

Joining instruction*

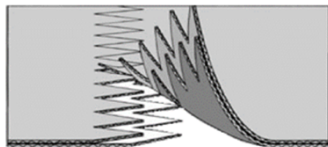


Product identification	S 12/2 E UM10 / V / U0	Article number	20200002
-------------------------------	-------------------------------	-----------------------	-----------------

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

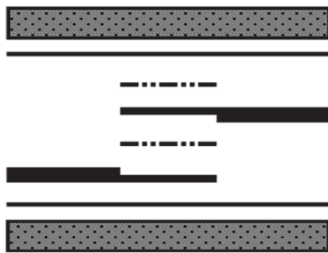
Endless joining

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	silicone pad
Joining material running side	silicone pad
Joining material inside	PVC foil white
Additional material	PU foil black (2x)



heating plate top
 S 12/2 E UM10/V/U0 // silicone paper mat
 PU-foil black
 conveyor belt (conveying site up)
 PVC foil white
 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	4 minutes	
Pressure	1 bar	
Note	use same material for edge demarcation	

Alternative joining methods

Finger joining alternative	single finger joining
Step joining	no
Wedge joining	no
Mechanical joining	yes A2 Alligator RS125

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: 02/19

*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.