

Joining instruction*

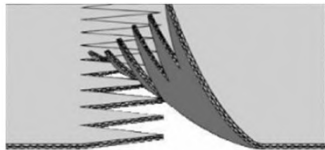


Product identification	F 5/2 E S03A / U0	Article number	20300004
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Product group food conveyor belt

Endless joining

Recommended joining	single finger joining	
Joining addition	95 mm	3,74 inch
Length of fingers (or steps)	80 mm	3,15 inch
Width of fingers	10 mm	0,39 inch



Joining material

Joining material conveying side	teflon glass fabric smooth
Joining material running side	silicone pad
Joining material inside	PU foil
Additional material	Elastosil E43 N



heating plate top
 teflon glass fabric smooth
 Elastosil E43 N²⁾
 conveyor belt (conveying site up)
 conveyor belt (conveying site up)
 PU foil ¹⁾
 teflon glass fabric structured + silicone pad
 heating plate bottom

Joining parameters

Heating temperature top	160 °C	320 °F
Heating temperature bottom	160 °C	320 °F
Heating time	2x3 minutes	
Pressure	2 bar	
Note	use same material for edge demarcation ¹⁾ components for first pressing ²⁾ components for second pressing	

Alternative joining methods

Finger joining alternative	double finger joining
Step joining	yes
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%. Reactive bonding(can be used after 12 hours)

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.