

# Joining instruction\*

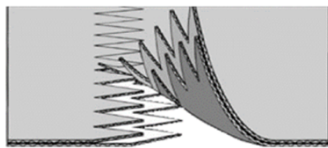


<b>Product identification</b>	<b>S 12/2 E V33L / U0</b>	<b>Article number</b>	<b>20100238</b>
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**Product group** special conveyor belt

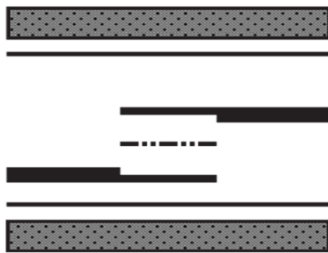
## Endless joining

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 L
Joining material running side	silicone pad
Joining material inside	PVC foil
Additional material	no



heating plate top  
silicone pad L

conveyor belt (conveying site up)  
PVC foil  
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	5 minutes	
Pressure	1 bar	
Note	use metal sheet (thickness minus 0.2 mm to belt thickness)	

## Alternative joining methods

Finger joining alternative	single finger joining
Step joining	yes
Wedge joining	on request
Mechanical joining	yes A3 Alligator RS187

## 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: 06/18

\*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.