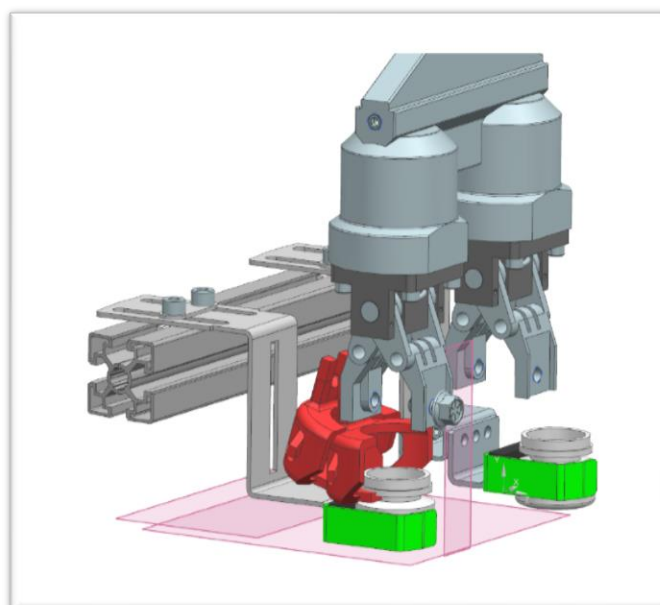
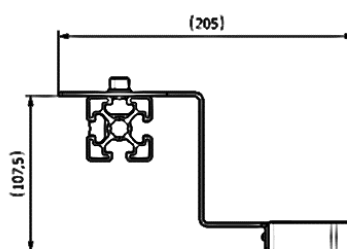
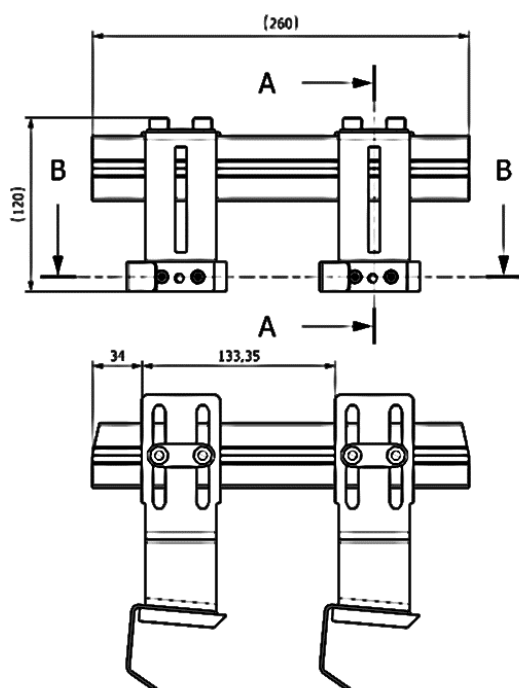
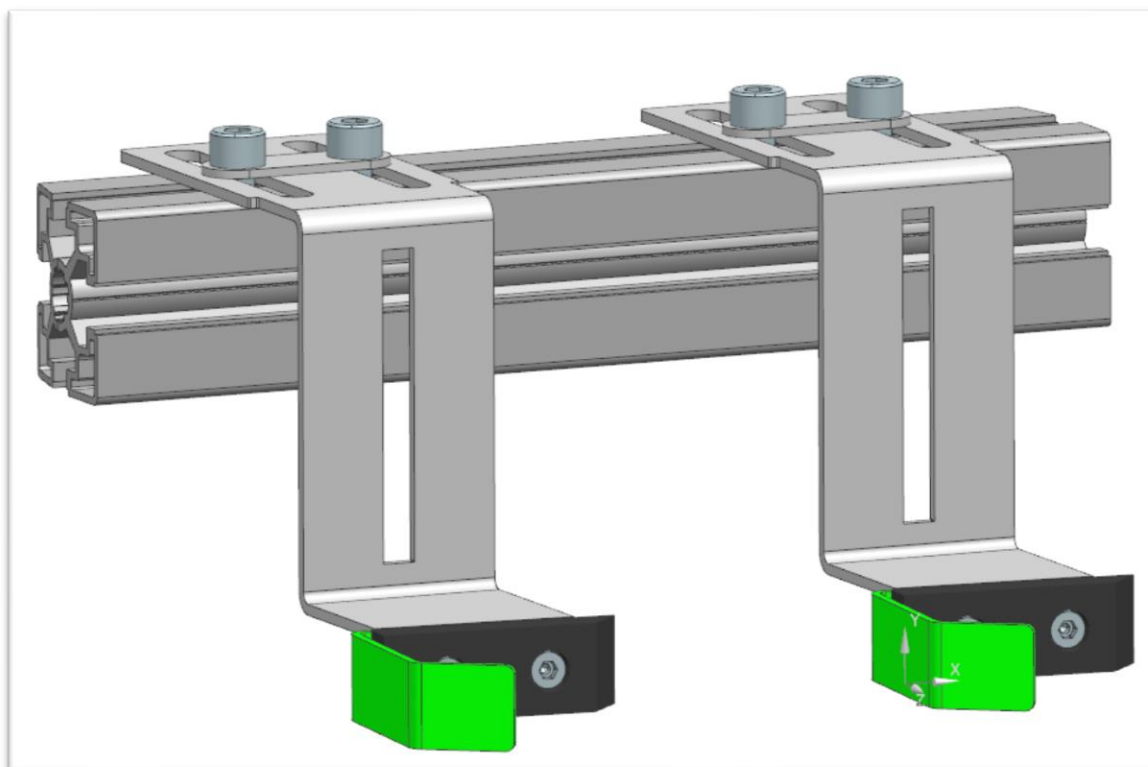
TG 4 1/4" R - T90001929

- Order number – T90001929
- AL Profile – 45x45x298
- Duratemp Finger and Pad
- For example, the product: Ø 60,5 mm, Height 93,2 mm; Ø 44 mm, Height 106,44 mm



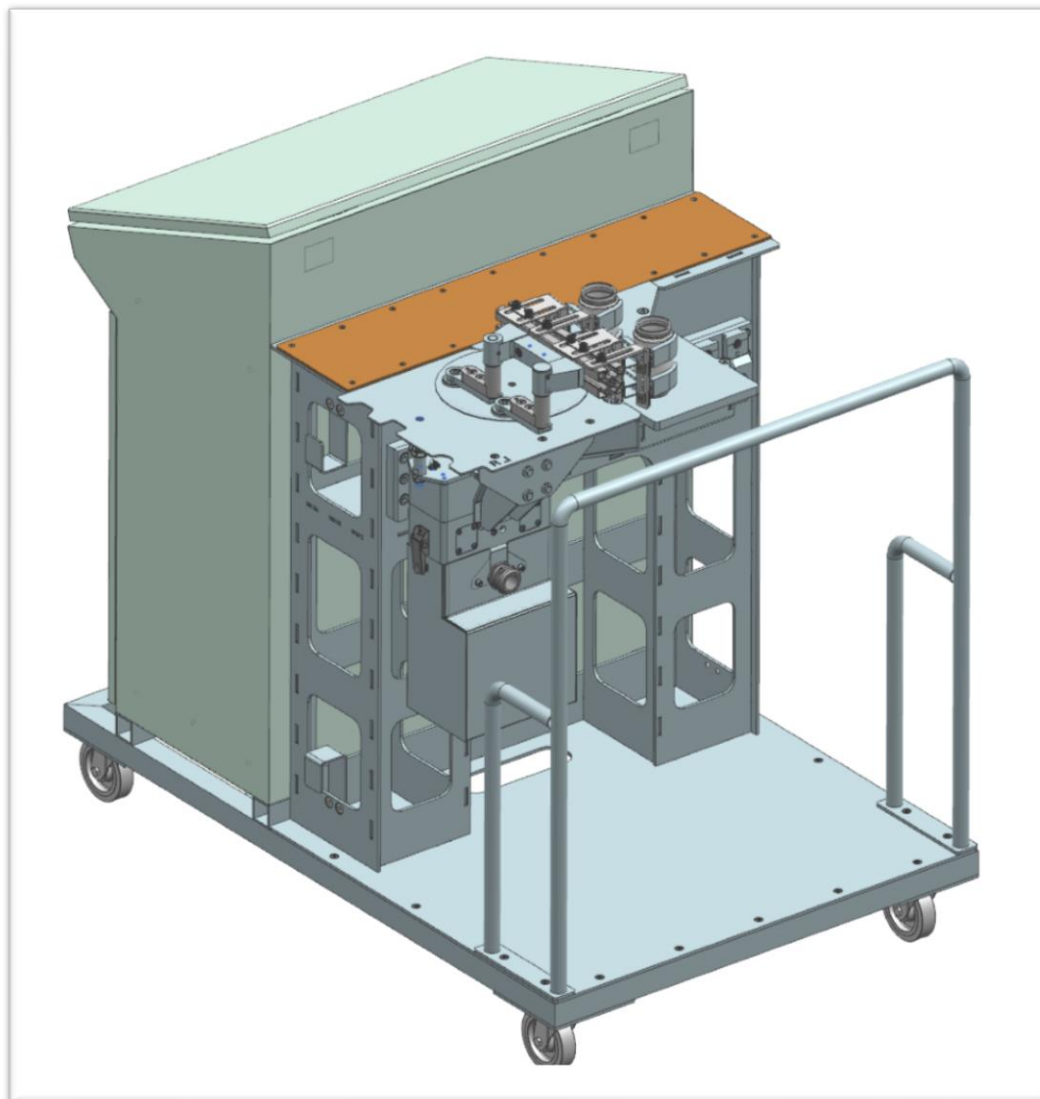
DG 4 1/4" R JAR - T90001932

- Order number – T90001932
- AL Profile – 45x45x260
- ceramic Finger + Duratemp Pad
- For example, the product: Ø 44 mm, Height 38 mm

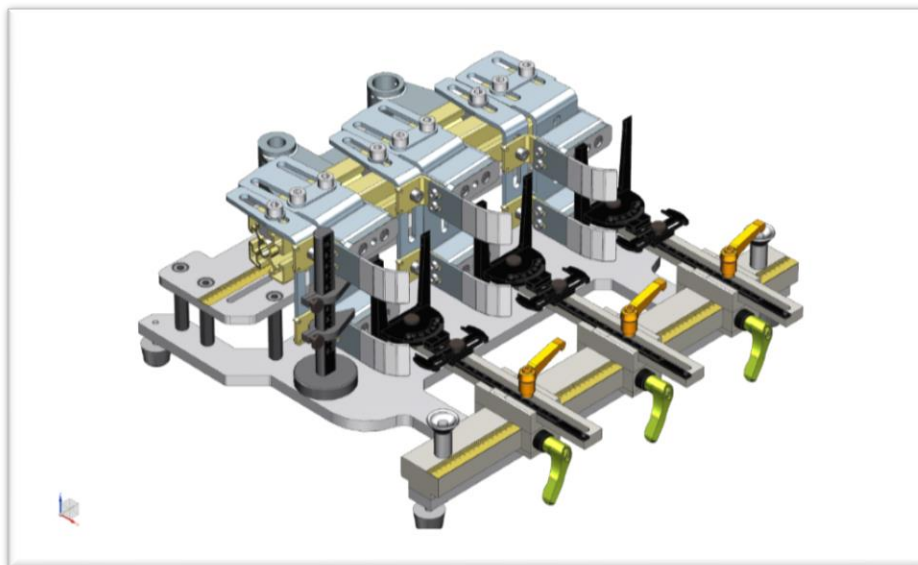


Accessories and JIGs for Pusher Fingers

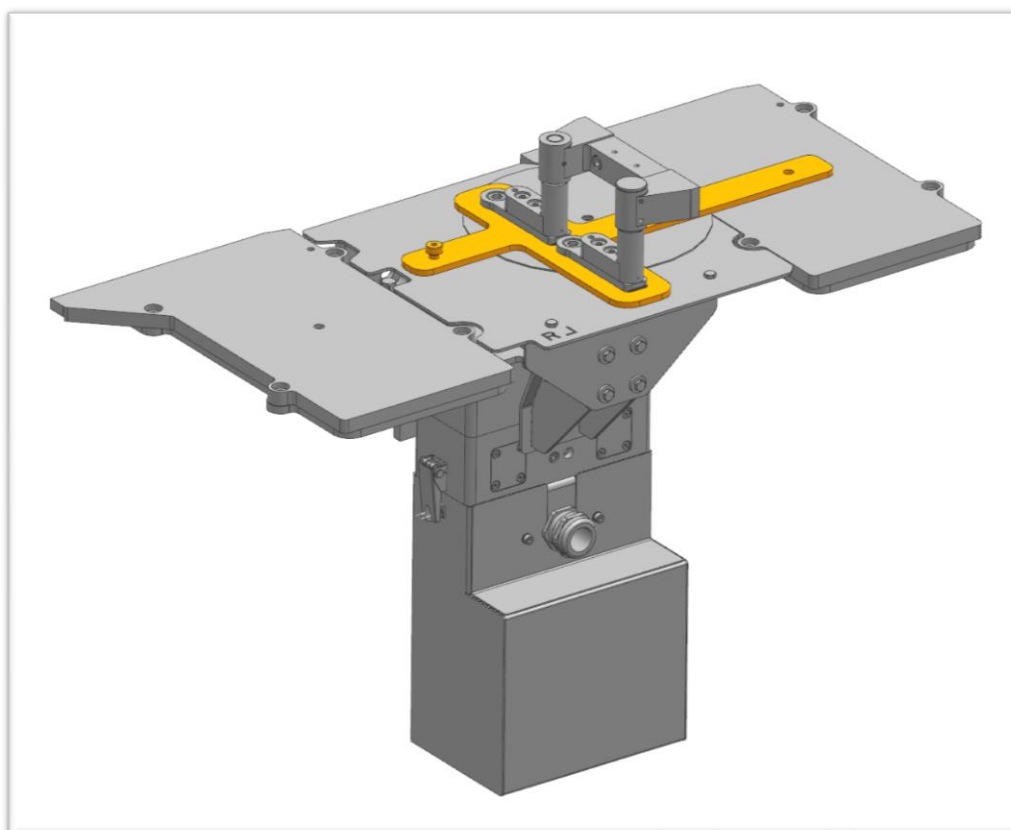
Pusher Tester II - T90001896



Pusher Finger JIG - T90000827



Reference position JIG - T90001924



Transport holders – T90003212

