Hot Splicing Code

Hot Splicing Code

Belt Types	Cover Stock & Edge Rubber	Tie Gum	Rubber Cement
General Cover Rubber including Rough Top	GC # 07	T # 31	J # 31
SAR	GC # 01	T # 31	J # 31
UIP	GC # 17	T # 31	J # 31
Heat Resistant : HC-510 HC-513 HC-710	 S # 51 TK # 60 X # 45	 T # 31 T # 53 X # 26	 J # 31 TK # 60 X # 26
Oil Resistant : OR-210 OR-220	 N # 30 N # 32	 N # 28 T # 31	 N # 28 J # 31
Fire Resisitant : FR-300T	C # 87	T # 31	J # 31
Chemical Resistant : CR	GC # 30	T # 31	J # 31

Material Hot Splicing

11 Step Hot Splicing

1. Drawing
2. Cutting and Peeling
3. Grinding
4. Cleaning
5. Cementing
6. Tie Gum Assembling
7. Joining
8. Cover Rubber Assembling
9. Press Curing
10. Finishing
11. Checking

Material Hot Splicing

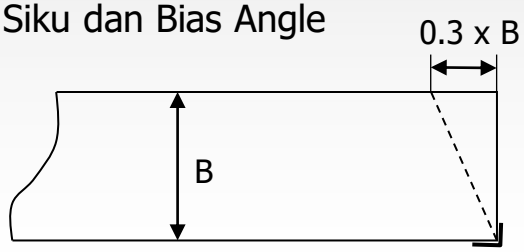
BACK

11 Step Hot Splicing

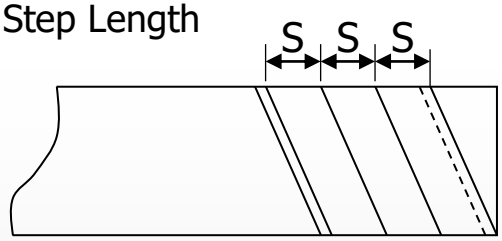
1. Drawing

$L = (0.3 \times B)+(S \times (n-1))+25$

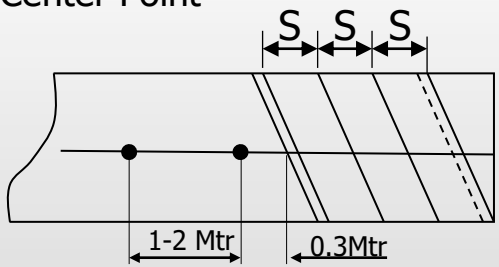
Siku dan Bias Angle



Step Length



Center Point



For example :

Spec Belt : 1300mm x EP-200 x 5P x 8.0 x 4.0 x 632Mtr
Grade : SAR
L = (0.3 x 1300)+(250 x (5-1))+25
= 1415mm

Fabric Strength (Kg/cm)	Step Length (mm)
50 – 120	150
121 – 150	200
151 – 200	250
201 – 250	300
251 – 350	350

Other Calculations Function:

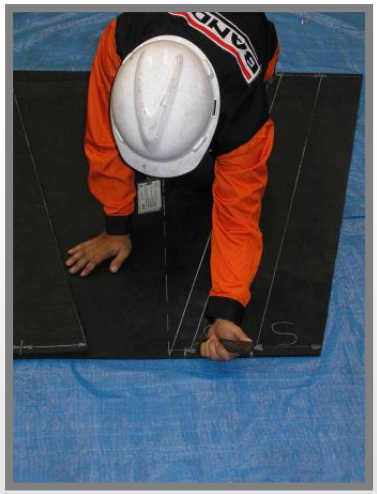
1. To estimate spare length belt
2. To estimate material Splicing needs.

11 Step Hot Splicing

BACK

2. Cutting and Peeling

- Cut and Peel Cover Rubber
- Cut Edge Gum
- Cut and Peel Canvas
- Cut and Smooth-down Canvas



11 Step Hot Splicing

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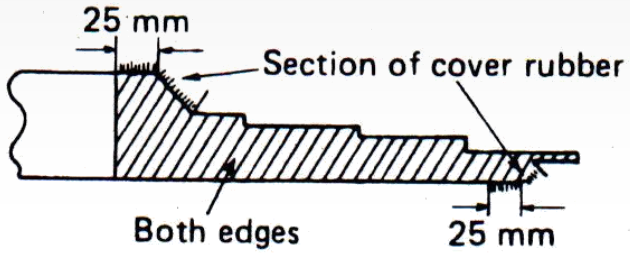
3. Grinding

Grinder & Coarsening Surface of crosscut Cover Rubber



Coarsening the surface cover with scratch of brush

Do not hurt canvas when grinding

BACK

11 Step Hot Splicing

4. Cleaning

Cleaning Surface of Extension with Wire Brush

Cleaning Surface of Extension with Dust-Cloth Wetted with Cleaning Solvent

Dust-Cloth have to be clean

11 Step Hot Splicing

BACK

5. Cementing

Dab glue to the surface extension till flatten.

During cementing cement brush has to be pressed, so glue can entering pores of canvas

Dab glue to the surface Tie Gum till flatten.

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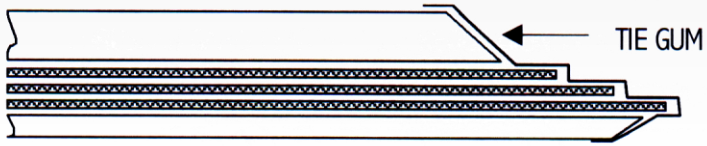
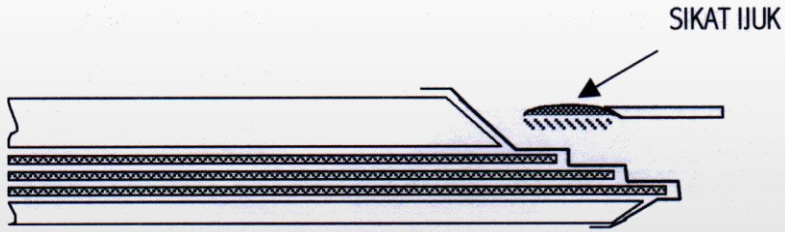
11 Step Hot Splicing

6. Tie Gum Assembling

Installation of Tie Gum on the surface of extension top cover



Cementing extension surface which have been attached by Tie Gum



11 Step Hot Splicing

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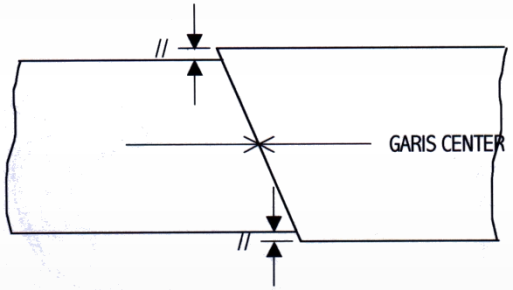
7. Joining

Attach Plastic Cover

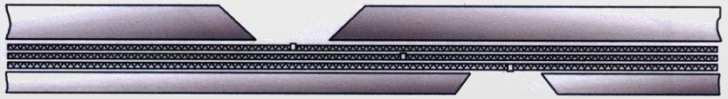
Centering

Attach both sides of extension by paralleling the center line mark



Joining Belt

Joint/ gumming both extension back part and discharged its plastic layer



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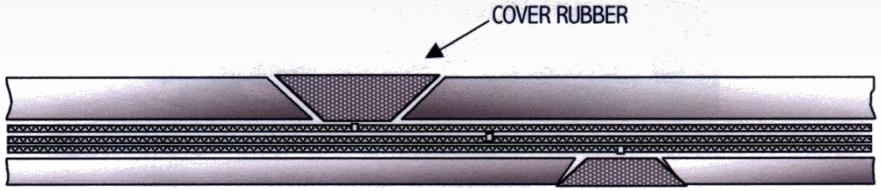
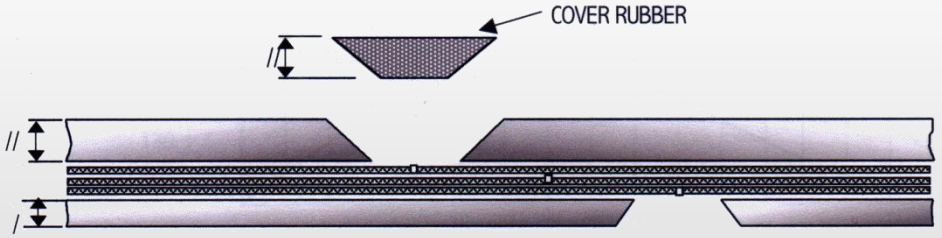
11 Step Hot Splicing

8. Cover Rubber Assembling

Cover Rubber installation at the end of extension of Top and Bottom Cover Rubber



Cover Rubber thickness must be equal with Top and Bottom cover thickness



11 Step Hot Splicing

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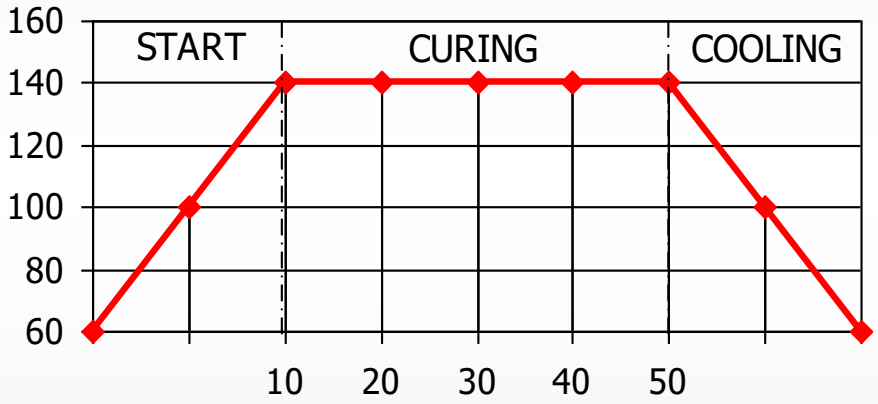
9. Press Curing

Hot Splicing Machine

"Cook' Belt with Vulcanizer Machine



Curing time Table *(minutes)*

Tebal Belt (mm)	Grade				
	Grade-M, FR-300J & Impact Rest., ***OR-210***	JIS – S, ***UIP, SAR, Rough Top***	OR-220, ***HC-510***, , CR, JIS-G,&L	***HC – 710***	***HC-513***
	143±2°C (menit)	148±2°C (menit)	150±2°C (menit)	164±5°C (menit)	***150±5°C (menit)***
≤ 6.0	***15***	***15***	***14***	***40***	***17***
6.1 ~ 7.0	***18***	***18***	***14***	***40***	***18***
7.1 ~ 8.5	***19***	***19***	***15***	***40***	***20***
8.6 ~ 10.0	***20***	***20***	***16***	***42***	***21***
10.1 ~ 11.5	***21***	***21***	***17***	***43***	***23***
11.6 ~ 13.0	***24***	***24***	***19***	***44***	***24***
13.1 ~ 14.5	***26***	***26***	***20***	***45***	***26***
14.6 ~ 16.0	***28***	***28***	***21***	***48***	***27***
16.1 ~ 17.5	***30***	***30***	***23***	***49***	***29***
17.6 ~ 19.0	***31***	***31***	***25***	***51***	***30***
19.1 ~ 20.5	***32***	***32***	***26***	***54***	***32***
20.6 ~ 22.0	***35***	***35***	***28***	***55***	***32***
22.1 ~ 23.5	***37***	***37***	***31***	***56***	***33***
23.6 ~ 25.0	***38***	***38***	***33***	***58***	***36***
25.1 ~ 26.5	***41***	***41***	***35***	***59***	***36***
26.6 ~ 28.0	***42***	***42***	***38***	***62***	***39***
28.1 ~ 29.5	***43***	***43***	***41***	***63***	***41***
29.6 ~ 31.0	***46***	***46***	***43***	***66***	-
31.1 ~ 32.5	***48***	***48***	***46***	***68***	-
32.6 ~ 34.0	***51***	***51***	***50***	***70***	-
34.1 ~ 35.5	***54***	***54***	***53***	***73***	-
35.6 ~ 37.0	***56***	***56***	***56***	***76***	-
37.1 ~ 38.5	***58***	***58***	***60***	***80***	-
38.6 ~ 40.0	***60***	***60***	***62***	***82***	-
40.1 ~ 41.5	***62***	***62***	***64***	***84***	-
41.6 ~ 43.0	***64***	***64***	***66***	***86***	-
43.1 ~ 44.5	***66***	***66***	***69***	***87***	-
44.6 ~ 46.0	***68***	***68***	***72***	***92***	-
46.1 ~ 47.5	***70***	***70***	***74***	***94***	-
47.6 ~ 49.0	***72***	***72***	***76***	***96***	-
49.1 ~ 50.0	***74***	***74***	***78***	***98***	-

11 Step Hot Splicing

BACK

10. Finishing

Neaten / Cut Overflow cover rubber at both sides and surface of extension with scissors

Buffing the joining surface

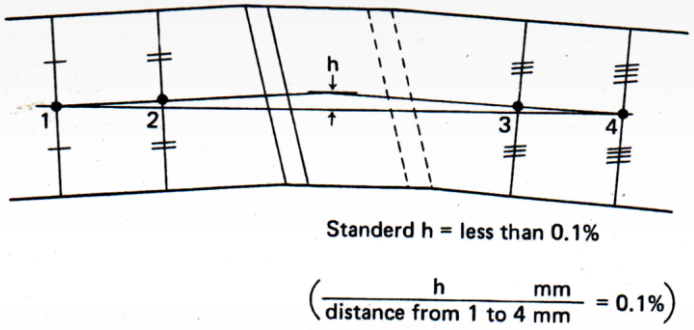
Neaten Edge Side Extension with Buffing machine

BACK

11 Step Hot Splicing

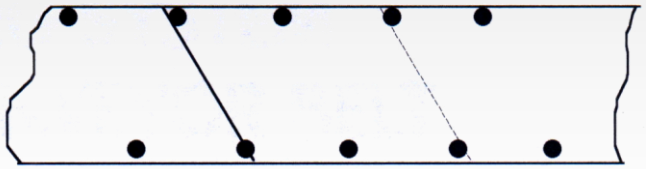
11. Checking

Straightness and Appearance Inspection

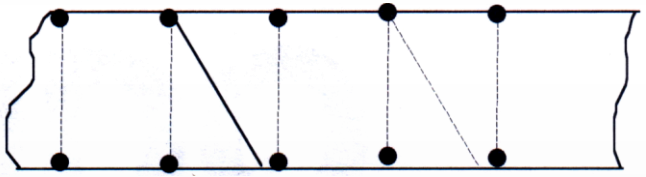


Hardness Check

Thick Inspection



Width Inspection



Length Inspection