



Splicing Tapes

Product Bulletin - PB206

Uncoated Abrasive Belt Splicing Tapes

Uncoated tapes are pre-primed to obtain maximum bond strength when using a thermosetting adhesive. The standard products consist of polyester film reinforced with polyester yarns. Below is listed our standard product line with suggested applications.

T1930	T1880	T1882	T1884	T9039	T1886	T1878
Yellow	Red	White	New Blue	Emerald	Green	Woven
Paper Fine Grit J & X Wt. Paper/Poly	120 grit and finer	120 grit to 60 grit	100-40 grit high flex	60 grit and coarser	60 Grit and coarser	Non-Woven Abrasives



TECHNICAL DATA

Part Number	Tape Thickness		Tensile Strength		Application Notes
	Metric	English	Metric N/cm.	English lbs./in.	
T1930	0.051 mm	0.002"	200 N/cm.	115 lbs./in.	ultra thin, replace lap, J-Weight
T1880	0.081 mm	0.0032"	325 N/cm.	185 lbs./in.	thin, versatile, highest flex
T1882	0.122 mm	0.0048"	455 N/cm.	260 lbs./in.	most versatile, strength & flex
T1884	0.170 mm	0.0067"	615 N/cm.	340 lbs./in.	High flex and tensile, uniform thickness.
T9039	0.198 mm	0.0078"	650 N/cm.	365 lbs./in.	Best properties of blue and green.
T1886	0.234 mm	0.0088"	650 N/cm.	380 lbs./in.	Strong abrasion and hinge resistant
T1878	0.140 mm	0.0055"	440 N/cm.	250 lbs./in.	air tools, surface conditioning

Standard Bias Angle: 55°, 67°, 75°

Standard Roll Widths: 19 mm and 25 mm

Standard Roll Lengths: 100 meter, 200 meter available

NOTE: 1. Please consult Customer Support for complete details about our products.

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PB206A



BELT MAKING PROCEDURE

SPLICE PREPARATION

1. Cut belts to desired angle.
2. Abrade ends with wire brush, sandblast, etc.
3. Apply adhesive to both belt ends and the yarn side of the splicing tape.

SUGGESTED ADHESIVE PREPARATION

	<u>Adhesive Formulation</u>	<u>Weight</u>	<u>Volume</u>
Resin:	Sheldahl A0455/A0651	100 parts by weight at 20% solids	100 volumes
Curing Agent:	Desmodur® RE or RFE	9-11 parts by weights	8 - 10 volumes

NOTE: Adhesive can be applied using a roller coater or brush and is compatible with spray equipment when diluted. Allow adhesive to dry at room temperature for 10-20 minutes or 4 to 6 minutes at 150°F

RECOMMENDED COATING GAP

T1880, T1882, T1878	300-400 microns plus tape thickness
ST1884 and ST1886	550-650 microns plus tape thickness

Allow adhesive to dry at room temperature for 20-40 minutes.

PRESSING

Place pre-tacked belt in bonding press with a release sheet/press pad configuration to prevent bonding to the heated bars. Suggested Press Cycle

	Metric	English
Temperature:	40°C to 60°C	104°F to 140°F
Pressure:	140 to 210 KG/sq. cm.	2000 to 3000 PSI
Time:	10 seconds	10 seconds

Adhesive open time is dependent upon coating thickness, press temperature and room environment.

ADHESIVE/CURING AGENT OR HARDNERS

Sheldahl A455 or A651 and Desmodur® RE or RFE

Desmodur® is a registered trademark of Bayer AG.

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