



## **DIRECTIONS FOR THE APPLICATION OF LARGE DECALS**

- 1) Preparation of surfaces: metal, plastic or fabric. **THIS STEP IS CRITICAL.**
  - A) Clean off all oil, grease, dirt, polish and stains. Use of a gentle solvent like denatured alcohol is recommended. Test the solvent in a small and inconspicuous area for damage to surface.
  - B) Surface is to be at room temperature, 60 to 80 degrees.
  - C) Anyone who is going to handle the decals should thoroughly wash hands to remove all dirt and natural skin oils.
  
- 2) Layout Preparation and Decal Alignment:
  - A) Using a washable pen or pencil, mark layout lines on the surface where the decal is to be applied. Some suggested layout lines are: a line aligned with the bottom of the decal, a line marking the center of the decal, lines marking the ends of the decal. Test the pen or pencil in an inconspicuous area to be sure the lines can be wiped away without leaving any residue. Mark the surface of the transfer film with lines that correspond to the lines on the application surface. For example, if the centerline was marked on the surface, measure and mark the centerline on the decal.
  - B) Leave the backing paper on the decal. Use painter's tape (or any tape that will not damage the application surface when removed) and tape the decal to the application surface aligning the layout lines on the decal with the lines on the surface. In the application step (next) you will be folding the decal back at the center, so make sure that the decal is well taped near the center and at the end opposite of the end you are folding back.
  
- 3) Application:
  - A) Pull one end of the decal loose from the surface and gently fold back at the center. You will be applying the folded portion of the decal to the surface, so if the decal is clear or translucent, make sure all layout lines that will be under the decal are removed. One can leave the portion of the lines outside the area that will be under the decal. However, the layout lines should no longer be needed if the end opposite the folded end of the decal is securely fastened. When applied, the folded end of the decal will be properly aligned if it is applied without folds or bubbles.
  - B) Start from the end of the folded portion and peel the backing off of the decal. Clean hands are important since any oils that get on the decal's adhesive will reduce its ability to adhere to the surface. Also, be very careful to not allow the adhesive surface of the decal to fold on itself. For very large decals, this might require an assistant to hold the decal while you peel off the backing. One could also temporarily tape the free end of the decal to hold it while peeling off the backing. After the decal has been peeled back to the center, cut the backing along a line near the point to which the decal has been folded.

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Aviation graphics on a higher plane.

- C) Lightly spray the back adhesive surface on the lifted end of the decal with Windex (or any other window type cleaner). Also lightly spray the surface where the decal is to be applied. A solution with the ratio of 2 oz. of dish soap per 1 gallon water can be used in place of window cleaner. The spray allows you to have some movement in the decal for a few minutes. You can skip this step if you can apply the decal smoothly without air bubbles and folds.
  - D) Apply the decal to the surface working from the center of the decal toward the end. Use a squeegee and diagonal strokes. Squeegee from the center toward the end as you place the decal to remove air bubbles, folds and moisture from the spray.
  - E) You can proceed to applying the other end before allowing the moisture to dry and the decal to adhere if you are careful to support the decal during the following steps. If you do not support the decal it can pull at the applied end causing it to move or twist. If you are in doubt, let the applied end dry. When you are ready, pull the tape off the other end and fold that end back. As before, make sure all the layout lines are removed from under area where decal will be applied. Peel off the backing as before except this time all the backing is removed. Lightly spray the surfaces. As before, apply the decal working from the center toward the end. Squeegee out the air bubbles, folds and moisture.
  - F) Permit the moisture to dry and the decal to adhere before attempting to remove the front transfer film. This requires patience. Once the decal has adhered the transfer film can easily be removed.
- 4) Enjoy your new decal. These procedures will help insure that your decal will be well adhered and can be enjoyed for many years.

**Note:** Newly painted surfaces must be allowed to dry prior to decal application. Decals can be gently molded around rivets and laps by using a hair dryer to warm and soften the decal.

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## Illustrations

Step 2) The following drawings show the layout lines on the application surface to the left and the decal to the right.



Example Decal



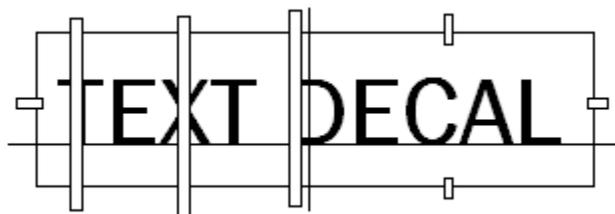
Layout lines when decal should be centered



Layout lines when decal should be aligned on the left.



Layout lines when decal should be aligned on the right.



Decal taped to surface with centered layout. The right end is the end that will be folded back.