



Install Tips, Dehydration and Premask Removal

After installing your graphics it's important they dry completely and no moisture remains trapped between your graphic and the surface. Heat will assist in this process.

Installation Tips

- Wets sanding tips:
 - You only need to wet sand in the area the graphics will be applied to. This applies to larger parts like hoods, etc.
 - Tape off the area where the graphics will be applied, leaving about an inch away from the graphics. During the clear coat step, your paint professional can wet sand the rest of the part if necessary to prep it for clear coat.
 - Lightly wet sand area with 2500 - 3000 grit or higher wet sanding paper. Frequently dip into water and keep the surface wet at all times.
 - Just a light scuff is all you need. To see how you are doing, wipe the area dry with a soft rag then rewet to continue.
- Use a wax and grease remover before and after wet sanding.
- Inspect the graphics as you apply them and make sure there is no debris under the graphics. Trapped debris will be visible after graphics are installed.
- Squeegee technique is important in removing trapped water.
 - After most of the water is squeegeed out, use a clean rag or microfiber and blot up all the water around and on top of the graphics and squeegee again.
 - Repeat this process (usually 4-5 times) with increasing firm squeegee strokes until no water is visible at the graphic edges. The premask layer protects the graphic so careful firm squeegeeing will not damage the graphic.
 - After this, you can begin to apply heat to ensure complete dehydration.

Dehydration Techniques

Professional

Convection Method

This is the optimum way of dehydration. Oven should be set to 200 degrees using a convection oven over a period of at least 15 minutes to create the bond. The goal is to bring the "PART or substrate" to 160 degrees before reducing the heat. Allow part to cool back to room temperature before removing the premask layer.



Non-Professional/DIY

Infrared or Heat Gun Method

If using this method, the heat should not be directed towards or come in direct contact with the graphic for an extended period, as blistering may occur. Keep the nozzle 6-10 inches from the part. Diffused heat works best. The goal is to bring the surface to 160 degrees before reducing the heat (typical heat gun set at high will reach this temperature in about 7-10 minutes). The surface should be hot, *almost* untouchable. Allow part to cool back to room temperature and let the graphics air dry for at least 10-24 hours. *We do not recommend leaving the part outside to dehydrate, as demonstrated in the installation video. A garage or indoor installation works best with controlled heat and environment.

Premask Removal

After the graphics have dehydrated, the premask (clear “gel-like” top layer) can be removed as follows:

- Start with a small and least visible graphic and pull a small amount of the premask layer slowly at a 180° (flat against the surface).
 - If the graphic is adhered, you can pull the premask in one smooth motion away.
 - If the premask is sticking or “catching” pull faster. It should come off very easily and smoothly.
- If the graphic is not adhered, spray a small amount of water and relay the lifted graphic section and dehydrate further.
 - Remove the premask again starting slowly, but from the opposite end.

To protect your graphics ***you must apply a clear coat*** protectant over them. We recommend the use of an automobile paint and body professional. A professional will have the experience and tools to deliver the best finish. If however you want to apply a clear coat yourself, using a high quality acrylic lacquer or better will yield very good results. Consult the manufacturers suggested application method. Be sure the surface is clean before clear coating. Use a wax and grease remover as a final preparation over the graphics and surface. It is safe to apply this cleaner over the graphics gently.

View the installation video at: www.speedgraphics.net/tv.htm

