XVT-2237



Product Code:	XVT-2237 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.

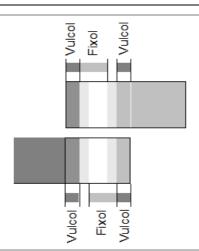
Skiving

Skiving device:	AT-300/301		
Settings	Settings		
Recommended joining angle:	90°		
Skiving angle (setting value):	3		
Paper grit:	50		
Target Skiving Length:	45-60 mm 1.8-2.4 inch		
Working Length:	85 mm		
Feeding speed, advance:	30		
Feeding speed, return:	50		
Mode of skiving:	1 or 3		
Number of operations:	1		

Application of Adhesives

Step 1

- > 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 Vulcol always just within the area of pure polyamide fabric. Fixol does not stick elastomer.
- > Use spatula or brush. Coat evenly and THINLY indicated elastomer areas (friction cover) of BOTH skived surfaces with Vulcol (see sketch). Avoid applying Vulcol twice.
- > Allow to dry for about 10 min.
- > 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.
- > The adhesives must exactly cover the prescribed surfaces. Put skived surfaces accurately on top of each other at the first attempt. Vulcol 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:	25 min
Cooling Time In Hot Pressing Device:	10 min

Inserts

	Тор	
3		Pressure plate; top (with thickness equalizer)

2	•	Belt (conveying side up)			
1	555	Heating plate; bottom (with set up plate)			
	Bottom				
Pres	sing Remarks:	REMARK: Carry out a QUALITY CHECK! - Meassure 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.			

Product Liability

If the proper selection and application of Habasit products are not recommended by an authorized Habasit sales specialist, the selection and application of

Habasit products, including the related area of product safety, are the responsibility of the customer.

All indications / information are recommendations and believed to be reliable, but no representations, guarantees, or warranties of any kind are made as to their accuracy or suitability for particular applications. The data provided herein are based on laboratory work with small-scale test equipment, running at standard conditions, and do not necessarily match product performance in industrial use. New knowledge and experiences can lead to modifications and changes within a short time without prior notice.

BECAUSE CONDITIONS OF USE ARE OUTSIDE OF HABASIT'S AND ITS AFFILIATED COMPANIES CONTROL, WE CANNOT ASSUME ANY LIABILITY CONCERNING THE SUITABILITY AND PROCESS ABILITY OF THE PRODUCTS MENTIONED HEREIN. THIS ALSO APPLIES TO PROCESS RESULTS / OUTPUT / MANUFACTURING GOODS AS WELL AS TO POSSIBLE DEFECTS, DAMAGES, CONSEQUENTIAL DAMAGES, AND FURTHER-REACHING CONSEQUENCES.

Last modification on 10/25/2018