

Joining instruction*

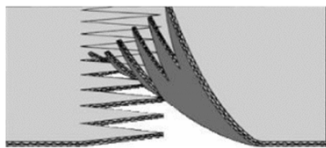


Product identification	Nonwoven 25 HC	Article number	20500001
-------------------------------	-----------------------	-----------------------	-----------------

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

Endless joining

Recommended joining	single finger joining	
Joining addition	105 mm	4,13 inch
Length of fingers	70 mm	2,76 inch
Width of fingers	10 mm	0,39 inch



Joining material

Joining material conveying side	silicone pad
Joining material running side	silicone pad
Joining material inside	3x PU hotmelt foil
Additional material	no



heating plate top
silicone pad



conveyor belt (conveying site up)
3x PU hotmelt foil
conveyor belt (conveying site up)
silicone pad
heating plate bottom

Joining parameters

Heating temperature top	160 °C	320 °F
Heating temperature bottom	160 °C	320 °F
Heating time	2 minutes	
Pressure	1 bar	
Note	split the material and put in 3 hotmelt foils, use metal sheet (thickness = belt thickness)	

Alternative joining methods

Finger joining alternative	no
Step joining	no
Wedge joining	on request
Mechanical joining	yes G002 A40 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: 03/19

*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.