

Joining instruction*

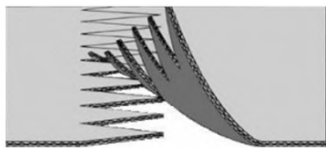


Product identification	F 3/1 E S03A / U0	Article number	20300001
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Product group	food conveyor belt
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Endless joining

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



Joining material

Joining material conveying side	teflon glass fabric smooth
Joining material running side	silicone pad
Joining material inside	PU foil
Additional material	Elastosil E43 N



heating plate top
 teflon glass fabric smooth
 Elastosil E43 N ²⁾
 conveyor belt (conveying site up)
 conveyor belt (conveying site up)
 PU foil ¹⁾
 teflon glass fabric structured + silicone pad
 heating plate bottom

Joining parameters

Heating temperature top	160 °C	320 °F
Heating temperature bottom	160 °C	320 °F
Heating time	2x3 minutes	
Pressure	2 bar	
Note	use same material for edge demarcation ¹⁾ first pressing ²⁾ second pressing	

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%. Reactive bonding(can be used after 12 hours)

Technical status: 11/22

*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.