



## TECHNICAL BULLETIN 7.04

### Application of SL24 Dimensional Products

This bulletin details specific surface preparation and application instructions of SL24 dimensional products onto vehicle 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 isopropyl alcohol (recommended) or BETCO® CitruSolv degreaser; follow immediately to dry the surface with clean dry towel. This should remove any residue remaining from the cleaning solvent.

#### APPLICATION TEMPERATURE:

The recommended temperature range for both the application surface and the part during installation is 15.6° - 43.3° C (60° - 110° F).

#### SPECIFIC SURFACE PREPARATIONS FOR:

- Fiberglass
  1. Use general cleaning procedures outlined above.
- Newly Painted
  1. Follow all drying and curing instructions provided by the paint manufacture prior to any surface preparation.
  2. Baked enamels can be immediately cleaned after cooling.
  3. Air-dried paints require five days of drying time before surface preparation.

#### RECOMMENDED PAINT SURFACES:

Always test adhesion and paint/adhesion compatibility prior to surface preparation and application.

1. High quality exterior grade paints.
2. OEM paint systems.

#### URETHANE PAINT SYSTEMS AND CLEAR COATS:

Outgassing can occur which will cause adhesive failure.

1. A minimum of 5 days curing time at 70 degrees F or above is required. Less than 5 days requires testing for outgassing.
2. Properly clean surface and apply a 2-inch by 2-inch piece of vinyl to the paint.
3. Check the test sample after 24 hours for bubbles due to outgassing. If no evidence of bubbles, application can be done.

#### NON-FLAT APPLICATION SURFACES:

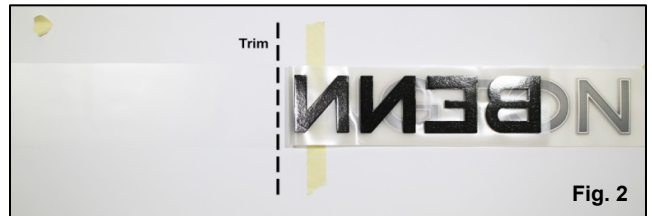
Maximum adhesion of SL24 product is dependent on a flat, smooth application surface. SL24 does have some ability to conform when applied, but textured or curved surfaces can interfere with adhesion. If a majority of the SL24 adhesive surface does not conform to the application surface to make permanent contact, installation failure can occur over time.

## APPLICATION GUIDELINES

**Place the SL24 component to the vehicle.** Proper alignment helps to ensure the proper location of the component. Use 3/4 inch masking tape to secure the component to the surface once proper alignment is achieved. With larger components, apply a strip of tape vertically through the center of the SL24 component and lightly tape each end to the application surface (**Fig. 1**).



**Remove the liner from the foam adhesive.** Remove the positioning tape on either side of the center hinge. Lift that half of the component and carefully peel away the liner from the foam adhesive prior to applying the component to the surface, being careful to keep contaminants off the adhesive (**Fig. 2**). Once the foam adhesive makes contact with an application surface, it cannot be repositioned. Now trim away that portion of the liner.



**Install the component.** Gently lay the first half of the component onto the application surface, making sure the component carrier is kept taut (**Fig. 3**). Use a 2 inch wide Speedball roller on the top of the applied component and firmly roll over all surfaces (**Fig. 4**). Remove the remaining tape and repeat the application process on the other half of the SL24 component.



**Remove the carrier.** Once completely applied, remove the component carrier by pulling back at a 180 degree angle to the application surface.

