

**Product code**

XVT-2237

**Product group**

Polyamide Folder-Gluer Belts

**Joining method**

Thermofix

**Contact**

Martin Nykl

**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
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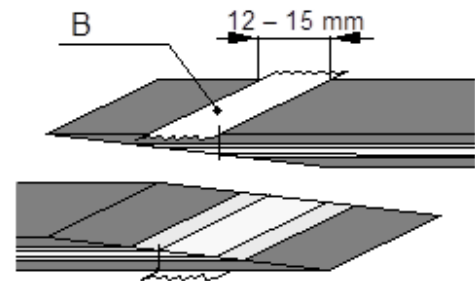
**Settings**

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

## Application of adhesives

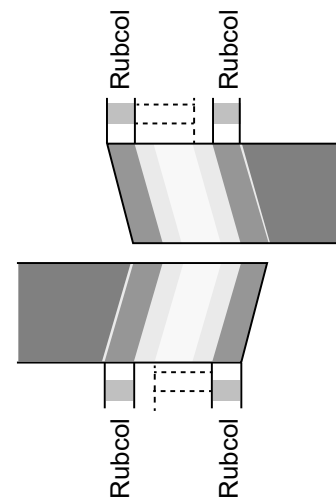
### Step 1

- > 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.



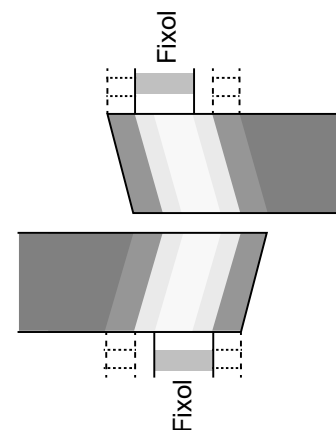
### Step 2

- > 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.



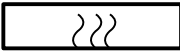






### Hot pressing

Hot pressing device	PM-02/04/06 family, PM-09/160W family
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### 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	<p>Carry out a <b>QUALITY CHECK!</b> - 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.</p> <p>HAT-12P insert is available from Habasit affiliates or representations.</p>
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