



TECHNICAL BULLETIN

APPLICATION INSTRUCTIONS

INSTALLATION PROCEDURE.

1. Turn the graphic over so the application tape is face down. Then peel the liner from the vinyl, rather than pulling the vinyl off the liner.
2. Holding the top corners of the graphic, lightly tack it into position.
3. In squeegeeing most graphics, begin in the center, and stroke the vinyl with an up and down motion. On the up stroke, your thumb should be at the bottom of the squeegee. On the down stroke, pull with your fingers on the top. This first stroke is your center line. All subsequent strokes work off of the initial center stroke. Each stroke must overlap the previous one. Try to keep the angle between the face of the squeegee and the application surface shallow, as you work. In addition, the squeegee should be angled slightly away from the center line. Imagine that you are pushing the air out from under the vinyl. Never angle the squeegee toward the center line...this produces bubbles. Maintaining good squeegee pressure is critical in forcing all of the air from under the vinyl. Wet application is not recommended. If you use the wet method, use a commercial grade application fluid and only spray a fine mist on the substrate. Do not saturate the substrate or the adhesive side of **VinylEFX™** vinyl.
4. If the application surface has seams, you must cut the vinyl along these seams. After cutting the film, use the edge of your squeegee to tuck the vinyl into the panel seam.
5. To remove the application tape, pull the tape against itself at a 180 degree angle. Resqueegee all of the edges and overlaps to prevent edge lifting. A low-friction sleeve on your squeegee prevents scratching of the vinyl graphics.
6. **EDGE SEALING IS RECOMMENDED.** Using a fine-tip brush, paint the edges of the **VinylEFX™** film with a commercial-grade product.



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knife plotters. For Gerber plotters, use a 30° blade. When cutting thicker **VinylEFX™** film constructions, such as Double-sided Gold Florentine or Coburn Phosphorescent Glow-In-The-Dark films, or when cutting very smaller letters or fine detail, use a 60° blade.

THERMAL DIE CUTTING. **VinylEFX™** films can be thermal die cut at heat settings between 295° and 300°F, at dwell times between ¼ and ½ second.

WEEDING. Begin weeding in the upper right corner of the material, working from right to left. Use care when weeding small letters or graphics with fine detail.

APPLICATION TAPE. Use a high tack application tape, such as R Tape AppliTape™ (#4075, #4076, #4775), R Tape Conform® Series (#4075RLA, #4076RLA, #4775RLA), or CLEAR CONFORM™ (AT-42, #2576).



Digitally-Printed Graphic

The graphic depicted above was printed on R Tape's **VinylEFX™** Gold Florentine Leaf, using the Gerber Edge. In printing this picture, the setting for cast vinyl was used.

SUBSTRATE PREPARATION.

1. Wash the substrate using warm water and detergent.
2. Remove remaining contamination, by cleaning the substrate a second time with isopropyl alcohol. Saturate a clean rag with alcohol and scrub the area to which the vinyl graphics will be applied. Before the solvent dries, use clean paper towels to wipe the dirt away.
3. Learn as much as you can about the paint system. Each paint formulation is different, with some containing additives such as wax and silicone, both of which can cause adhesion problems. Some formulations of powder-coated paints can also be a problem. As a rule of thumb, allow a paint system to dry for one week, before graphics installation, especially if it's a polyurethane paint. Cure time can vary depending on the ambient temperature, humidity and the amount of hardener used. Application of graphics over a paint system that has not fully cured can result in the formation of bubbles underneath the vinyl, resulting from the paint outgassing.

APPLICATION TEMPERATURE. For optimal results, apply graphics at temperatures of 70° F (21° C) or above.

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