

<b>Product Code:</b>	HAT-8P <a href="#">Click here to open Product Data Sheet</a>
<b>Product Group:</b>	High duty conveyor and processing belts
<b>Joining System:</b>	Thermofix

### Important

- Joining is also possible with other Habasit devices.
- Machine setting data should be derived from the relevant operating instructions.
- Read the operating instructions of the necessary tools carefully before making the first joint.
- All data are approximate values and defined under the following standard climatic conditions:
  - > 23 °C/73 °F, 50 % relative humidity (DIN 50005/ISO 554), working voltage 225 - 235 V / 105 - 115 V.
  - > Any change of these data may require different temperature and/or time and/or pressure.
- For further support, please contact the Habasit company responsible for your location.

### Skiving

<b>Skiving device:</b>	AT-300/301
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### Settings

<b>Recommended joining angle:</b>	90°
<b>Skiving angle (setting value):</b>	3
<b>Paper grit:</b>	50
<b>Target Skiving Length:</b>	30-40 mm <i>1.25-1.6 inch</i>
<b>Working Length:</b>	70 mm
<b>Feeding speed, advance:</b>	40
<b>Feeding speed, return:</b>	60
<b>Mode of skiving:</b>	1 or 3
<b>Number of operations:</b>	1

### Application of Adhesives

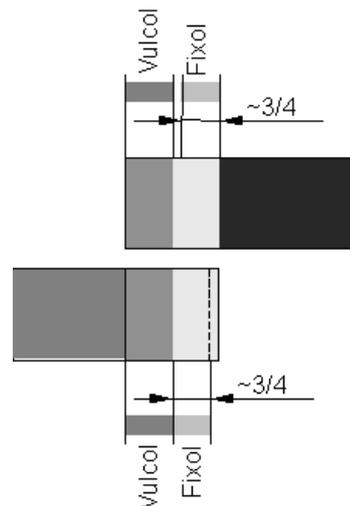
#### Step 1

- > After skiving the center of the skived fabric areas may be fluffy (see sketch) and full with rubber dust.
- > This fluff **MUST BE CLEANED** by blowing it out with oil free compressed air or brushing it out and dissolved/rubbed down when applying adhesive.



#### Step 2

- > Mark off elastomer (conveying cover) and polyamide fabric areas (traction layer) with fine straight lines running parallel to the cutting edge (ball point pen or pencil).
- > Mark limit between Fixol and Vulcol always just within the area of pure polyamide fabric. Fixol does not stick elastomer.
- > Use spatula or brush. Coat evenly and **THINLY** the elastomer areas (conveying cover) of **BOTH** skived surfaces with Vulcol (see sketch). Avoid applying Vulcol twice.
- > Allow to dry for about 5 min.
- > Use an acid-resistant brush. Coat evenly and **THINLY** the marked 3/4 of the polyamide fabric area (traction layer) of **BOTH** skived surfaces with Fixol (see sketch). Rub in Fixol until fluff has dissolved and fabric becomes tacky.
- > Allow to dry for about 2 min.
- > The adhesives must exactly cover the prescribed surfaces. Put skived surfaces accurately on top of each other at the first attempt. Vulcol sticks on contact!
- > Close adhesive containers well.



### Hot Pressing PT-300

<b>Hot Pressing Device:</b>	PT-300
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### Settings

<b>Belt/Tape Width Range:</b>	0-300 mm <i>0-12 inch</i>
<b>Pressing Temperature, Bottom:</b>	120 °C 250 °F
<b>Pressure setting:</b>	17 Nm
<b>Pressing Time:</b>	30 min

**Cooling Time In Hot Pressing Device:** 10 min

### Inserts

**Embossing Media, Bottom:** FNIP-120

#### Top

4		Pressure plate; top (with thickness equalizer)
3		Belt (conveying side up)
2		Embossing media (structured side up)
1		Heating plate; bottom (with set up plate)

#### Bottom

**Pressing Remarks:** REMARK: Carry out a QUALITY CHECK! - Belt thickness over the joint area must be +0.05 / +0.15 mm / +2 / +6 thou. According to experience, application requirements or customer recommendation the thickness of the joint area can deviate from above specification.  
REMARK: Sometimes shrinkage cracks form in the fabric on the running side. This can be prevented by using FNIP embossing foil. Besides use Teflon insert.

### Product Liability

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Last modification on 08/17/2010