

Installation Bulletin for LG Hausys Win-Deco

Storage and processing conditions

LG Hausys Pressure Sensitive Adhesive products are delivered in rolls which should be stored either suspended or standing on the roll blocks provided in a cool, dry place. Avoid exposure to sunlight. Prior to the production process the PSA films should be accommodated to the humidity and temperature prevailing in the processing area. The optimal conditions are a relative humidity of 50% to 60% and a temperature range between 18°C and 22°C. Higher variations of the above mentioned conditions can lead to a higher degree of shrinkage of the release paper. The result is a limited flatness of the self-adhesive material and dimensional changes when cutted. Please refer to our Technical Product bulletins on our website <http://sign.lghausys.eu/en> as well.

Surface Preparation

1. The surface must be cleaned thoroughly before applying the product. Clean the glass surface thoroughly with a neutral cleaning agent which does not contain any wax. Spray the glass surface completely with a soap solution.
2. Clean the surface thoroughly with a glass scraper to remove any dirt. Remove any dirt by rubbing the pane with a rubber squeegee and speed up the drying process in the edges by using a lint-free cloth or paper towels which will not leave any lint or dust behind on the surface.
3. Spray the pane again until wet.

Application Temperature and Environment

1. Application must be administered indoors where temperature and humidity can be controlled.
2. The optimal air and vehicle surface temperature for film application is 18°C ~ 22°C. If the air and vehicle surface is lower than the recommended temperature, sufficient stretching may not be obtained and the initial adhesion of film may not be strong enough to last permanently because of the rapid drop of the film temperature. If the air and/or vehicle surface temperature during application is excessively high, the initial adhesion may be too strong and can result in problems where the film may over-stretch, and trapped air may not successfully release.
3. In order to achieve sufficient bond between the film and vehicle, the vehicle must not be exposed to cold or wet climate for 24 hours after film application.
4. The above instructions must be complied with to prevent the film from developing shrinkage or film memory problems.

Removing Silicone Paper

1. Lay the e-cut film with the film side down on a flat and even surface. Pull back only as much release liner as necessary to start application. Always draw the release paper from the film, never the other way round.
2. Remove the backing paper from the foil and spray the adhesive surface of the foil at the same time as removing the protective foil.

Application Techniques

1. LG Hausys recommends to use only material with the same LOT number for the same color. Principally there are two main application techniques: dry and wet application. Wet application should only be done when the outside temperature is above 20°C.
2. Spray the exposed adhesive side with low-surface-detergent and lay it upon the application surface. One of the benefits of wet application is the easy way of precise positioning.
3. Press the foil onto the surface with a felt wiper, make sure that the water is completely removed with a small amount of pressure and that there is no water between the foil and the surface.
4. In the case of applications across overlapping rubber seals or expansion joints, use a sharp knife to separate the foil in these places so that the foil does not come off when it is exposed to movement.
5. Soak up excess water on the edges with a dry cloth or rag.
6. Hold up the graphic on one side first and remove only half of the release paper. Then, place the graphic on the vehicle surface and stretch it over the areas to be covered. Repeat above installation procedures for remaining portion of graphic.
7. Apply film using a felt-tip squeegee. For application on curved areas, soften the film before application by using a heat gun to heat up the surrounding areas of curvature and the film to the temperature of approximately 80°C. Continuous use of the heat gun in the same spot may cause damage to the film; therefore, position of heating must be constantly changed.
8. When application is completed, cut off the edges after film has sufficiently cooled down. If the film is cut along the edges of the vehicle, the cut edges may become loosened or the film can shrink when washing the vehicle afterwards. Therefore, the edges must be cut with some reserves left and tucked inside.
9. For areas with severe curvatures, sufficiently stretch and soften the film with a heat gun before application. On areas with protrusions and indentations, apply film along the surface without stretching or forcing into position. Finish up the corner areas by pressing down on the film using the round tip of a squeegee.
10. If air bubbles remain after application, use an air release tool to remove only the large bubbles, as smaller bubbles disappear within several days when exposed to sunlight.
11. The above instructions must be complied with to reduce the possibility of application failure or film memory problems.

After Application

1. Wait three days after applying the Win-Deco foil, until complete adhesion of the foil to the surface has occurred.

Removal

1. To remove film after use, temperature of both air and surface must be above 10°C. Removal at lower temperatures may be more difficult as the film can become brittle and/or leave adhesive residue traces.
2. Using a heat gun, etc., heat up the part of film to be removed to a temperature of approximately 70°C. Lift up the edges of the film and remove it, maintaining a 90° angle between the film and vehicle surface.
3. Application of film to a surface where the coating has not been sufficiently hardened may cause damage to the surface.
4. Residue remaining after removal of film can be cleaned by using solvent or a designated remover. Always test vehicle finish for solvent, cleaner, or chemical compatibility first.
5. Defects will only be recognized as a defect only on products sold as “removable” and then, when the residue remaining is more than 30%. This warranty will only apply to LG Hausys’ recommended removal methods. LG Hausys should be notified of warranty claims no later than seven (7) business days after the attempted removal.