

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 <i>2.4-3.1 inch</i>
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

- > 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
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### Settings

Belt/Tape Width Range:	0-300 mm <i>0-12 inch</i>
Pressing Temperature, Bottom:	120 °C <i>250 °F</i>
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)
<b>Bottom</b>		
<b>Pressing Remarks:</b>		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