

General Information

ORALITE® FD 1403 / FD 1404 / FD1405 reflective trims are a tough weather and solvent resistant product designed for rugged outdoor maritime use. These are used for application onto rigid and non-rigid maritime substrates i.e. life rafts, life buoys, life vests and life boats.

For more information on ORALITE® FD 1403 / FD 1404 / FD1405, please reference the Technical Product Bulletins, which are available at orafol.com or from your ORAFOL representative.



Adhesive Application

ORALITE® FD 1403 / FD 1404 / FD1405 reflective trims are supplied with a pressure sensitive adhesive. The adhesive is protected by a release liner, which shall be removed by peeling, without soaking in water or solvents.

- The surface should be cleaned and allowed to dry (please ensure that all silicone or mould release agents on moulded polymer materials have been thoroughly cleaned before adhesive application).
- ORAFOL recommends isopropyl alcohol or a comparable cleaner. ORAFOL recommends the cleaner isopropyl alcohol with a concentration of isopropyl alcohol (2-Propanol) greater than 98%*. Please check the Safety Data Sheet from the cleaner manufacturer to verify this.
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- The adhesive liner should be partially removed and the tape aligned to its final position.
- Uniform pressure with a suitable squeegee should be applied to produce full contact with the substrate, but not impart wrinkles.
- After the tape has been applied it should be passed over with a squeegee to ensure 100% contact.
- Cover the squeegee with a soft cloth to prevent scratching the surface of the tape.

*Other Surface Preparation Cleaners may contain slow evaporating solvents, scented additives etc. that may affect final adhesion properties. ORAFOL cannot accept warranty claims when such cleaners are used. Please contact ORAFOL Customer Service if in any doubt.

Application temperature

To ensure proper adhesion between the tape and the substrate, bonding materials must be applied when both substrate and tape temperature is between 15° C and 38° C.

Bonding time

The applied material should remain at temperatures between 15° C and 38° C for at least one hour after application (one hour applies for application temperatures of 23° C and higher, longer periods maybe necessary for lower temperatures). If applied directly on an inflatable device, it is recommended that the device is not inflated or deflated during this period.

Difficult Substrates

For some substrates that are difficult to bond to, a suitable primer maybe needed.

The addition of moderate heat (~70°C/160F) in a controlled manner (e.g. stationary heat press) for a short period (<10seconds) can help to improve the adhesion and shorten the bonding time. Please contact ORAFOL Customer Service for further information.

Sewing Instructions

ORALITE® FD1403 reflective trim is also supplied with sewable fabric backing. ORALITE® FD 1403 reflective trim is a single layer product and can be stitched in any area of the surface. ORAFOL recommends that the products are sewn at a minimum of 3 mm in from the edge and the number of stitches should not exceed 8 per 25,4 mm. The following guidelines can be helpful in reducing drag that is sometimes encountered when sewing ORAFOL reflective trims:

- Use one of the following presser feet: Teflon coated roller or a walking presser foot.
- Reduce the pressure on a standard pressure foot.
- Occasionally use a small amount of silicon* applied with spray or sponge.
- Double needle sewing machine with puller.

*Note

Some spray lubricants may contain oil /solvents that can lead to fabric dye migration /bleeding into reflective trims.

The following precautions are recommended:

Pretest any lubricant prior to use. Apply a small amount of lubricant onto the surface of the reflective trim and then cover with fabric swatch for 24 hours. Inspect trim for staining after fabric removal.

Always wipe away excess lubricants after application

If you have any questions regarding lubricant compatibility, please contact ORAFOL's customer service team.

Stockage

All rolls including partially used rolls should be stored in original packaging, lying flat, tightly wound around a 3" diameter core and taped. Store in a clean and dry area, away from direct sunlight. Store at room temperature 23° C and 50% r.h.

IMPORTANT NOTICE

All ORALITE® products are subject to careful quality control throughout the manufacturing process and are warranted to be of merchantable quality and free from manufacturing defects. Published information concerning ORALITE® products is based upon research which the Company believes to be reliable although such information does not constitute a warranty. Because of the variety of uses of ORALITE® products and the continuing development of new applications, the purchaser should carefully consider the suitability and performance of the product for each intended use, and the purchaser shall assume all risks regarding such use. All specifications are subject to change without prior notice.

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