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INSTRUCTIONS FOR USE RATHGEBER SELF-ADHESIVE LABELS

At Rathgeber we do our utmost to ensure that our products reach you in perfect condition. To help you during the application process and to ensure the effectiveness of the adhesive we recommend you to read and observe our instructions for use.

- 1. GENERAL INSTRUCTIONS**
- 2. STORAGE INSTRUCTIONS**
- 3. CLEANING INSTRUCTIONS**
- 4. USAGE INSTRUCTIONS**
- 5. PRODUCT SPECIFIC INSTRUCTIONS**
 - 5.1 Film placards
 - 5.2 ROYALPLAST®
 - 5.3 Inscrutable aluminium foil labels
 - 5.4 Free standing lettering (on application tape)
 - 5.5 Front panels and keyboard films
 - 5.6 Aluminium and stainless steel plates



1. GENERAL INSTRUCTIONS

- The application surface must be clean, dry, free of dust, oils, oxides, release agents and other contaminants.
- Plastic parts and lacquer which contain e.g. silicone may negatively affect adhesion.
- Certain plasticizers will continue to evaporate from plastics for a certain period after production. The adhesive strength of the label may be affected by application surfaces containing such plasticizers.
- Not all surfaces are suited for applying adhesives. Please note that adhesion varies on different surfaces.

Our instructions for use are based on our many years of experience and of course the application tests which we perform ourselves on a regular basis. The environmental and operating conditions are always customer specific and these will always affect the application process and the adhesive. Therefore we cannot take on any responsibility for your very own and specific applications and operation purposes. Performing own application tests is absolutely mandatory and required.

2. STORAGE INSTRUCTIONS

- Protect self-adhesive products from direct exposure to sunlight. Avoid large variations in temperature and high humidity.
- We supply self-adhesive products packaged so that they can be stored in their packaging at a room temperature (of approximately 20°C and approx. 50% relative humidity).
- Do not store heavy items on top of your products.
- Always use self-adhesive products within 12 months of purchase. After this time, we cannot guarantee that they will adhere correctly.

3. CLEANING INSTRUCTIONS

Please clean the surface carefully with a suitable household cleaner.

Always wipe in the same direction, e.g. from right to left. Allow the cleaner to set for a short time afterwards. We recommend to use our surface cleaner FT 100:

www.rathgeber.eu/en/corporate/services/cleaner

Please carefully observe the manufacturer's instructions for use when using solvents and chemicals. It is recommended to wear suitable eye protection and gloves when cleaning. Aggressive cleaners can damage the surface.

4. USAGE INSTRUCTIONS

- The set time for the adhesive is 72 hours. Please avoid large fluctuations in temperature and humidity during the hardening of the adhesive.
- The temperature of the surface and the self-adhesive product must be between 15°C and 25°C. Please warm the area if necessary and ensure that no condensation forms. The optimum relative humidity for use of self-adhesive products is

between 40% and 55%.

- Apply adequate pressure (approx. 20 N/cm²) when affixing the label (e.g. with a scraper, roller or press). This will improve bond strength.
- Observe the expiry date of the adhesive (see packaging).
- During use be sure not to touch the adhesive layer.

RATHGEBER also provides numerous aids for use, e.g. surface cleaner FT 100 for the application surface, templates, positioning and removal aids.

5. PRODUCT SPECIFIC INSTRUCTIONS

5.1. FILM PLACARDS

- Wet the application surface with water (recommended ratio: 1 drop of silicone-free rinsing agent to ½ litre of water).
- Position the placard as required on the wet film.
Using the enclosed scraper or a soft cloth carefully smooth out water, working your way from the middle to the edge.
- Bubbles, which accrue, can be pierced with a pin and/or smoothed out with a scraper or cloth.

We recommend sealing the edges of the label with a hard wax (e.g. car wax) once dry.

5.2. ROYALPLAST®

ROYALPLAST® Classic labels are intended for use on flat surfaces only.

For use on curved surfaces we recommend ROYALPLAST® Konvex labels.

5.3. INSCRIBABLE ALUMINIUM FOIL LABELS

Position the aluminium foil face down on a flat, clean surface and slowly pull away the release paper on the reverse at an acute angle.

Place the aluminium foil on the surface to be glued and smooth out with your hand or a roller.

5.4. FREE STANDING LETTERING (ON APPLICATION TAPE)

- CHROMOTION® lettering
 - ROYALPLAST® lettering
 - Free standing foil lettering
 - FLEXXLINE®, self-adhesive
 - Free standing acrylic lettering
 - Free standing metal lettering
 - FINOCHROM®
- Place the lettering face down on a flat, clean surface and slowly remove the release paper at an acute angle.
 - Using the application tape, position the label or lettering as required. Press down firmly when in position. Slowly peel away the application tape at an acute angle.

Should the plate or lettering come away with the application tape, roll the tape back in to position, just enough so that pressure can be re-applied at the appropriate point. Then try removing the application tape again until all letters have transferred.

- For FINOCHROM® and free standing film letterings we recommend using an aid (usually a roller for small lettering, or a doctor knife for large lettering).
- Take particular care when affixing small and/or particularly fine lettering. A delicate hand may be required as the adhesive surface is relatively small and lettering may come away with the application tape.

5.5. FRONT PANELS AND KEYBOARD FILMS

To protect the surface, we often use protective film on front panels and keyboards (sometimes on both sides of windows). Please ensure that these are removed before adhesion.

5.6. ALUMINIUM AND STAINLESS STEEL PLATES

The surface of aluminium and stainless steel plates are often protected by film. Ensure this is removed before use.

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Date 05/2020