

DECAL APPLICATION INSTRUCTIONS

To ensure that decals adhere properly to the application surface, follow the instructions below.

CLEAN

Most surfaces are best prepared by cleaning with a 50:50 mixture of isopropyl alcohol (rubbing alcohol) and water prior to applying decal. (***Most rubbing alcohol carried in drug stores is a 50:50 mixture**)

Listed below are some exceptions that may require additional surface preparation.

- ▶ **HEAVY OILS:** a degreaser or solvent-based cleaner may be required to remove heavy oil or grease from a surface and should be followed by cleaning with the alcohol/water mixture.
- ▶ **ABRASION:** Abrading a surface, followed by cleaning with the alcohol/water mixture, can remove heavy dirt or oxidation and can increase surface area to improve adhesion.
- ▶ **ADHESION PROMOTERS:** Priming a surface can significantly improve initial and ultimate adhesion.
- ▶ **POROUS SURFACES:** Materials such as wood, particleboard, concrete, etc. need to be sealed before application to provide a unified surface.
- ▶ **UNIQUE MATERIALS:** Special surface preparation may be needed for glass and glass-like materials, copper, and copper containing metals, and plastics or rubber that contain components that migrate.

PRESSURE

Bond strength is dependent upon the amount of adhesive-to-surface contact developed. Firm application pressure develops better adhesive contact and helps improve bond strength.

TEMPERATURE

Application temperature of the surface needs to be at least 50° F for best bonding to occur. Note that the surface temperature and air temperature may differ depending on the location of the product in reference to sun and shade.

MOISTURE

It is pertinent that the surface is dry and free of condensed moisture before application.

TIME

After application, the bond strength will increase as the adhesive flows onto the surface. Allow ample time for adhesion to occur. At room temperature approximately 50% of ultimate bond strength will be achieved after 20 minutes, 90% after 24 hours and 100% after 72 hours. This flow is faster at higher temperatures and slower at lower temperatures.