

# Joining instruction\*

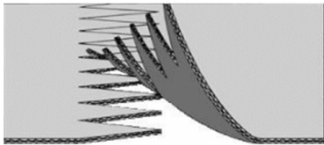


**Product identification** F 4/2 B 0 / U / 0 **Article number** 20400029.2

**Product group** food 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	no
Additional material	no



heating plate top  
silicone pad



conveyor belt (conveying site up)



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	6 minutes	
Pressure	1.5 bar	
Note	use metal sheets (same thickness) or same material	

## Alternative joining methods

Finger joining alternative	no
Step joining	no
Wedge joining	no
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: 04/20

\*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.