

Product code

CM-4/30F

Product group

Polyamide Folder-Gluer Belts

Joining method

Flexproof

Contact

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Edition date

08/05/2024

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.

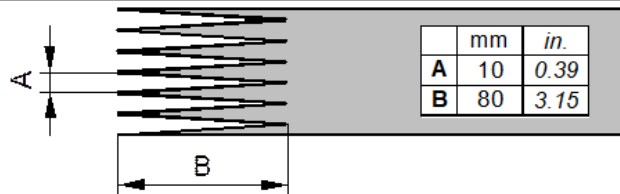
Finger cutting

Finger cutting device

AF-1200/1201 family

Dimensions

Trim finger tips to assure optimal joining quality.



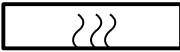






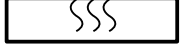
Hot pressing

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

Pressing temperature, top	170 °C 340 °F
Pressing temperature, bottom	170 °C 340 °F
Pressure setting	1.2 bar 17 psi
Pressing time	5 min

Inserts

Top		
8		Heating plate; top
7		Heat equalizing plate; top
6		Teflon or silicone paper dull
5		Belt (conveying side up)
4		Teflon or silicone paper dull
3		Molleton
2		Heat equalizing plate; bottom
1		Heating plate; bottom
Bottom		

Pressing remarks	Clamping bars can get hot and mark the belt. Remove them after closing and pressurizing the press.
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