

Joining instruction*

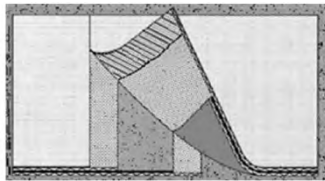


Product identification	F 12/2 ES 0 / V / 0	Article number	20400003
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Product group food conveyor belt

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		



Joining material

Joining material conveying side	silicone paper glossy
Joining material running side	silicone pad
Joining material inside	PU hotmelt foil
Additional material	no



heating plate top
release paper mat
conveyor belt (conveying site up)
PU hotmelt 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	5 bar	
Note	use metal sheet (thickness minus 0.2 mm to belt thickness)	

Alternative joining methods

Finger joining alternative	double finger joining
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%.

Technical status: 03/23

*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.