

# Instruction of how to connect the flat driving belts of REKO “POLIFIX” with frictional layers from rubber or PA textile

## 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 1 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.

Belt's power type	Length of abraded PA foil
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.

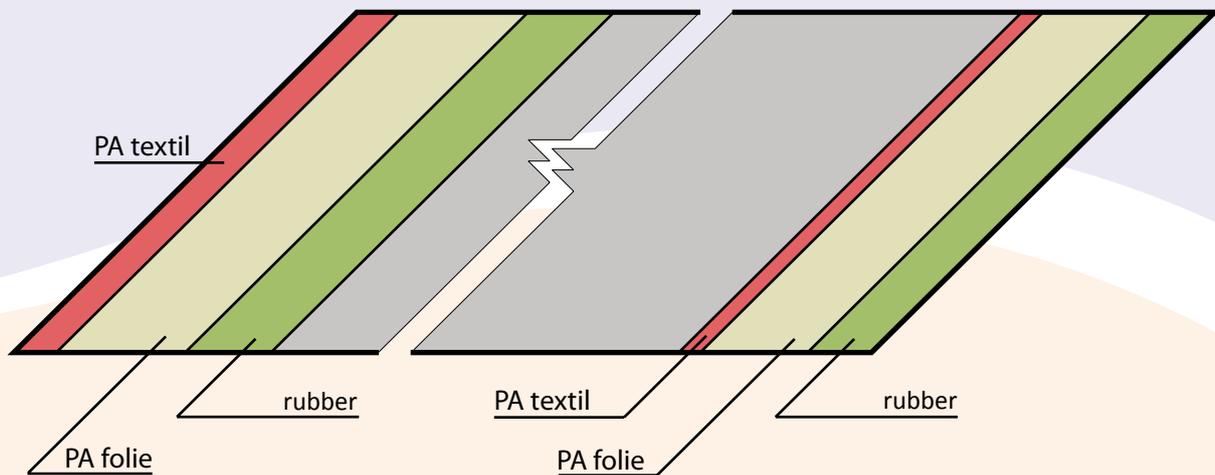
5. Using the hair pencil, you have to coat both abraded junction edges by the „K“ (F1) glue on the PA foil as well as the PA textile. You have to execute a fine coating layer and you have to suck out any excess of glue by cotton cloth. Any remaining excess of glue is inadmissible! The drying time is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

6. The friction layer (rubber) must be coated with CHEMOPREN glue and left to dry up to a slightly adhesive status.

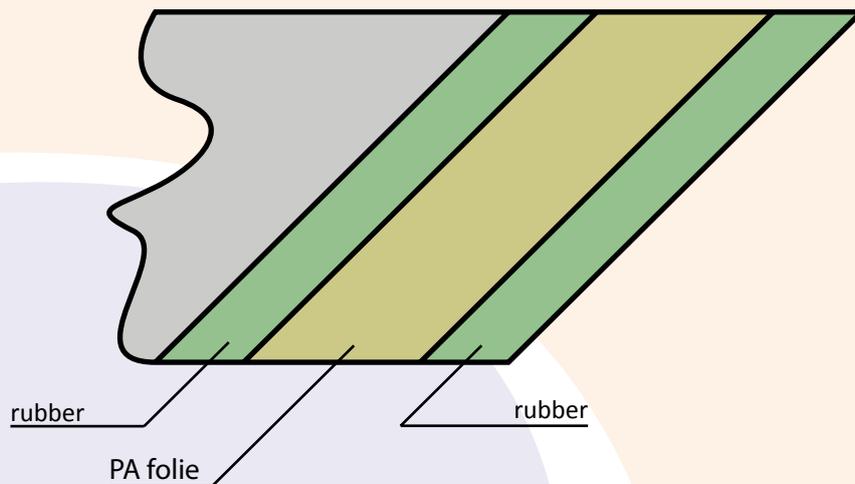
**7.** The REKO LTD is supplied by glue under the name „K (F1) GLUE,, in 700, 320, 85, 35 and 20g packages. The Chemopren glue is available for purchasing in the retail shop. Warning: these glues contain solvents of 1st grade of inflammability and they can bite the skin. If the skin is stained with, wash out the stained area immediately.

**8.** 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.

## Type GTI



## Type GGT



*We wish you good speed at work.*

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

**REKO s.r.o.**, Husova Str. 249, ZIP CODE 551 01 Jaroměř

e-mail: [odbytpasy@reko-sro.cz](mailto:odbytpasy@reko-sro.cz)

[www.reko-sro.cz](http://www.reko-sro.cz)

tel: 491 840011-19

fax: 491840021

DIČ: CZ44499850

IČO: 44499850