



Specialty Uncoated Abrasive Belt Splicing Tapes

Uncoated tapes are pre-primed to obtain maximum bond strength when using a thermosetting adhesive. Below is our Specialty product line with suggested applications.

| T900800* | T1881 | T1883 | T9062 | T9071 |
|-------------------------------------------|-------------------|---------------------|-------------------|---------------------|
| Clear Film | Orange | Gold | Ruby | Pearl White |
| Paper or Polishing Belts, No yarn profile | 120 grit or finer | 120 grit to 60 grit | 120 grit or finer | 120 grit to 60 grit |



SPECIFICATION

| Model Number | Tape Thickness (Max.) | | Tensile Strength (Min.) | | Application Notes |
|-----------------|-----------------------|---------|-------------------------|--------------|-----------------------------------------------------|
| | Metric | English | Metric | English | |
| T900800* | 0.080 mm | 0.0031" | 130 N/cm | 75 lbs./in. | Paper or polishing belts, no yarn profile |
| T1881 | 0.107 mm | 0.0042" | 290 N/cm | 165 lbs./in. | Ultimate abrasion and heat resistance |
| T1883 | 0.145 mm | 0.0057" | 402 N/cm | 230 lbs./in. | Ultimate abrasion and heat resistance |
| T9062 | 0.102 mm | 0.0040" | 290 N/cm | 165 lbs./in. | Thin, highest flex & rougher surface |
| T9071 | 0.152 mm | 0.0060" | 490 N/cm | 280 lbs./in. | Most versatile, superior strength & rougher surface |

Standard Bias Angle: 55°, 67°, 75° (reverse angles indicated by the letter "R" after model number)

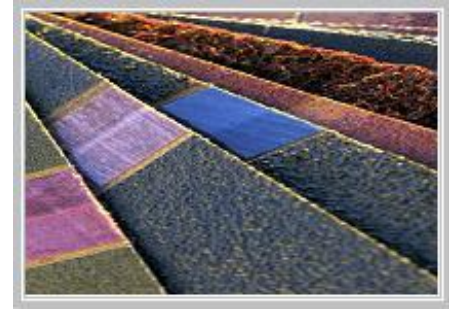
Standard Roll Widths: 19 mm (¾") and 25.4 mm (1")

Standard Roll Lengths: 100 meter (200 meter available)

Minimum Order Quantities could be required for certain Angles and Widths.

Please consult Customer Support for complete details about our Specialty products.

* Clear Film - See pressing instructions on page 2



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 | Weight | Volume |
|---------------|---------------------------|-----------------------------------|----------------|
| Resin: | Sheldahl® Brand Adhesives | 100 parts by weight at 20% solids | 100 volumes |
| Curing Agent: | Sheldahl® NE-S | 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 66°C (150°F).

RECOMMENDED COATING GAP

| Product Type | Coating Gap |
|---------------------------|-------------------------------------|
| Clear, Orange, Gold, Ruby | 300-400 microns plus tape thickness |
| Pearl, White | 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.

| Press Cycle | Metric | English |
|--------------|-------------------------------------|------------------|
| Temperature: | 40°C to 60°C | 104°F to 140°F |
| Pressure: | 140 to 210 kg _f /sq. cm. | 2000 to 3000 PSI |
| Time: | 10 seconds | 10 seconds |

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

***Clear Film** – Must be pressed Hot at 85°C (185°F) for 10 seconds

ADHESIVES AND CURING AGENT / HARDENER

Sheldahl® Brand Adhesives (see [IMPB-1000](#)) and Sheldahl® NE-S Curative (see [IMPB-1080](#))

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