



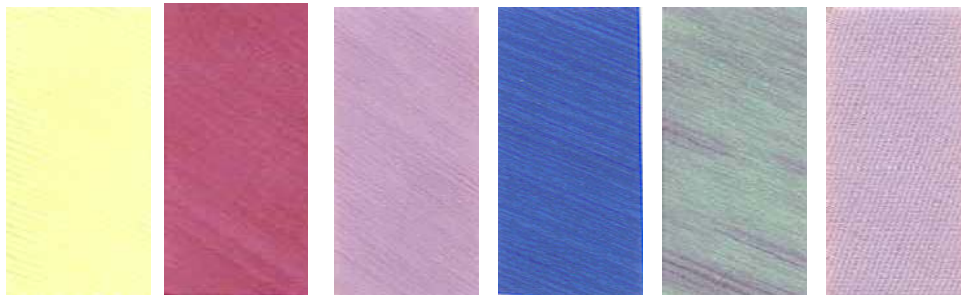
# Splicing Tapes

## Product Bulletin - PB207D

### Coated Abrasive Belt Splicing Tapes

Sheldahl has applied an exact thickness of dry, thermosetting adhesive to the yarn surface of the tape. The expected results when using this tape are reduced splice thickness, increased joint consistency, reduced labor and decrease solvent usage.

<u>T1931</u>	<u>T1787</u>	<u>T1789</u>	<u>T1641</u>	<u>T1727</u>	<u>T1877</u>
Yellow (YL -FCP)	Red (PK - FCP)	Purple (WH - FCP)	New Blue (BL - FCP)	Green (GR - FCP)	Woven (FABRE)
Paper Fine J & X Wt. Cloth/Poly	120 grit and finer	120 grit to 60 grit	80 grit and coarser	60 grit and coarser	Air Tools & Non- Woven Abrasives



#### TECHNICAL DATA

Part Number	Tape Thickness		Tensile Strength		Application Notes
	Metric	English	Metric N/cm.	English lbs./in.	
T1931	0.051 mm	0.002"	200 N/cm.	115 lbs./in.	ultra thin, replace lap, J-Weight
T1787	0.076 mm	0.003"	325 N/cm.	185 lbs./in.	thin, versatile, highest flex
T1789	0.114 mm	0.0045"	455 N/cm.	260 lbs./in.	most versatile, strength & flex
T1641	0.163 mm	0.0064"	615 N/cm.	340 lbs./in.	high strength, high flex, uniform thickness
T1727	0.216 mm	0.0085"	650 N/cm.	380 lbs./in.	Strong abrasion and hinge resistant
T1877	0.140 mm	0.0055"	440 N/cm.	250 lbs./in.	air tools, surface conditioning

Standard Bias Angle: 55°, 67°, 74° and 80°

Standard Roll Widths: ¾" and 1"

Standard Roll Lengths: 76 meters (152 meters available)

#### NOTE:

1. Tape Storage and Shipment: Coated tapes are shipped in insulated cartons with dry ice. Rolls are individually packaged, with a desiccant, in a sealed plastic bag. To assure a shelf life of 90 days tape, must be stored -29°C (-20°F) or lower.
2. 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**

	<b><u>Adhesive Formulation</u></b>	<b><u>Weight</u></b>	<b><u>Volume</u></b>
Resin:	Sheldahl A0455 or A0651	100 parts by weight at 20% solids	100 volumes
Curing Agent:	Desmodur® RE or RFE	9-11 parts by weight	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 20-40 minutes or 4 to 6 minutes at 150°F

### **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

	<b>English</b>	<b>Metric</b>
Temperature:	165°F to 185°F	75°C to 85°C
Pressure:	2000 to 3000 PSI	140 to 210 KG/sq. cm.
Time:	5-9 seconds	5-9 seconds

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

### **ADHESIVE/CURING AGENT OR HARDNERS**

Sheldahl A455 or A651 with Desmodur® RE or RFE  
Desmodur® is a registered trademark of Bayer AG.

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