

# Joining instruction\*

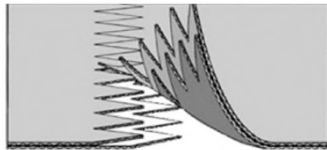


<b>Product identification</b>	<b>S 12/2 E V30ST / U0</b>	<b>Article number</b>	<b>20100046</b>
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**Product group** special conveyor belt

## Endless joining

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



## Joining material

Joining material conveying side	silicone pad ST
Joining material running side	silicone pad
Joining material inside	PVC foil
Additional material	no



heating plate top  
silicone pad ST  
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 A4 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: 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.