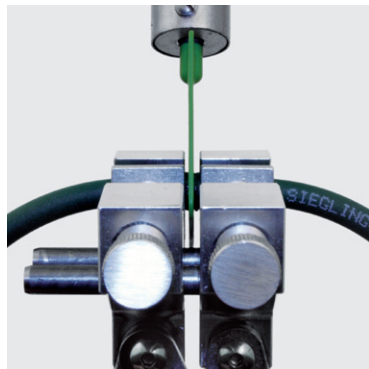


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Endless joint for  
Forbo Siegling  
TRANSILON round belts



**Endless joint for Forbo Siegling TRANSILON round belts**

**Bienefeld GmbH & Co. KG**

Ütterlingser Straße 20

58791 Werdohl

Phone: +49 (0)23 92/93 93-0

Fax: +49 (0)23 92/15 07

E-Mail: [info@bienefeld-gmbh.de](mailto:info@bienefeld-gmbh.de)

Internet: [www.bienefeld-gmbh.de](http://www.bienefeld-gmbh.de)

- 1 Cut the TRANSILON round belt to length with the special scissors (Fig. 1), paying attention to achieving perpendicular cut faces.

Since material will be melted off, the TRANSILON round belt should be cut longer than the desired final length by the joint addition of approx. 3 mm (notch 1) or approx. 6 mm (notch 2).

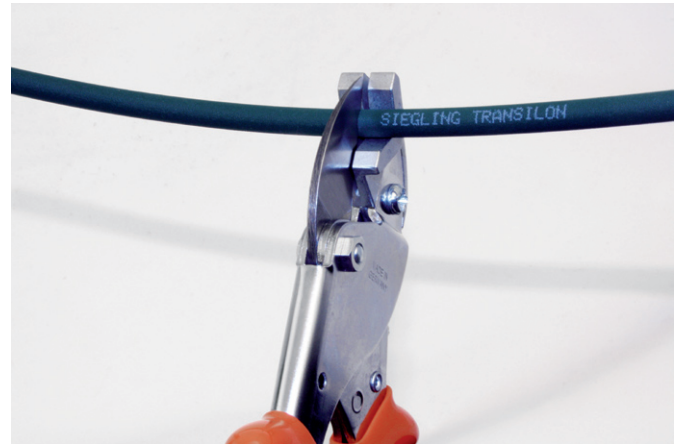


Fig. 1

- 2 Bolt the soldering iron holding device to a table, work bench or similar; secure the soldering iron with the welding bit mounted to it in such a way that the welding bit is vertical (Fig. 2).

Heat up the soldering iron for approx. 8 minutes. The correct welding temperature is 230 °C and has been reached when doughy melted surfaces come about at the ends of the round belt. The welding temperature is too high if the material forms blisters or if melted material drips off.

- To achieve a lower temperature: Draw the welding bit further out from the soldering iron
- To achieve a higher temperature: Insert the welding bit deeper into the soldering iron.

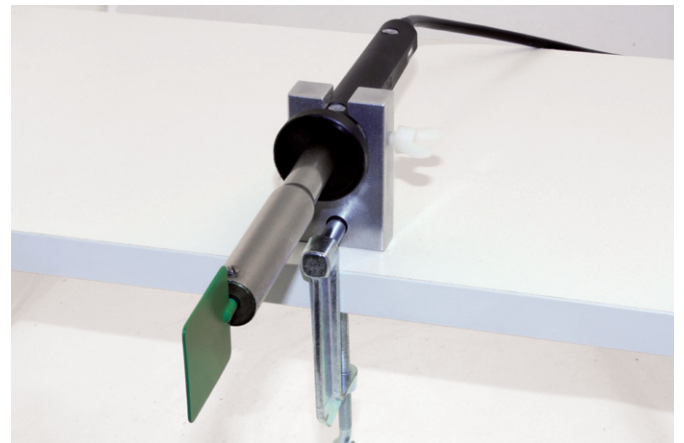


Fig. 2

- 3 Welding the ends of the round belt with the Bienefeld round belt jointing clamp:

Engage the bar for the pressure setting as follows:

- Setting 1 for round belts of 3 to 6 mm diameter notch 1 (Fig. 3)

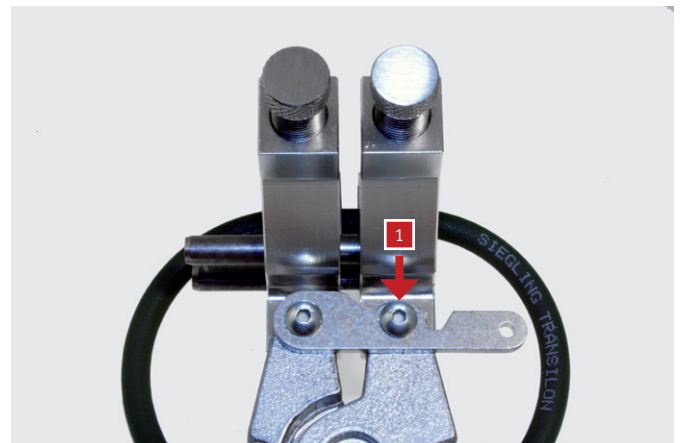


Fig. 3

- 4 • Setting 2 for round belts of 7 to 15 mm diameter notch 2 (Fig. 4)

Insert the ends of the round belt in the jointing clamp in such a way that the cut surfaces touch each other in the middle of the clamp opening.

Clamp the ends of the belt with the clamping screws manually.

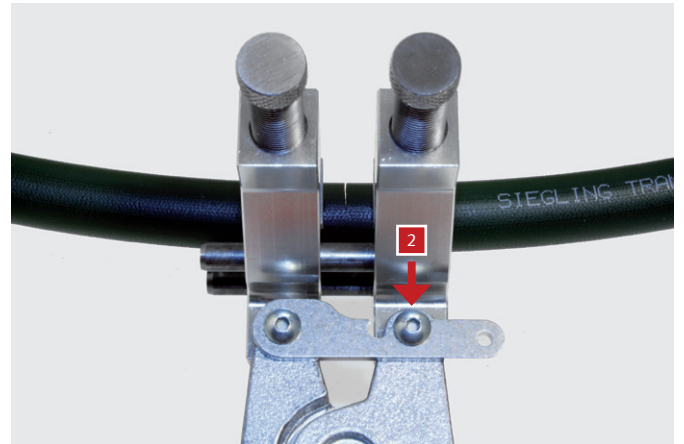


Fig. 4

- 5 Press the handle of the jointing clamp together to such an extent that the bar disengages and a gap is created between the ends of the belt.

Push the open jointing clamp over the welding bit in such a way that the ends of the round belt are positioned as far as possible centrally above the welding bit (Fig. 5). Open the handle of the jointing clamp slowly and melt the round belt.

When the ends have melted sufficiently, open the jointing clamp rapidly, draw it away from the welding bit and join the ends of the belt together by the spring pressure.

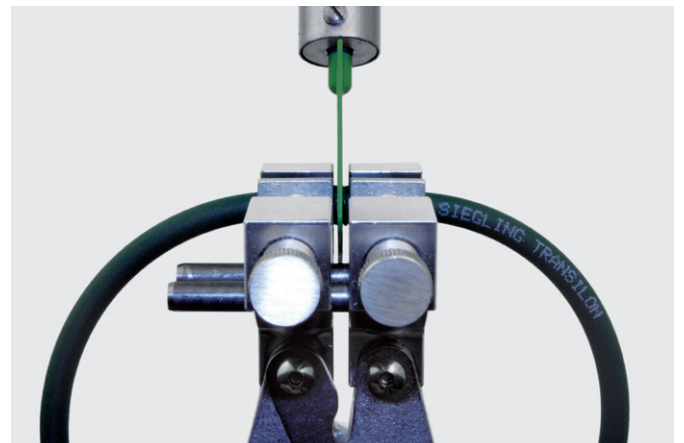


Fig. 5

- 6 TIP: The melting process can be observed better if the jointing clamp is turned! (Fig. 6)

**WARNING: Melting generates vapours hazardous to health! Ensure adequate ventilation. Do not inhale the vapours!**

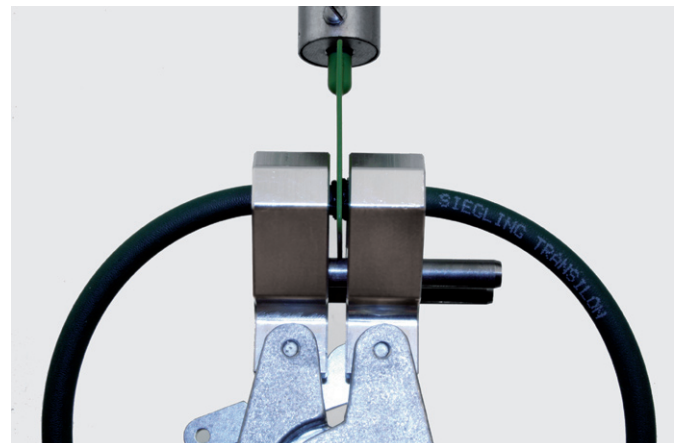


Fig. 6

- 7 Allow the welded joint to cool down for approx. 3 minutes (Fig. 7) (with belts  $\geq 8$  mm diameter, support this process with cold water).

Never bend or stretch the belt when it is still warm.

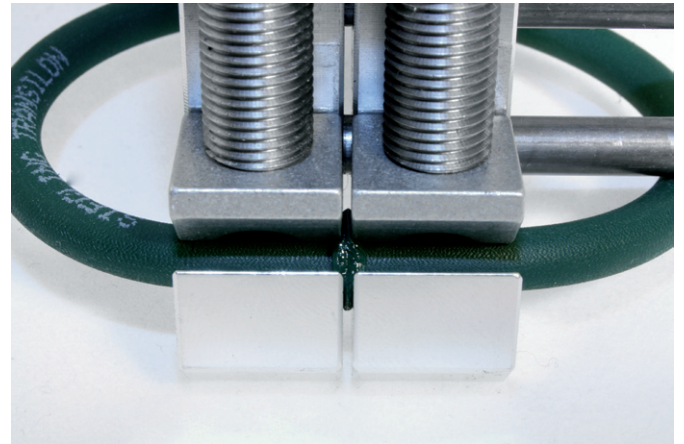


Fig. 7

- 8 Cut off the welding bead (Fig. 8) or grind it off with a sanding disk. In addition the welded joint can be smoothed with the welding bit.

Clean the welding bit only with cotton cloths.

**Bienefeld supplies round belts, devices and accessories ex stock.**



Fig. 8