

Splicing Manual		Nitta Industries Europe GmbH	
Classification No.	NIE-0036 LS NLG-Eng.	21-May-13	
Product Name	GUH-12A Skived Joint	Date	Remarks

1. TOOLS AND ADHESIVE TO BE USED.

★ NLG BOND

Adhesive and hardener Shelf Life	1 year (under sealed condition)
Mixing weight ratio	10(adhesive) : 1(hardener)
Shelf Life after mixing	usually:8 hours, summer:4hours

★ NLG press

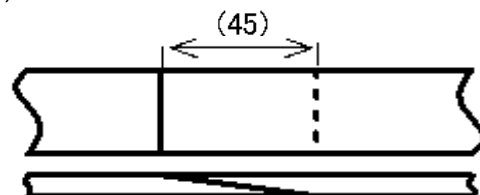
★ Process Paper (Matt pattern)

★ Steel plate

★ Cutter

2. Splice length

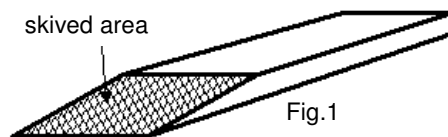
★ right angle : 45 mm



Detail of splice area

3. BONDING PROCEDURE.

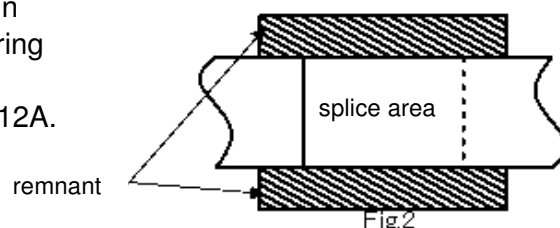
- I Wipe off the skived area as shown in Fig.1 with a cloth which makes solvents(MEK, alcohol, etc.) moistened in order to get rid of oil and dirt.
- II Spread the BOND thinly and evenly on the skived area.(Fig.1)
- III Allow the applied the BOND to dry for about 5 minutes.
- IV Re-apply the BOND to the same area.
- V After applying 2nd coat of the BOND, put two skived ends together in 3 to 10 minutes, and place the splice area into the press within 20 minutes.
- VI On top of the splice area, place a Process Paper and then a steel plate, and start to press.



Note :

Put the remnant of the belt on the both sides as bar in order to prevent transformation of the splice area during pressing. See Fig.2

The remnant of the belt as bar should be used GUH-12A.



* Press conditions

press temperature	upper plate	140 ± 5 °C
	lower plate	140 ± 5 °C
heating time	5 min. after reaching established temperature	
pressure	0.4 ± 0.1 MPa	
cooling	Allow the press temperature fall below 40°C	

- VII After the press temperature falls below 40°C, remove the splice area from the press.
- VIII Trim off the bar remnant from the splice area.
- IX Scrape off the extra adhesive that is forced out from the pressing of the splice area.
- X Measure the thickness of the splice area.

* Belt dimension (Standard value)

belt thickness	1.3 ± 0.15 mm
splice area	belt thickness + 0.3 / -0.15 mm

© Diagonal skived joint is also possible.