

# Joining instruction\*

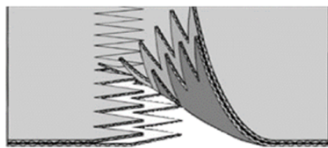


<b>Product identification</b>	<b>S 8/2 E V05H / U0</b>	<b>Article number</b>	<b>20100041</b>
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<b>Product group</b>	special conveyor belt
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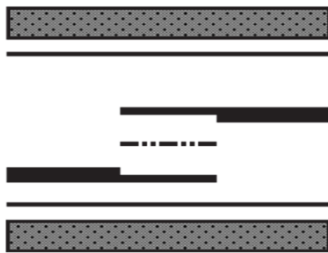
## Endless joining

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	glue: mix HELMITIN GPV-S + HELMITIN 49631 (5%)



heating plate top  
 release paper mat  
 conveyor belt (conveying site up)  
 PVC foil/apply glue on both sides  
 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 same material for edge demarcation	

## 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.