

Product Code:	XVT-2236 Click here to open Product Data Sheet
Product Group:	Polyamide folder-gluer belts
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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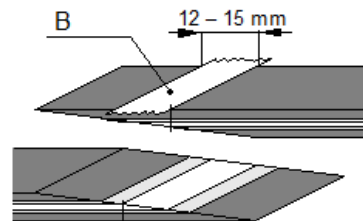
Settings

Recommended joining angle:	90°
Skiving angle (setting value):	0
Paper grit:	50
Target Skiving Length:	70-80 mm 2.75-3.1 inch
Working Length:	140 mm
Feeding speed, advance:	18
Feeding speed, return:	36
Mode of skiving:	1 or 3
Number of operations:	2

Application of Adhesives

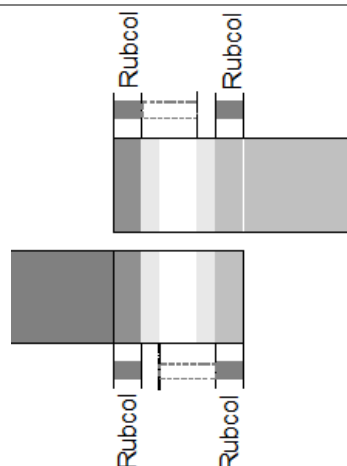
Step 1

- > 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.



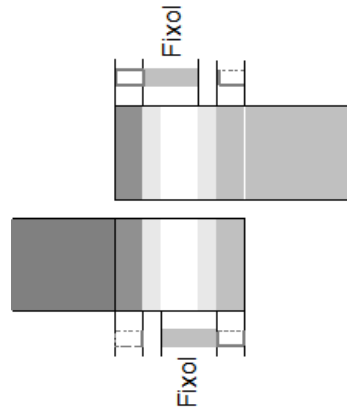
Step 2

- > 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 an acid-resistant brush. Coat evenly and THINLY the entire polyamide area (traction layer and 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 PT-300

Hot Pressing Device: PT-300

Settings

Belt/Tape Width Range:	0-300 mm 0-12 inch
Pressing Temperature, Bottom:	120 °C 250 °F
Pressure setting:	17 Nm
Pressing Time:	40 min
Cooling Time In Hot Pressing Device:	10 min

Inserts

Top		
3		Pressure plate; top (with thickness equalizer)
2		Belt (conveying side up)
1		Heating plate; bottom (with set up plate)
Bottom		
Pressing Remarks:	REMARK: Carry out a QUALITY CHECK! - 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.	

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Last modification on 10/25/2018