

## Basic instructions for jointing transporting belts

- 1** Measure necessary length of belts. In to this measure add one times length of join. According to the thickness, we recommend 40 up to 100 mm length of join.
- 2** Both end of belt grind down by hand or by machine in to the scotch, that after application at each other was thickness of join same as thickness of belt. Both grind down ends must be absolutely clean. Is possible clean them by e.g. petrol, acetone, ethyl acetate.
- 3** We strongly recommend, if is possible know exactly duration of belts before order, apply accomplishment in "Ready for join". In this case is mentioned just plain length. Size of join, will than add by producer himself. In this case you will miss point no. 2 in this manual.
- 4** Prepared grind down ends will be than coat by glue which is product on REKO LTD. "SADA TRANS". This glue is provided in 700, 325 and 85g packages. Glue is ready in a moment and will be ready for use after mixed component D 418 and hardener U 7000 together in proportion 5 up to 10 % hardener on weight of glue. Endurance of this way prepared glue is for approximately 8 hours. It is possible mixed it with ethyl acetate acetone.  
Apply on belt two times in thin layers. Is necessary wait with first layer up to entire dry, second layer of glue up to gently sticky status. Advice: adhesives include dissolvent which are flammable of 1. Class.
- 5** Join tag together at each other (watch exact linearity) and put into the press machine. It is possible used for example shaved beam and as well as squeeze them by carpentry clamp. Let it dry this way minimally 24 hours. After removing is recommended let it incubate more or less one day. Join after that clean up of rest of adhesives and belt is ready for use.
- 6** Whole process of joining is possible make faster by pressing belt in heatinsulated press machine and keep temperature more or less 90 °C. Time of pressing is than 2 hours and than let belt in press machine up to become cold. Whole process is possible to make faster by hot, for example hot air. More in point 5 in this manual.
- 7** With advantage is possible used joining with stainless steel clip, which are provided by REKO LTD. More about joining technologies in our technical documentation.
- 8** In case of some incomprehension feel free contact us personally or by phone.

If interested in, do not hesitate to contact us:

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