

Product Code:	F-0 Click here to open Product Data Sheet
Product Group:	Polyamide machine tapes
Joining System:	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

Skiving device:	AT-300/301
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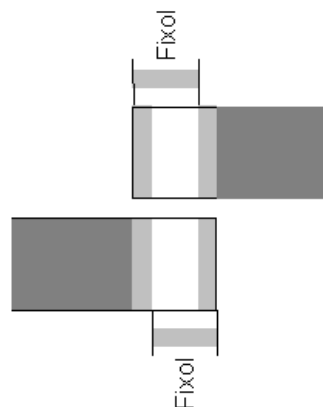
Settings

Recommended joining angle:	90°
Skiving angle (setting value):	6
Paper grit:	50
Target Skiving Length:	10-15 mm 0.4-0.6 inch
Working Length:	60 mm
Feeding speed, advance:	40
Feeding speed, return:	60
Mode of skiving:	1 or 3
Number of operations:	1

Application of Adhesives

Step 1

- > Cut away extreme outer green elastomer lip along the fabric within the black area (Fixol will not stick elastomer).
- > Use an acid-resistant 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.
- > Little grooves appear in the friction covers by cutting away the elastomer lips. These must not be compensated by shifting the skived surfaces.



Hot Pressing PT-300



Hot Pressing Device:	PT-300
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Settings

Belt/Tape Width Range:	0-300 mm 0-12 inch
Pressing Temperature, Bottom:	120 °C 250 °F
Pressure setting:	17 Nm
Pressing Time:	5 min
Cooling Time In Hot Pressing Device:	5 min

Inserts

Top		
3		Pressure plate; top (with thickness equalizer)

2		Belt (conveying side up)
1		Heating plate; bottom (with set up plate)
Bottom		

Product Liability

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Last modification on 08/17/2010