

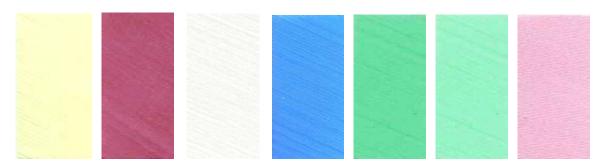
Splicing Tapes

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.

<u>T1930</u>	<u>T1880</u>	<u>T1882</u>	<u>T1884</u>	<u>T9039</u>	<u>T1886</u>	<u>T1878</u>
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

	Tape Thickness		Tensile Strength		Application Notes
Part Number	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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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

	Adhesive Formulation	<u>Weight</u>	Volume
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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