



## TECHNICAL BULLETIN 4.03

### Preparation of Painted Recreational Vehicle 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.

#### GENERAL SURFACE PREPARATIONS:

All surfaces are considered contaminated until properly cleaned. Thus, all surfaces **MUST** be cleaned prior to any application of vinyl graphic products. See the following steps:

1. Wash the surface with detergent and water, then thoroughly rinse the surface with water and dry completely.
2. Saturate a clean cloth with a solvent approved by local EPA regulations and wipe the surface to remove any contaminants such as silicone, wax, chalk or adhesives.
3. Dry the surface with a lint free towel before the solvent evaporates.
4. Spray the surface with one of the following products:
  - Isopropyl alcohol (recommended for fiberglass)\*
  - BETCO® CitruSolv degreaser P.N. 209 OR 3M® Citrus Base Industrial Cleaner P.N. 62-4456-8530-8 (recommended for corrugated metal) Note: To locate a local distributor for BETCO® CitruSolv call 888-462-3826.

Wipe immediately with a clean dry towel to dry the surface.

#### SPECIFIC SURFACE PREPARATIONS:

The following procedures describe specific surface preparation. All surfaces need to be evaluated to determine which of the following procedures is appropriate.

#### PAINTED CORRUGATED METAL SURFACE PREPARATIONS:

- Aluminum – Gloss Smooth Pre-painted
  1. Spray surface area where vinyl graphics are to be applied with a liberal amount of BETCO ® CitruSolv degreaser OR 3M® Citrus Base Industrial Cleaner.
  2. Wipe surface dry with a clean dry towel using a horizontal motion parallel to corrugated metal pattern. Be sure to wipe all surfaces of the profile completely dry.
  3. Spray surface with Isopropyl Alcohol. \*
  4. Wipe surface completely dry with a clean dry towel using a horizontal motion parallel to corrugated metal pattern.
- Aluminum – Krystal Kote™ painted
  1. Spray surface area where vinyl graphics are to be applied with a liberal amount of BETCO® CitruSolv degreaser OR 3M® Citrus Base Industrial Cleaner. **DO NOT USE** Isopropyl Alcohol to clean Krystal Kote™ surfaces.
  2. Wipe surface dry with a clean dry towel using a horizontal motion parallel to corrugated metal pattern. Be sure to wipe all surfaces of the profile completely dry.

Caution: An application surface that has been cleaned thoroughly can still provide poor adhesion in the lower areas of the textured Krystal Kote surface due to liquid retention caused by capillary action. This problem can be overcome by using a heat gun to dry the surface.

#### FIBERGLASS SMOOTH SURFACE PREPARATIONS:

- Fiberglass – Kemlite™ Filon (Slightly Textured)
  1. Clean any silicone, caulk, or adhesives with a clean towel saturated with a solvent in accordance with local, state and federal regulations. Acetone, lacquer thinner, and similar products are not recommended by the manufacturer of fiberglass substrates.
  2. Spray surface area where vinyl graphics are to be applied with a liberal amount of Isopropyl Alcohol. \*\*
  3. Wipe surface completely dry with a clean dry towel.

- Fiberglass – Kemlite™ Medallion (Smooth High Gloss)
  - Vetroresina™ (Smooth High Gloss)
  - Fabwell™ (Smooth High Gloss)
  - Masterfab™ (Smooth High Gloss)

1. Clean any silicone, caulk, or adhesives with a clean towel saturated with a solvent in accordance with local, state and federal regulations. Acetone, lacquer thinner, and similar products are not recommended by the manufacturer of fiberglass substrates.
2. Spray surface area where vinyl graphics are to be applied with a liberal amount of Isopropyl Alcohol. \*\*
3. Wipe surface completely dry with a clean dry towel.

\* The use of Isopropyl Alcohol as a cleaning agent is restricted in some regions. Nothing in this Technical Bulletin is intended as a recommendation to violate federal, state, or local regulations.

**\*\* When the use of Isopropyl Alcohol is restricted, substitute BETCO® CitruSolv® degreaser OR 3M® Citrus Base Industrial Cleaner to clean fiberglass surfaces.**