

Joining instruction*

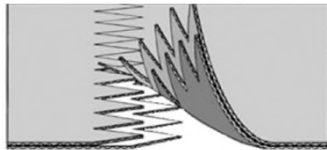


Product identification	S 8/2 E U01N / U0	Article number	20200001
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Product group	standard conveyor belt
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Endless joining

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	release paper mat
Joining material running side	silicone pad
Joining material inside	no
Additional material	glue: mix HELMITIN GPV-S + HELMITIN 49631 (5%)



heating plate top
release paper mat
conveyor belt (conveying site up)
apply glue on both sides
conveyor belt (conveying site up)
silicone pad
heating plate bottom

Joining parameters

Heating temperature top	150 °C	302 °F
Heating temperature bottom	150 °C	302 °F
Heating time	2 minutes	
Pressure	1 bar	
Note	flash off glue for about 15 min, 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 G00

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: 03/24

*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.