

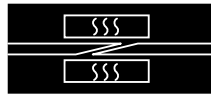
## Hot pressing device PQ-59





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## 0 Preliminary remarks

PQ-59 is a hot pressing device for joining spindle tapes and Habasit machine belts with a width up to 50 mm and a thickness of 3.6 mm with the Quickmelt or Flexproof method.

With additional cooling tong and a guide rail with a suitable width for your application, a joining system is obtained, which allows to replace a tape within a few minutes.

PQ-59 press has been improved compared to the previous model PQ-58, as for the new electronic control and a safety system for overheating that bases on a safety thermostat, which is installed on the welding upper plate.

## 1 General information

### 1.1 Application

The hot pressing device PQ-59 has been designed for Flexproof or Quickmelt manual and mobile hot-pressing of Habasit machine tapes, made with Hamid range and W-8 / W-16 spindle tape with Quickmelt and Flexproof systems. Tapes can reach a width up to 50 mm/2 inches and a thickness up to 3.6 mm/0.14 inches.

Hot pressing device PQ-59 has been designed according to approved technical principles, with an advanced technology and in compliance with the standards in force.

	<p>It is assumed that all assembly, maintenance and repair operations, as well as the hot-pressing device correct operation, are carried out by qualified personnel or supervised by reliable, skilled specialists.</p> <p>Due to limited space, these instructions cannot cover every aspect regarding operation, maintenance or repairs. Indications provided in this manual regard the use of machines by qualified personnel.</p> <p>In case of doubts or for further details, contact the manufacturer (see chapter 1.4).</p>
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### 1.2 Safety indications

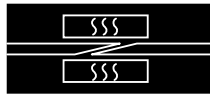
In this operation manual the symbols of **WARNING** and **NOTE** are found. These symbols indicate danger or special indications to observe.

	<p><b>WARNING</b> If disregarded, serious injuries and/or damages may occur.</p>
--	--

	<p><b>NOTE</b> It indicates an important and not obvious technical information even for skilled personnel.</p>
--	--

#### 1.2.1 General instructions

	<p>Read all warnings regarding danger and relative instructions</p>
--	---



In case danger warnings and relative instructions are disregarded, electric shocks, fire and/or serious accidents may occur.

The mains connection plug of the tool must be suitable to the grip. Do not apply any modification to the plug. Do not use adapter plugs. Not modified and suitable plugs reduce the risk of electric shock.

Store the tool in a place repaired from rain and humidity. Water penetration in the tool enhances the risk of electric shock.

Do not use the cable for purposes others from those indicated and do not use it to carry or hang the tool or to remove the plug from the socket.

Do not approach the cable near heat sources, oil, cutting edges nor to moving parts of the machine. Damaged or tangled cables increase the risk of electric shocks.

### 1.2.2 Safety precautions

Do not use the tool if tired or under the effect of drugs, alcoholic beverages and medicines.

Always wear individual protection devices, as well as protective gloves.

When the tool is not used, it must be stored out of reach of children. Do not allow not trained personnel or that have not read the instructions to use the tool.

### 1.2.3 Improper use

Hot pressing device PQ-59 has been designed exclusively for applications described in this user manual. An improper use and an application for different purposes than those described in the instructions are not allowed.



Habasis declines any responsibility for the consequences of an improper use.

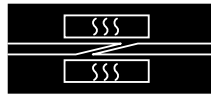
Observe all assembly, operation and maintenance indications of the machine, as well as all technical data! This will avoid any problem/damage to persons or objects.

The term QUALIFIED PERSONNEL refers to persons authorised to carry out the required work.

These persons must be adequately trained and have such an experience in their field to be able to reckon and prevent danger. They are aware of the relative dispositions and safety regulations.

## 1.3 CE Conformity declaration

Together with the machine, HABASIT ITALIANA Spa has provided the CE conformity Declaration, according to the European Directive 2006/95/EC - Attachment III - B.



## DICHIARAZIONE DI CONFORMITÀ

DECLARATION OF CONFORMITY

2006/95/CE – Allegato III - B



Noi We

**HABASIT ITALIANA S.p.A.**  
Via del Lavoro, 50  
I - 31016 Cordignano (TV) - ITALY

dichiariamo sotto la nostra esclusiva responsabilità *declare under our sole responsibility*  
che il prodotto: *that the product:*

**Dispositivo di pressatura a caldo Hot pressing device**

Modello: *Series:*

**PQ-59/6; PQ-59/8**

è conforme alle seguenti norme armonizzate: *is in conformance with the following harmonized standards:*

DIN EN 60335-1 (VDE 0700-1):2007-02; EN 60335-1:2002+A11+A1+A12+corr.+A2:2006

DIN EN 60335-1/A13 (VDE 0700-1/A13):2009-05; EN 60335-1/A13 :2008

DIN EN 60335-2-45 (VDE 0700-45):2009-02; EN 60335-2-45:2002+A1 :2008

DIN EN 62233 (VDE 0700-366):2008-11; EN 62233 :2008

DIN EN 62233 Ber.1 (VDE 0700-366 Ber.1):2009-04; EN 62233 Ber.1 :2008

Riconosciute dall'istituto tedesco VDE con rilascio *Recognized by the German VDE certificate n°*  
del certificato n°40012165 e quindi risponde alla *40012165 and is consequently in conformity with*  
direttiva europea 2006/95/CE *the european directive 2006/95/CE*

Il Fascicolo Tecnico viene conservato presso: *The Technical File is stored at:*

**HABASIT ITALIANA S.p.A.**  
Via del Lavoro, 50  
I – 31016 Cordignano (TV) - ITALY

Cordignano,

Il Direttore Generale  
*General Manager*

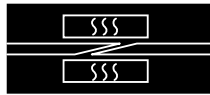
Ugo Passadore

Il Responsabile della Divisione Macchine  
*Head of Machines and Tools Department*

Matteo Mapelli

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## 1.4 CE plate

The CE plate has been placed on the machine body:



## 1.5 Supply terms

Q.ty	Article
1	Hot pressing device PQ-59 is packed in a box
1	User manual

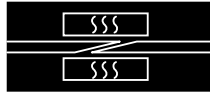
## 1.6 Accessories available



Fixed width guide rails for welding, inclusive of covering plate:

6 mm	H080672006	3/8"	H080672113
8 mm	H080672008	1/2"	H080672101
10 mm	H080672010	5/8"	H080672114
11 mm	H080672011	3/4"	H080672102
12 mm	H080672012	7/8"	H080672109
13 mm	H080672013	1"	H080672103
14 mm	H080672014	1 1/8"	H080672110
15 mm	H080672015	1 1/4"	H080672104
16 mm	H080672016	1 3/8"	H080672105
18 mm	H080672018	1 1/2"	H080672106
20 mm	H080672020	1 5/8"	H080672111
22 mm	H080672022	1 3/4 "	H080672107
25 mm	H080672025	1 7/8 "	H080672112
30 mm	H080672030	2"	H080672108
35 mm	H080672035		
40 mm	H080672040		
50 mm	H080672050		

N. 2 blocking devices are required for each guide rail.



Adjustable width guide rails for welding, from 25 to 50 mm, inclusive of 1 covering plate for tapes with widths of 25, 30, 40, 45 and 50 mm and 2 metal blocking devices (H080672201) or from 1/2" to 2", inclusive of 1 covering plate for tapes with widths of 1/2", 3/4", 1", 1 1/4", 1 1/2", 1 3/4" and 2", and 2 metallic blocking devices (H080672202).



Use Habasis guide rails only. In particular, avoid using metallic guide rails, because they could damage the hot pressing device.

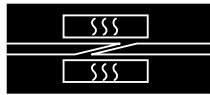
Scissors for cutting to length AQ-40 (H080690020)

Flexproof AF-102 cutter (H080690060)

Flexproof AF-61 cutter:

- Flex 8x30 (H080690710)
- Flex 6x30 (H080690715)

CD-60 cooling tong (H080690030)



## 2 General description of the machine

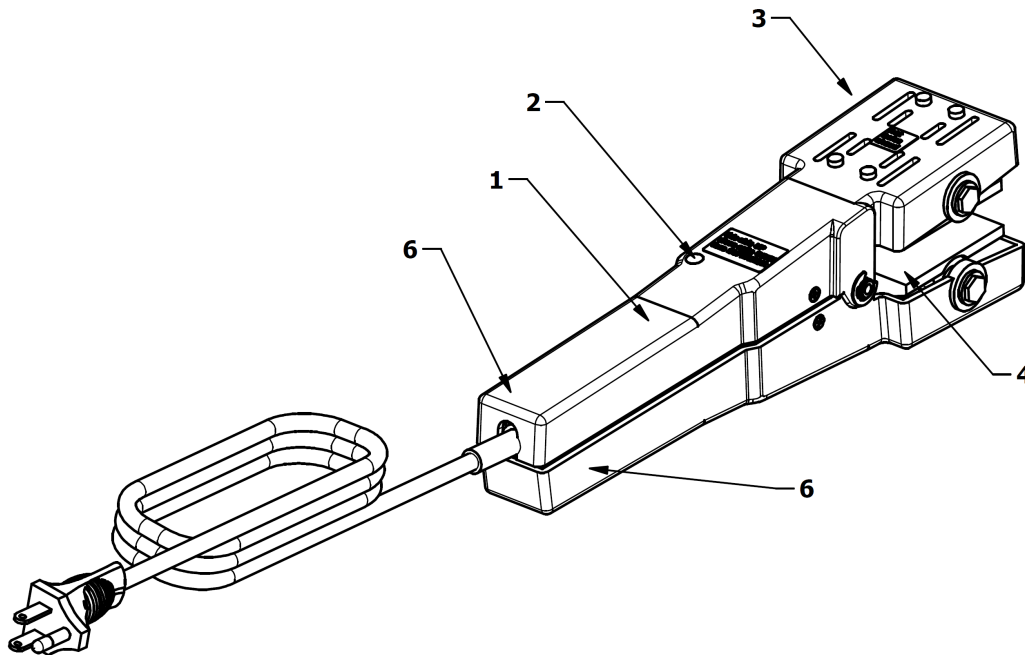


Illustration: 1

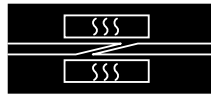


Illustration: 2

### Illustration legend 1 and 2

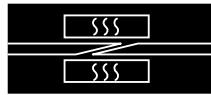
- 1 Top side of the hot pressing device
- 2 Light indicator
- 3 Hot pressing area
- 4 Pivoting metal heating plates
- 5 Rating plate
- 6 Heat insulated handles
- 7 Adjustment potentiometer of the heating controller
- 8 Cover screw of trimmer potentiometer





### 3 Technical data

Features	UM	Value
▪ <b>ELECTRIC</b>		
- Nominal power voltage	Vac	1x230 V (PQ-59/8); 1x120 V (PQ-59/6) 50Hz
- Overall installed power	W	2 x 225
▪ <b>PNEUMATIC</b>		
- Compressed air pressure	bar	min.5...Max. 6
▪ <b>PRODUCTION</b>		
- Belt maximum width	mm [inc]	50 [2.0]
- Belt max. thickness	mm [inc]	3.6 [0.14]
- Flexproof finger max. length	mm [inc]	35 [1.4]
- Closed belt minimum length	mm [inc]	250 [10]
- Maximum deviation of the heating plates	°C [°F]	± 3 [± 5.4]
- Heating time at 190 °C [374 °F]	[min]	5
▪ <b>OVERALL DIMENSIONS</b>		
- Dimensions( <i>length height x depth</i> )	mm [inc]	280L x 120H x 70W [11L x 2.8W x 4.7H]
▪ <b>WEIGHTS</b>		
- Net weight	kg [libbre]	0.83 [1.85]



## 4 Operation mode

The hot pressing device PQ-59 operates according to the pressing tongs principle: to open the heating plates pressed together by springs, apply substantial pressure to both handles.

Hot pressing device PQ-59 works with a pressing temperature of 190 °C / 374 °F, preset in the factory, even if the temperature can be adjusted within a range from 120°C / 248°F to 190°C / 374°F.

The heating plate temperature is adjusted by an electronic circuit. Each heating plate is equipped with a replaceable electric heating element; the lower heating plate is even equipped with a thermal sensor, the upper one with a safety thermostat. The activation of the hot pressing device is indicated by a light indicator, located on the handle. Press PQ-59 can work within a temperature range from 120°C / 248°F to 190°C / 374°F, which can be adjusted by using the trimmer located on the upper handle side. The temperature tolerance compared to the set point is of +/-3°C / 5.4°F.

### 4.1 Operative mode of the led indicator

Located on the upper handle, the led indicator indicates the operation status of the press:  
press in heating mode: red light.

Set point reached and thermostation: green light switches on when the control gives power to heaters.

In case of overheating beyond safety limits, the safety thermostat intervenes by opening the contacts and the green led starts flashing with an on-off frequency of 1 sec. See chapter "5.5 Malfunctioning" for relative information.

## 5 Commissioning

Ensure the voltage specified on the rating plate (5) corresponds to the connected voltage.



The tool indicating 230 V can be also connected to the 220 V mains.  
As well as for the 120 V version, 110 V power supply is tolerated.

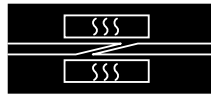
Ensure the metal pressing plates (4) are clean.

Verify the heating plate temperature. The temperature is preset in the factory at 190°C/374°F. If a lower temperature is required, the temperature adjuster can be adequately set (see 5.2: Measuring the temperature of the plate).



The operation safety is ensured if handle (1) with light indicator (2) is facing upwards  
(cable connection on the upper handle).

For the fixed operation, place hot pressing device PQ-59 on a stable and heat-resistant surface.



Do not hang the hot pressing device by using the connection cable!  
During work breaks, place the hot pressing device on a plane surface with the marked side facing upwards, if still connected to the mains.

## 6 Hot pressing of belts/tapes

For Hamid machine tapes → manual 32103 and welding parameters for single products.

For spindle tape W-8, W-16 → manuals 32110, 32111 and welding parameters for single products.



For Hamid machine tapes → manual 32103 and welding parameters for single products.  
For spindle tape W-8, W-16 → manuals 32110, 32111 and welding parameters for single products.

Connect the power cable and pre-heat the hot pressing device for about 5 minutes. Light indicator (2) will change from a continuous light during heating up to intermittent light, as soon as the set temperature is reached.



Do not touch the hot pressing area (3).  
Keep water and fusible materials away from the device.

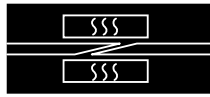
Open the hot pressing device by applying pressure on handles (6); place the guide rail by using the belt/tape ends located in the hot pressing device, as described in the relative manual (see also chapter 9).

Close the hot pressing device.

Once the prescribed pressing time is over, remove the guide rail and let it cool under pressure in an appropriate device → chapter 11.



After use, unplug the hot pressing device from the power supply and let it cool completely before storing it in its packaging.



## 7 Maintenance

Keep the hot pressing device always clean. Regularly clean the pressing plates and remove material residuals.

	<p>Always clean the press with the device unplugged from the mains, by using a moist or solvent dampened cloth.</p> <p>Do not connect the press to the mains until the it is completely dry.</p>
--	--

Periodically, ensure the power cable and the socket do not present any defects (damaged insulation, etc.); if so, remove or replace them with spare parts of the same type.

### 7.1 Measuring the temperature of the plate.

Once a month, ensure the process temperature of the heating plate is correct:

This operation must be carried out indoors, protected from draught and with a room temperature between 18 and 25 °C.

Fasten the temperature sensor between heating plates (4) and heat it for 5 minutes. Both plates are thus measured jointly.

Heat the press for at least 5 minutes.

The operating temperature is reached when the electronic control unit switches on and off the heating in short intervals; green light indicator (2) will flash, according to the on and off phases of heaters activation.

The temperature probe inserted between the two plates will indicate the set point temperature.

If the temperature is not correct, intervene on the trimmer, located on the upper handle, by adjusting the temperature. Wait 5 minutes, in order to stabilise the system and verify the value and tolerance of  $\pm 3^{\circ}\text{C}$  /  $5.4^{\circ}\text{F}$  on the temperature indicator.

### 7.2 Adjustment of the thermostat

	<p>All interventions on the hot pressing device that involve electric components must be carried out only by specialised personnel</p> <p>Observe local standards regarding the required training for such personnel</p>
--	--

PQ-59 can operate within a temperature interval from 120°C / 248°F to 190°C/347°F.

If the measured temperature deviates from the set value, it must be adjusted as follows (see also chapter 5.2):

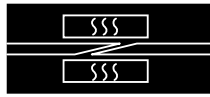
Remove cover screw (8) from adjustment potentiometer (7)


Move the adjustment potentiometer of heating control unit (7), by using an insulated screw driver, rotating it slightly:

- clockwise, in order to raise the temperature
- counterclockwise, in order to low the temperature.

After 5 minutes, measure the temperature of the plate and repeat the operation, if required.


Re-cover adjustment potentiometer (7) with appropriate cover screw (8).



	During the adjustment phase, ensure the temperature does not rise above 195°C / 383°F. Excessive temperatures may damage the hot pressing device or activate the safety thermostat
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### 7.3 Replacement of the power cable

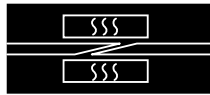
Periodically verify the power cable. In case it is damaged, replace it with the same type (H05-RNF). Special equipment is required to be sure that this repair is carried out exclusively by trained personnel.

	All interventions on the hot pressing device that involve electric components must be carried out only by specialised personnel. Observe local standards regarding the required training for such personnel.
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### 7.4 Malfunctioning

The led indicator shows the operation status of the press:

Status of the indicator	Description
<b>ON; red light</b>	The press is heating the plates, the set point temperature has not been reached yet
<b>Flashing; green light</b>	The temperature of the press is stabilising; the led activation corresponds to the heaters activation.
<b>Flashing with a frequency of 1 sec.; green light</b>	Over temperature. The temperature has risen beyond 200°C / 392°F. The press is not working correctly. Switch off the press by disconnecting the plug and wait until it cools (below 100°C/ 212°F). In this way, the alarm is reset. Power the press and ensure it is operating correctly. In case the safety thermostat opens the contacts, unplug the power cable and wait until it cools. Then power the press and verify its operation. if the problem persists, contact your dealer for after-sales service.



## 7.5 Ordering accessories/spare parts

Spare parts and accessories can be ordered directly to the manufacturer at the following address:

**Habasit Italiana S.p.A.**  
Via del Lavoro 50  
**31016 CORDIGNANO (TV)**  
Tel.: +39 0438 9113  
Fax: + 39 0438 912374  
E\_mail : [info@habasit.it](mailto:info@habasit.it)  
Internet: [www.habasit.com](http://www.habasit.com)

Please specify clearly the code of the ordered components.

Indicate codes according to section 8.3 Drawings - Assembly of the press and, if possible, the voltage required for the connection to the mains.



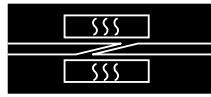
Spare parts of different brands non-conforming to Habasit specifications are not allowed.  
Habasit declines any responsibility for the consequences of using Habasit non original spare parts.

## 7.6 Guarantee

All tools are subject to an accurate final control. Pressing devices are guaranteed for 1 year in case of material and manufacturing faults, providing that they are used correctly.

## 7.7 Technical advice

Our experts are available for any advice. For technical inquiries regarding the operation and conditions of the hot pressing device, contact the manufacturer at the above-mentioned address.



## 8 After-sales technical assistance

Habasis Italiana S.p.A. technical assistance is available to answer to your requests and may be found at the following address:

### **Habasis Italiana S.p.A.**

Via del Lavoro 50

**31016 CORDIGNANO (TV)**

Tel.: +39 0438 9113

Fax: + 39 0438 912374

E\_mail : [info@habasit.it](mailto:info@habasit.it)

Internet : [www.habasit.com](http://www.habasit.com)

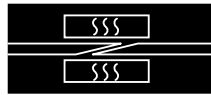
### **Product liability, application considerations**

The proper selection and application of Habasis products, including the related area of product safety, is the responsibility of the customer.

All indications / information are recommendations and believed to be reliable, but no representations, guarantees, or warranties of any kind are made as to their accuracy or suitability for particular applications. The data provided herein are based on laboratory work with small-scale test equipment, running at standard conditions, and do not necessarily match product performance in industrial use. New knowledge and experiences can lead to modifications and changes within a short time without prior notice.

BECAUSE CONDITIONS OF USE ARE OUTSIDE OF HABASIT'S AND ITS AFFILIATED COMPANIES CONTROL, WE CANNOT ASSUME ANY LIABILITY CONCERNING THE SUITABILITY AND PROCESS ABILITY OF THE PRODUCTS MENTIONED HEREIN. THIS ALSO APPLIES TO PROCESS RESULTS / OUTPUT / MANUFACTURING GOODS AS WELL AS TO POSSIBLE DEFECTS, DAMAGES, CONSEQUENTIAL DAMAGES, AND FURTHER-REACHING CONSEQUENCES.

This use and maintenance manual and its attachments are translated from original language (Italian).



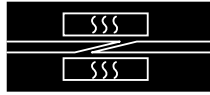
## Hot pressing device PQ-59



## Attachments

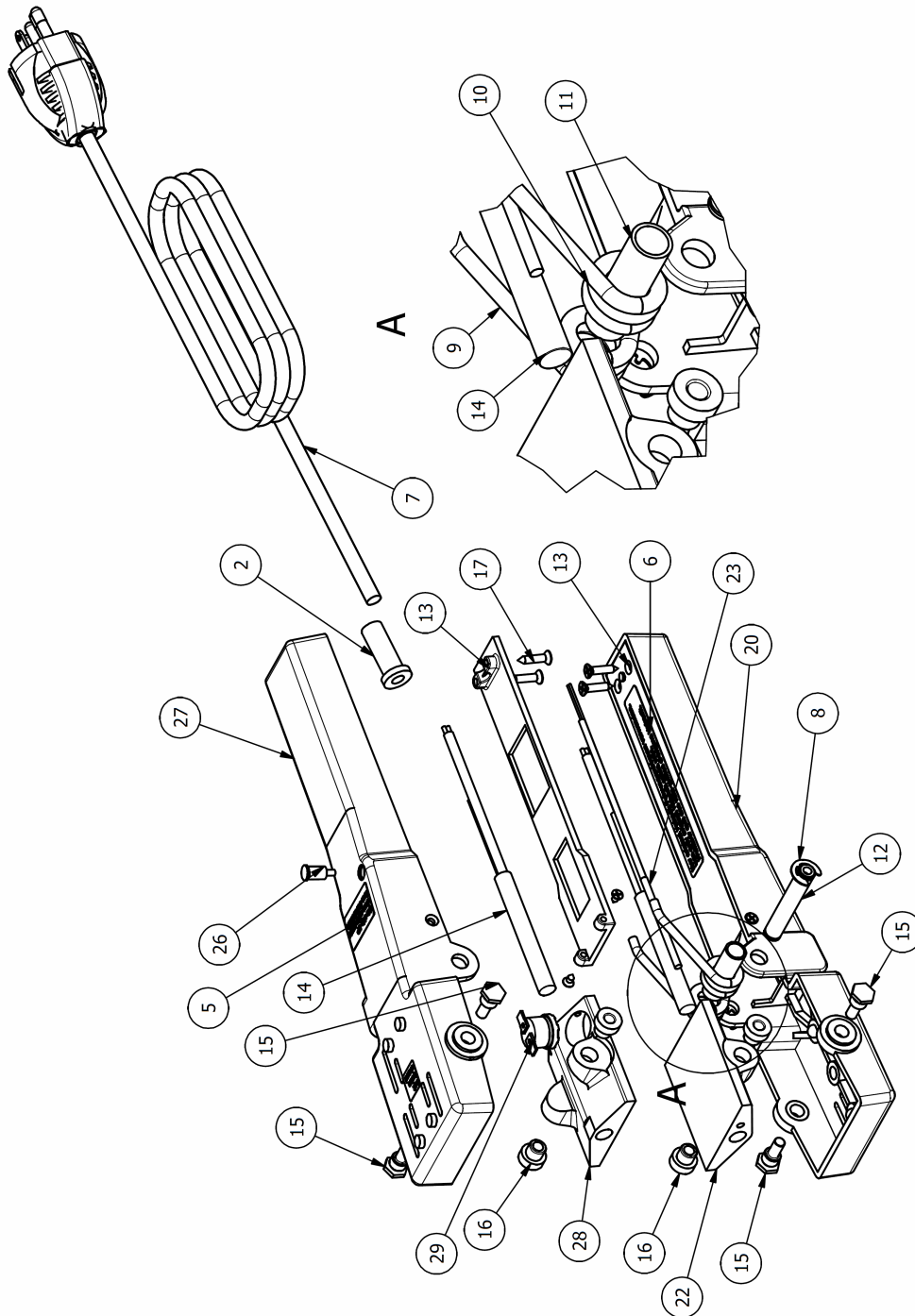
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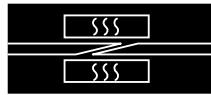




## 9 Spare parts

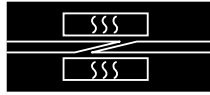
PQ-59/8 230V – H08D007206



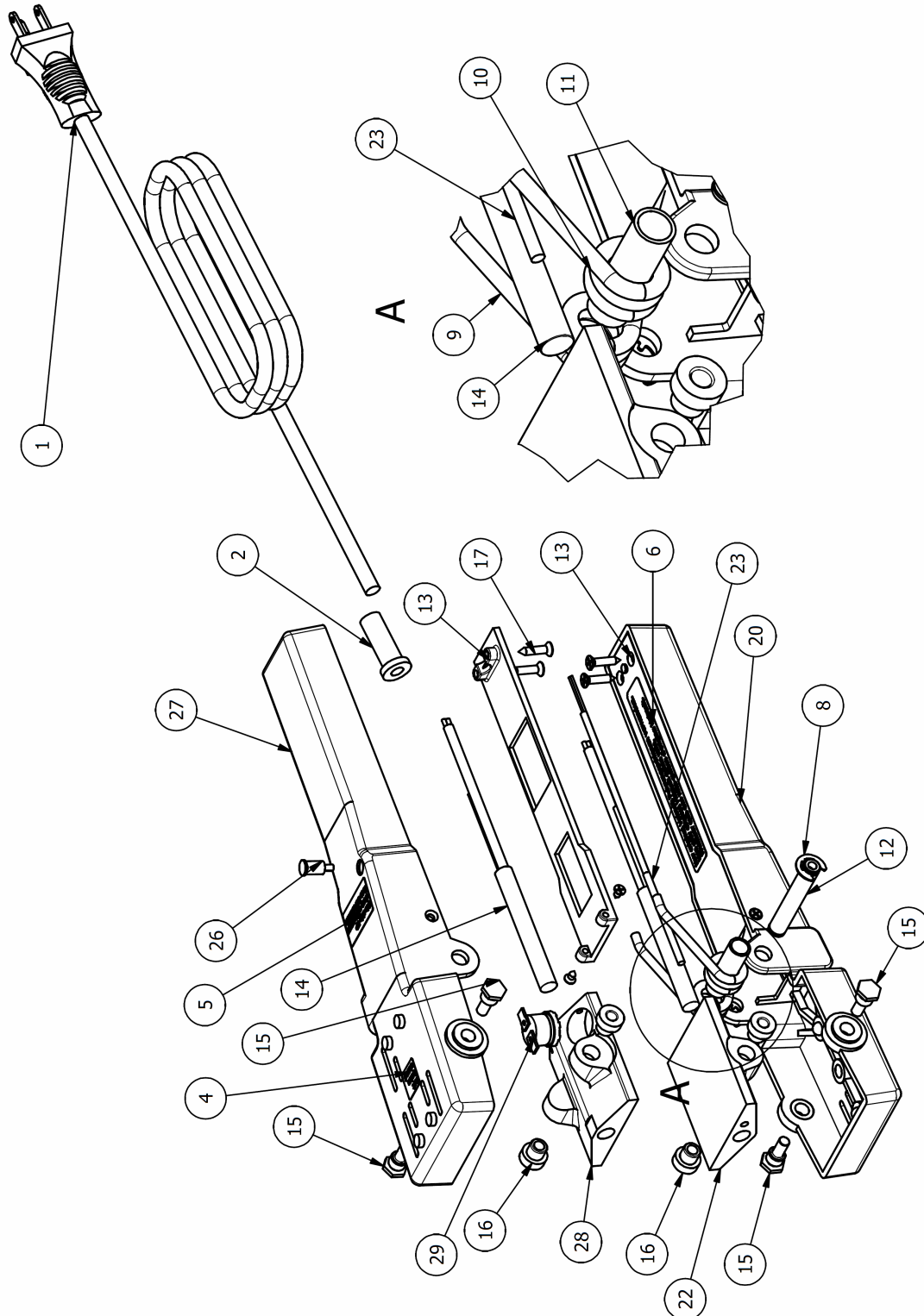


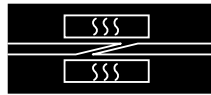
**H08D007206 PQ-59/8 230V**

POS.	QT.Y	CODE	DESCRIPTION
2	1	H080704756	POWER CABLE GLAND
4	2	H080708000	"HOT" LABEL
5	1	H080708001	"UPPER PART" LABEL
6	1	H080708002	"USE OF ORIGINAL WELDED TEMPLATES" LABEL
7	1	H080300203	EURO POWER CABLE 230V
8	2		TAPER LOCKING RINGS ANSI B27.7 - 8
9	1	H080700004	TONG OPENING LEFT SPRING COD.4FK1183A
10	1	H080700003	TONG OPENING RIGHT SPRING COD.4FK1183A
11	1	H080700017	HANDLE PIN SPACER P-0024000
12	1	H080700007	PIN FOR SPRING
13	2	H080702002	HANDLE COVER 702002 PQ-PF P-0283000C
14	2	H080703503	HEATING CARTRIDGE PQ-58 PQ-59 120V
15	4	H080700019	PLATE FASTENING SCREW
16	4	H080702013	PTFE/CARBON INSULATING BUSH
17	4	H080701011	SELF-THREADED SCREW UNI 6955 - ST3,5 X 16 - C - H
20	1	H08D007203	LOWER HANDLE PQ-59
22	1	H08D000014	LOWER WELDING PLATE PQ-59
23	1	H080709514	SENSOR NTC 220 KOHM
26	1		OPERATION INDICATOR
27	1	H08D007201	UPPER HANDLE PQ-59 USA VERSION
28	1	H08D007204	UPPER WELDING PLATE PQ-59 WITH SEAT FOR THERMOSTAT
29	1	H08N050180	THERMOSTAT PQ-59 EAW COL02



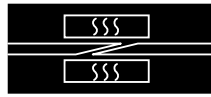
**PQ-59/6 120V – H08D007205**





**H08D007205 PQ-59/6.120V**

POS.	QT.Y	CODE	DESCRIPTION
1	1	H080704007	USA POWER CABLE 120V
2	1	H080704756	POWER CABLE GLAND
4	2	H080708000	"HOT" LABEL
5	1	H080708001	"UPPER PART" LABEL
6	1	H080708002	"USE OF ORIGINAL WELDED TEMPLATES" LABEL
8	2		TAPER LOCKING RINGS ANSI B27.7 - 8
9	1	H080700004	TONG OPENING LEFT SPRING COD.4FK1183A
10	1	H080700003	TONG OPENING RIGHT SPRING COD.4FK1183A
11	1	H080700017	HANDLE PIN SPACER P-0024000
12	1	H080700007	PIN FOR SPRING
13	2	H080702002	HANDLE COVER 702002 PQ-PF P-0283000C
14	2	H080703503	HEATING CARTRIDGE PQ-58 PQ-59 120V
15	4	H080700019	PLATE FASTENING SCREW
16	4	H080702013	PTFE/CARBON INSULATING BUSH
17	4	H080701011	SELF-THREADED SCREW UNI 6955 - ST3,5 X 16 - C - H
20	1	H08D007203	LOWER HANDLE PQ-59
22	1	H08D000014	LOWER WELDING PLATE PQ-59
23	1	H080709514	SENSOR NTC 220 KOHM
26	1		OPERATION INDICATOR
27	1	H08D007201	UPPER HANDLE PQ-59 USA VERSION
28	1	H08D007204	UPPER WELDING PLATE PQ-59 WITH SEAT FOR THERMOSTAT
29	1	H08N050180	THERMOSTAT PQ-59



## 10 Required accessories

### 10.1 Guides, blocking devices

- These accessories are required for producing perfect fusion joints. The width and number of guide rails to be used depend on the width of the used tape and on the machine/system requisites.
- Once the tape ends have been placed into the corresponding guide rail of fixed width → illustration (3) or adjustable width → illustration (4) and fastened with the covering plate, the two blocking devices are applied sidelong to prevent the tape from moving during the hot pressing process.
- Place the guide rail exactly at the centre of the open hot pressing device and close it → illustration (5). This ensures uniform distribution of the heat to the guide rail and joint.



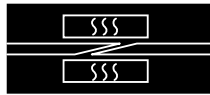
Illustration 3



Illustration 4



Illustration 5



## 10.2 Cooling tong CD-60

- Cooling tong CD-60 is designed for the rapid cooling of the joint, when this is still inside the guide rail → illustration (6). Once the specified pressing time is over, the cooling tong must be fastened on the guide rail as soon as possible.
- If repeatedly used, the cooling tong heats. It can be cooled by immersing it in cold water.

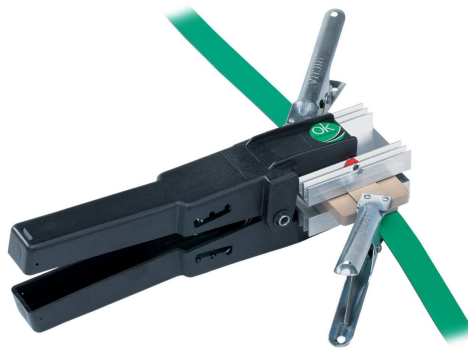


Illustration 6

## 10.3 Preparing devices

### 10.3.1 Scissors for cutting to length AQ-40

Scissors for cutting to length AQ-40 allow the accurate cutting of tapes at an angle of 60°. These scissors can be used to cut to length tapes up to 40 mm/1,57 inches width and 3 mm/0,12 inches thick → illustration (7).

### 10.3.2 Flexproof cutter AF-102

Flexproof cutter AF-102 is used to prepare (finger cutting) Habasit machine tapes with a width up to 100 mm and thick 2 mm, for Flexproof (finger) joints. The device is suitable for the standard Habasit 8 x 30 mm finger geometry. The tape is placed and blocked on an aluminium surface. Fingers are then manually cut. The cutter is placed on the surface with a pin inside a row of grooves; the angle is given by a guiding block fastened to the cutter → illustration (8).



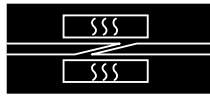
Illustration 7



Illustration 8

### 10.3.3 Flexproof cutter AF-61

The AF-61 is a device used to prepare (die-cutting) Habasit tapes and belts with a width up to 60 mm/2.36 in. and thick 3 mm/0.12 in. for Flexproof (finger) joint. It is suitable for the Habasit standard finger geometry



with a pitch of 6x30mm or 8x30 mm (different cutting heads to be defined when ordering). Die-cutting is performed by moving the blade carrier cart on a indexed guide rail, with accurate finger cutting and consequently an ideal joint resistance.

AF-61 is suitable to produce small/large quantities of spindles and machine belts off pre-cut coils. → **illustration (9).**

AF-61/8x30 - Flex 8x30mm article code H080690710

AF-61/8x30 - Flex 8x30mm article code H080690715

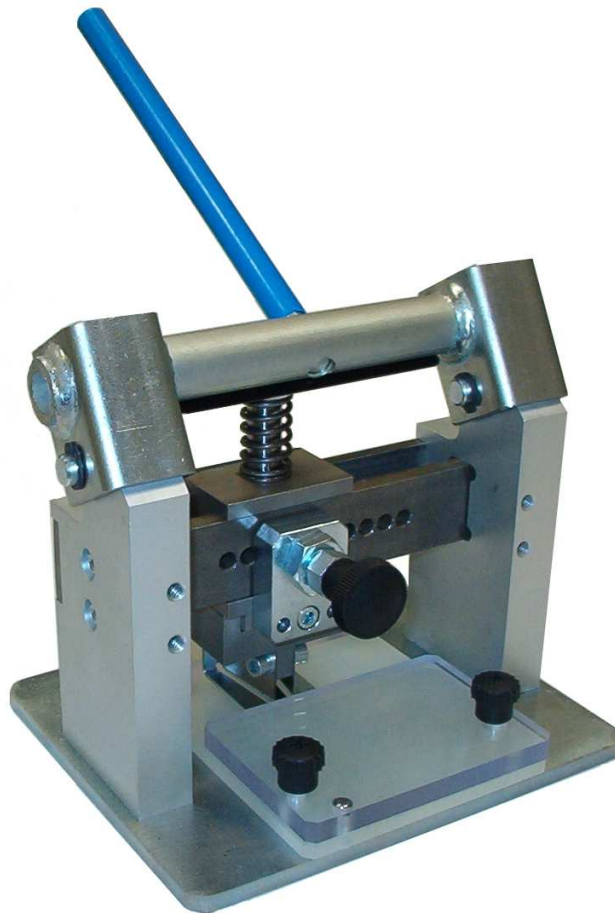
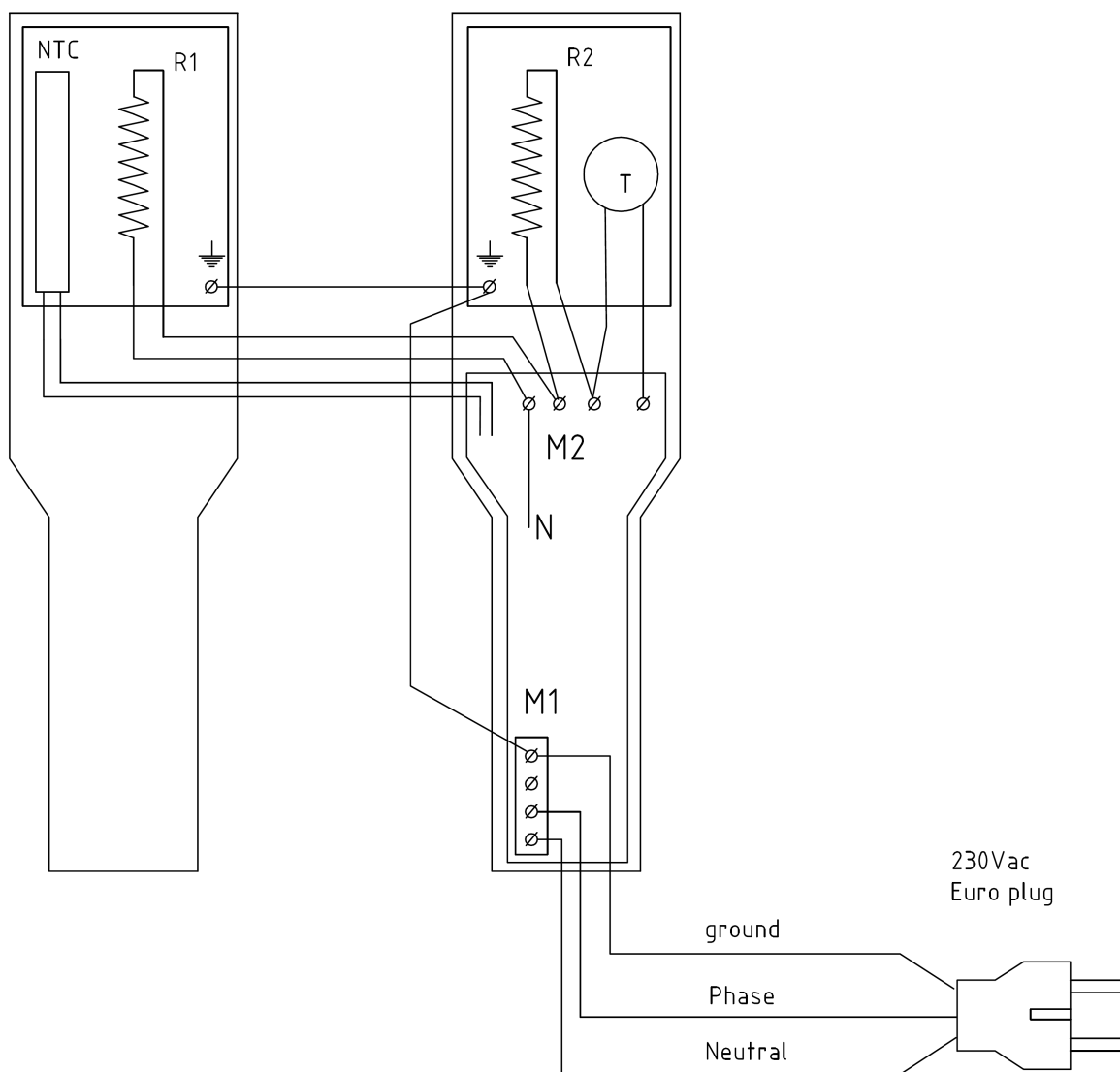


Illustration 9



## 11 Wiring diagram

### 11.1 Wiring diagram PQ-59/8 (230V)



**NTC** Temperature sensor NTC

**R1** Lower plate heater

**R2** Upper plate heater

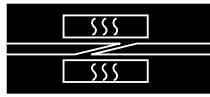
**T** Safety thermostat

**M1** 4 poles power clamp

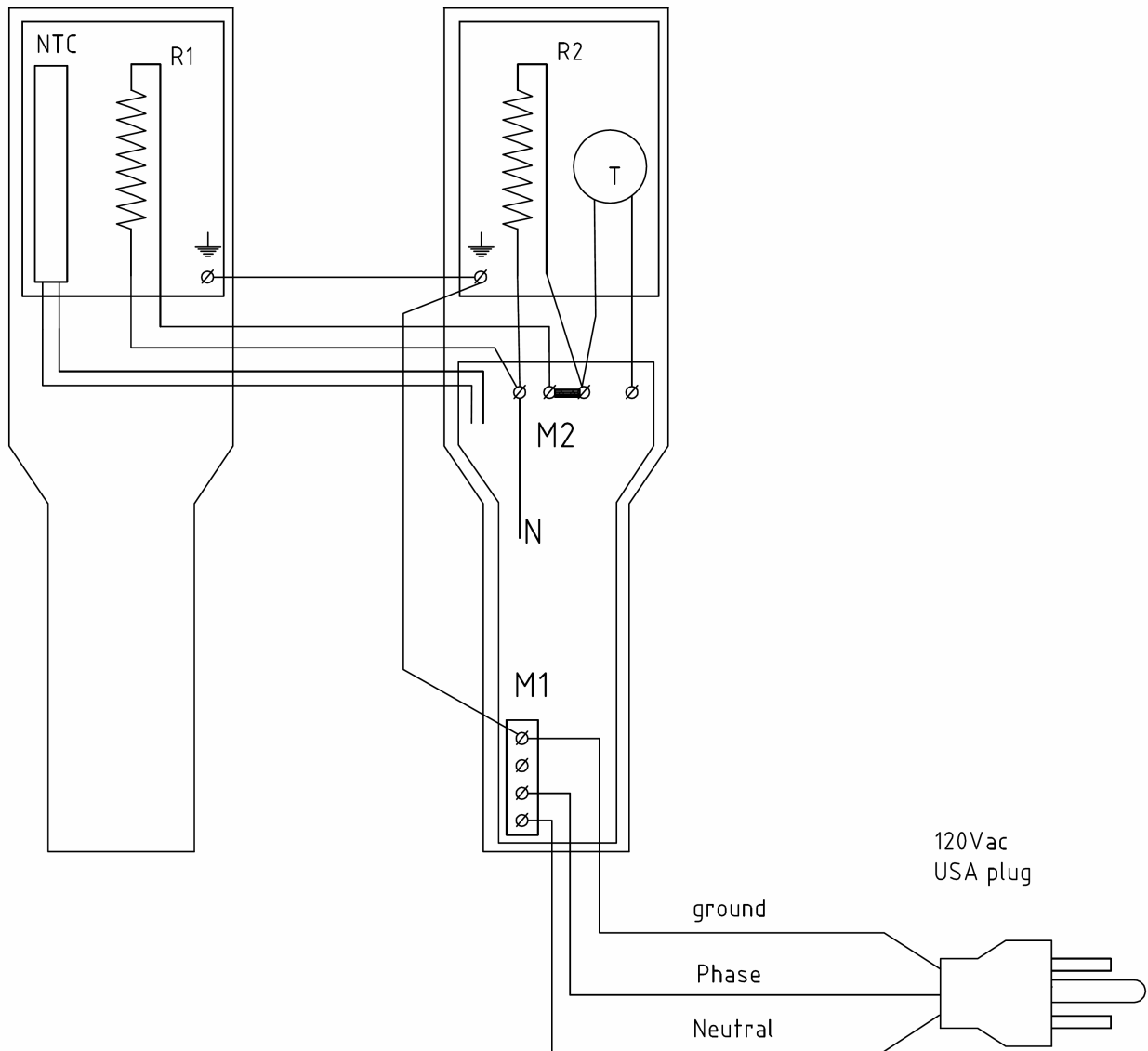
**M2** Output connection 4 pole clamp

**No.** Neutral line





## 11.2 Wiring diagram PQ-59/6 (120V)



**NTC** Temperature sensor NTC

**R1** Lower plate heater

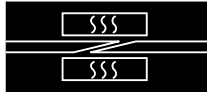
**R2** Upper plate heater

**T** Safety thermostat

**M1** 4 poles power clamp

**M2** Output connection 4 pole clamp

**No.** Neutral line

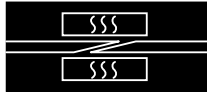


## 12 A1 - Preventive Maintenance Checklist

Responsible: A: Machine operator  
 B: Maintenance technician

Operations to be carried out (for further information and reference numbers, see user manual no. 36007)	Every day	Performance periodical (monthly)			Spare part code Evaluation criterion
		1	6	Observation	
<b>1. Cleaning</b>					
1.1 Clean the pressing device after use by removing residues	A				
<b>2. Inspect the power cable</b>					
2.1 Examine the cable and plug to ensure they do not have defects		B			damaged insulation, faulty connections
<b>3. Measuring the temperature of the heating plates</b>					
3.1 Proceed as indicated in the user manual 36007, section 5.2		B			

Observations and notes:



## 13 A2 - Summery form of preventive maintenance operations

Machine type:

Machine no.:

Commissioning date:

Operations to perform - see checklist (daily operations not registered)	control subseque nt	performed		control subseque nt	performed		control subseque nt	performed		control subseque nt	performed	
		check	date		check	date		check	date		check	date
2.1 Verify any damages of the cable												
3.1 Measure the heating plate temperature												

Observations, repairs: