

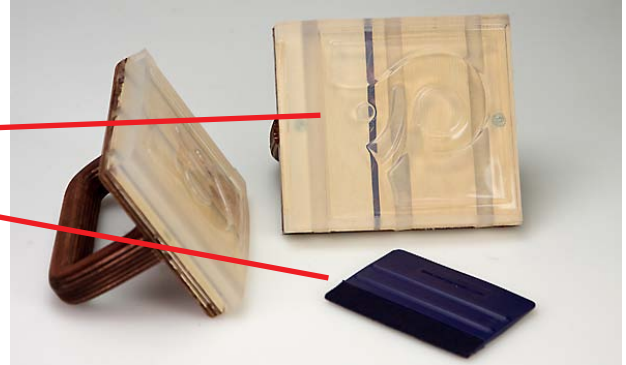
## INTRODUCTION

This instruction has been created for the application of 3D decals. There is also a video which includes the principles of applying a three dimensional decal and we show how to use the application tool required in the applying. The video and these applying instructions can also be downloaded from the web address [www.brandid.fi/cargotec3d](http://www.brandid.fi/cargotec3d)

For the applying you will need:

- 3D Decal
- 3D Application Tool \*
- Scraper \*
- Cleansing Equipment \*

\*(can be ordered from Brand ID,  
see appendix for images and  
product codes)



### ! BEFORE YOU START

Application shall take in a clean place free of dust and extreme temperatures. Both the surface where the label is to be mounted and environment (indoor) should have an application temperature minimum 18°C (64°F).

## 1. Cleaning

Ensure that the surface is absolutely clean. There can be no dirt, grease or other impurities on the surface. If required, please clean the surface with the cleaning chemical:

- Isopropyl alcohol (CAS 67-63-0) OR
- Avery Surface Cleaner (code: ZA1206)

## 2. Decal position

Verify the exact place of application from the blueprint and mark it with for example a felt pen. After this you can try the decal on and ensure it will be applied to the right position.

## 3. Removal of backing paper

Remove the backing paper from the letters, but leave the backing paper of the elephant logo in place.

## 4. Application of the letters

Direct the decal and press on the letters. Then, use the scraper to carefully press further on the letters, so that the adhesive is activated. There is a pressure sensitive adhesive on the decal which requires a sufficient pressure to be permanently applied.

## 5. Removal of application tape

After this, remove the application tape on top. Also remove the elephant logo from the application tape.

## 6. Application tool

Now take the application tool with a curved surface and carefully place the decal on it upside down. Then remove the backing paper and try not to touch the adhesive. The directing groove in the application tool should be directed at the first letter. This will ensure the decal is attached in the correct position.

you may also watch as video: [www.brandid.fi/cargotec3D](http://www.brandid.fi/cargotec3D)

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## 7. Applying the elephant decal with the tool

Place the groove of the application tool carefully against the letter and push the decal from the direction of the first letter to attach it to the surface. The curved surface pushes all the air away from under the decal when it is being applied. Remember to use enough power to ensure the decal is applied correctly.

*! NOTE: Even we do NOT recommend to use mild soap water during the installation at any point, it can be considered for elephant decal IF a proper application tool is not available. When a mild soap water is used, it requires a lot longer time to achieve the final adhesion. Mild soap water is used to get the air away from under the decal when it is being applied.*

## 8. Reaction time of the adhesive

Let the adhesive react at least 30 minutes in the applying temperature to ensure its final adhesion.

## 9. Specification and conditions

See appendix for specifications and conditions.

If you have any questions, please contact us:

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you may also watch as video: [www.brandid.fi/cargotec3D](http://www.brandid.fi/cargotec3D)

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## Specification of 3D Logotype

A three-dimensional decal with metallic-look surface. All materials and surface treatments are suitable for outdoor use and for harsh conditions.

Colours: metallic paint: silver 3, gray paint, lacquers

Material: Polycarbonate with special treatment, UV inhibitors + polyurethane

### Product performance in outdoor use

The chosen supplier Brand ID specializes in demanding industrial graphics and sign products. Manufacturing and all raw materials are categorized according outdoor performance, chemical performance and other characteristics that affect warranty and performance of the product. Manufacturer warranty is 5 years for these products in outdoor use.\*

Extensive testing has done to ensure first class quality. Product testing has done on painted surfaces provided by several Cargotec factories using materials from their production.

### Definition

These decals are for outdoor use. They shall be UV and moisture resistant. The decals shall withstand temperatures ranging from -40 °C to +70 °C in combination with chemical resistance.

### Application and conditions

Application shall take in a clean place free of dust and extreme temperatures. Both the surface where the label is to be mounted and environment (indoor) should have an application temperature of >18°C (64°F).

The surface where decal is mounted shall not contain any chemicals but pure paint. Paint with self cleaning properties is not allowed, since they contain silicone or similar additives. If necessary, the surface must be cleaned with Isopropanyl alcohol (CAS 67-63-0).

Any non metallic or non painted surface must have surface energy > 38 mJ/m<sup>2</sup> to ensure enough adhesive power. Tester is available from Brand ID.

### Specification of performance

- Decals with pressure sensitive adhesive
- Temperature range -40°C to +70°C (-40°F to 158°F)
- Minimum installation temperature >18°C (64°F)
- Required reaction time for adhesive 30 minutes in installation temperature.
- After application, 24hrs is required before washing with high pressure water gun.
- Average adhesive power after 24 hrs: 35N/25mm (FINAT TM 1)
- 5 year outdoor warranty\*

\* normal climate Central Europe or similar amount of UV radiation (900 — 1200 kWh/m<sup>2</sup>) per year.

### 3D Installation tools

For 3D decal, we developed a tool for installation/application. It's purpose is to make application easier and to achieve the best possible result.

For each size of the 3D decal is a corresponding tool. Here is a list of tools available, please use code mentioned below when ordering.



This tool has a groove, which is exactly same size as a letter in decal. This groove helps to get correct distance between elephant logo and the first letter of the decal. Please, see video instruction how to use this.

3D TOOL CODE	SIZE OF THE ELEPHANT LOGO (mm)
20 697	50 x 50 mm
20 698	80 x 80 mm
20 699	100 x 100 mm
20 700	120 x 120 mm
20 701	190 x 190 mm

order: [sales@brandid.fi](mailto:sales@brandid.fi)

**Cleaning chemical:** Avery Surface Cleaner ZA1206. **CODE: 20 769**

**Scraper (blue):** **CODE: 5317**

