

<b>Product Code:</b>	F-1 <a href="#">Click here to open Product Data Sheet</a>
<b>Product Group:</b>	Polyamide machine tapes
<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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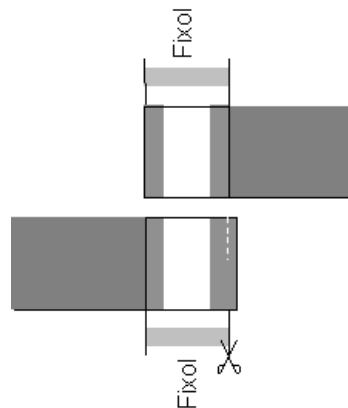
#### Settings

<b>Recommended joining angle:</b>	90°
<b>Skiving angle (setting value):</b>	4
<b>Paper grit:</b>	50
<b>Target Skiving Length:</b>	18-25 mm <i>0.7-1 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

- > 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 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.
- > Close adhesive containers well.



### Hot Pressing PT-300


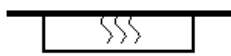
<b>Hot Pressing Device:</b>	PT-300
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#### Settings

<b>Belt/Tape Width Range:</b>	0-300 mm <i>0-12 inch</i>
<b>Pressing Temperature, Bottom:</b>	120 °C <i>250 °F</i>
<b>Pressure setting:</b>	17 Nm
<b>Pressing Time:</b>	10 min
<b>Cooling Time In Hot Pressing Device:</b>	10 min

### Inserts

Top		
3		Pressure plate; top (with thickness equalizer)

2		Belt (conveying side up)
1		Heating plate; bottom (with set up plate)
<b>Bottom</b>		

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Last modification on 08/17/2010