

Product code

CM-4/50F

Product group

Polyamide Folder-Gluer Belts

Joining method

Flexproof

Contact

Martin Nykl

Edition date

08/05/2024

Status

Option

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.

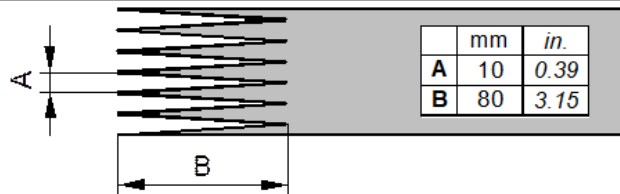
Finger cutting

Finger cutting device

AF-100/US

Dimensions

Trim finger tips to assure optimal joining quality.



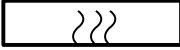
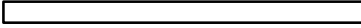
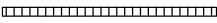

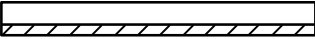

Hot pressing

Hot pressing device	PF-61 / PF-62
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Parameters

Belt/Tape width range	0 - 35 mm <i>0 - 1.4 inch</i>	> 35 - 50 mm <i>> 1.4 - 2 inch</i>	> 50 - 60 mm <i>> 2 - 2.4 inch</i>
Pressing temperature, top	180 °C <i>355 °F</i>	180 °C <i>355 °F</i>	180 °C <i>355 °F</i>
Pressing temperature, bottom	180 °C <i>355 °F</i>	180 °C <i>355 °F</i>	180 °C <i>355 °F</i>
Pressing time	10 min	12 min	12 min
Cooling time	10 min	12 min	12 min

Inserts

Top		
6		Heating plate; top
5		Covering plate (offset for easier removal)
4		Teflon
3		Belt (conveying side up)
2		Guide rail (exactly centered in press)
1		Heating plate; bottom
Bottom		

Pressing remarks	<p>35-50 mm / 1.4-2.0 in. belt width: use guide rails with wide base plate. Cool belt/tape after hot pressing with appropriate cooling tong. If cover plate sticks to the belt: cut a strip of Teflon exactly the width of the belt (using the cover plate as a template) and place it on the belt.</p> <p>50-60 mm / 2.0-2.4 in. belt width: use guide rails with wide base plate.</p>
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