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General hints

Please observe the following points when making the joint:

- Use original Habasit guide rails only!
- Note the type and width of the guide rail!
- Tape width = guide rail width: Do not force the tape ends into the guide rail!
- Never unplug heating press during hot-pressing!
- After joining, always check the visual quality of the joint!
- Install the tape so that the black side (high coefficient of friction) lies on the driving pulley or the cylinder, and the green side (low coefficient of friction) is on the spindle whirl.

1 Preparing

1.1 Read the tool operating instructions and the joining instructions carefully before making the first joint.

1.2

W-8 mm in.
A 6 0.24
B 30 1.18

W-16 mm in.
A 8 0.31
B 30 1.18

W-8: Standard dimension of fingers

W-16: Standard dimension of fingers

1.3 Die-cutting device AF-30, AF-61, AF-100, AF-102 (8 x 30)

1.4 Heating press PQ-57 or 58

1.5 Cooling tongs CD-60

Up-to-date Joining Data Sheets and Tool Data Sheets
For updated Joining Data Sheets / Instructions and Tool Data Sheets visit the Habasit website at
www.habasit.com
2 Die-cutting the tape ends from the coil

2.1
On the black side measure off 140 mm/5.5 in. from the tape end and mark point A.

2.2
– place tape end on die-cutting table, black side up
– push tape against rear edge
– align point A with table edge on left-hand side
– fix tape with belt clamps and die-cut.

2.3
On the black side measure off required tape length x from point A and mark point B.

2.4
– place tape end on die-cutting table, black side up
– push tape against rear edge
– align point B with table edge on left-hand side
– fix tape with belt clamps and die-cut.

3 Inserting the tape into the guide rail

3.1
Insert the first tape end, green side up, into the center of the guide rail. The guide rail must fit the belt width.

3.2
Insert second belt end and push it firmly against the first.

3.3
Position the covering plate on top, press it down and fix it crosswise with clamps at both ends of the guide rail.
4

Hot-pressing

4.1
Plug in cable and heat up heating press until preset temperature is reached (at least 10 minutes). Preset pressing temperature is 190°C/375°F.

4.2
Clamp heating press onto guide rail with inserted tape.

4.3
Make sure the guide rail lies perfectly centered in the press.

4.4
Pressing time

| W-8: 3 min | W-16: 3 min |

Set pressing time and wait till time has expired. The heating press must remain plugged in while pressing.

4.5
After expiry of the pressing time, remove heating press from the guide rail.

4.6
Cooling time

| W-8: 3 min | W-16: 4 min |

Immediately clamp cooling tongs onto guide rail!

Make sure the cooling tongs lies centered over the joint. Set cooling time and wait till time has expired.

4.7
Take care that the temperature of the cooling tongs does not rise above 30°C/86°F. If necessary, use a second set of cooling tongs, or cool down in cold water.

4.8
After cooling is complete, remove tape from guide rail by pulling off constantly and quickly.

Let the tape cool down to room temperature.
Quality check of the joint

5.1 After the tape has cooled down, check the joint quality.

5.2 Joint is ok.

5.3 Carefully cut off tape material that has oozed out with scissors.

5.4 1. Penetration too strong
    ➔ reduce pressing time.

5.5 2. Penetration too little
    ➔ increase pressing time.

5.6 Holes and gaps
    ➔ make sure that finger-tips indent closely.

5.7 Finger-tips sticking out
    ➔ die-cut more precisely.
6 Installing the tape

6.1 2 jockey pulleys

6.2 1 jockey pulley

Install tape. **Black side on driving pulley or cylinder, green side on the spindle whirls.** Check that the tape is threaded in correctly and runs in the middle of the spindle whirls.
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