

## Instructions for Joining GTI and GGT Flat Drive Belts

1. Apply Cement K adhesive with a brush to the sanded polyamide (PA) surfaces. The adhesive should be applied in a thin layer.

The working time of Cement K adhesive is approximately 40–50 minutes at room temperature.

2. Approximately 15 minutes before the end of the Cement K working time, apply Vukoplast D 418 (DML 400) adhesive mixed with 5–10% Desmocol R hardener to the sanded rubber (G) surfaces.

Apply two coats:

- the first coat until dry
- the second coat until slightly tacky

3. Assemble the joint so that the individual layers align correctly, i.e.:

PA layer to PA layer, G layer to G layer

Place the secured joint into a heated pressing device and bond it under a minimum pressure of 0.5 MPa at a temperature of 90–100 °C for 30 minutes.

It is necessary to maintain a constant temperature during the process.

After heating, allow the belt to cool under pressure to a maximum temperature of approximately 30 °C.

Clean the joint from excess adhesive. The belt can then be fully loaded and put into operation.

