

# Joining instruction\*

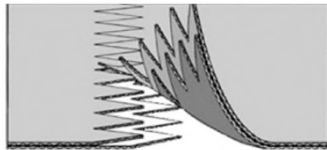


|                               |                                 |                       |                   |
|-------------------------------|---------------------------------|-----------------------|-------------------|
| <b>Product identification</b> | <b>S 12/2 E G50AR / U / U01</b> | <b>Article number</b> | <b>20700004.2</b> |
|-------------------------------|---------------------------------|-----------------------|-------------------|

**Product group** special conveyor and process belt

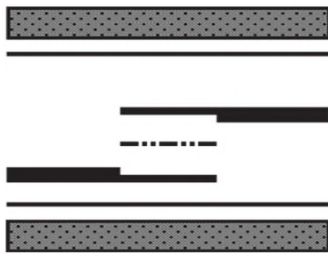
## Endless joining

|                              |                       |  |           |
|------------------------------|-----------------------|--|-----------|
| 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 | teflon glass fabric smooth                                |
| Joining material running side   | teflon glass fabric smooth                                |
| Joining material inside         | glue: mix HELMITIN GPV-S + Vernetzer HELMITIN 49631 (10%) |
| Additional material             | no  |



heating plate top  
teflon glass fabric smooth

conveyor belt (conveying site up)  
glue: mix HELMITIN GPV-S + Vernetzer HELMITIN 49631 (10%)  
conveyor belt (conveying site up)  
teflon glass fabric smooth  
heating plate bottom

## Joining parameters

|                            |  |        |
|----------------------------|--|--------|
| Heating temperature top    | 125 °C   | 257 °F |
| Heating temperature bottom | 125 °C   | 257 °F |
| Heating time               | 5 minutes  |        |
| Pressure                   | 1,5 bar  |        |
| Note                       | Apply glue on both sides and allow adhesive to evaporate for a short time. Use same material for edge demarcation. |        |

## Alternative joining methods

|                            |            |
|----------------------------|------------|
| Finger joining alternative | no         |
| Step joining               | no         |
| Wedge joining              | on request |
| Mechanical joining         | yes A40    |

## Notes on installation

Remove the tape at < 60 ° C. 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.