

Joining instruction*

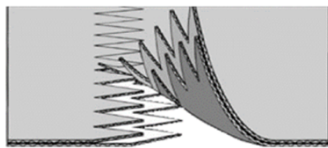


| | | | |
|-------------------------------|------------------------------|-----------------------|-----------------|
| Product identification | S 12/2 E V10N / U0 FR | Article number | 20100012 |
|-------------------------------|------------------------------|-----------------------|-----------------|

| | |
|----------------------|------------------------|
| Product group | standard conveyor belt |
|----------------------|------------------------|

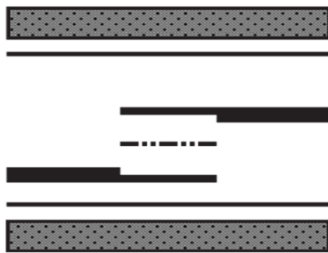
Endless joining

| | | |
|---------------------|-----------------------|-----------|
| 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 | release paper mat |
| Joining material running side | silicone pad |
| Joining material inside | PVC foil |
| Additional material | no |



| |
|-----------------------------------|
| heating plate top |
| release paper mat |
| 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 | 3 minutes | |
| Pressure | 1 bar | |
| Note | use metal sheet (thickness minus 0.2 mm to belt thickness) | |

Alternative joining methods

| | |
|----------------------------|-------------------------|
| Finger joining alternative | single finger joining |
| Step joining | yes |
| Wedge joining | on request |
| Mechanical joining | yes G002 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: 01/19

*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.