

## Hot-pressing device PT-100



The PT-100 is a hot-pressing device for Thermofix joining of Habasit belts and tapes up to a width of 100 mm and a thickness of 6 mm. The lower press plate is heated and is equipped with a detachable set-up plate with clamping springs for secure positioning of the belt ends. Its knuckle joint mechanism allows easy adjustment for different belt thicknesses. Together with the integrated pressure equalization pad, it ensures reliable hot pressing for even the most demanding glued belt joints.

The PT-100 hot-pressing device is equally well suited for workshop use and on-site installations.



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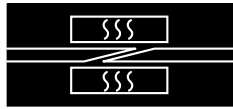
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**Appendix:**

- Checklist preventive maintenance:
- Report sheet preventive maintenance
- Product Liability



## 1. General information

### 1.1 Application

The hot-pressing device PT-100 was specifically designed for the rapid and safe hot pressing of Habasit driving and conveyor belts using the Thermofix procedure. The belts/tapes can be up to 100 mm / 4 inches wide (right-angle skiving, 90°), respectively 75 mm / 3 inches (75° diagonal) or 45 mm / 1.8 inches (60° diagonal).

The maximum belt thickness is 6 mm / 0.24 inches.

The press is suitable for both stationary and portable use.

The PT-100 hot-pressing device was developed solely for the purposes described in the operating instructions. Improper use, or use for other reasons than those described in the instructions, is not permissible. Habasit accepts no liability for the consequences of improper application.

The hot-pressing device PT-100 is manufactured according to recognized engineering principles and state-of-the-art technology, and complies with applicable regulations.

These operating instructions imply that all assembly, maintenance, and repair work, as well as operation of the press, be carried out by skilled personnel or monitored by responsible specialists.

For reasons of scope, these instructions cannot cover all possible aspects of operation, maintenance, or repair. The indications given herein refer to the use of the machines according to their designated purpose by skilled personnel.

In case of doubt or if further detailed information is required, please consult the manufacturer (Chapter 1.4)

### 1.2 Important safety terms

In these operating instructions, you will find the terms WARNING, CAUTION, and INDICATION. They signal dangers or special information to be borne in mind.

**WARNING** If disregarded, there is a danger of severe injury, and/or severe material damage.

**CAUTION** If disregarded, there is a danger of injury, and/or material damage may be caused.

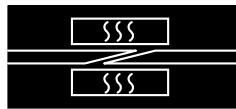
**INDICATION** Technical information is emphasized if it is important and not readily apparent, even for skilled personnel.

Please observe all indications for assembling, operating, and maintaining the machines, as well as all technical data! This will prevent possible trouble and/or damage to people or materials.

**Skilled personnel** refer to persons authorized to perform the required work. These people have been sufficiently trained and introduced to their field of activity so that they are able to recognize and prevent dangers. They are aware of the pertinent provisions and safety regulations.

### 1.3 Scope of supply

Qty.	Item
1	PT-100 hot-pressing device packed in a carton box, with
1	Exchangeable set-up plate with tensioning springs, and
1	Operating instructions



### 1.3.1 Available accessories

- Temperature measuring device (N-28714 or N-28715) for checking the pressing temperature
- Special set-up plate with belt/tape guide at customer request

## 1.4 Ordering of accessories/spare parts

Spare parts and accessories can be ordered directly from the manufacturer.

Address:

Habasit Italiana S.p.A.  
Via A. Meucci 8, Zona Industriale  
I-31029 Vittorio Veneto/TV  
Tel. ++39 438 91 13  
Fax ++39 438 91 2374

Please accurately describe the parts required.  
State the numbers according to Section 8, Drawings.

**WARNING**

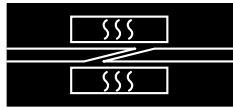
The use of parts by other manufacturers not meeting Habasit specifications is not admissible.  
Habasit declines all responsibility for the consequences if non-Habasit parts are used.

## 1.5 Warranty

All tools undergo a strict final inspection. On the assumption of correct handling, they are warranted against material and manufacturing defects for 1 year.

## 1.6 Technical advice

Our specialists will be pleased to advise you. For technical questions concerning function and condition of the hot-pressing device, please contact the manufacturer (see Chapter 1.4 for the address).



## 2. Mode of operation

The hot-pressing device PT-100 operates at a pressing temperature of 120 °C / 248 °F, preset at the factory. The press can be adjusted according to the belt/tape thickness. Its closing mechanism functions on the knuckle joint principle.

The exchangeable heating plate with integrated overheating fuse and temperature regulator (thermostat) is located in the bottom part (4) of the pressing device. A lamp (LED) in the lower handle indicates that the hot-pressing device is operating.

The set-up plate (2) with two clamping springs (5) is located unattached on the lower pressing plate.

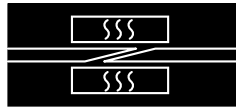
## 3. Initial start-up

- Check to make sure that the voltage indicated on the rating plate (8) conforms to the electrical connection voltage.
- Check to make sure that the set-up plate (2) and the metal pressing plates are clean.
- Check temperature of the heating plate. The temperature is preset at the factory at 120 °C / 248 °F. If a lower temperature is required, the temperature regulator can be adjusted accordingly (see 5.1, Measuring of the plate temperature).

<b>INDICATION</b>	For safe operation, the signal lamp (12) must face to the left side (cable connection to lower handle) and adjusting knob (6) is on top.
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- For stationary operation, place hot-pressing device PT-100 on a solid and heat-resistant support.
- For safe operation, the hot-pressing device can be screw mounted to a bench/frame. Threaded holes M6 (10) are located on the underside of the bottom part (4) of the press.

<b>WARNING</b>	Do not suspend the hot-pressing device from its cable! When not in use, place the hot-pressing device on a level surface with the marked face upwards.
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#### 4. Hot-pressing of belt/tape

Process: Thermofix guidelines 3210 and individual product datasheets

- Apply adhesive(s) to the prepared belt/tape ends.
- By raising the upper handle (7), unlatch the clamp clip (1) and flip up top part of press (3) to open pressing device.
- Open right and left clamping spring (5) of the set-up plate (2). Insert one prepared belt/tape end exactly centered (skived surface up) and fix it with clamping spring – see Ill. 2.
- Superimpose the other belt/tape end congruently and fix it with clamping spring (5).

INDICATION	Adhesive is only to be applied outside the hot-pressing device.
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- Flip down top part of press (3). By raising the upper handle (7), latch clamp clip (1) into catch bracket. With adjusting knob (6), line up the hinge arms of the upper handle (7) flush with the hinge arms of the clamp clip (2) – see Ill. 2 (A).
- Tension the press plate by pushing down the upper handle (7). In tight space conditions in mobile applications, the top part of the press (3) can be removed by pulling out the hinge pin (9) and then be put back horizontally over the bottom part of the press for tensioning and hot pressing.

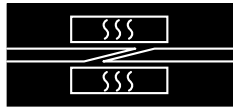
INDICATION	Pull adjusting knob (6) towards handle during closing procedure. This avoids lateral slipping of skived belt/tape ends in the press and ensures that the joint is straight.
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- Plug in electrical connecting cable and preheat hot-pressing device. The preheating time is approx. 12 minutes. The control-LED (12) extinguishes when the preset temperature is reached.

WARNING	Do not touch the hot-pressing zone. Keep device away from water and meltable substances.
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- Observe the dwelling time in the press (pressing time + 12 minutes preheating time). Leave pressing device plugged in until hot-pressing process is completed.
- After completion of the hot-pressing process, pull out the electrical connecting plug. Open pressing device (as described above), take out the belt/tape, and let cool for a few minutes before installation.

WARNING	After use, disconnect the hot-pressing device from the power supply and allow it to cool completely before storing it.
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## 5. Service

### 5.1 Maintenance

- Keep the hot-pressing device clean at all times. Clean the pressing plates and the set-up plate (2) regularly and remove all material residues.

**WARNING** For cleaning with a cloth moistened with water or solvent, the press must be disconnected from the power supply.  
Do not reconnect to the power supply until the press is completely dry.

- Periodically inspect the power supply cable and connector plug for defects (insulation damage, etc.) and rectify or replace with the correct type where necessary.

### 5.2 Measuring of the plate temperature

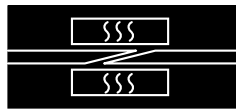
Check the operating temperature of the hot-pressing device once a month.

- Carry out this check in an interior room in a draft-free environment with an ambient temperature of between 18 °C / 64 °F and 25 °C / 77 °F
- Place the temperature sensor of a measuring device between the set-up plate (2) and the not-tensioned top part of the press (utilize only the weight of the press upper part itself).



**INDICATION** Measure plate temperature only with set-up plate (2) located in place.

- Heat up press for at least 12 minutes.
- The operating temperature is reached when the temperature regulator switches off and on in intervals, whereby the control-LED (12) extinguishes and illuminates again.
- The temperature measuring device should not deviate by more than  $\pm 6 \text{ °C}$  /  $\pm 10.8 \text{ °F}$  from 120 °C / 248 °F.
- If this is not the case, the temperature regulator has to be adjusted. See 5.2, Adjusting of the temperature regulator.



### 5.3 Adjusting of the temperature regulator

The maximum plate temperature of 120 °C / 248 °F, preset at the factory, must not be exceeded by more than  $\pm 6$  °C /  $\pm 10.8$  °F from 120 °C / 248 °F. It can therefore only be adjusted with a precision temperature measuring device (see 1.3.1, Available accessories).

<b>WARNING</b>	All work on the hot-pressing device involving electrical parts has to be carried out by the respective specialists only. Observe your local laws concerning required training of such personnel.
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- Remove cover disk (11) on the underside of the bottom part (4) of the pressing device.
- Move adjustment potentiometer of the heating control, using an insulated screwdriver, by slightly turning:
  - clockwise: temperature will rise,
  - counterclockwise: temperature will drop.
- After 5 minutes, measure plate temperature to check as described above.
- Proceed carefully and adjust gradually. Observe temperature change.
- Re-install potentiometer cover disk (11).

<b>CAUTION</b>	Make sure not to let the temperature rise above 126 °C / 258.8 °F during adjustment. Excessive temperatures may damage the hot-pressing device or blow the integrated thermo fuse (P-893000).
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### 5.4 Replacement of the power cord

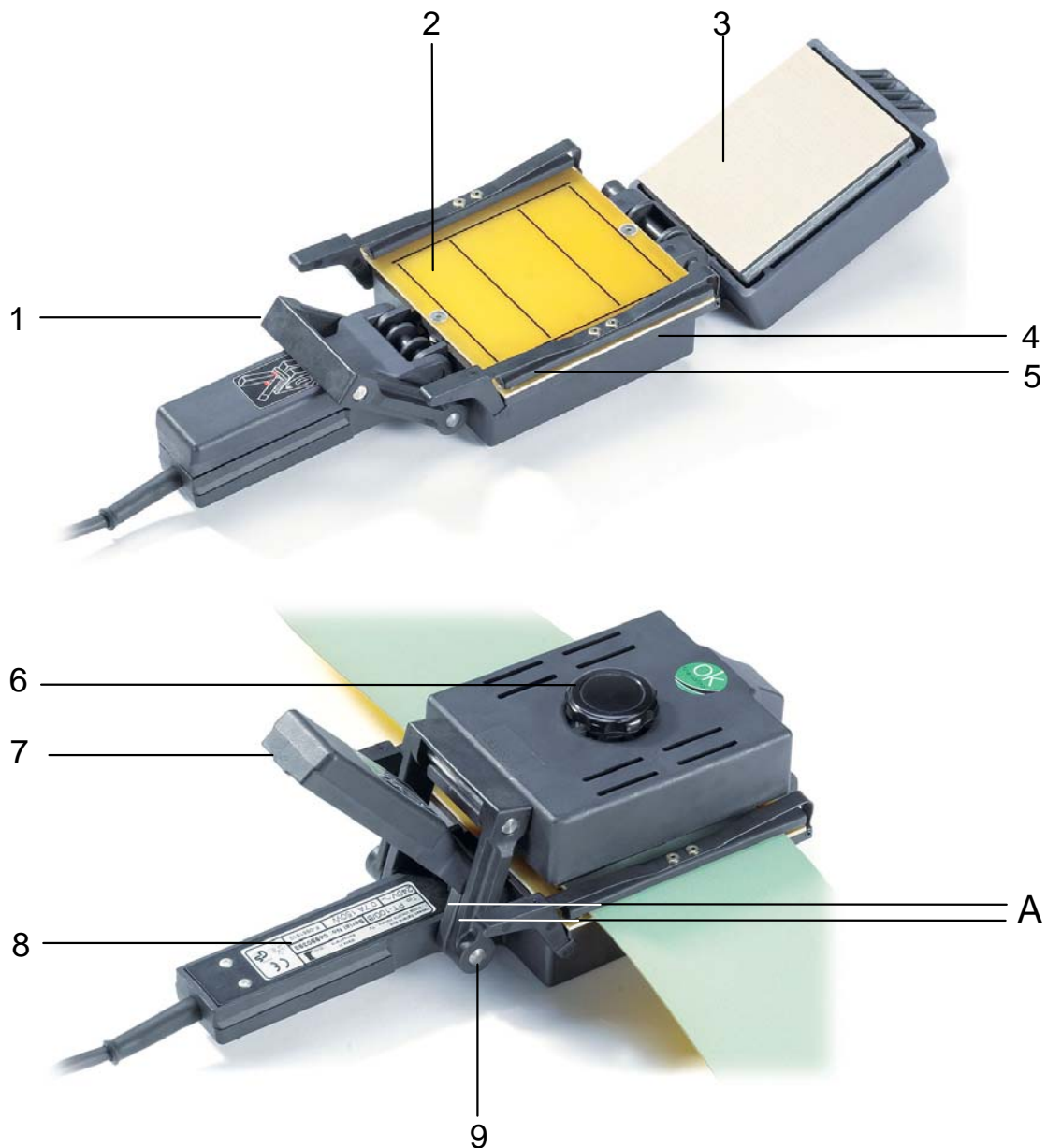
Check power cord periodically. In case of damage, replace with the same type (H05-RNF). To make sure only skilled staff will carry out this repair, special tools are required for this operation.

<b>WARNING</b>	All work on the hot-pressing device involving electrical parts has to be carried out by the respective specialists only. Observe your local laws concerning required training of such personnel.
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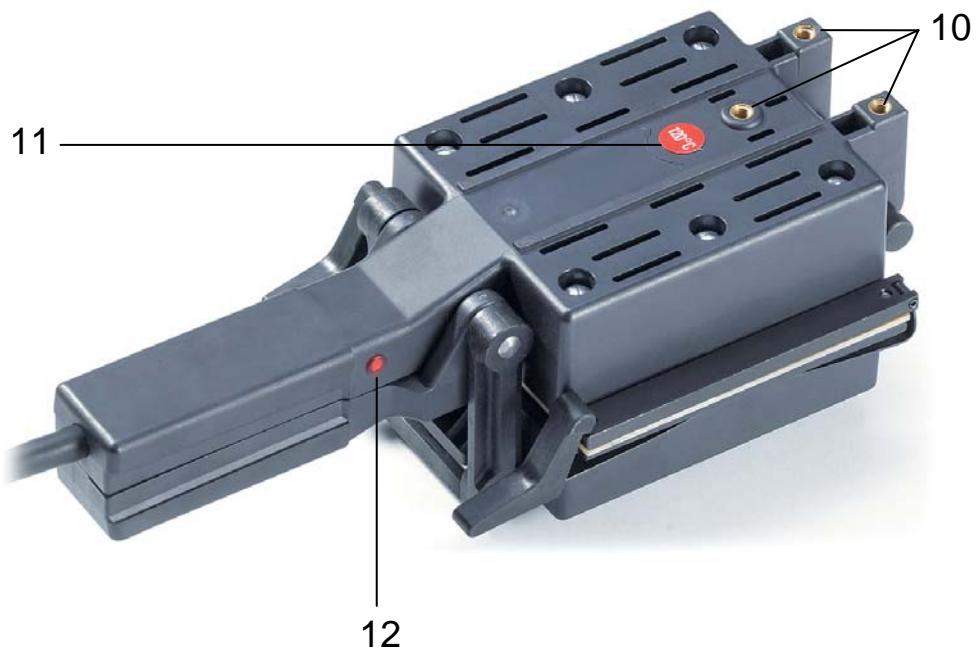
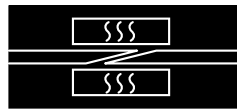


## 6. Illustrations



### Legend:

- 1 Clamp clip
- 2 Set-up plate
- 3 Top part of press
- 4 Bottom part of press
- 5 Clamping spring
- 6 Adjusting knob
- 7 Upper handle
- 8 Rating plate
- 9 Hinge pin



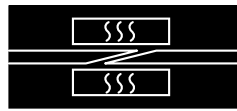
**Legend:**

- 10 Fastening threads
- 11 Cover disk
- 12 LED



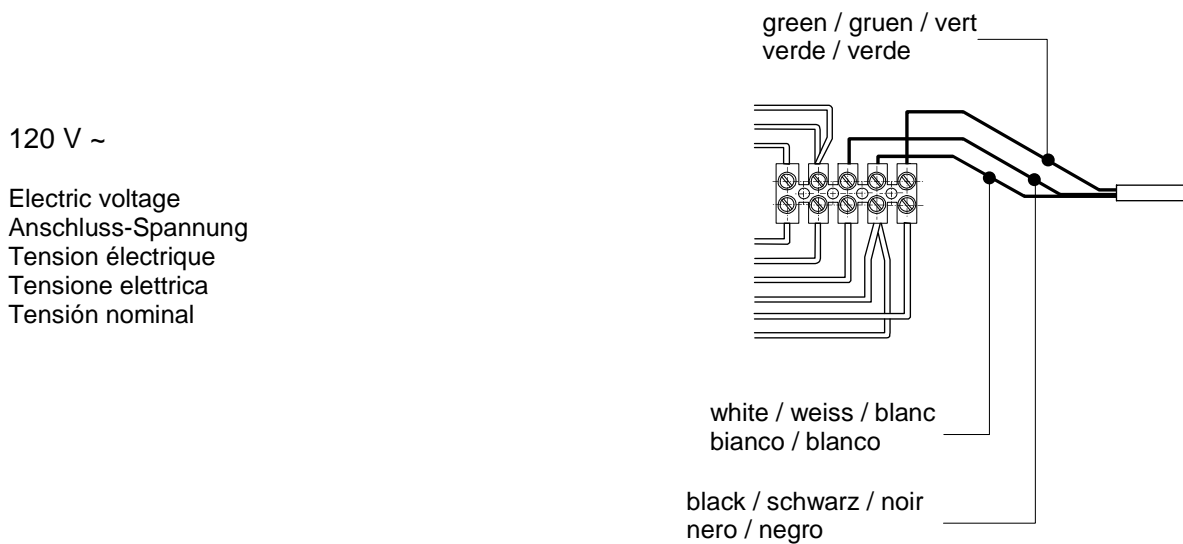
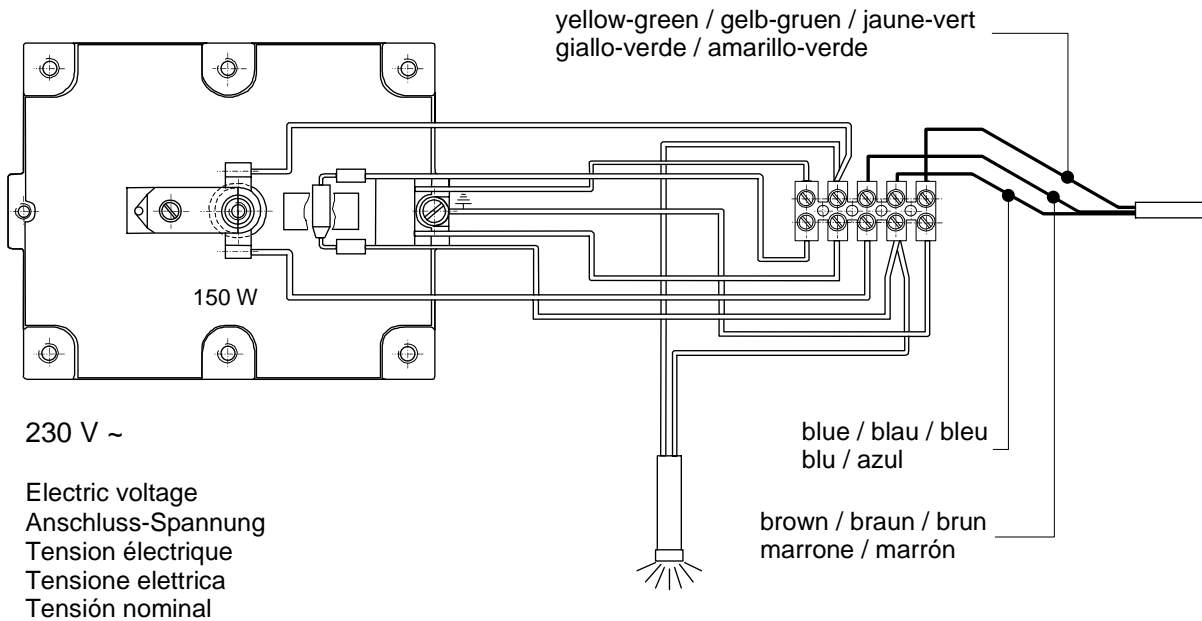
## 7. Technical data

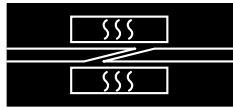
Max. belt width [mm] [ <i>in.</i> ] with 90° joining angle	100	4.0
Max. belt width [mm] [ <i>in.</i> ] with 75° joining angle	75	3.0
Max. belt width [mm] [ <i>in.</i> ] with 60° joining angle	45	1.8
Belt/tape thickness max. [mm] [ <i>in.</i> ]	6	0.24
Max. skiving length [mm] [ <i>in.</i> ]	85	3.3
Min. endless belt/tape length [mm] [ <i>in.</i> ]	375	15
Max. deviation of plate temperature [°C] [°F]	± 6	± 10.8
Heating up time to 120 °C / 248 °F [min.]	12	
Power consumption [W]	1 x 150	
Voltage [V~]	230 (PT-100/8) or 120 (PT-100/6)	
Dimensions (L x W x H) [mm] [ <i>in.</i> ]	285 x 128x 102	11 x 5 x 4
Net weight [kg] [ <i>lbs.</i> ]	2	4.4



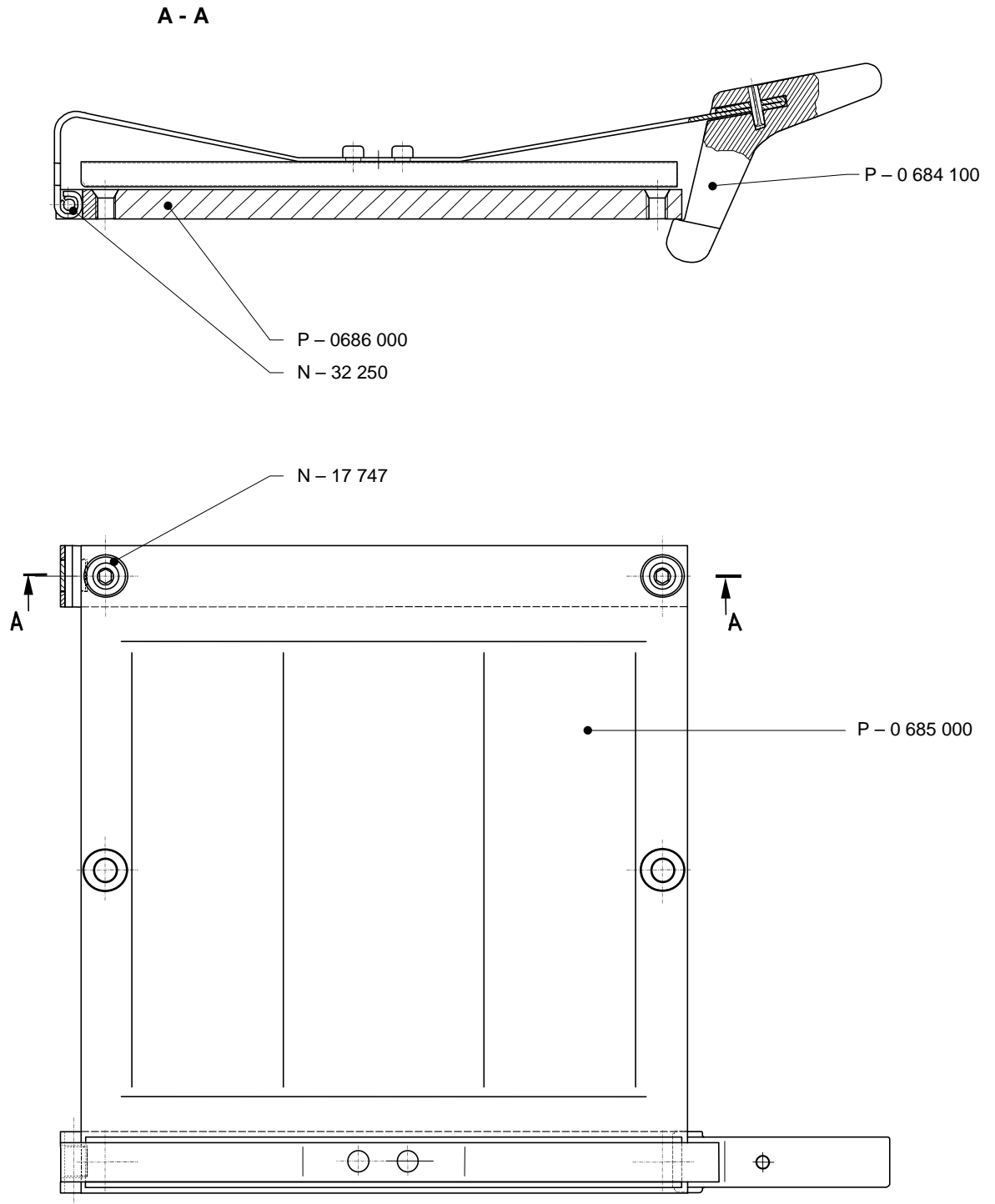
## 8. Drawings

### 8.1 Electrical connection



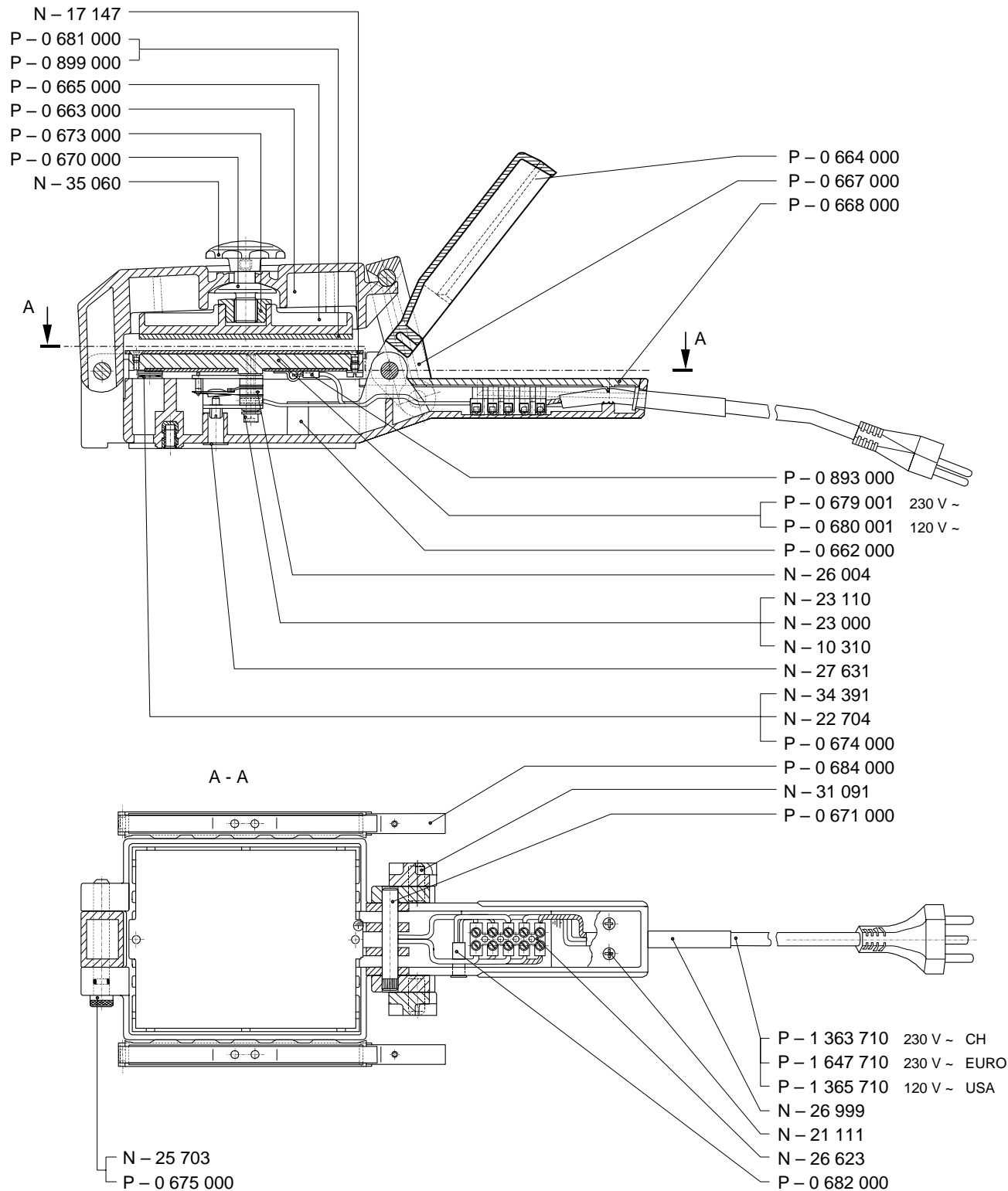


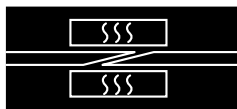
## 8.2 Set-up plate with spares numbers





### 8.3 Assembly drawing and spares numbers





**Checklist preventive maintenance  
Hot-pressing device PT-100**

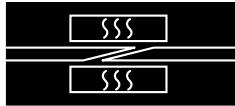


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**Responsible persons:**  
**A: Machine Operator**  
**B: Maintenance Technician**

Work to be carried out (see operating instructions No. 3618 for further information and reference numbers)	Daily	Performance periodically (monthly)		Remarks	Spares number Evaluation criterion
		1	6		
<b>1. Cleaning</b>					
1.1 Clean the press after use, remove residual deposits	A				
<b>2. Inspect the connector cable</b>					
2.1 Examine the cable and connector plug for defects		B			damaged insulation, defective couplings
<b>3. Measurement of the heater plate temperature</b>					
3.1 Proceed as detailed in operating instructions 3618, Section 5.2		B			

Remarks and notes:



**Machine type:**

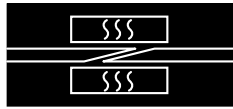
**Machine no.:**

**Date of first placing in operation:**

Actions to be performed – see checklist (daily work not recorded)	Next	Performed		Next	Performed		Next	Performed		Next	Performed	
	Check	Initials	Date	Check	Initials	Date	Check	Initials	Date	Check	Initials	Date
2.1 Inspect the cable for damage												
3.1 Measure the heater plate temperature												

**Observations, repairs:**





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

If the proper selection and application of Habasit products are not recommended by an authorized Habasit sales specialist, the selection and application of Habasit products, including the related area of product safety, are 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.

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