

Joining instruction*

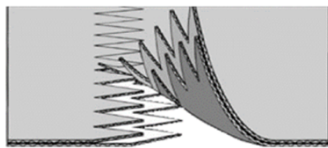


| | | | |
|-------------------------------|----------------------------|-----------------------|-----------------|
| Product identification | F 12/2 E V20FG / U0 | Article number | 20100058 |
|-------------------------------|----------------------------|-----------------------|-----------------|

Product group food conveyor belt

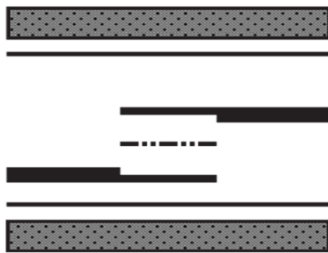
Endless joining

| | | | |
|---------------------|-----------------------|--|-----------|
| Recommended joining | double finger joining | | |
| Joining addition | 105 mm | | 4,13 inch |
| Length of fingers | 55 mm | | 2,17 inch |
| Width of fingers | 20 mm | | 0,79 inch |



Joining material

| | |
|---------------------------------|-----------------|
| Joining material conveying side | silicone pad FG |
| Joining material running side | silicone pad |
| Joining material inside | PVC foil |
| Additional material | no |



heating plate top
silicone pad FG
conveyor belt (conveying site up)
PVC foil
conveyor belt (conveying site up)
silicone pad
heating plate bottom

Joining parameters

| | | |
|----------------------------|--|--------|
| Heating temperature top | 165 °C | 329 °F |
| Heating temperature bottom | 165 °C | 329 °F |
| Heating time | 2 minutes | |
| Pressure | 1 bar | |
| Note | use same material for edge demarcation | |

Alternative joining methods

| | |
|----------------------------|------------------------|
| Finger joining alternative | single finger joining |
| Step joining | yes |
| Wedge joining | on request |
| Mechanical joining | yes A3 Alligator RS125 |

Notes on installation

Loosely assemble the conveyor belt and then tighten until it works seamlessly with full band loading. With no less than an elongation at fitting of 0.3%.

Technical status: 09/16

*mentioned parameters are based on experience in production of endless seamed belt with our tools. By using other tools the parameters can differ. Specifications subject to change without notice.