

3.7 Application methods for Avery Dennison® SignFlex 2200 issued: 11/2014

Introduction

Avery Dennison SignFlex can be applied either dry or wet.
Applications on used, scuffed or scarred flexible substrates are not recommended.
All graphics must be premasked with paper application tape such as PM 62.
The use of plastic application tapes is not recommended.

Preparation

Application temperature: for both wet and dry application the minimum is 10°C.

At lower temperatures (1 - 10°C) a special application fluid is required.

Application tools:

- Squeegee.
- Atomiser (such as plant sprayer) to dispense application fluid.
- Methylated spirits or a proprietary cleaner, to clean the surface prior application.
- Hot air gun.
- Sufficient cloth or paper to absorb the application fluid after application.
- Application fluid: a 2:1 mixture of methylated spirits with water.

Application procedure

Before application, all flexible face materials must be cleaned by wiping over the surface with a cloth soaked in methylated spirits.

Large pre-spaced texts can be hand cut into sections to facilitate application.

For large texts or logos which involve overlapping sections, allow a 5 mm overlap.

Overlaps should face to the rear or the bottom of the vehicle wherever possible. Generally, we do not recommend the use of knife blades that have been resharpened, as a different knife angle may change cutting performance. As the calliper of the films as well as the composition may vary, each material may require a specific adjustment of the knife blade: check before you start.

IMPORTANT: Avery Dennison SignFlex 2200 can be applied to a wide variety of flexible, PVC coated substrates. As some PVC coated substrates have been topcoated or treated otherwise, applicators should convince themselves that good adhesion can be obtained before actual use.
Use the knife to cut through the liner.

We recommend to regularly check the flatness of the surface of the drum or plotter table.

Application Procedure

1. Position the graphic (or its sections) on the face of the flexible substrate and fix it on the top edge with a suitable masking tape. Make sure that there are no wrinkles or puckers. The masking tape on the top edge must be able to serve as a hinge and should have sufficient adhesion to hold the graphic in place.
2. Once the entire graphic is in the right position, the first section should be rolled up (liner outwards) from the bottom to the hinge, without releasing the hinge.
Remove the liner for a maximum distance of 60 cm, starting from the top edge of the hinge.

For wet application:

- Spray the application fluid on both the adhesive side of the graphic and on the flexible substrates surface so that there is a fluid film on both.
- Apply the graphic to the curtain and squeegee it down with firm overlapping squeegee strokes to remove all fluid. Work your way down from top to bottom and to the middle of the edges of each section.
- Proceed with the other sections of the graphic as indicated in points 3. or 4. until the entire graphic has been applied. For wet application, make sure that all application fluid has been removed properly.
- The application tape can be removed at an angle of 180° downwards, 5-15 minutes after the completion of the application. However, with:
 - matt flexible substrates,
 - application temperature of 1-10°C,the application requires a dwell time of 10 - 30 minutes.
- Re-squeegee the surface of the graphic and, if it has been applied wet, wipe away any liquid expelled with an absorbent cloth. Check that all edges have been applied properly.
Take particular care with small pre-spaced graphics, lettering and fine details: gentle heat applied via a hot air gun ensures good adhesion, particularly at low application temperatures.
- Once the graphic has been applied, the flexible substrate must be kept for at least 2 hours at a temperature of 10°C or higher in order to allow the adhesive to settle down and any remaining application fluid to evaporate. Immediate use of the flexible substrate at low temperatures (e.g. in frosty conditions) may result in delamination.
- After completion of the application and the settling down period (see point 8), the flexible substrates or banners should be packed flat or wound for storage with the Avery Dennison SignFlex graphics to the **outside** of the pack or roll.