



TECHNICAL BULLETIN 5.06

Application of Vinyl Graphic Products to Fiberglass Surfaces

This bulletin details specific surface preparation and application instructions of vinyl graphic products onto non-vehicular surfaces. Applications will be successful if the instructions are followed completely.

STORAGE of VINYL GRAPHIC PRODUCTS:

- Place vinyl graphic products lying flat in a clean storage area, free from excessive moisture and direct sunlight.
- Maintain ambient temperatures between the ranges of 65° - 100°F (18° - 37°C).

SURFACE PREPARATION FOR VINYL GRAPHIC PRODUCTS:

All surfaces are considered contaminated until properly cleaned. Thus, all surfaces **MUST** be cleaned prior to any application of vinyl graphic products. It is recommended that the substrate being applied on is evaluated to determine proper preparation. Reference **4.00 SURFACE PREPARATION** section for specific performance criteria.

GENERAL REQUIREMENTS FOR APPLICATION:

Tools

- The following tools are recommended for use and available from Sharpline by calling toll-free 1-800-888-4888.
 - Felt Block Application Squeegee P/N 0882-55
 - 3M Gold Squeegee P/N 0881-55
 - Snappy Knife P/N 077-55
 - Heat Gun P/N 9751-55
 - Air Release Tool P/N 0885-55

Temperature

- Apply vinyl graphic products when the air and application surface temperatures are above 50°F and below 100°F.
- Surfaces may be mechanically heated when air and application surface temperatures are below the minimum requirements. This may be accomplished by a portable heater, heat lamps, hot water or steam. If hot water or steam is used, the surface must be dried thoroughly before application.

Key Points

- Before beginning application, insure the surface was properly cleaned as previously outlined
- Check that air and surface temperatures exceed the minimum requirements.
- Use firm pressure with squeegee and/or felt block.
- Use overlapping strokes.
- Remove the application masking at a 180° angle.
- Re-squeegee entire graphic after removal of application masking.
- Make sure hands are clean.

APPLICATION SEQUENCE FOR VINYL GRAPHIC PRODUCTS:

1. Position Vinyl Graphic

It is recommended that the vinyl graphic be positioned in place on the surface with masking tape. As an aid for aligning and registering the graphic on the surface prior to application, make register marks on the side edge of the surface with a lead pencil, a marking pen, or small pieces of masking tape.

2. Remove Liner

Lay back one half of the vinyl graphic against the application surface and remove the liner by sharply flicking the graphic edge toward the face of the graphic with the ball of the thumb or a fingernail. A small bend at a corner or edge will cause the liner to separate from the graphic. Pull the liner away in a continuous motion at a 180° angle.

Note: Always remove the liner from the vinyl graphic rather than the vinyl graphic from the liner.

3. Apply Vinyl Graphic

Align vinyl graphic to register marks and tack it to the surface with thumb pressure at the corners. For larger graphics, use one or more additional tack points along top edge.

Using an application tool (felt squeegee), begin application at the vertical center of the vinyl graphic and apply all the way to one edge. Then, return to center with overlapping strokes and repeat the procedure - applying to the opposite edge.

4. Remove Application Masking

Mist application masking with an Easy-On™ or water solution, allow this to soak for a minimum of two minutes. This will release the bond between the application masking and the face of the vinyl graphic. Remove application masking from the face of the vinyl graphic by pulling masking back upon itself always at a 180° angle.

5. Remove Entrapped Air

Inspect the graphic for air bubbles. To eliminate these bubbles, puncture the graphic at one end of the bubble with an air release tool and press out entrapped air with a felt squeegee moving towards the puncture.

6. Re-squeegee Vinyl Graphic

When the entire graphic has been applied; re-squeegee the entire graphic using a felt squeegee.