



Vinyl Wrapping System Application Guide

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1. Storage

- The VWS ranges offer a two-year storage guarantee for materials provided they have been kept at temperatures of +15°C to +25°C and at relative humidity of 40 to 60%.
- Avoid direct exposure of the vinyl to high temperatures (near radiators, direct sunlight.... etc.)
- Any part used rolls should be kept vertical or horizontally hung on racks. Rolls should never be placed on their sides as this could lead to a large matt section appearing in the whole roll.

From time to time rolls may become matt in parts. The softness of the material means that the surface can take on the appearance of the release liner in the next single turn. This is perfectly normal and reversible. The VWS range will regain its glossy appearance once applied to the substrate (car, truck ... etc) although the time it takes to regain its original finish will depend on the temperature. In winter it may take several days, or in summer, just a few hours when exposed to sunlight. If a hot air gun is used during application, it could take just a few seconds.

2. Preparation/Cleaning the Application Surface

The best result is achieved by careful preparation of the surface before wrapping. It is recommended that the film be applied indoors, in a clean, well lit, dust free environment.

- Lights, handles, aerials, trims and any other protruding items should be removed, where possible, before application.
- Car wax and polish residue must be completely removed.
- Newly painted vehicles must be allowed 7-10 days drying time.
- Clean all surfaces thoroughly using a four stage preparation process: -
 1. Thoroughly wash the surface to remove all dirt either by hand or in an automatic car wash.
 2. In a warm workshop environment, where the vehicle is at 17 -24°C clean again with a white spirit/water mix at approximately 10% white spirit to water to remove any surface contamination, wax or silicone etc. Pay particular attention to recess areas when de-greasing and cleaning.
 3. Finally clean the recesses and rebates with isopropyl alcohol or methylated spirit. Wipe dry with a lint free cloth before the alcohol/spirit has had an opportunity to evaporate.

To ensure complete drying of the surface before application, a heat gun can be used. If not any moisture trapped beneath the film will lead to failure.

The surface should now be suitable for application.

3. Application

3.1 Dry Method

Dry application is the preferred technique and the only method recommended and warranted.

Applications are best performed in clean and dry workshop conditions with the surface allowed to reach ambient temperatures of 20°C. Application to a cold substrate will adversely affect the adhesive bonding characteristics by reducing the adhesive tack. In the same way higher temperatures could result in the adhesive becoming more aggressive which could lead to pre tack where the film adheres to the substrate prematurely

- Tools required: -
 - Soft and hard squeegees.
 - Scalpel/retractable trimming knife.
 - Tape measure.
 - Heat gun.
 - Cleaning/de-greasing cloths and materials.
 - Basic toolkit (for handle/trim removal).
 - Rivet brush.
 - Cotton gloves.
- For three-dimensional surfaces that require the vinyl to be shaped or moulded around rivet heads, corrugations, welded areas... etc, some heat applied by a heat gun may be required.
- The application of this film to a vehicle is best performed by two people. Overall wrapping times can be reduced with the assistance of a third person to remove and replace trims, handles, lights... etc and on larger vehicles when wrapping roofs and 'difficult to get to' places.
- Measure and cut the first panel of material. Lay the vinyl face down on a table and remove the protective release liner at an angle of about 30 degrees.
- Offer the material up to the panel and, taking an approximate horizontal centre line, run a finger across the panel width to secure the centre. Use as little tension as possible when applying the film. Slightly tension the film upward and, using finger pressure, 'tack' the upper corners. Repeat downwards for the lower section.

- Apply broad overlapping horizontal strokes using a soft squeegee to secure the large areas of material, (ignore recesses/handles for the moment). The unique adhesive will allow air bubbles to be dispersed easily. If any large bubbles become trapped or a crease appears then warm the vinyl surface, 'tap' the material away from the vehicle and then re-squeegee.
- When wrapping using material produced on Premium Apply Liner it is essential that the whole surface is thoroughly squeegeed during application, paying particular attention to large areas such as the roof and bonnet.
- Where recesses and stepped changes of section are encountered, the film should be laid or fed into and around these sections applying as little tension as possible. Use a hard squeegee edge to ensure that the material is well adhered to the internal angles/returns of the recesses. NOTE: If using heat, use only the minimum amount required - 60°C -80°C, and work in small areas.
- Heat the film again in these areas to ensure the adhesive is fully activated – this will help achieve ultimate adhesion in these difficult areas.

It is not required or advisable to post heat the film when using material produced on Premium Apply Liner.

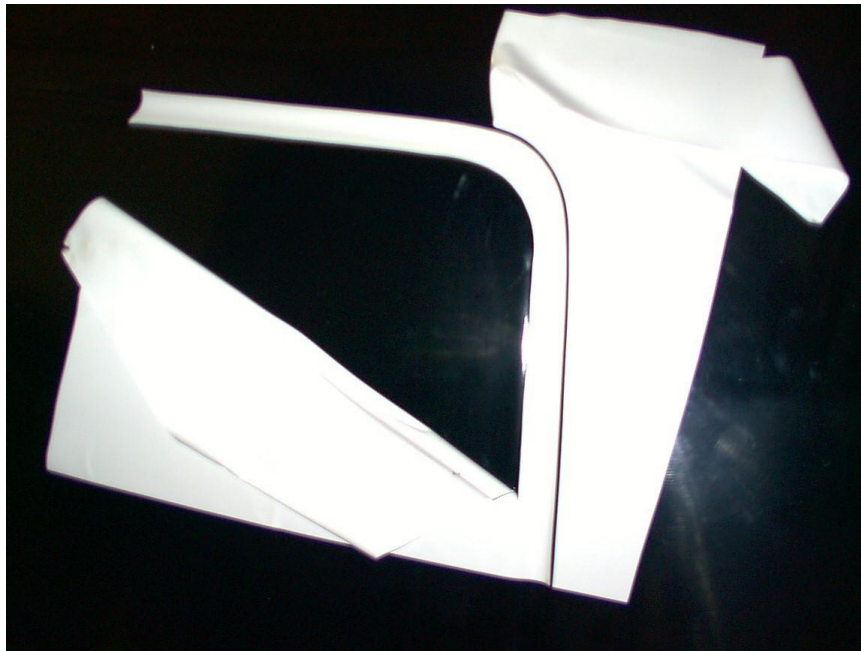
- For compound curves and complex multi curves, such as the rectangular grooves on panel vans, special techniques must be used. This involves laying a cut section into the groove, the edges of which are then overlapped by the vinyl covering the van side. See section 3.1.1 for further information
- **Caution: If using a heat gun, keep it at least 200mm away from the vinyl surface and use broad sweeping movements to heat the vinyl.** Use only the minimum amount of heat at all times. Overheating the film will contribute to adhesive failure.
- During fitting, care should be taken not to overstretch the film. Minimum tension should be used and it is best to average the 'stretch' over as large an area as possible.

If the film is being printed, it is suggested that the design is carefully planned to allow for 'stretch' zones around door edges/recesses and for cutting and fitting into recesses.

- The film should not be cut flush to the edges of bonnets, doors boot or panel edges. Instead, the film should be wrapped around the edges by about 6mm to minimise the exposed edges of the vinyl.
- The film should not be cut to the edges of rubber mouldings but must be applied under the moulding to eliminate the possibility of exposed edges of the vinyl.
- Text can be applied separately after wrapping.

- As with all vinyl, printed materials must be thoroughly dried for a minimum of 24 hours to eliminate the chance of retained solvents affecting the adhesive properties. The use of ICC Profiles is highly recommended to maintain compatibility.
- If overlaminating the printed vinyl please allow a minimum of 48 hours for the inks to cure before lamination.
- Application to materials such as ABS, PP or rubber is not recommended. Do not apply VWS to these surfaces if long-term decoration is required.
- After application, do not clean the vinyl with a solvent-based cleaner. Normal vehicle washing procedures should be used.
- For further advise regarding Premium Apply application please refer to Premium Apply Application Guide WI 506

3.1.1 Applying to Panel Van Recesses



- 1 Apply VWS over the panel and recess. Cut a strip of the film (fillet) wide enough to fit into the recess and internal edges allowing material for trimming. Remove the excess material leaving the fillet. Working from the centre of the recess outwards in both directions, squeegee the vinyl into the base of the recess, around the internal radii and up to the outside edges of the recess. Remove the waste from the panels.



- 2 Apply VWS to the flat panels and cut to overlap the edges of the vinyl in the recesses. Use gentle heat if necessary on the corners. This application method hides the joint line from view and ensures that the vinyl remains in the recesses.



- 3 Demonstration of a completed recess corner. Some material has been removed from the recess for clarity.

3.2 Wet Method

- Wet application under normal conditions is not recommended because: -
 - This method of application, combined with the low initial grab of the adhesive, produces very little initial tack.
 - Trapped water will restrict adhesion and makes it very difficult to “work” the material into recesses and around complex shapes.
 - The ultimate adhesion may be compromised, particularly in a cold climate.
- Film applied by wet application will not be warranted with regard to removal.
- If a wet application method has been employed, the vehicle must be kept in a heated environment for 24 hours after application and after this period of time the whole vinyl surface should be re-heated with a heat gun and squeegeed firmly. Pay particular attention to recess and swage line areas.

After application, do not clean the vinyl with a solvent-based cleaner. Normal vehicle washing procedures should be used.

4. Aftercare

Hand washing/conventional carwashes should not present a problem to the film. However, it is suggested that the use of power washes, steam cleaning and washing systems involving chemicals is discouraged. All of these can cause accelerated damage to any vinyl product.

Once cleaned, the surface can be polished/protected with a conventional car wax product.

Scuffmarks should be removed by a gentle rub with ‘T-Cut’ cutting compound and the gloss brought back by re-heating the vinyl followed by the application of a wax based polish.

5. Removal

Ideally the vehicle should be placed in a warm environment at about 20°C for at least 2 – 3 hours before attempting removal.

- Heat the vinyl to a temperature of +60°C to +80°C using a heat gun.
- Starting at an edge gently peel the vinyl away from the surface. This is best done at a 30-degree angle. Work gradually down each panel heating and peeling as necessary.
Caution: Do not snatch the material away from the surface or attempt to remove any areas that have not been heated.
- If there are any problems with removal – **STOP** – and contact the VWS supplier for detailed advice on how to proceed.



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- **DO NOT** continue to remove the film unless advised to do so by the VWS supplier.
- The VWS supplier cannot be held responsible for inappropriate removal methods or for poor paint/lacquer adhesion to the vehicle bodywork.

6. Caution

- This film is not a cure for rust! It is recommended that it is only fitted to paintwork that is in good condition.
- Whilst the film will cope with most recesses and swage lines, it is possible to over-stretch the film. Very deep/textured recesses (similar to those found on the Mercedes Sprinter, Vito and other panel vans) can still present difficulties.
- Before wrapping vehicles with these types of recesses, please contact your KPMF distributor for specific application advice.
- It is strongly recommended that any printed vinyl is thoroughly dried for a minimum of 24 hours to eliminate solvent retention before being applying to vehicles. Solvent retention will affect the adhesive properties and the removability of the film.
- If laminating the printed vinyl please allow a minimum of 48 hours for the inks to cure before lamination.
- It is essential that the same batch of film is used for the same end application

7. Warranty

Kay Premium Marking Films are produced under careful quality control and are warranted to be fit for the purpose and free from defect in material and workmanship. Any material shown to be defective to our satisfaction at the point of sale shall be replaced free of charge. Kay Premium Marking Films Limited liability to the purchaser shall in no circumstances exceed the cost of the amount of the defective material supplied.

8. Material Supply

- Supplies of material, training and application advice can be obtained through your local KPMF distributor.

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