

Avery Dennison Instructional Bulletin 2.07

Application of Avery® SignFlex 2200

Introduction

Avery® SignFlex 2200 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 tapes. 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
- Spray bottle (such as plant sprayer) to dispense application fluid
- Methylated spirits or a proprietary cleaner, to clean the surface prior application
- Heat gun
- Sufficient cloth or paper to absorb the application fluid after application
- Application fluid 2:1 mixture of methylated spirits with water

Application Procedure

- Flexible substrates must be tensioned prior to application of Avery Signflex 2200.
- Before application, all flexible curtains must be cleaned by wiping 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 5mm overlap.
- Overlaps should face the bottom of the sign and the rear and bottom of the vehicle wherever possible.

Generally, the use of knife blades that have been resharpened is not recommended, as the different knife angles 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. Wrong adjustment may cause the knife to cut through the liner.

NOTE: Avery® SignFlex 2200 can be applied to a wide variety of flexible, PVC substrates. As some PVC coated substrates have been topcoated or treated, applicators should test the substrate to ensure adhesion can be obtained before use.

The following application procedure should be followed when applying Avery SignFlex 2200 using the dry method:

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. Peel approximately 60cm of the liner away, starting from the top edge of the hinge.
3. Apply the graphic to the curtain and squeegee it down with firm overlapping squeegee strokes. Work your way down from top to bottom and from the middle to the edges of each section.
4. Proceed with the other sections of the graphic until the entire graphic has been applied.



5. The application tape should be removed at an angle of 180° downwards, 5-15 minutes after the completion of the application. However with matt flexible substrates, and an application temperature of 1-10°C, the application requires a dwell time of 10-30 minutes.
6. Re-squeegee the surface of the graphic. 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.**
7. Once the graphic has been applied the flexible substrate must be kept for at least 4 hours at a temperature of 10°C or higher in order to allow the adhesive to settle down. Immediate use of the flexible substrate at low temperatures (e.g. in frosty conditions) may result in delamination.

The following application procedure should be followed when applying Avery SignFlex 2200 using the wet method:

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. Peel approximately 60cm of the liner away, starting from the top edge of the hinge.
3. Spray fluid on both the adhesive side of the graphic and on the flexible substrates surface so that there is a fluid film on both.
4. 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 from the middle to the edges of each section.
5. Proceed with the other sections of the graphic until the entire graphic has been applied. Make sure that all application fluid has been removed properly.
6. The application tape can be removed at an angle of 180° downwards, no less than 15 minutes after the completion of the application. However with matt flexible substrates, and an application temperature of 1-10°C, the application requires a dwell time of at least 30 minutes.
7. Re-squeegee the surface of the graphic. If it has been applied wet, wipe away any liquid expelled with an absorbent cloth. Check 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.**
8. Once the graphic has been applied the flexible substrate must be kept for at least 4 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 the flexible substrates or banners should be packed flat or wound for storage with Avery® SignFlex 2200 graphics to the outside of the pack or roll.

For further information, contact your local Avery Graphics representative.