

# Joining instruction\*

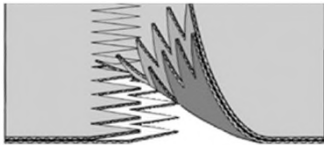


<b>Product identification</b>	<b>S 12/2 E G50AR / U / U01</b>	<b>Article number</b>	<b>20700004</b>
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**Product group** special conveyor and process belt

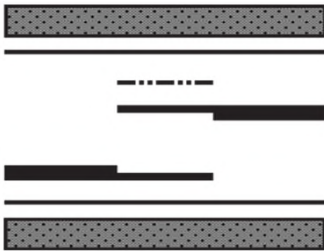
## Endless joining

Recommended joining	double finger joining	
Joining addition	105 mm	4,13 inch
Length of fingers (or steps)	55 mm	2,17 inch
Width of fingers	20 mm	0,79 inch



## Joining material

Joining material conveying side	F 12/2 E V20A / U0 as embossing mat
Joining material running side	silicone pad
Joining material inside	no
Additional material	teflon spray



heating plate top  
F 12/2 E V20A / U0  
teflon spray  
conveyor belt (conveying site up)

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	4 minutes	
Pressure	1,5 bar	
Note	before welding apply Teflon spray onto the rubber, don't let the spray get into the split, use same material for edge demarcation	

## Alternative joining methods

Finger joining alternative	no
Step joining	no
Wedge joining	on request
Mechanical joining	yes A2, A3, A40

## Notes on installation

Remove the tape at < 60 ° C. 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: 12/22

\*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.