

These assembly instructions apply to: NKK





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Scope of delivery

Please refer to the delivery note for the scope of delivery.
 Check the packaging for possible transport damage. In the event of damage to the packaging, check the contents for completeness and possible damage. Inform the carrier in the case of damage.

Designation

The glueing consoles of the series NKK are hereafter referred to as „NKK“.

Version of document

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1 General information

Use and storage

Before installing the NKK read these instructions carefully. It is the basis for any action when dealing with the NKK, and may be used for training purposes. The instructions should be subsequently stored at the operation site.

Target group

The target group for these instructions is technical staff, who have basic knowledge in mechanics.

Therefore, only staff who are trained in these fields may work on the NKK.

The NKK may only be installed, put into operation, maintained, troubleshot and disassembled by persons authorised by the operator.

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Limitation of liability

All technical information, data and instructions for installation, operation and maintenance in these instructions are based on the latest information available at the time of printing and take our past experience to the best of our knowledge into account.

No claims can be derived from the information, illustrations and descriptions in these operating instructions.

The manufacturer does not assume liability for damages resulting from:

- failure to observe the instructions,
- improper use,
- unauthorised repairs,
- technical modifications,
- use of non-permissible spare parts.


Translations are made to the best of our knowledge.


NetterVibration does not assume liability for translation errors, even if the translation was made by us or on our behalf. Only the original German text remains binding.


Instruction and warning symbols

The following instruction and warning symbols are used in these instructions:

Personal injuries

⚠ DANGER	
	signifies an immediate danger. Disregard of this notice will result in death or severe bodily injuries.

⚠ WARNING	
	signifies a potential danger. Disregard of this notice can result in death or severe bodily injuries.


⚠ CAUTION	
	signifies a potentially dangerous situation. Disregard of this notice can result in minor or moderate bodily injuries.

Material damages

NOTICE	
signifies potential material damage. Disregard of this notice can result in material damage.	

Notes

IMPORTANT	
indicates actions, methods or notes that are not relative to safety, e.g. useful information and tips.	

	Environmentally safe disposal indicates the obligation of environmentally safe disposal.
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2 Safety

Intended use The glueing consoles of the series NKK are fastening devices for pneumatic and electric Netter vibrators for mounting e.g. on bunkers and silos. Any other use is considered improper.

Safety devices There are no separate safety devices.

Qualification of qualified personnel Installation, commissioning, maintenance and troubleshooting of the NKK may only be performed by authorised qualified personnel. All handling of the NKK is the responsibility of the operator.

Liability

IMPORTANT

NetterVibration assumes no liability for personal injuries and material damages if technical changes to the product were made or the notices and regulations in these instructions were not observed.

Rust-free surfaces

IMPORTANT

The NKK may only be glued to rust-free metal surfaces. Use on other materials must be clarified with **NetterVibration**.

Data sheets

IMPORTANT

Before use, read the technical data sheets and safety data sheets of the primer (adhesion agent), glue and cleaner for precautions and safety instructions.

The applicable safety regulations must be observed.

Vibrators

IMPORTANT

The safety instructions for individual vibrators can be found in the operating instructions of the respective vibrator.

3 Technical data

Permissible operating conditions

Operating temperature	-20 °C to 100 °C
Processing temperature	15 °C to 40 °C

Series name

The following NKK types are available:

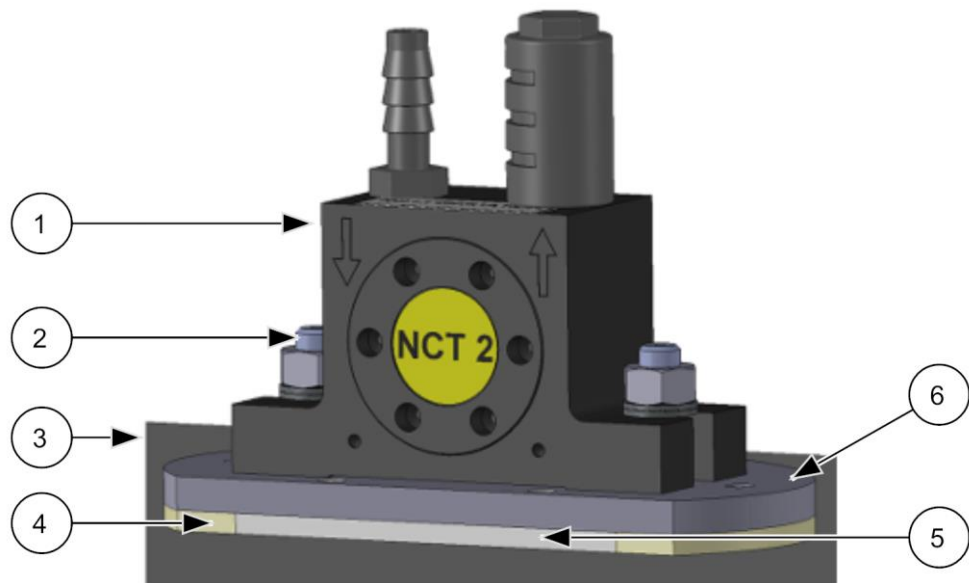
NKK G for flat smooth surfaces

NKK R für cylindrical surfaces

NKK K für conical surfaces

4 Design and function

Design



- | | | | |
|---|------------------|---|------------|
| 1 | Vibrator | 4 | Glue strip |
| 2 | Mounting bolt | 5 | Glue |
| 3 | Adhesive surface | 6 | NKK |

Function

NKK are fastening devices for pneumatic or electric Netter vibrators.

The vibration is transmitted evenly and gently to the glued container wall by the elastic glue. A previously applied primer increases adhesion of the glue to the glueing surface.

5 Transport and storage

Transport conditions

Special conditions of transport are not required.

Packaging

The NKK are packed and ready for assembly. Accessories and add-on parts are delivered unmounted, unless otherwise agreed upon.

The packaging protects the NKK from transport damage. The packaging material has been selected from an environmentally safe and technically disposable point of view and is therefore recyclable.

The return of packaging to the material cycle conserves raw materials and reduces the amount of waste.

Storage

Observe the following conditions when storing the NKK:

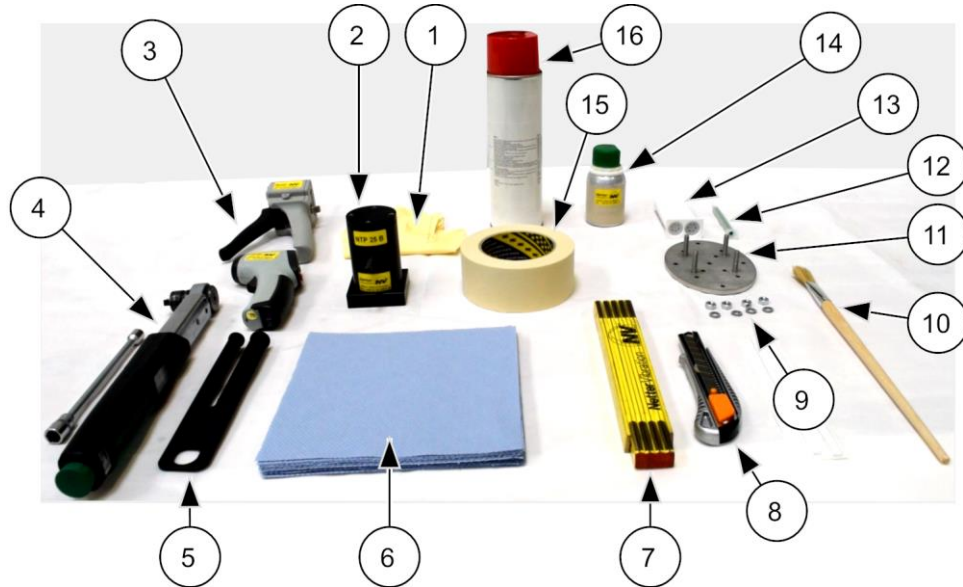
- Store the NKK in a dry and clean environment.
- Protect the glue kit during storage from exposure to UV, weather and ozone.
- The storage time of the glue in the unopened original container is 9 months, that of the primer 12 months.
- The permissible storage temperature of the primer and the adhesive is 10 °C to 25 °C.

6 Installation

Safety instructions

IMPORTANT
Observe the safety instructions in Ch. Safety, page 5.

Overview



- | | |
|-------------------------|-------------------------|
| 1 Gloves | 9 Nuts and lock washers |
| 2 Netter vibrator | 10 Brush |
| 3 Dispensing applicator | 11 NKK |
| 4 Torque wrench | 12 Static mixer |
| 5 Plunger | 13 Cartridge with glue |
| 6 Paper towel | 14 Primer |
| 7 Yardstick | 15 Adhesive tape |
| 8 Utility knife | 16 Cleaner |

Procedure

When installing the NKK carry out the following steps in succession:

Pre-cleaning surfaces

1. Remove any coatings, paints, etc. before glueing.
2. Put on clean gloves.
3. Clean the surfaces onto which the glue is applied with an alcoholic solution, e.g. with isopropanol.
4. Repeat the procedure if contamination is still visible. Both surfaces must be clean, dry and free of grease.



Pre-cleaning

Applying primer

1. Apply the primer thinly and evenly to the container wall **and** the NKK.
2. Allow the treated areas to evaporate for at least 5 minutes until the primer has dried.



Upper surface of NKK with bolts



Bottom surface of NKK with bolts

Attaching glue strips

1. Press the supplied glue strips all around on the bottom surface of the NKK so that a small gap of ca. 3 mm between both ends remains open.

The glue strips ensure that the required distance (3 mm) between the NKK and the container wall is maintained.



NKK with glue strips (bottom surface)

Pre-glueing

1. Press the NKK against the container wall so that the glue strips seal the gap between the NKK and the container wall.

The dwell time is 3-5 minutes.



Pre-glueing of console

Preparing glue

1. Open the cartridge and unscrew the static mixer.
2. Insert the cartridge with static mixer into the appropriate dispensing applicator.
3. Discard the first 2 cm of the glue strand which emerge from the static mixer.



Dispensing applicator, cartridge and static mixer

Filling in glue

1. **Only for PKL:** Close the self-clinching nuts with screws.
2. Fill the glue in the drill holes of the NKK. If vertically mounted, start in the middle of the NKK at the bottom.
3. Add glue to each drill hole until glue emerges from at least one other drill hole.
4. Remove the discharged adhesive.



Glue in drill holes

The static mixer should be replaced if the application is interrupted for more than 5 minutes at 23 °C.

Curing of glue

The NKK are ready for use after 12 hours. This applies for temperatures from 15 °C to 40 °C. The curing time of the glue is shorter at higher temperatures.

Sealing drilled holes

Perform the following steps one after the other **only when used in the food sector:**

1. Drill out the glue residues in the drill holes.
2. Apply a suitable primer to the areas to be glued.
3. Seal the drill holes **and** the gap between the edge of the NKK and the container wall with a suitable silicone.
4. Apply a suitable smoothing agent to the glued areas.

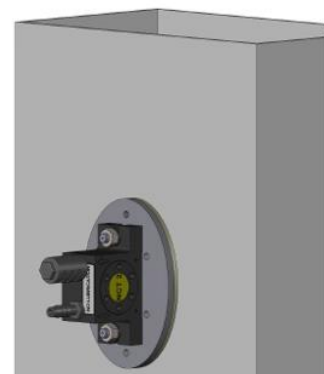


Sealing with primer

Mounting vibrator

1. Screw the pneumatic or electric Netter vibrator to the NKK.

Further information can be found in the operating instructions of the respective Netter vibrator.



Mounted vibrator

QR code for installation

For the online assembly instructions of the NKK scan the following QR code or use the link:



or <https://www.youtube.com/watch?v=AkO-kw0fpa8>

Checklist installation

Ensure that the following steps have been performed:

- Surface pre-cleaned?
- Primer applied?
- Glue strips attached?
- NKK pre-glued to container wall?
- Glue prepared?
- Glue filled in drill holes?
- Glue cured?
- In food sector: Drill holes sealed?
- Netter vibrator mounted?

7 Spare parts and accessories

Ordering of spare parts

Please provide the following details when ordering spare parts:

- required amount
- description and position of spare part
- type of NKK

Possible accessories

The following accessories are available for the NKK:

Component	Description
Glue	For glueing the NKK to a mounting surface
Dispensing applicator	
Static mixer	For mixing the glue components
Primer	For cleaning the surfaces to be glued

8 Annex

Data sheets

Please observe the technical data sheets and safety data sheets of the primer and glue.

These are available on request from **NetterVibration**.