

General Decal Application

BDESIGNS has no control over your decal application and therefore takes no responsibility for any losses or personal injury of any kind, incurred by you or any other party. If you are not experienced in decal application we recommend you have a local professional shop apply the decals. It is highly recommended you use an installer who is experienced in motorcycle decal application.

READ DIRECTIONS THOROUGHLY BEFORE STARTING

Tools and Material Required

- Low adhesion masking tape.
- Spray bottle and dishwashing detergent.
- Hard rubber or plastic squeegee.
- Tape measure (preferably cloth).
- Vinyl gloves so you don't get fingerprint "grease" on the decals or application areas.
- An ammonia based cleaning product such as Windex.

Decal Installation Procedure

1. If the surface has been freshly painted, allow at least a week for proper curing time before installing decals. Paint will off-gas as it cures, and can attack the adhesive backing of the decals. The off-gassing **may** also cause small bubbles to appear after the decal has been applied. These bubbles can increase in size and quantity as time passes. Paint cure times can vary depending on air moisture content, temperature, paint chemical composition and how much hardener is used. Professional painters use more or less hardener in the paint to speed or slow the cure time. If the decals are being clearcoated over after installation, please refer to "General Clearcoating Guidelines" instructions for proper surface preparation before installing the decals.
2. **DO NOT RUSH YOUR APPLICATION!**
3. Most decals come with a clear or paper based "transfer" material over top of the decals to aid in handling and placement of the decal. The transfer material also allows you to pull off and reposition the decal if it hasn't been pressed down. Handle only the outer edges of the transfer material. Do not put your fingers onto the back area of the decal graphic. The decals are very sticky, don't let it crease, or fold over on itself. For the decals that don't have the transfer material, ignore any references to that material.
4. Installation temperatures are **very** important! Decal installation **must** be done in a warm environment, but not in direct sunlight, not on a hot part and not in a dusty environment. **DO NOT** install decals in cold temperatures. Cold temperatures will prevent the decals from sticking to the surface properly. Cold temperatures will also cause the adhesive on the transfer materials to become stiff and more aggressive and on printed decals can pull some of the colours off the decals (this will look like speckles of missing colour).
5. All Surfaces must be cleaned and all wax removed. To remove the wax, only use an ammonia based cleaner such as Windex. You can also purchase cleaners from automotive paint supply shops that work very well. **DO NOT** use any solvents or alcohols.
6. Use the masking tape to underline or act as a reference to where you want to place the decal.
7. With your spray bottle, mix by spoon, 2 -3 drops of dishwashing detergent with one litre (quart) of water. Liberally mist the solution on the area you want to place the decal. This mist will enable the decal to be gently lifted off if it is not placed correctly.
8. Ideally, you want to hold a decal vertically by an edge of the transfer material, while you pull the backing material away from the decal. This position will minimize dust settling on the adhesive side of the decal, If you find this difficult to do, or with large decals, position the decal with the transfer material (decal) facing down, gently lift up an edge or corner of the backing material. Slowly and carefully peel the backing material away from the decal/transfer material. The decal will stay attached to the transfer material. Use tweezers for very small decals. Place the decal in the proper position, according to your guides and measurements. Gently slide the decal into position. Too much pressure will distort the decal.
9. While gently applying pressure with your fingers/hand/palm (depending on decal size) to hold the decal in position, use the squeegee to squeeze the water out from under the decal. Squeegee in all directions starting from the centre if possible and work the solution and air bubbles toward the outside edges. Repeat several times to ensure the bubbles have been worked out. **Note: If you have clear transfer material on your decals, you may need to use a hair dryer to warm the decal (not very warm or hot!) before you remove the transfer material, for ease of removal.** Mist the outer face of the transfer material and let the decals sit for about 10 to 15 minutes. With your fingernail, lift one corner of the transfer material and **slowly** peel it off 180 degrees (basically folding it back on itself). Pulling at 90 degrees or straight up, may damage the decals. If you pull the transfer material off too quickly, it can damage the decal material. On printed decals, this may also cause small speckles of colour to be removed with the transfer material. As an

estimate you are trying to achieve a speed of approximately 1.5 – 3 mm per second (1/16” to 1/8” per second). This time can be affected by many variables, so please take your time to ensure the removal is successful.

10. Check to make sure all the water/air has been removed. If not, re-apply the transfer material and remove any remaining water/air. This helps ensure good adhesion and helps to conform the vinyl decals on irregular shapes. These processes remove air and water from under the decal.
11. Decals should be allowed 24 hours to dry. If there are any small air bubbles remaining after drying, use a sewing needle to poke a tiny hole to release the air. For decals that are going to be clear coated over, it is imperative that any bubbles are removed before you apply the finish over top of the decals. A higher level of heat may be required during step 7 and this step, to work out stubborn air bubbles – DO NOT USE A HEAT GUN – a hair dryer should be more than enough. Again, an experienced decal installer will know how to do this. Small bubbles will disappear over time with exposure to sun, as the air slowly seeps out and the heat from the sun “tightens” the vinyl material.
12. If you find that any small speckles of missing colour have appeared if the decals were not removed properly, you can try touching them up with a Laser Point Sharpie colour marker. You can test different colours. If a colour is too dark or too light, simply remove the marker with a Kleenex that has a small amount of alcohol on it and try another colour.
13. If you are clear coating overtop of the decals, clean all soap and water residue off with an ammonia based cleaner such as Windex. **DO NOT** use any solvents or alcohols.
14. If you are not clear coating over the decals, you may apply a coat of wax to shine the part and decal up.