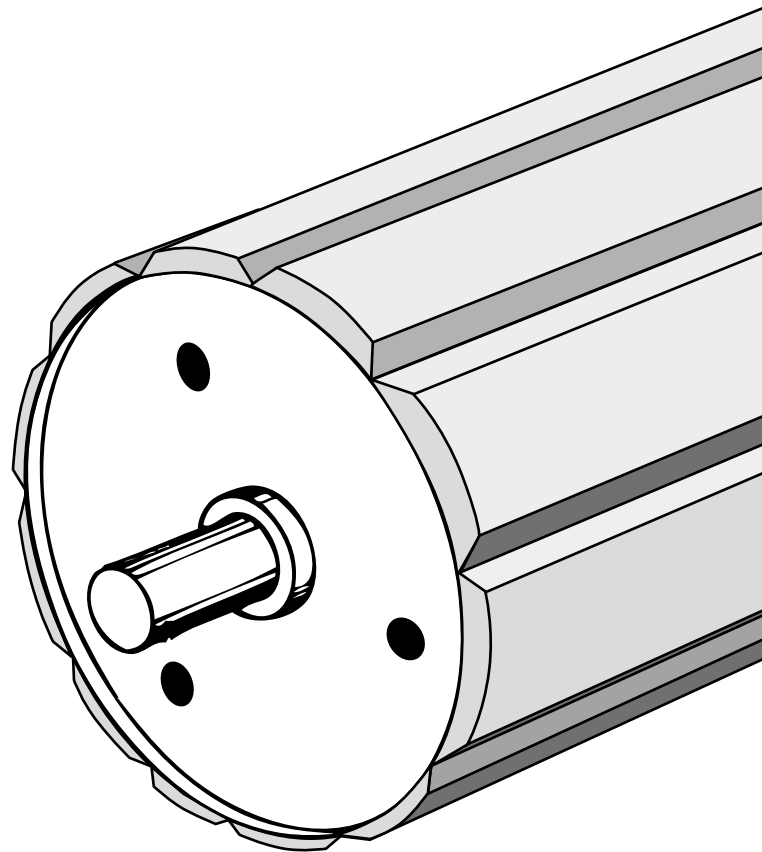




NILOS

Instructions for rubber cylinder coatings with rubber/ ceramic covering strips



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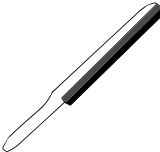
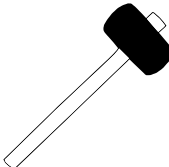
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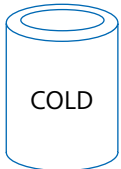
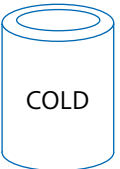

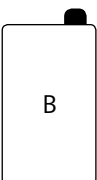


Material requirements

Material	Item no.	Material	Item no.	Material	Item no.
	K 0605 Cobbler's knife		K 0604 Saddler knife		K 0482 Stop bracket
	K 0661 + K 0661A Chalked string with powder		K 0609 Angled blade		K 0634 Whetstone with wooden handle
	H 0612 Knurled roller		K 0615 Flat roller		K 0628 Rubber hammer
	K0791-A Angle grinder for working steel		(For item no. see page 19 of tool catalogue) Fibre discs		K 0626 Brush
	K0792-A + K0731 Rotary sander for working rubber		K 0747 / 62 / 61 Wheel wire brush		K 0658 Safety goggles
	K 0627 Hand brush		K 0624 Folding rule		X 2901012 Rubber cylinder covering strips
	X 2801012 Cylinder covering strips Ceramic/rubber		For item no. see page 9 Cylinder covering strips Ceramic/rubber		


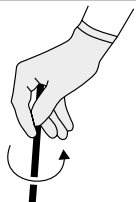
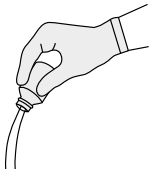


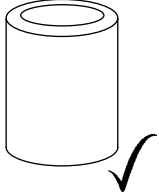
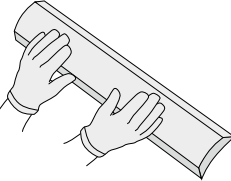
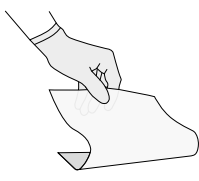
Instructions for rubber cylinder coatings with rubber/ceramic covering strips



Material requirements and legend

Material	Item no.	Material	Item no.	Material	Item no.
	H 0050-K TOPGUM TL-T50, 700 g can Benzine-based two- component cold adhesive		H 0259-K TOPGUM TL-T60, 700 g can Benzine-based two- component cold adhesive		H 0050-H Universal hardener, 40 g bottle
	H 0315 Type B, 0.5 L Benzine-based cleaning agent		H 1139 SH Primer, 750 g		K 0662 Protective gloves

Legend

	Work waiting time		Stir		Add hardener - activate cold adhesive
	Brush on thinly and evenly		Adhesion test using test on back of hand		Ready for processing
	Apply cylinder covering		Remove protective film		

Instructions for rubber cylinder coatings with rubber/ceramic covering strips



Emergency information
Phone: +49 173 5306827

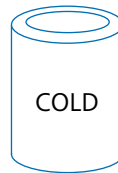
TOPGUM TL-T50/60

Safety instructions:

P 210: Keep away from heating, spark, open flames, hot surfaces. Do not smoke! P 280: Wear safety gloves/safety clothes/safety glasses and face mask. P 273: Avoid effluent on environment. P 243: Avoid electrostatic charging. P 301+310: IF SWALLOWED: Contact poison center or doctor immediately. P 303+361+353: If contact with skin or hair: Remove all wet clothes and wash/shower skin/hair. P 305+351+338: Rinse with water for a few minutes. Remove lenses and rinse again. P 331: Do not bring to anacatharsis.

Danger instructions:

H 225: Liquid and vapours inflammable. H 315: Skin irritation possible. H 319: Provoke strong irritation of eyes. H 336: Can bring sleepiness and numbness. H 304: Can bring death if swallowed. H 410: Toxic for water organism by longtime effect.



Danger



SH Primer

Safety instructions:

P210: Keep away from heat/sparks/open flames/hot surfaces. No smoking. P280: Wear protective gloves/protective clothing/eye protection/face protection. P302+P352: IF ON SKIN: Wash with plenty of soap and water. P303+P361+P353: IF ON SKIN (or hair): Remove/Take off immediately all contaminated clothing. Rinse skin with water/shower. P304+P340: IF INHALED: Remove victim to fresh air and keep at rest in a position comfortable for breathing. P305+P351+P338: IF IN EYES: Rinse cautiously with water for several minutes. Remove contact lenses, if present and easy to do. Continue rinsing. P370+P378: In case of fire: Use ABC powder for extinction. P501: Dispose of contents/container to local/regional/national/international regulations.

Danger instructions:

H332: Harmful if inhaled. H319: Causes serious eye irritation. H225: Highly flammable liquid and vapour. H315: Causes skin irritation. H335: May cause respiratory irritation.



Danger



Instructions for rubber cylinder coatings with rubber/ceramic covering strips



Poison Control Center Berlin
Phone: +49 30 19240



Danger

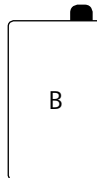
Universal hardener

Safety instructions:

P101: If medical advice is needed, have product container or label at hand. **P102:** Keep out of reach of children. **P232:** Protect from moisture. **P270:** Do not eat, drink or smoke when using this product. **P273:** Avoid release to the environment. **P280:** Wear protective gloves/protective clothing/eye protection/face protection. **P284:** Wear respiratory protection. **P305+P351+P338:** IF IN EYES: Rinse cautiously with water for several minutes. Remove contact lenses, if present and easy to do. Continue rinsing. **P405:** Store locked up.

Danger instructions:

H302+H312+H332: Harmful if swallowed, contact with skin or by inhalation. **H312+H332:** Harmful in contact with skin or by inhalation. **H319:** Causes serious eye irritation. **H332:** Harmful if inhaled. **H336:** May cause drowsiness or dizziness. **H351:** Suspected of causing cancer. **H372:** Causes damage to organs. **H410:** Very toxic to aquatic life with long lasting effects.



Danger

Cleaning agent type B

Safety instructions:

P210: Keep away from heat/sparks/open flames/hot surfaces. - No smoking. **P243:** Take precautionary measures against static discharge. **P261:** Avoid breathing mist/vapours/spray. **P280:** Wear protective gloves/protective clothing/eye protection/face protection. **P273:** Avoid release to the environment. **P301+P310:** IF SWALLOWED: Immediately call a POISON CENTER or doctor/physician. **P303+P361+P353:** IF ON SKIN (or hair): Remove/Take off immediately all contaminated clothing. Rinse skin with water/shower. **P305+P351+P338:** IF IN EYES: Rinse cautiously with water for several minutes. Remove contact lenses, if present and easy to do. Continue rinsing. **P304+P340:** IF INHALED: Remove victim to fresh air and keep at rest in a position comfortable for breathing. **P331:** Do NOT induce vomiting.

Danger instructions:

H225: Highly flammable liquid and vapour. **H315:** Causes skin irritation. **H336:** May cause drowsiness or dizziness. **H304:** May be fatal if swallowed and enters airways. **H411:** Toxic to aquatic life with long lasting effects.

Instructions for rubber cylinder coatings with rubber/ceramic covering strips



Safety instructions

Abide by the safety instructions on the sleeves, labels and data sheets as well as the occupational safety regulations.

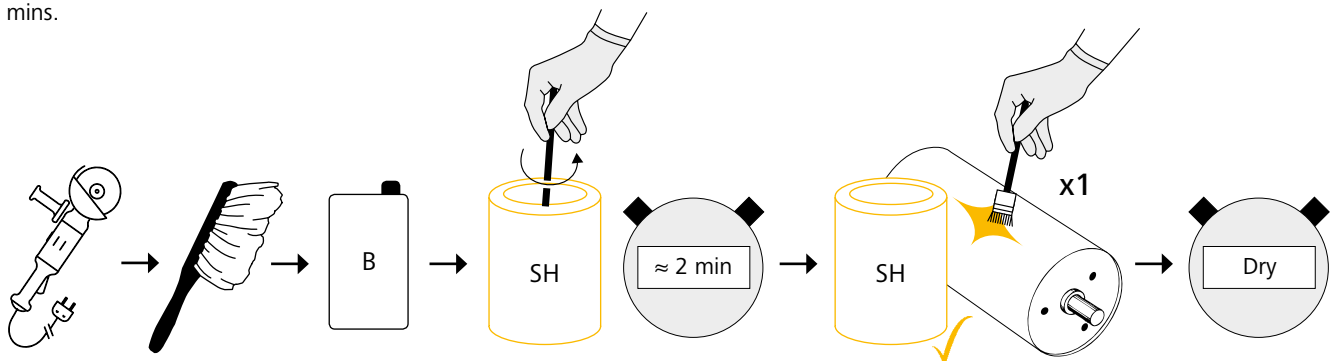
We would be happy to send you safety datasheets on request. Alternatively you can find these at www.nilos.de under Downloads.



1. Preparations

1.1 Preparing the cylinder surface

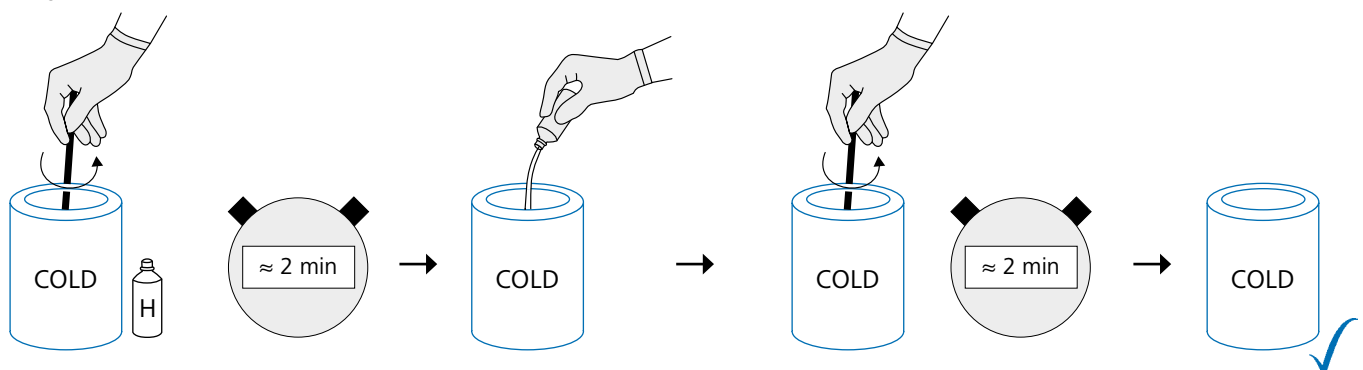
Remove the old cylinder covering in its entirety. Metallically clean the steel body by sandblasting or roughing-down, clean carefully with hand brushes and wash down with type B cleaning agent. Prepare the bonding agent (SH) and then brush it onto the grease-free surface. Then leave to dry for at least 30 mins.



1.2 Activating the adhesive

CAUTION: please observe the respective working instructions of the adhesive which you are using!

Stir the adhesive for 2 mins.
Mix the adhesive thoroughly with the universal hardener for 2 mins.



Instructions for rubber cylinder coatings with rubber/ceramic covering strips

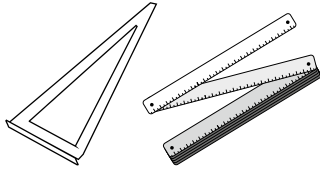
1.3 Cutting the covering strips to size

When using cover strips from rolls, these must be cut to size accordingly before processing the cylinder dimensions.

If using ceramic covering strips, the strips may need to be cut a little shorter than the length of the cylinder – corresponding to the position of the ceramic plates – so that a narrow strip without cylinder covering appears at the edge of the cylinder.

The number of strips required should be calculated on the basis of the cylinder circumference and laid out on a workbench, ready for use.

Cylinder circumference = 3.14 x cylinder diameter



thickness x width x length ¹	RB-K / normal quality Item no.
12 x 204 x 700	T 1807
12 x 204 x 900	T 1808
12 x 204 x 1,000	T 1809
12 x 204 x 1,100	T 1810
12 x 204 x 1,200	T 1811
12 x 204 x 1,300	T 1812
12 x 204 x 1,500	T 1813
12 x 204 x 1,700	T 1814
12x 204 x 2,000	T 1815
12 x 204 x 2,500	T 1816
order-specific	T 1817

thickness x width x length ¹	RB-VK / extinguishing quality Item no.
12 x 204 x 700	T 1818
12 x 204 x 900	T 1819
12 x 204 x 1,000	T 1820
12 x 204 x 1,100	T 1821
12 x 204 x 1,200	T 1822
12 x 204 x 1,300	T 1823
12 x 204 x 1,500	T 1824
12 x 204 x 1,700	T 1825
12x 204 x 2,000	T 1826
12 x 204 x 2,500	T 1827
order-specific	T 1828

When processing it should be ensured that covering strips and the cylinder surface are free from grease, dirt, dust or moisture.

Instructions for rubber cylinder coatings with rubber/ceramic covering strips

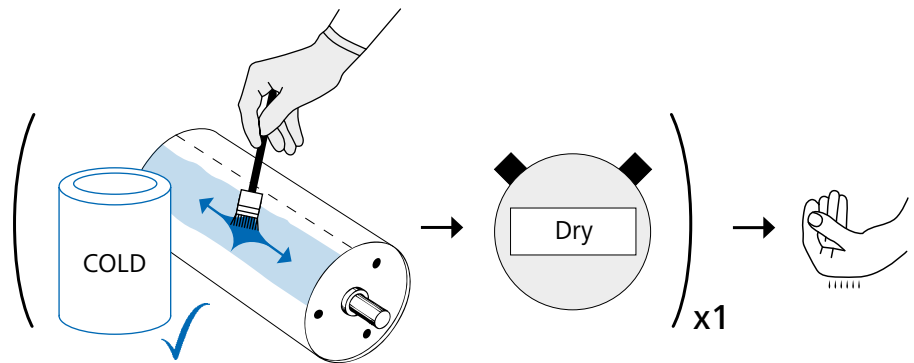
2. Covering the cylinder

2.1 Coating the cylinder

Carefully brush the cylinder along its length with adhesive and leave to dry.

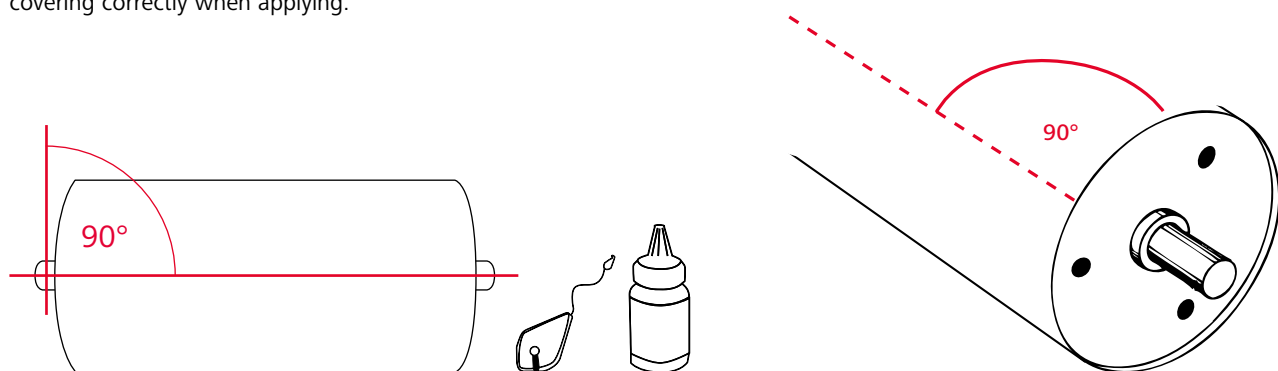
CAUTION: if using cover strips, always ensure that the second coat is applied only in the direction of the strips. Here you must ensure that the coating is a little wider than the cover strip.

The total processing time for the adhesive to activate is about 3 hours, but this can vary from one adhesive to another.



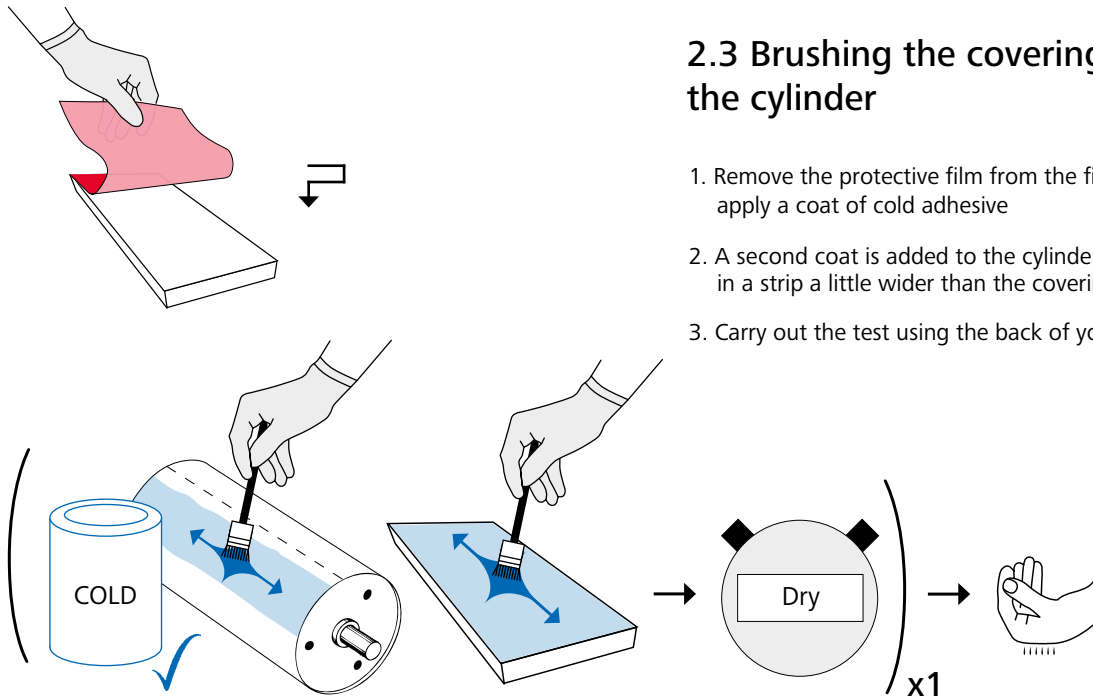
2.2 Marking the cylinder

Mark the cylinder with a guide line along the cylinder axis using grease-free chalk powder in order to position the cylinder covering correctly when applying.



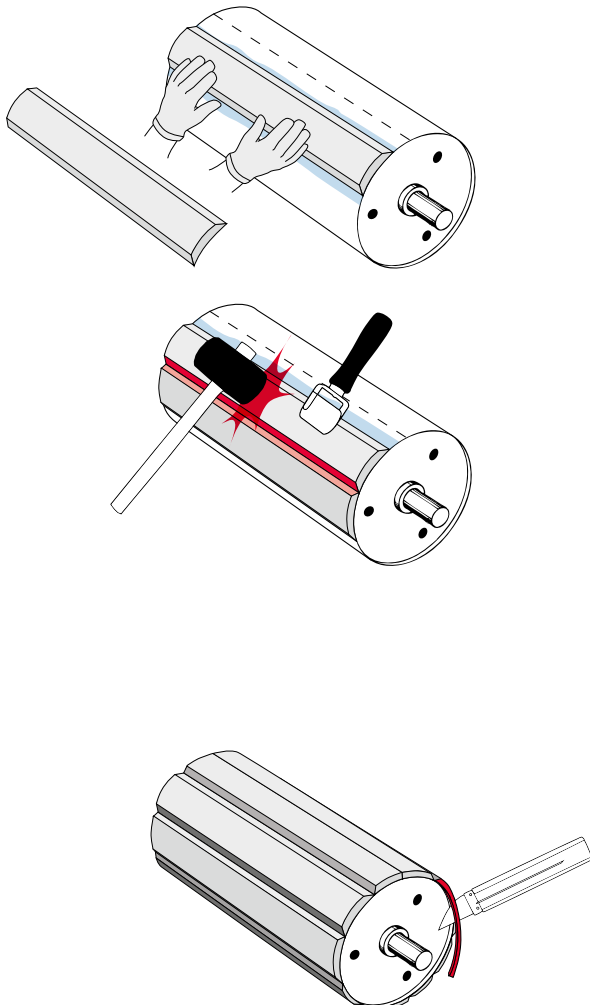
Instructions for rubber cylinder coatings with rubber/ceramic covering strips

2.3 Brushing the covering strips and the cylinder



1. Remove the protective film from the first covering strip and apply a coat of cold adhesive
2. A second coat is added to the cylinder along the guide line in a strip a little wider than the covering strip to be glued on.
3. Carry out the test using the back of your hand.

2.4 Covering the cylinder



1. Position the first strip along the guide line centred in relation to the cylinder edges. Roll out from the centre towards the outside and tap gently. Air gaps must be avoided.
2. Stick down, roll out and tap down the covering strips all over the cylinder, leaving no gaps.

Covering strips must always run parallel to the cylinder axis. If the last uncovered distance is narrower than the width of the covering strip, this must be trimmed and adjusted accordingly.

Gently roll the joints between the strips again using a knurled roller. Seal strip joints and, where necessary, covering-free areas at the edge of the cylinder with silicon.

3. Cut the overhanging rubber from the cylinder edges after approx. 4 hours and grind until smooth. If need be, seal the cutting edges with cold adhesive or silicon and trim tread grooves if need be.

Do not put cylinders into operation for at least 4 hours.



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