

Decal Application Guide



**TRADE FILM LAMINATION
PAR EXCELLENCE**

Application Guide Outline

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Application

- The surface and accompanying ambient area should be 40°F or above for dry application.
- Note application temperature listed in the product bulletin of film used either pressure sensitive or static cling.

Surface Preparation

- The application surface must be clean and free of any dirt, grease, oil, wax, dust, gum or foreign matter.
- Household and/or available commercial cleansers or cleaning solvents can be used to remove contaminants from the application surface.
- After cleaning, the surface should be rinsed with clean, warm water and dried with a clean, lint free soft cloth.

Surface Types

GLASS

- Clean the glass surface thoroughly with non-ammonia based cleaner followed by isopropyl alcohol (IPA, rubbing Alcohol).
- Dry surface with dry, lint -free towel or cloth.
- The flashing of the IPA may cool the surface quickly and cause possible condensation. Allow the surface to dwell for 10 minutes before applying decal.

METAL and PAINTED METAL:

- Some metal and painted metal surfaces may require preparation by pre-wiping with solvents. Consult the manufacturer for recommended cleaning solvents.

SIGN GRADE WOOD/MDO:

- Wood surfaces should be sign grade and buffed with solvent saturated steel wool.
- Wipe clean and allow to air dry for at least 8 hours.
- Hardwood surfaces should clean, primed, and painted prior to decal application and had two weeks of dwell time to cure/ dry properly.

PLASTIC and SYNTHETIC LSE SURFACES

- All plastic surfaces should be carefully tested for adhesive compatibility. Wiping solvents such as mineral spirits or isopropyl alcohol are used for pre-wiping plastics. Check with the plastic manufacture for their solvent recommendation.

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Application Tips:

- If the application requires a seam, we recommend having no more than a 1/8" overlap.
- Never cut or release air bubbles with a knife or razor blade. This may allow moisture into the adhesive side of the film creating a future area for delamination or hazing of the adhesive.
- If using an application tape to hold decal in place while applying, be sure to use a lower tack tape. When removing, always peel slowly at a 180° angle.
- Be sure to make any alternations with placement before the product is applied with a squeegee. This increases bond and makes repositioning difficult.

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Application Tools

- Squeegee, stiff cardboard, or clean cloth
- Pin or needle
- Proper cleaning supplies

Application Method

- Clean and dry the application surface.
- Mark the desired decal position
- Align and apply decal by starting at the top of the decal. To assist positioning, fold down the first inch of the release liner at the top of the decal.
- Apply the adhesive coated side at the top of the decal to the application surface. Gradually remove release liner and squeegee decal as you go.
- If air bubbles occur puncture with a pin or needle and smooth down with squeegee.

Post Application Dwell

- Most pressure sensitive adhesives require 24-48 hours to develop complete adhesion to application surface Clean and dry the application surface.
- To provide maximum decal durability, edge sealing is recommended.
- The edge sealant is normally composed of an overprint clear ink or varnish with a similar chemical formulation to that of the ink used to print the decal.