

# Joining instruction\*



Product identification

F 6/1 E U03N / U0

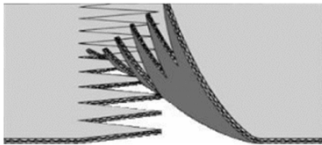
Article number 20200022

Product group

food conveyor belt

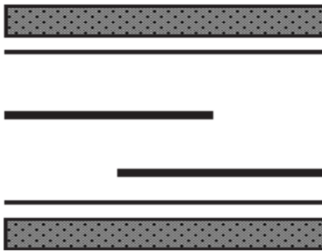
## Endless joining

Recommended joining	single finger joining
Joining addition	105 mm 4,13 inch
Length of fingers	70 mm 2,76 inch
Width of fingers	10 mm 0,39 inch



## Joining material

Joining material conveying side	release paper mat/silicone pad
Joining material running side	silicone pad
Joining material inside	no
Additional material	no



heating plate top  
release paper mat/silicone pad  
conveyor belt (conveying site up)  
conveyor belt (conveying site up)  
silicone pad  
heating plate bottom

## Joining parameters

Heating temperature top	150 °C	302 °F
Heating temperature bottom	150 °C	302 °F
Heating time	3 minutes	
Pressure	1 bar	
Note	use metal sheet (thickness plus 0.1 mm to belt thickness)	

## Alternative joining methods

Finger joining alternative	no
Step joining	no
Wedge joining	no
Mechanical joining	yes G001

## 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: 02/19

\*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.