

7.0 Procedure for Mixing Usco 5680 Splicing Kits

- 7.1 Remove the rims from both the resin and curative cans. (Screw top curative cans, rims do not have to be removed.)
- 7.2 A hot air oven or a hot plate can be used to heat the resin and curative. Use a thermometer to assure the correct temperature of the resin and curative. Wipe off thermometer to avoid cross-contamination.

Ensure belt ends are dry. Any moisture in the fabric will result in the splice compound foaming due to the liberation of CO₂ and weaken the material.

Processing Data:

Resin Temp. 120°F - 135°F (49°C - 57°C)

Curative Temp. 120°F - 135°F (49°C - 57°C)

If the curative has been exposed to low temperatures during shipping or storage, the appearance may be putty-like or else there may be sand-line particles in the bottom of the can. Dip a stir stick into the bottom of the can, and if particles are evident on the stir stick, heat the curative 200°F - 212°F to re-melt the particles. Cool down the curative to 120°F - 135°F before mixing the resin. ⁴

N.B. Using lower temperatures give a longer working life, but the two components will be more viscous, and therefore, more difficult to mix. Higher temperature will facilitate easier mixing, but the mixed life will be reduced.

Mixed Life 10-20 minutes before it becomes too thick to pour or spread.

Cure 4 hours minimum @ 212°F (100°C) to achieve maximum physical properties.

Curing for less time or a cooler temperature may impair the repair/splice.

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- 7.3 With resin and curative at the correct temperatures, add the curative to the resin while stirring the resin, Avoid pouring the curative down the inside wall of the resin can.
- 7.4 Using the square-tipped wooden stirrer, thoroughly scrape the walls, bottom corners and bottom of the can.
- 7.5 Continue stirring and scraping for approximately 2-3 minutes to assure a homogenous mixture.
- 7.6 Discard the stirrer. Do not use it to scrape the urethane from the can or to apply the urethane to the belt.
- 7.7 Pour the liquid urethane from the cleanest inside wall of the can.