



PURPOSE:

The purpose of this procedure is to provide specific instructions for the application of pressure-sensitive adhesive coated film products.

SCOPE:

This specification covers the application of self adhesive flexible vinyl decals to general surfaces.

INSTRUCTIONS:

When applying pressure sensitive adhesive coated materials it is essential that the application process must be carried out on surfaces at a minimum temperature of 15°C.

Application method:

1. Ensure that the application surface is completely free from paint, grease, dust or other imperfections and inclusions.
2. If necessary, warm the decal and the application surfaces before applying. Ensure that the temperature does not become too high or repositioning of the applied decal will become difficult.
3. If the temperature of the application surface drops below the dew point of the surrounding air moisture condensation will form and prevent a good contact between adhesive and substrate.
4. Carefully wipe the application area with a clean lint-free cloth dampened with Isopropyl Alcohol or equivalent solution. Allow the area to dry thoroughly.
5. Locate the application tape, if used, to the body, if possible with the decal material still attached.
6. Carefully remove the backing paper from the adhesive surface avoiding contamination.
7. Squeegee or roll the surface of the application tape to ensure thorough contact with the painted / glass surface using firm pressure from the centre of the decal towards the outer edges.



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8. Remove the application tape; pulling back at an angle of 180°C will aid easy removal.
9. Check decal application and re-squeegee if necessary.
10. Spraying the application surface with a soap solution (a mix of 1% washing-up liquid and 99% water) prior to application may assist with the operation as this allows the material to slide before squeegeeing.

If using the above method of application, liberally apply the soap solution to the application surface before application.