



2024 CAFA CONVENTION

MARCH 20 - 23, 2024 | SANDESTIN GOLF AND BEACH RESORT
MIRAMAR BEACH, FL



DIRONDAK SPECIALTY ADHESIVES, INC.

Coated Abrasive Belt Conversion Process

- Cut to length
- Scuffing / Skiving
- Adhesive application
- Tape application
- Pressing
- Slitting

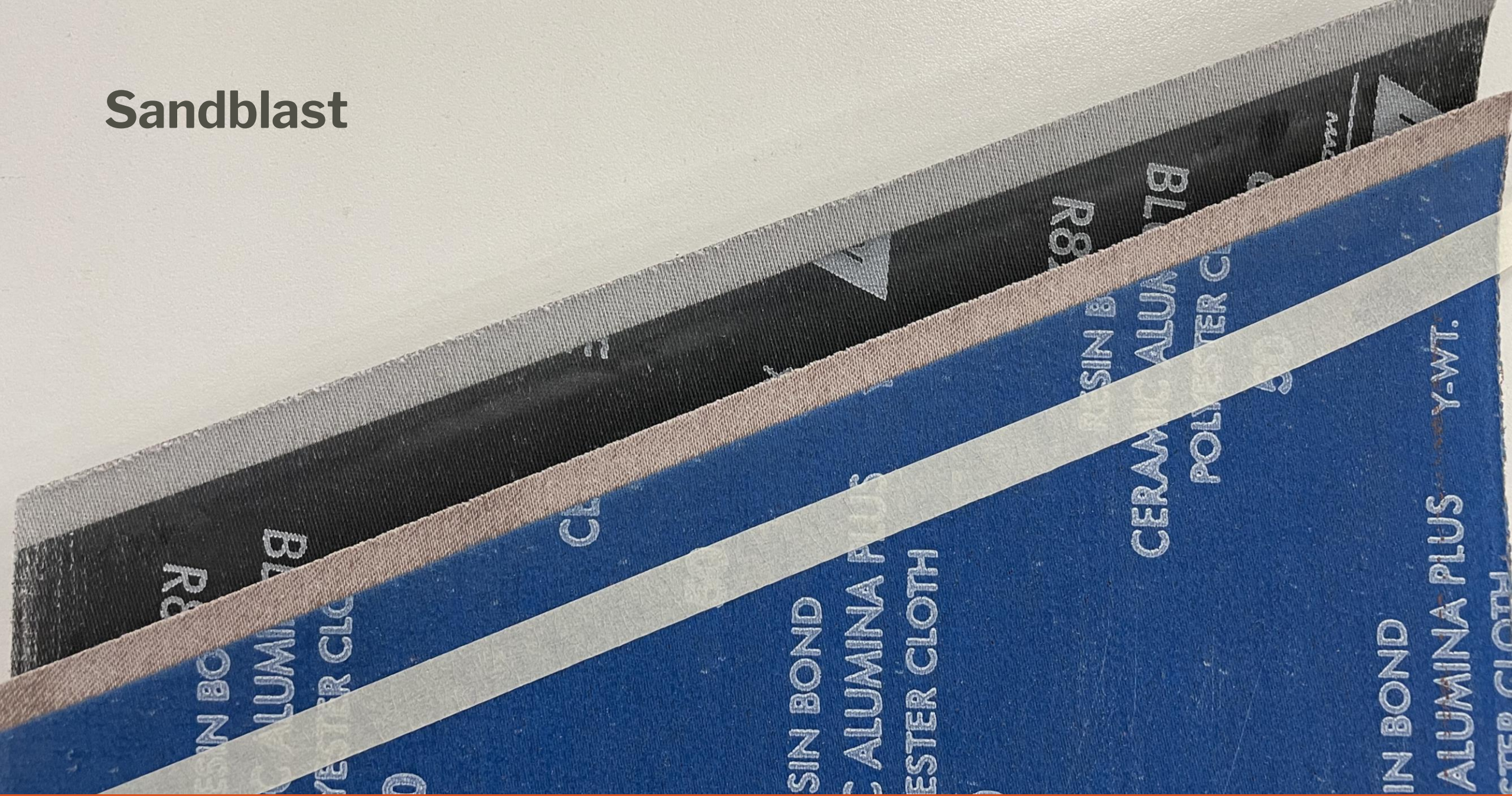
Cut to Length

- Clean cut
- Grain impaction

Scuffing / Skiving

- One of the most critical processes
- Depth of scuff
- Geometry of scuff
 - Width
 - Bevel
- Scuff Method
 - Coated abrasive belt
 - SCM belt
 - Wire wheel
 - Sand blast
 - Clean & strip wheel
 - Soft pulley for coarse grit
 - Combination of methods
 - Air clean out
- Scuff Depth
 - Too deep
 - Too shallow

Sandblast

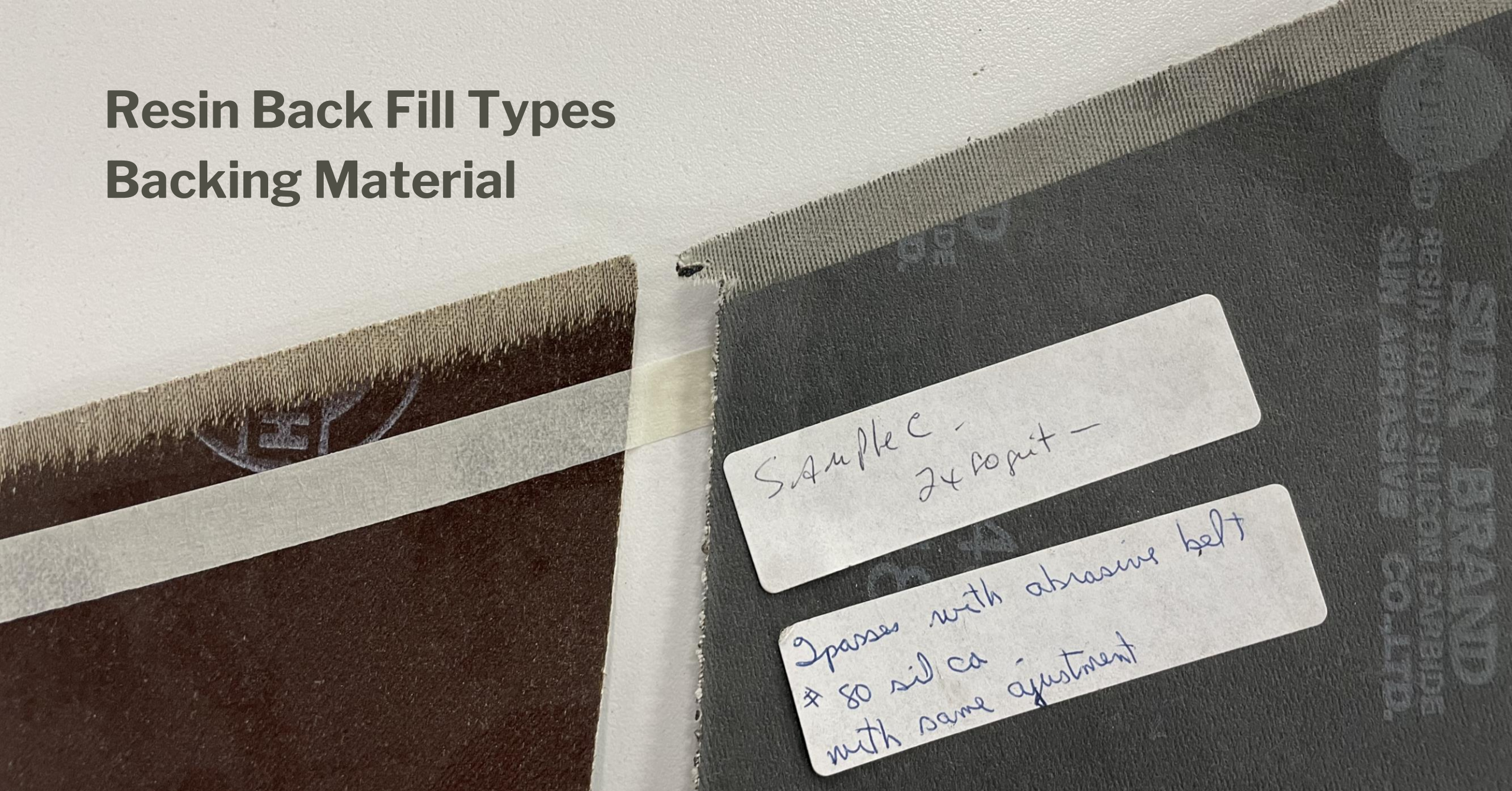




Inadequate Scuff

Resin Back Fill Types

Backing Material

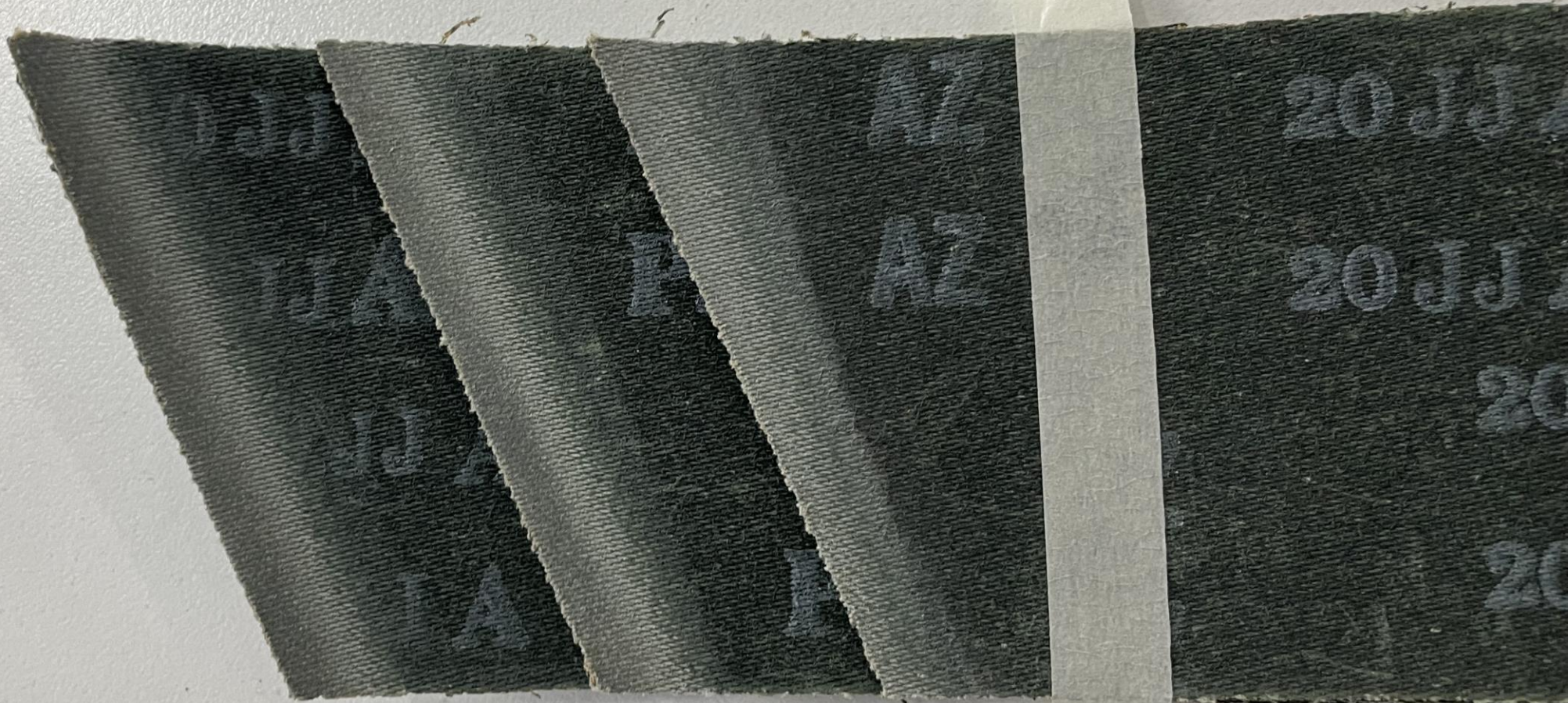


Sample C -
2x Rogit -

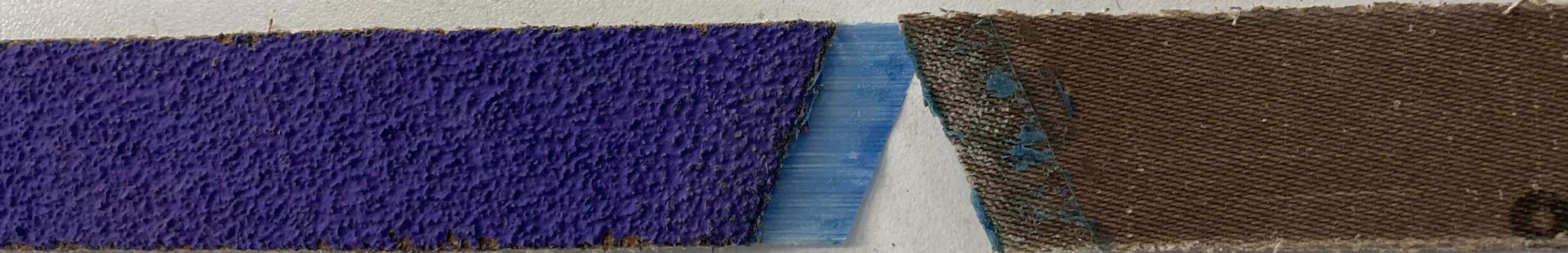
2 passes with abrasive belt
80 sil ca
with same adjustment

Scuff Consistency

- Depth
- Width



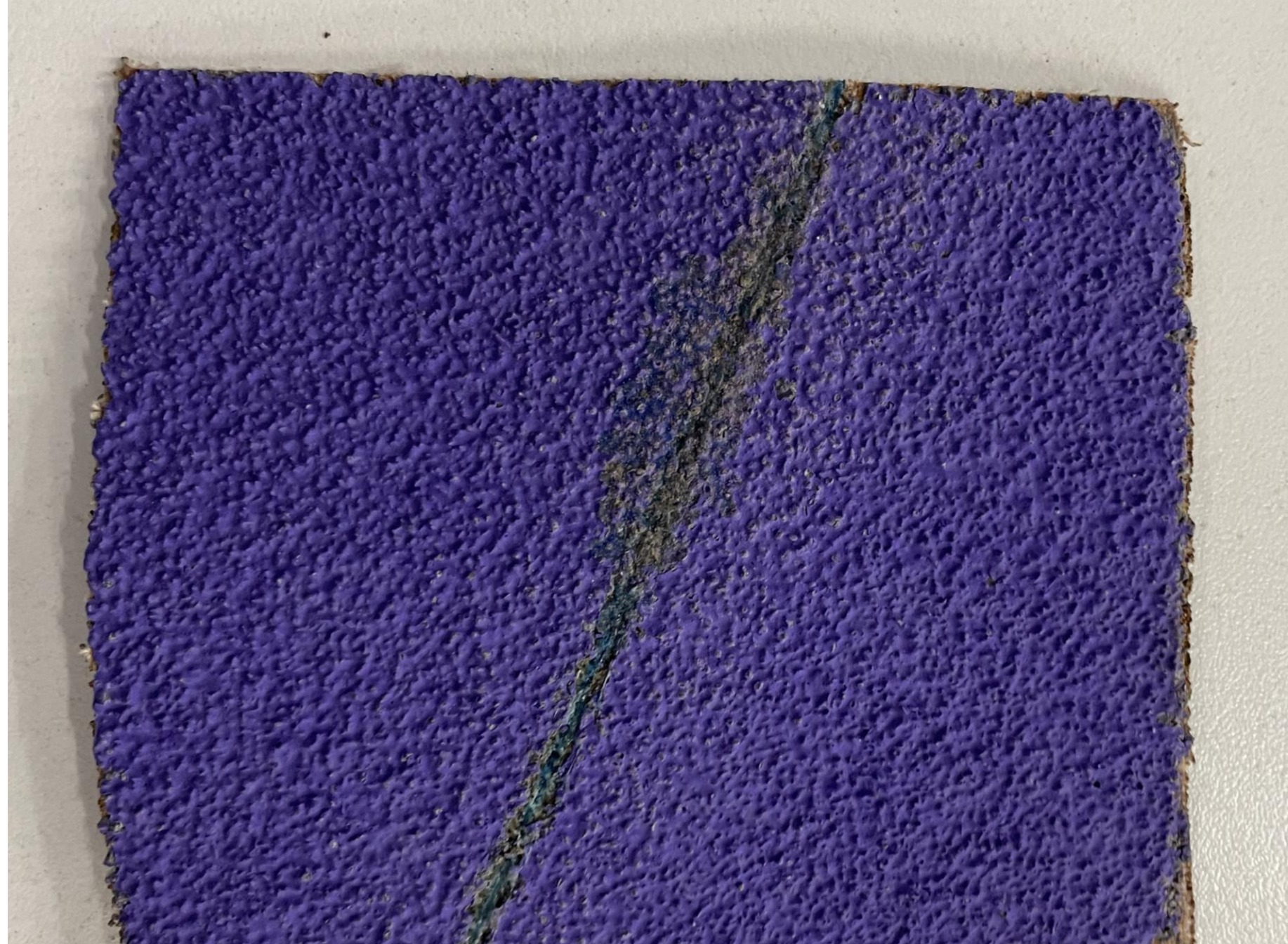
Inadequate Scuff



Adhesive Application

- Roller
- Spray
- Speed
- Adhesive quantity
- Drying temperature
- Drying time

Excessive Adhesive Application



Solvent Entrapment





Biko

Narrow Belts Productivity

Two-Stage Lap Processing



Biko

14

141

141X

141X1

141X2

141X3



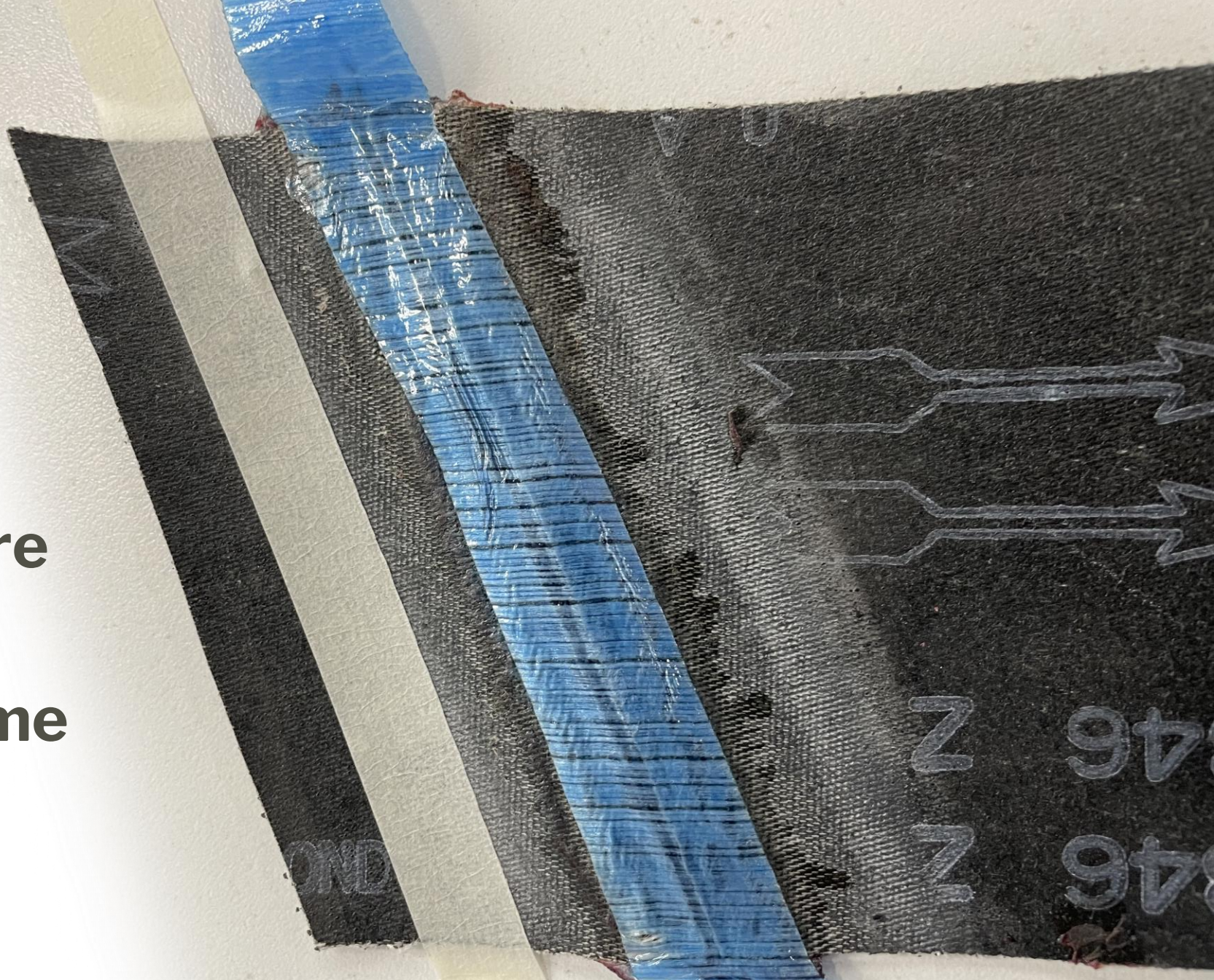
Biko

Produkt
Produkt

Adhesive Application / Pressing

- Tape alignment
- Bias standardization
- Bias offset ($\pm 7^\circ$)
- Bias vs. Material Yield
- Press time, temperature, pressure
- SCM material

Press Temperature
Press Time
Adhesive Cure Time



Press Misalignment



Miscellaneous

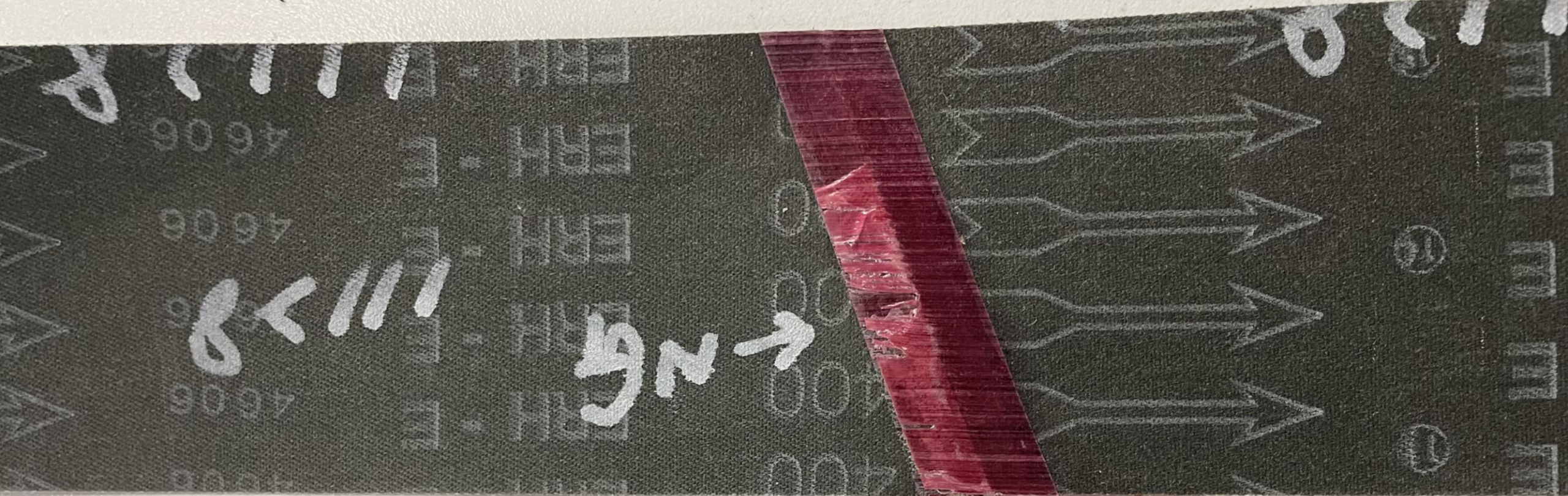
- Machine / back up platen failure
- Coated tape properties
 - Shelf life
 - Open time

Machine Issue



Wear Issue





Wear Issue

Backing Damage

- Machine
- Excessive Scuff





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