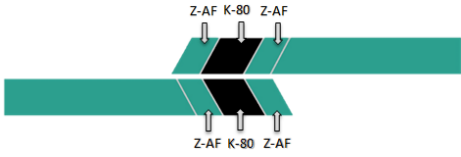


Joining Technical Data Sheet


Name	GG 33
Product Group	GG P-Line Belts

Recommended Joining Procedure	Skived Joint
	

Adhesives, Required Materials and Equipment
Skiving Device (Ziligen ZTA series is recommended)
Adhesives; Z-AF cement, K-80 glue
Brushes, Spatula
For Pressing; Teflon or Silicone, Inserts
Hot Press (Ziligen ZEHP series is recommended)

Application of Adhesives
Mark off rubber areas and polyamide areas with fine straight lines running parallel to the cutting edge.
Use brush. Apply thin (one lap) coating of Z-AF cement homogeneously to indicated rubber areas of both skived surfaces.
Then, Apply thin (one lap) coating of K-80 glue homogeneously to polyamide area of both skived surfaces.
After applying K-80, put on the ends top of each other immediately(10 s).
Adhesives should not be mixed. Mark limit between rubber and polyamide areas. (See sketch)
Make sure layers accurately match each other. (Rubber to rubber, polyamide to polyamide)
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Pressing
Place belt and inserts into press as shown in the figure.
Close the press and tighten nuts evenly.

Layout Components								
	<table border="1"> <tr> <td>Heating plate; top</td> </tr> <tr> <td>Upper Steel Sheet</td> </tr> <tr> <td>Silicone Sheeting or Teflon</td> </tr> <tr> <td>Belt + Shim Bars</td> </tr> <tr> <td>Silicone Sheeting or Teflon</td> </tr> <tr> <td>Equilising Rubber</td> </tr> <tr> <td>Plate; bottom</td> </tr> </table>	Heating plate; top	Upper Steel Sheet	Silicone Sheeting or Teflon	Belt + Shim Bars	Silicone Sheeting or Teflon	Equilising Rubber	Plate; bottom
Heating plate; top								
Upper Steel Sheet								
Silicone Sheeting or Teflon								
Belt + Shim Bars								
Silicone Sheeting or Teflon								
Equilising Rubber								
Plate; bottom								

Press Settings	
Upper Plate Temperature	110 °C
	230 °F
Pressing Time	30 min

Any change of these data may require different temperature and/or time and/or pressure.

Shim bars should be same thickness with belt.

After pressing, clean the edges. Joined belt can be ready for use in 4 hours.

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