

# Joining instruction\*

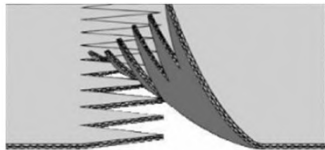


|                               |                           |                       |                 |
|-------------------------------|---------------------------|-----------------------|-----------------|
| <b>Product identification</b> | <b>F 2/1 E U01N / U01</b> | <b>Article number</b> | <b>20200019</b> |
|-------------------------------|---------------------------|-----------------------|-----------------|

**Product group** food conveyor belt

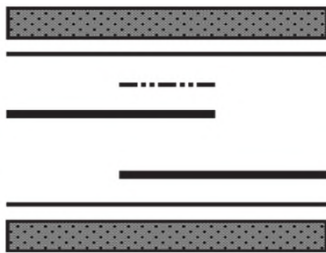
## Endless joining

|                              |                       |           |
|------------------------------|-----------------------|-----------|
| Recommended joining          | single finger joining |           |
| Joining addition             | 105 mm                | 4,13 inch |
| Length of fingers (or steps) | 70 mm                 | 2,76 inch |
| Width of fingers             | 10 mm                 | 0,39 inch |



## Joining material

|                                 |                                |
|---------------------------------|--------------------------------|
| Joining material conveying side | release paper mat              |
| Joining material running side   | release paper mat/silicone pad |
| Joining material inside         | PU foil transparent            |
| Additional material             | no                             |



heating plate top  
release paper mat  
PU foil transparent  
conveyor belt (conveying site up)

conveyor belt (conveying site up)  
release paper mat/silicone pad  
heating plate bottom

## Joining parameters

|                            |  |        |
|----------------------------|--|--------|
| Heating temperature top    | 150 °C                                 | 302 °F |
| Heating temperature bottom | 150 °C                                 | 302 °F |
| Heating time               | 3 minutes                              |        |
| Pressure                   | 1 bar                                  |        |
| Note                       | use same material for edge demarcation |        |

## Alternative joining methods

|                            |         |
|----------------------------|---------|
| Finger joining alternative | no      |
| Step joining               | no      |
| Wedge joining              | no      |
| 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.