

Joining instruction*



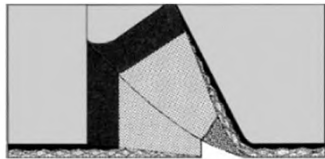
Product identification	Nonwoven 60 HC	Article number	20500003
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Product group	standard conveyor belt
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Endless joining

Recommended joining	wedge joining	
Joining addition	100 mm	3,94 inch
Length of fingers (or steps)		
Width of fingers		

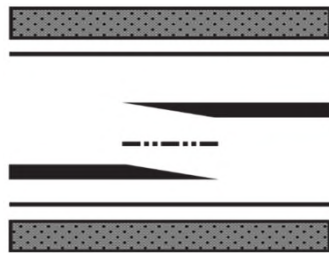
wedge joining
100 mm 3,94 inch



Joining material

Joining material conveying side	silicone paper glossy
Joining material running side	silicone pad
Joining material inside	PU hotmelt foil
Additional material	no

silicone paper glossy
silicone pad
PU hotmelt foil
no



heating plate top
silicone paper glossy

conveyor belt (conveying site up)
PU hotmelt foil
conveyor belt (conveying site up)
silicone pad
heating plate bottom

Joining parameters

Heating temperature top	160 °C	320 °F
Heating temperature bottom	160 °C	320 °F
Heating time	2 minutes	
Pressure	1 bar	
Note	use metal sheet (thickness = belt thickness)	

160 °C 320 °F
160 °C 320 °F
2 minutes
1 bar
use metal sheet (thickness = belt thickness)

Alternative joining methods

Finger joining alternative	no
Step joining	no
Wedge joining	on request
Mechanical joining	yes A4 Alligator RS187

no
no
on request
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.