

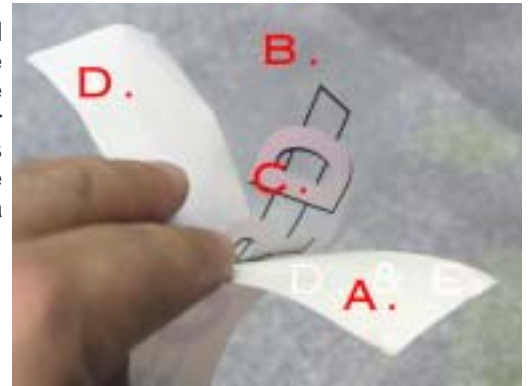


# Decal Application Instructions

## Clear-Coatable - Dry App (“rub-on”) Decals

**Storage:** Always store the unused decals in sealed bags and/or in an air tight covered container (i.e. Rubbermaid or Tupperware) to prevent deterioration of the adhesive and plasticizer lose. It is highly recommended to store the decals in a cool, dark, slightly humid area. Heat, UV light, and dryness can all have a detrimental effect on the flexibility of this product over the long term.

**Decal Construction:** This type of decal consists of five layers: A. adhesive-backed support paper, B. self releasing clear plastic film, C. the actual decal - also known as the “image area”, D. silicone release liner. The stock consists of the first two layers: the support paper coated with an adhesive layer, which in turn holds the self-releasing clear plastic film in position during the printing process. The decal itself (image area) is constructed by printing various layers of clearcoats and the image itself. The final image area layer is a pressure sensitive film used to bond the decal to your frame. Finally, a silicone impregnated release liner protects the image areas before mounting.



### Preparation:

- Find an area relatively free of dust and dirt where you can firmly support the frame, fork or other part to be decaled in a way that allows you to lay down the decal precisely. You’ll want to be able to look down the tube to line up the decal straight.
- Get a Bondo squeegee, available from your hardware store, also known as a “burnisher”.
- Use Windex or a similar non-residue cleaner to clean the surface. The area to be decaled must also be dry, and free of dust.

**Application:** Remove needed decals from the protective bags. Clean the surface on which decals are to be mounted. To prepare the decal for mounting, first remove support layer (“A”) by folding a corner of the stock down to separate the clear plastic and decal off the entire sheet of backing stock. Then remove the silicone release liner (“D.”) to expose the back of the decal (adhesive side). Care must be taken while separating stock not to prematurely break the bond between the decal to the plastic film. A slow and steady peel works much better than a ripping motion. If you have broken that bond anywhere on the decal it will now be visible by looking through the plastic film at the face of the decal. The separation areas will look frosted and will always be on corners or edges. This by no means scraps the decal, but you must be aware of these areas because once they touch the surface you are mounting on, you will not be able to lift the decal and reposition it. When mounting the decal care should be taken to get the correct position on the first attempt. You can’t stick it down and peel it back off with much success. Once positioned rub the decal down with your fingers, taking care not to trap air bubbles.



**At this point, using a clean dry rag, buff the decal down by rubbing the rag back and forth. This serves three purposes: First it bonds the adhesive to the frame with a combination of heat and pressure. Secondly, the rubbing loosens up the releasing agent that is bonded to the backside (squeegee side) of the clear film. Thirdly, rubbing the decal down before squeegeeing the decal down will eliminate the possibility of stretching the decal while squeegeeing. This in turn, will eliminate stress cracks, which could appear up to 2 weeks after mounting. THE IMPORTANCE OF THIS STEP CANNOT BE UNDERSTATED.**

**Burnishing:** Burnish the decal down with some sort of hard burnisher: a bondo squeegee or some other form of hard plastic applicator works the best. Be sure to burnish down the entire decal, reburnish the decal again. This second burnishing will cause the clear stock to move laterally, which separates the clear from the now mounted decal. This is how the release is achieved. You can actually see the two separate at this time. (Do not attempt to burnish the decal down once and then peel the stock up, this will cause the decal to rip and create a major scrap problem.) Slowly peel back the clear film making sure all areas of the decal have released properly. If any haven’t reburnish again.

**Inspection/bubble removal:** After removing the clear film, examine the decal to make sure the decal is laying flat on the frame. If any wrinkles, bubbles, or flaws remain reapply the clear film and work the area with burnisher. Large bubbles can be poked with a pin and burnished.

**Final Buffing/Prep for Clearcoating:** Buff the decal down with a clean dry lint free rag. Nylon or polyester work much better, than cotton, because they will leave no fibers stuck to the edge of the decals.

At this point, any tiny bubbles or waves in the decals will flatten themselves out with in about one half hour. Heating the decal slightly will speed this up. The decal is now ready for clearcoating, and baking at no more than 250F / 121C.

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Thanks to Gary at Screen Specialties for these instructions.

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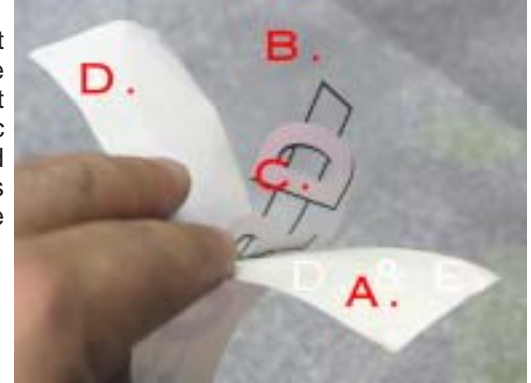


# Decal Application Instructions

## Top Mount - Dry App (“rub-on”) Decals

**Storage:** Always store the unused decals in sealed bags and/or in an air tight covered container (i.e. Rubbermaid or Tupperware) to prevent deterioration of the adhesive and plasticizer lose. It is highly recommended to store the decals in a cool, dark, slightly humid area. Heat, UV light, and dryness can all have a detrimental effect on the flexibility of this product over the long term.

**Decal Construction:** This type of decal consists of five layers: A. adhesive-backed support paper, B. self releasing clear plastic film, C. the actual decal - also known as the “image area”, D. silicone release liner. The stock consists of the first two layers: the support paper coated with an adhesive layer, which in turn holds the self-releasing clear plastic film in position during the printing process. The decal itself (image area) is constructed by printing various layers of clearcoats and the image itself. The final image area layer is a pressure sensitive film used to bond the decal to your frame. Finally, a silicone impregnated release liner protects the image areas before mounting.



### Preparation:

- Find an area relatively free of dust and dirt where you can firmly support the frame, fork or other part to be decaled in a way that allows you to lay down the decal precisely. You'll want to be able to look down the tube to line up the decal properly.
- Get a wax and grease remover from your hardware or better auto parts store. THE DECAL MOUNTING SURFACE MUST BE VERY CLEAN TO GET A GOOD BOND. THERE IS NO WAX, POLISH OR FINISHING RESIDUE ON THE SURFACE. AFTER MOUNTING, YOU CAN APPLY WAX OR POLISH RIGHT OVER THE DECAL.
- Get a Bondo squeegee, available from your hardware store, also known as a “burnisher”.
- Use Windex or a similar non-residue cleaner to clean the surface. The area to be decaled must also be dry, and free of dust.

**Application:** Remove needed decals from the protective bags. Clean the surface on which decals are to be mounted. To prepare the decal for mounting, first remove support layer (“A”) by folding a corner of the stock down to separate the clear plastic and decal off the entire sheet of backing stock. Then remove the silicone release liner (“D.”) to expose the back of the decal (adhesive side). Care must be taken while separating stock not to prematurely break the bond between the decal to the plastic film. A slow and steady peel works much better than a ripping motion. If you have broken that bond anywhere on the decal it will now be visible by looking through the plastic film at the face of the decal. The separation areas will look frosted and will always be on corners or edges. This by no means scraps the decal, but you must be aware of these areas because once they touch the surface you are mounting on, you will not be able to lift the decal and reposition it. When mounting the decal care should be taken to get the correct position on the first attempt. You can't stick it down and peel it back off with much success. Once positioned rub the decal down with your fingers, taking care not to trap air bubbles.



**At this point, using a clean dry rag, buff the decal down by rubbing the rag back and forth. This serves three purposes. First it bonds the adhesive to the frame with a combination of heat and pressure. Secondly, the rubbing loosens up the releasing agent that is bonded to the backside (squeegee side) of the clear film. Thirdly, rubbing the decal down before squeegeeing the decal down will eliminate the possibility of stretching the decal while squeegeeing. This in turn, will eliminate stress cracks, which can appear up to 2 weeks after mounting. THE IMPORTANCE OF THIS STEP CANNOT BE UNDERSTATED.**

**Burnishing:** Burnish the decal down with some sort of hard burnisher: a bondo squeegee or some other form of hard plastic applicator works the best. Be sure to burnish down the entire decal working from the center to the edges. Be sure to hold the plastic film down while burnishing, to avoid ripping or wrinkling the decal. Now, reburnish the decal, starting from one side on the film but not on the decal. Work into the decal. This will separate the edge of the decal from the film. Continue the separation across the rest of the decal. After this, burnishing the plastic film normally has separated from the decal, if not just peel it off. If by some chance the decal hasn't separated at this point spend more time burnishing.

**Inspection/bubble removal once the decal is mounted:** If there are any bubbles in the decal...tiny ones will pull themselves down in about a half hour, larger ones can be popped with a pin and burnished down. As with all pressure sensitive decals, it takes several days for the bond to really set in. Try to avoid major abrasion to the decal for about one week.

**Removing the decal:** If the decal is bonded to raw metal just rub the decal for quite awhile with a strong solvent like M.E.K. or a Lacquer thinner, or you can sand it off. If mounted on a painted frame that would be damaged by strong solvents, heat the decal up a little to soften the adhesive and scrape the decal off with the edge of a stiff piece of plastic (like a credit card) it will be slow going.