

Product Code:	XVT-2238 <a href="#">Click here to open Product Data Sheet</a>
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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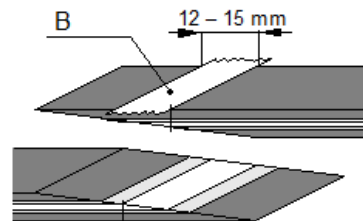
### Settings

Recommended joining angle:	90°
Skiving angle (setting value):	1.5
Paper grit:	50
Target Skiving Length:	60-80 mm 2.4-3.1 inch
Working Length:	100 mm
Feeding speed, advance:	30
Feeding speed, return:	50
Mode of skiving:	1 or 3
Number of operations:	1

## Application of Adhesives

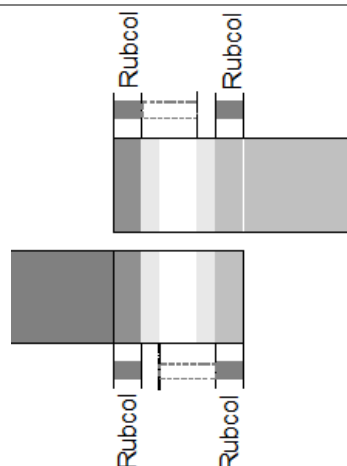
### Step 1

- > 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.



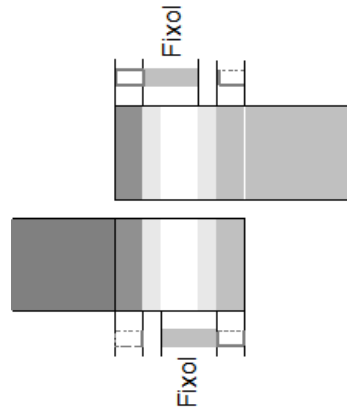
### Step 2

- > 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:** 30 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.

## Product Liability

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Last modification on 10/25/2018