

# Application Instructions for Avery Dennison<sup>TM</sup> Films Smooth Wall RV

Instructional Bulletin #4.00.1 (Revision 1)  
Dated: 12/31/14

## 1.0 Consult Product Data Bulletin

- Before starting application consult the appropriate product data bulletin for information regarding minimum and maximum application temperatures, recommended substrates, and immediate service conditions before and after application. These factors are critical to a successful application and future decal performance. Once assured that all factors are understood with respect to the product, and all factors comply with the product recommendations, cleaning and surface preparation can begin.

NOTE: Documentation of application date, material lot number, and application conditions (temperature, etc.) is required to support warranty claims in the event of decal failure.

## 2.0 Surface Preparation

- All application surfaces must be considered contaminated and must be cleaned according to Instructional Bulletin #1.10 Surface Cleaning and Preparation .
- The surface must be completely dry. Check all seams, rivet heads, and corrugations for any remaining moisture or solvent. If moisture or solvent is present, a heat gun may be used to dry the surface completely. Do not use a torch or open flame.

NOTE: Always ensure the painted surface has been properly processed per the paint manufacturer's specifications or recommendations. The drying or curing period of the paint system must be followed. Failure to adhere to the above can result in poor decal performance and difficult removal characteristics.

## 3.0 Application Tools

- Squeegee
- Heat Gun
- Razor Knife
- Rivet Brush
- Masking Tape
- Weed Burner (torch with flame spreader attached)
- Marking Pencil
- Air Release Tool (Straight Pin)

## 4.0 Temperature

- Ambient Air Temperature - Air temperature of environment
- Surface Temperature - Substrate temperature of vehicle or surface

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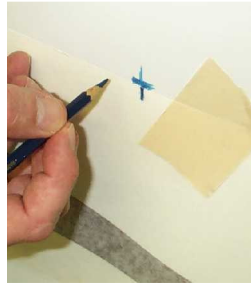
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NOTE: The markings can be applied if the ambient air and substrate surface temperature are between the minimum and maximum application temperature specified in the appropriate Product Data Bulletin. If the substrate surface temperature is below minimum requirements, the substrate must be heated until minimum application temperature has been achieved. During cold temperature months, it is recommended to use a weed burner on the surface of the substrate before and after application. This will increase the surface temperature of the substrate and accelerate the ultimate adhesion of the film.

## 5.0 Registration

- Use a pencil, pen, or marking tape, to mark the decal location on the application surface.
- If a chalk line has been used, replace all chalk marks with pencil or pen lines. Remove the chalk dust before applying decal. Dust from a chalk line, like dirt will cause poor adhesion.



## 6.0 Key Application Tips Before Proceeding

- Surfaces must be completely clean and prepared according to Avery Dennison Instructional Bulletin #1.10. This is a critical first step toward successful decal application.
- Follow the guidelines toward minimum and maximum application temperatures and required service conditions before and after application.
- Do not use application fluid or the “wet method” during installation. Water or application fluid not properly removed from underneath the film can remain between the substrate and the decal thereby reducing ultimate adhesion.
- The decal must be squeegeed before **and** after premask removal. During premask removal, decals are exposed to potential edge lifting. In order to eliminate this, re-squeegee the decal (paying particular attention to the edges). Wrap a squeegee sleeve or soft clean rag around the squeegee to prevent potential damage to the decal.
- All smooth body seams or edges must be cut flush with the edge, and be free of caulk, and sealant. The decal must be re-squeegeed along the cut edge to prevent potential edge lifting.
- The use of a rivet brush and heat source are recommended when applying graphics onto textured substrates.

## 7.0 Application Procedures

The following instructions show a step by step procedure for installing large premasked markings on a flat surface. The method used is the Center Hinge Method. Other methods can be used (such as top or vertical hinge method or no hinge method) at the discretion and expertise level of the applicator. For questions regarding application procedures or instructional videos on proper application techniques contact Avery Dennison’s Customer Technical Support Department.

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## 7.1 Application procedure large premasked marking center hinge method – Avery Dennison Films

1. Using previously marked registration marks position the marking on the application surface using small pieces of tape to hold it in place.



2. Once the decal has been properly registered, apply a masking tape hinge along the center edge of the decal.



3. Cut through the masking tape along the sides of the decal, being careful not to score the application surface.
4. Tack the graphic at the edge, application tape to application tape.

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6. Flip the marking up over the hinge and remove the liner. Always remove the liner from the marking.



7. Carefully cut the liner near the center hinge. Do not cut into the substrate. DO NOT TEAR the liner as paper fibers may be left behind.



8. Hold the decal away from the application surface with one hand.



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9. Begin to squeegee from the top center downward and outward. Use firm, short, overlapping strokes that run the entire height of the decal. Continue using the squeegee until the first side of the decal is applied. Hold the squeegee at the angle shown, when dragging the squeegee in the direction of the arrow.



10. Remove the masking tape hinge. Re-squeegee the top edge to which the tape hinge was applied using overlapping, upward strokes.

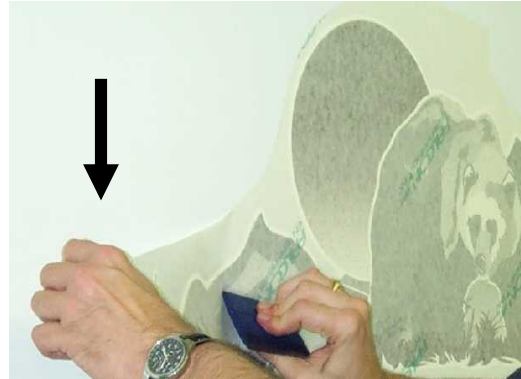
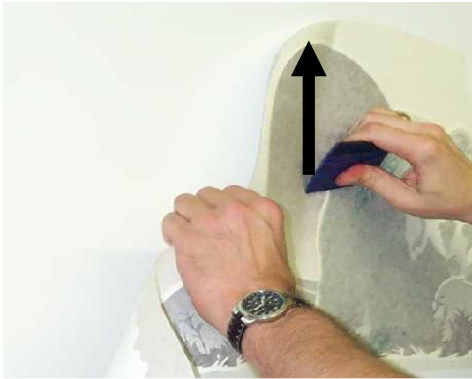


11. Pull the second half of the decal back on the first side (which has been applied). Remove the liner from the graphic.



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12. Squeegee the graphic as before, from the top center downward and outward. Use firm, short, overlapping strokes that run the entire height of the decal. Continue using the squeegee until the second side of the decal is applied. Hold the squeegee at the angle shown, when dragging the squeegee in the direction of the arrow.



13. Remove the premask/application tape from the decal by peeling back on corner of the mask and pulling it back at an 180° angle. Continue pulling the application tape against itself until the application is completely removed.



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14. Re-squeegee the entire decal using very firm squeegee pressure, including all edges. Pay close attention to the edges, ensuring the graphic is completely adhered to substrate.



15. Puncture any air bubbles with a straight pin, push air towards the pinhole with your thumb, and re-squeegee from the edge of the bubble towards the puncture.



### 7.2.2 Application Temperature

- Reference minimum and maximum temperatures on Product Data Bulletin.

*Revisions have been italicized.*

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