



## 22k NON-PRINTABLE INSTRUCTIONS

*PLEASE READ THESE INSTRUCTIONS THOROUGHLY BEFORE CUTTING.*

This product is top-coated with Tedlar®--nothing sticks to this surface--DO NOT CLEARCOAT

### PRELIMINARY

Before cutting, be sure the product code on your box of SignGold does NOT have a letter "P" contained in it. This is important as this letter designates the Thermal-Printable product. The TP product cuts at a different knife pressure setting so check before using to be sure you have the correct product for your particular job. NOTE: Gold can have slight color differences between rolls. If using 2 rolls for the same job, ask distributor to order 2 rolls from the same RUN so color is the same. Or, order 1 full roll to handle the job.

### CUTTING

Always make a "test cut" before cutting, at least until you have become familiar with SignGold's properties. ALWAYS USE A SHARP BLADE. Cutting an upper case Helvetica "A" or "N" serves as a great test for blade sharpness.

A standard angle blade used for cutting standard PVC vinyl is fine; no special blade is needed...cuts like butter.

Our non-printable product cuts and weeds as good or better than a good quality high performance cast vinyl.

Never cut SignGold products too deep...Just enough pressure to kiss-cut the material so weeding is easy. Cutting too deep into the poly-liner can cause the adhesive to settle into the cuts thus causing difficulty in getting the SignGold to release from the liner.

Never allow SignGold products to be rolled backwards (with the release liner to the outside). Try to keep the material flat as it goes through your cutter to keep down the chance of tunneling. Always cut material at room temperature and do not cut material during cold temperatures below 50 degrees as premature release from the liner resulting in tunneling is possible.

### WEEDING

Weeding SignGold is actually easier than weeding many high performance vinyls. It is recommended that you weed your job immediately after cutting. Do not leave for the next day.

### APPLICATION

SignGold should be applied dry as the preferred method. But, a light spray of application fluid is okay. Never use application fluid with ammonia. Be sure to squeegee out all fluid under the SignGold film.

Use a "medium to high" tack application tape. On letters or graphics taller than 8 inches, a "high" tack tape is recommended. Using a translucent application tape like Transferite clear 1310 or R-Tape clear medium tack Conform series will make registration to your outline easier.

To insure good adhesion on vehicles, SignGold is best applied over high performance cast vinyl like Gerber/3M 220 series vinyl. On dark color vehicles, high performance cast vinyl is highly suggested under SignGold. If it is necessary to remove SignGold later for some reason, it removes much easier because the high performance cast material is under SignGold.

**NEVER APPLY SIGNGOLD MATERIAL OVER WATER-BASED, ACRYLIC, OR LATEX FINISHES.**

When applying SignGold to acrylic or polycarbonate sheets, remove substrate protective sheeting and allow surface to outgas at least 24 hours before applying any SignGold product.

Applying SignGold over wood or HDU, the surface must be sealed using an oil-based or epoxy coating to restrict moisture exposure from behind the SignGold. We recommend West Systems Epoxy #105 Resin with the appropriate hardner.

### SEALING & FINISHING

As indicated above, SignGold does not need clearcoated as the DuPont Tedlar over the gold is all that is needed as a top-coat. Tedlar is an outstanding PVF crystal clear film that helps give SignGold outstanding durability in demanding exterior applications.

EDGE SEALING WITH ONE SHOT 4005 KEEPS the 12-14 YEAR WARRANTY VALID. Note: Better edge seal coverage and protection will be achieved using a traditional brush application. Seal-It pens are acceptable but use great care not to miss any areas during the sealing process. Use a liberal coating to insure SignGold edge is sealed to the vehicle background or vinyl if an outline is used.

### TECHNICAL ASSISTANCE

*We encourage you to contact our SignGold Technical Advisor, Larry Hoppe, at 845-649-9858 with any questions or concerns. Larry is available weekdays, 8-5:30 Eastern Time to share technical info.with our customers to insure success the first time! We take great pride in our technical advice service.*