

## Instruction for connecting the flat driving belts made by REKO "POLIFIX" Firm with frictional layers from leather or artificial leather (fibrous material)

### Operating sequence:

1. Measure out a needed belt length. To such a measured length, you have to add 1x junction length. The junction length is determined by length of abraded PA traction foil. See the table for recommended length values of abraded traction foil in individual power types of belts.
2. Where the equipment is not fitted out with a sufficient tightening, we recommend to shorten the measured length by 1 up to 2.5% initial tension.

Výkonový typ řemene	Délka obroušené PA folie
60 - 100	12 - 15mm
140	25mm
200	35mm
280	45mm
400	60mm

3. You are required to abrade both ends of the belt manually, e.g. by a rasp file or using the respective grinding machine, to get them edged so that the obtained junction thickness corresponds to the belt thickness. The abraded ends must be absolutely clean. You are allowed to provide the clean status, for example, using gasoline, acetone, ethyl acetate.

4. In possibility to measure out the precision length prior to ordering the belt, you are recommended to get it supplied in execution of a belt as „prepared for junction“. In this case, you have to indicate the net value as reduced by the initial tension see the point 2. The manufacturer has to add the junction length value. By this, the point 3 drops out.

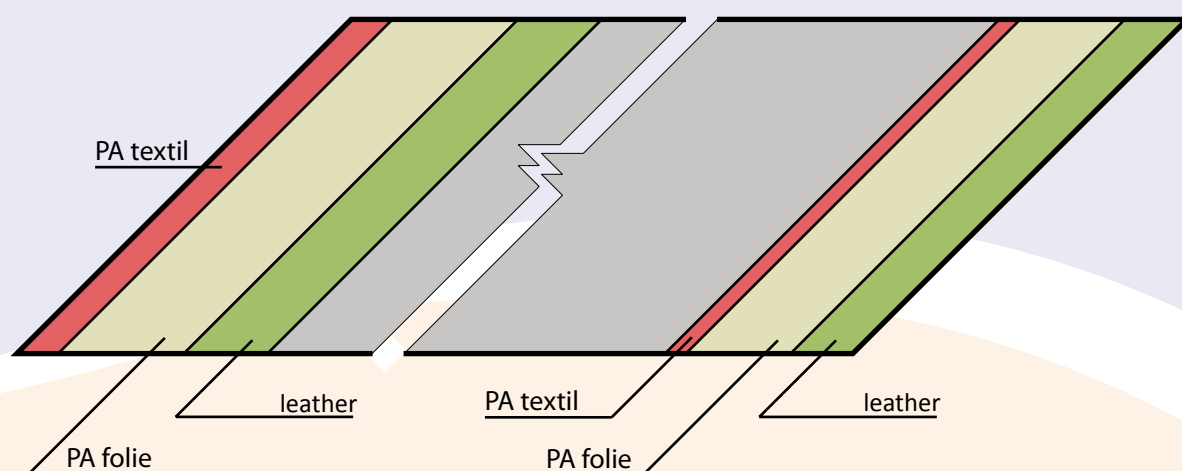
5. Using the hair pencil, you have to coat both abraded junction edges by the „K“ (F1) glue on the PA foil as well as the PA textile. You have to execute a fine coating layer and you have to suck out any excess of glue by cotton cloth. Any remaining excess of glue is inadmissible! The drying time is about 20-30 minutes at ambient temperature. Warning: the F1 glue can bite the skin, so if it is stained, you must immediately wash out the stained skin surface.

6. You have to coat the frictional layer (leather or artificial leather) by the glue, which had been premixed with hardener as dosed in 5 up to 10 % mass of glue. Prepared in such a way, the glue has about 8 hours durability. You have to make 3 (three) coatings. First two coatings up to a complete dry status, the last coating up to a slightly adhesive status.

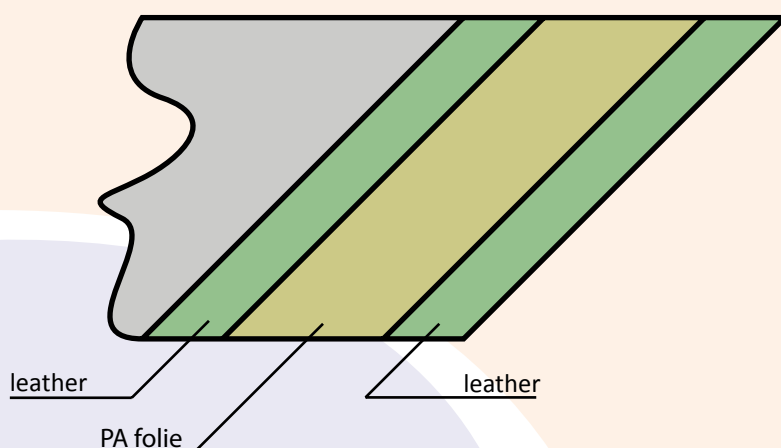
**7** To achieve the junction, you have to put one edge on another (pay attention to observe the precise linearity) so that the individual layers are side-matching, i.e. the PA foil on the PA foil etc. You have to put the junction so fixed into the heating press and obtain the tight junction at minimum 0.5 Mp pressure and 90 up to 100°C temperature during 30 minutes. In necessity of operating the belt as soon as possible, the welding time should be prolonged to the 45 - 60 minutes of total duration. After you have achieved this duration, you have to turn out the heating and leave it for cooling still under the constant pressure. After unloading, it is necessary to leave the junction maturing for about 1 day (24 hours). Afterwards the junction must be cleaned from any overflows of glue, and the belt can be loaded in a full extent.

**8** The REKO LTD is supplied by glues under the name „SADA POLIFIX = POLIFIX SET“ in 700, 320 and 85g packages. Warning: these glues contain solvents of 1st grade of inflammability.

## Typ **UTI**



## Typ **UUI**



*We wish you good speed at work.*

In case of interest, do not hesitate to contact us:

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