### Jointing Recommendations

#### NITTA BELT TYPE: 2 SRAFP 02/W2 IM

**FINGER JOINT**
- Recommended
- Preparations
- Foil on top: PU white soft

**FINGER-OVERLAP-FINGER JOINT**
- Possible
- Preparations
- Foil between: PU white soft

#### STEPPED JOINT
- Not advised
- Preparations

<table>
<thead>
<tr>
<th>Length of joint</th>
<th>-</th>
<th>mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>Insert length IL</td>
<td>-</td>
<td>mm</td>
</tr>
<tr>
<td>Overlap length</td>
<td>-</td>
<td>mm</td>
</tr>
</tbody>
</table>

**BELT FASTENER**
- Type: A2-G002-RS62

#### WATER-COOLED PRESS

<table>
<thead>
<tr>
<th>Press temperatures</th>
<th>Pressure (bar)</th>
<th>Dwell-time (Minutes)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Top 155 °C (311 °F)</td>
<td>125 °C (257 °F)</td>
<td>60 °C (140 °F)</td>
</tr>
<tr>
<td>Thermo-couple 140 °C (284 °F)</td>
<td>125 °C (257 °F)</td>
<td>60 °C (140 °F)</td>
</tr>
<tr>
<td>Bottom 125 °C (257 °F)</td>
<td>60 °C (140 °F)</td>
<td></td>
</tr>
<tr>
<td>Cooling 60 °C (140 °F)</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

**Building sequence in water-cooled press:**
- Top element
- Fibre glass board
- SL-80 silicone cloth
- Prepared joint
- SL-80 silicone cloth
- Fibre glass board
- Bottom element

**Special Instructions:**
Prepare joint with siliconized tape on bottom

#### AIR-COOLED PRESS

<table>
<thead>
<tr>
<th>Press temperatures</th>
<th>Pressure (bar)</th>
<th>Dwell-time (Minutes)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Top 155 °C (311 °F)</td>
<td>125 °C (257 °F)</td>
<td>60 °C (140 °F)</td>
</tr>
<tr>
<td>Thermo-couple 140 °C (284 °F)</td>
<td>125 °C (257 °F)</td>
<td>60 °C (140 °F)</td>
</tr>
<tr>
<td>Bottom 125 °C (257 °F)</td>
<td>60 °C (140 °F)</td>
<td></td>
</tr>
<tr>
<td>Cooling 60 °C (140 °F)</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

**Building sequence in air-cooled press:**
- Top element
- SL-80 silicone cloth
- Prepared joint
- SL-80 silicone cloth
- Fibre glass board
- Bottom element

Date of issue 07-04-2020

---

This sheet must be considered as a guideline only. Every jointing press is different and may call for different press settings.
Nitta Corporation of Holland B.V. recommends therefore that every operator makes his own test joints with his equipment and determines the final jointing data based on these tests.