

# Joining instruction\*

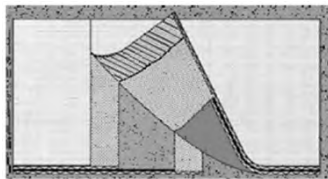


<b>Product identification</b>	<b>F 4/2 E S0 / S0</b>	<b>Article number</b>	<b>2030002</b>
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<b>Product group</b>	food conveyor belt
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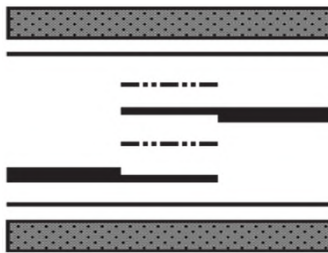
## Endless joining

Recommended joining	step joining 70°	
Joining addition	80 mm	3,15 inch
Length of fingers (or steps)	80 mm	3,15 inch
Width of fingers	mm	inch



## Joining material

Joining material conveying side	teflon glass fabric structured
Joining material running side	teflon glass fabric structured
Joining material inside	Elastosil E47
Additional material	Elastosil E43 N



heating plate top  
 teflon glass fabric structured  
 Elastosil E43 N <sup>2)</sup>  
 conveyor belt (conveying site up)  
 Elastosil E47 <sup>1)</sup>  
 conveyor belt (conveying site up)  
 teflon glass fabric structured  
 heating plate bottom

## Joining parameters

Heating temperature top	160 °C	320 °F
Heating temperature bottom	160 °C	320 °F
Heating time	2x2 minutes	
Pressure	5 bar	
Note	use same material for edge demarcation <sup>1)</sup> first pressing <sup>2)</sup> second pressing	

## Alternative joining methods

Finger joining alternative	double finger joining, staggered, be aware of silicon residue on running side
Step joining	yes
Wedge joining	no
Mechanical joining	yes G001 Alligator RS62

## 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.