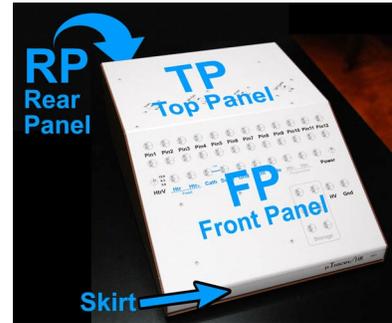


uTracerHR Vinyl Application Process

5/12/19

- Define **FP** = front panel, **TP** = top panel, **RP** = rear panel, as seen at right.
- Setup on the kitchen bar counter: Paper towel work area, spray bottle with soapy water, pins, scissors, camera, lights?, X-acto knife, masking tape, penlight, squeegee, paper towels, heat gun, alcohol, paper towels, nitrile gloves. Lay craft paper on the work surface, 2" of #22 wire.
- Be careful with the squeegee, else the matte finish could be marred.
- Make pinholes at corners of the top panel and ends of the panel.
- Trim the front and back ends of the art, leaving enough length to wrap around the flanges and adhere to their other sides. 3/8"?
- Cut V-notches or cuts at the corners.
- Cut the end corners as shown at right.
- Don the gloves and clean the panel with alcohol-- visible panels and 2" edges on back.
- Place the vinyl face down on the table with backing still in place.
- Remove the backing from the TP section of the vinyl (including pinholes) by pulling up the backing from the RP section, cutting off the RP backing, then pulling up the backing from the TP section and cutting off the TP backing. Then reapply the RP backing.
- Spray the chassis TP and TP adhesive surface with soapy water.
- Align the chassis TP with the pin holes and set it down, pressing down.
- To turn the panel over without disturbing alignment:
 - Push the FP down to the table without shifting its position on the art. Hopefully, the art moves up with the TP.
 - Slip a hand under the TP art as soon as possible to keep it attached.
 - Put the other hand over the back of the TP. Clasping the TP and art between hands, flip the chassis and art over.
- Adjust alignment for the TP either visually or using a light or by poking wire through the pinholes. Check the other corners. Squeegee the TP.
- Fold the margins over the sides of the TP and apply it to the back with your fingers and squeegee.
- Remove the backing of the RP art. Spray it and the RP.
- Squeegee the RP art to the surface, starting from the TP center and working back towards the rear flange.
- Fold the margins over the sides of the RP and apply to the back with your fingers and squeegee.
- Pick up the RP to roll the art around the bottom flange and onto the back of the flange.
- Fold the margins over the flange and apply to the back with fingers and squeegee.
- Remove the backing of the FP. Spray it and the FP.
- Squeegee the FP art to the FP, starting from the TP center and working forward and out to the sides.
- Fold the margins over the sides of the FP and apply it to the back with your fingers and squeegee.
- Squeegee the skirt art to the surface, starting from the FP center and working out to the sides.



- Fold the margins over the skirt and apply to the back with fingers and squeegee.
- Pick the FP up to roll the art around the bottom flange and squeegee it onto the back of the flange.
- Fold the margins over the flange and apply to the back with fingers and squeegee.
- Go over and squeegee the whole thing, checking for bubbles and wrinkles.
- Allow at least an hour to dry and it's done! (Gentle handling for 24 hrs.)

TIPS:

- Clean panels with alcohol.
- Add 2 to 3 drops of dish soap for every quart of water.
- Re-squeegee after 24 hours.
- Water on top of the graphic can protect the graphic from marring by the squeegee.
- When handling vinyl with exposed adhesive, can use a piece of backing paper on the back to avoid touching the adhesive.

In my notes on the process, I found this comment:

Checking the artwork dimensions: 8.000 x 11.931. The overall length is about 0.1" short, meaning we want to bring in both ends by 0.05. Favor the alignment to the origin (the line between FP, TP).

I also found this post-mortem on how the application process went:

- It worked!
- Applied the vinyl more or less as given [in the process above].
- The adhesive wasn't as aggressive as I'd imagined. After using spray for the TP, RP and rear flange, went dry with the FP, skirt and front flange, except for the overspray and drops which remained from the other operations.
- Needed to cut the margin flaps of the skirt and flange to about 5/8" or so. Also needed to cut end corners as shown [in the photo on page-1].
- Wasn't able to tweak the alignment after flipping the panel*--became stuck down. Came out okay though. May want to check while still inverted by pushing the FP down without rotating.
- Would have been nice to tweak the length of the art--fell short by ~0.06. This is odd because we expected the orientation to be transverse to the "paper path". Perhaps they ran my job beside another one. If orientation isn't predictable, can't tweak the length.

*This refers to the step beginning with, "To turn the panel over".