Joining Data Sheet
XVT-2237

Product code
XVT-2237

Product group
Polyamide Folder-Gluer Belts

Joining method
Thermofix

Contact
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Edition date
22/11/2021

Status
Master

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

Skiving device	AT-1200/2400

Settings

Recommended joining angle	75°
Skiving angle (setting value)	3
Skiving-disk	3°
Paper grit	40
Target skiving length	45-60 mm *1.8-2.4 inch*
Feeding speed, advance	1
Disk speed	1
Number of operations	1

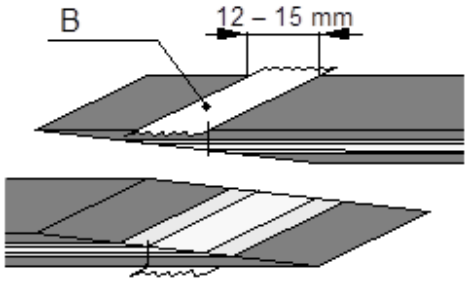
Application of adhesives

Step 1

> Apply a masking tape (paper type about 0.1 mm thick) to the surface ON EACH SIDE to increase pressure in polyamide zone.

> Start in the transition area between top fabric and polyamide layer in direction to thinner wedge end.

> Tape makes sure that the most critical part of the joint gets enough pressure.



Step 2

> Mark off elastomer (friction cover) and polyamide areas (traction layer and intermediate fabric layers) with fine straight lines running parallel to the cutting edge (ball point pen or pencil).

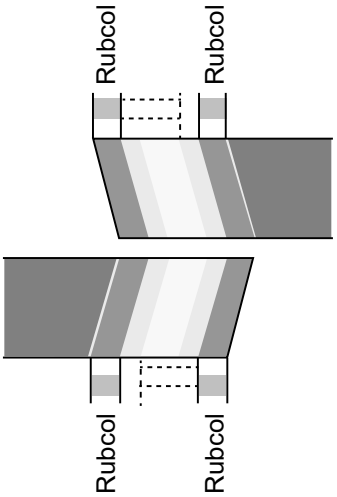
> Mark limit between Fixol and Rubcol always just within the area of pure polyamide fabric. Fixol does not stick elastomer.

> Add total quantity of component B to component A of the Rubcol adhesive and mix THOROUGHLY.

> The Rubcol mixture (A+B) will begin to harden after 3 h. Close container with plastic lid if process is interrupted.

> Use spatula or brush. Coat evenly and THINLY indicated elastomer areas of BOTH skived surfaces with Rubcol (see sketch).

> Allow to air for about 30 min.



Step 3

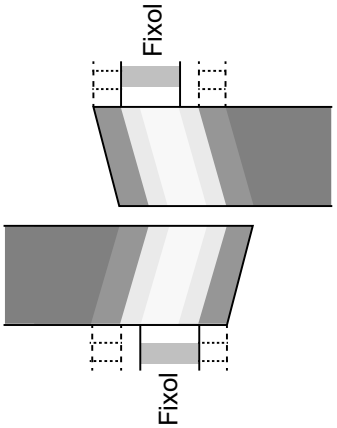
> Use a natural bristle brush. Coat evenly and THINLY the indicated polyamide area (traction layer and one of both intermediate fabric layers) of BOTH skived surfaces with Fixol (see sketch).

> Rub in with brush (on traction layer only) until Fixol 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. Rubcol sticks on contact!

> Close adhesive containers well.



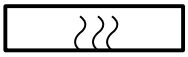
Hot pressing

Hot pressing device	PM-02/04/06 family, PM-09/160W family

Parameters

Pressing temperature, top	120 °C *250 °F*
Pressing temperature, bottom	120 °C *250 °F*
Pressure setting	2.5 bar *36 psi*
Pressing time	15 min

Inserts

Top		
7		Heating plate; top
6		HAT-12P insert (green side down)
5		Silicone paper dull (coated side down) or Teflon
4		Belt (conveying side up)
3		Silicone paper dull (coated side up) or Teflon
2		Heat equalizing plate; bottom
1		Heating plate; bottom
Bottom		

Pressing remarks	Carry out a QUALITY CHECK! - Measure thickness over the joint area. In the center it must be: -0.05/+0.05 mm / -2/+2 thou. And over the whole area: -0.05/+0.10 mm /-2/+4 thou. According to experience, application requirements or customer recommendation the thickness of the joint area can deviate from above specification. HAT-12P insert is available from Habasit affiliates or representations.

Product liability