SHELDAHL

A Multek Brand

Product Bulletin

Coated Abrasive Belt Splicing Tapes

Coated Tape has an exact thickness of dry, thermosetting adhesive applied 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.

T1931	T1787	T1789	T1641	T1727	T1877
Yellow (YL –FCP)	Red (PK – FCP)	Purple (WH – FCP)	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

TYPICAL DATA

	Tape Thickness		Tensile Strength		Application Notes
Part Number	Metric	English	Metric N/cm.	English lbs./in.	
T1931	0.064 mm	0.0025"	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: 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 at -29°C (-20°F) or lower.
Please consult Customer Support for complete details about our products.

A Multek Brand

Product Bulletin

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.

SUGGESTED ADHESIVE PREPARATION

Ingredient	Adhesive Formulation	Weight	Volume
Resin:	Sheldahl A0455 or A0651	100 parts by weight at 20% solids	100 volumes
Curing Agent:	Desmodur® RE	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.

SUGESSTED PRESS CYCLE

Place pre-tacked belt in bonding press with a release sheet/press pad configuration to prevent bonding to the heated bars. Suggested Press Cycle

Parameters	English	Metric
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

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

ADHESIVE/CURING AGENT OR HARDNERS

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

Product data is for information only and may vary dependent on individual products and processes.
Multek does not guarantee, nor will it accept obligation or liability based on the use of this data.
All data is subject to change without notice.