

## Application instructions

ORALITE® VC 104+ Curtain Grade Segmented can be applied onto trucks and trailers with new and old PVC curtains.  
Important: **The ORAFOL warranty is applicable to new curtains only.**

## Curtains

The performance of the adhesive will depend greatly on the curtain surface. Every curtain type should be assessed individually for suitability. Graphics printed by digital/screen/stencil technique and using clear coats or varnishes for additional durability need to be assessed for ORALITE® VC 104+ Curtain Grade Segmented adhesion. ORAFOL accepts no responsibility for poor adhesion to clear coat or pre-treated curtains. It is the applicator's responsibility to ensure that the curtain is suitable for application.

## Tools required

- Pen and/or masking tape
- Clean cloths
- Craft knife or scissors
- Squeegee with sleeve to avoid scratching the material
- Cleaner: Isopropyl alcohol (IPA) and/or soapy water
- Used curtains only: Abrasive pad

## Application temperature

To ensure proper adhesion between the tape and the cleaned curtain bonding materials must be applied when both curtain and tape temperature is between 15° C and 38° C. The temperature needs to be consistent for at least one hour after application. NB! It is recommended that ORALITE® VC 104+ Curtain Grade Segmented is stored at temperatures between 18° C and 28° C.

## Where to apply

It is recommended to position the tape minimum 5 cm above the buckles. Use the guidelines provided in Regulation ECE 104 to ensure that the tape is in general positioned correctly on the vehicle. Check [www.ece104.com](http://www.ece104.com) for more information.

## Initial preparation

The tape can be applied either on a flat surface, or while tensioned on the trailer. If on a flat surface, lightly tension the curtain ensuring that the curtain surface is flat. An example of how to do this is to place a weight at both ends of the length of the curtain. When applied on a trailer, position a board behind the curtain to ensure enough pressure can be applied to the tape when using the squeegee. This is done most easily by having at least two people to do the application. It is recommended that the curtain is not over-tensioned during application.

### Used Curtains:

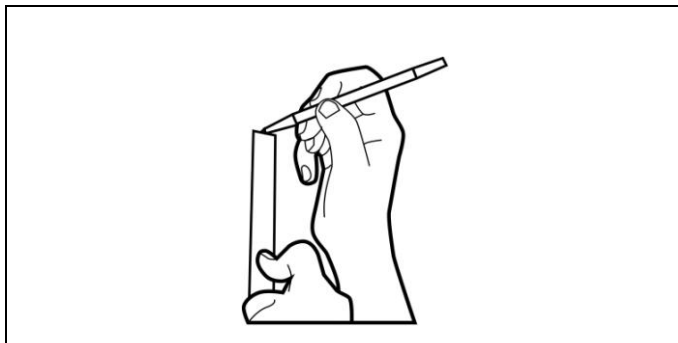
Survey used curtain for suitability of application, avoiding application over tears, holes or repairs. NB! It is the applicator's responsibility to ensure that the curtain is suitable for application.

## Surface cleaning

The purpose of cleaning the curtain is to remove any dirt or contamination. It is very important that the surface is free of dust and grease, and ideally the surface should be smooth. Use a clean cloth with isopropyl alcohol to wipe the surface in one direction only to avoid spreading contamination. With a dry clean cloth wipe away the cleaner before evaporation. Repeat this process until the surface is clean, i.e. when there is no visual dirt or contamination transfer onto the cloth. For curtains with coatings which adversely react with isopropyl alcohol, soapy water is recommended (98% water, 2% soap). Ensure the surface is dry and that either the isopropyl alcohol or soapy water has completely evaporated before commencing application.

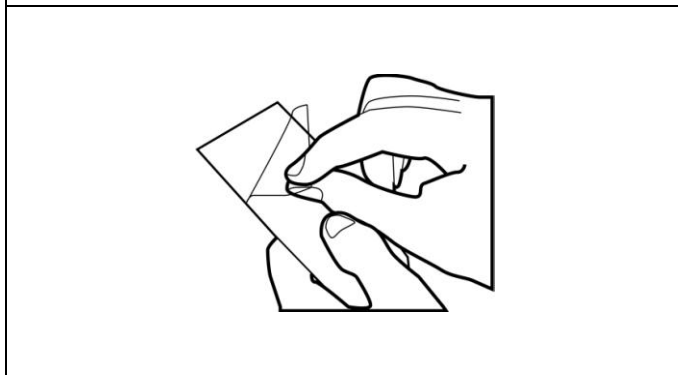
### Used Curtains:

An additional step is required for used curtains: After completing the above cleaning process, abrade the area with an abrasive pad, and clean again using a clean cloth with isopropyl alcohol.



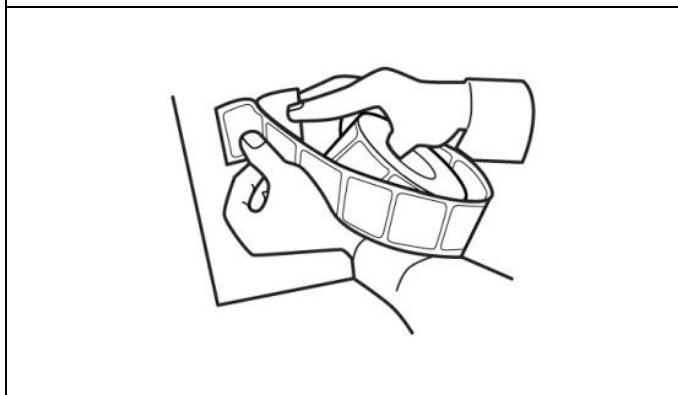
**STEP 1:**

Mark out a pencil line guide, or alternatively apply a strip of masking tape. Do not use chalk line or other means that may leave residue on the surface.



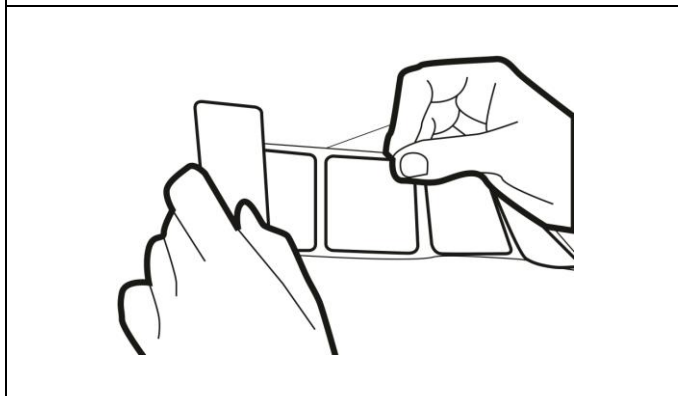
**STEP 2:**

Peel back the adhesive liner on the first segment. Avoid touching the exposed adhesive once the liner has been removed.



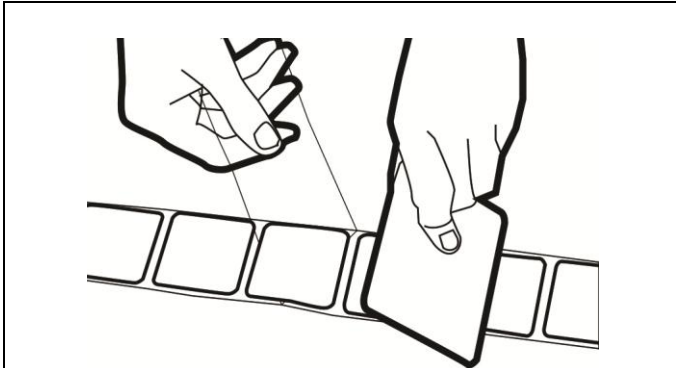
**STEP 3:**

Tack it onto the application surface with a squeegee.



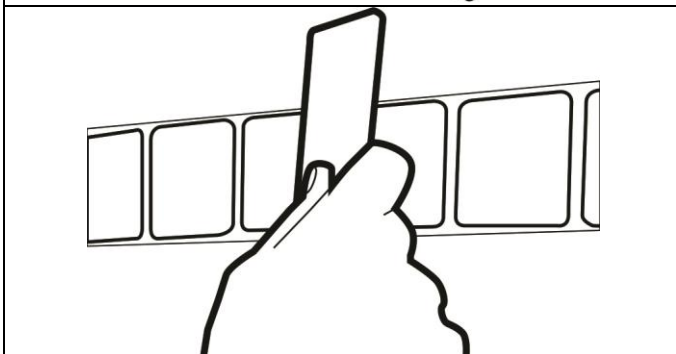
**STEP 4:**

Squeegee.



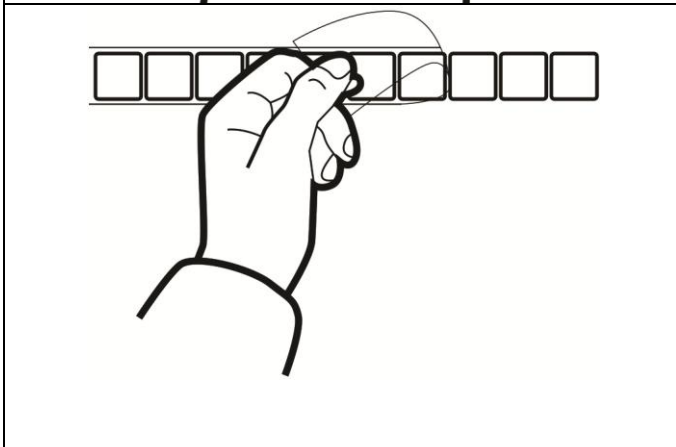
**STEP 5:**

Squeegee the tape down as the adhesive liner is removed. Ensure that the exposed adhesive only comes in contact with the curtain through the pressure of the squeegee. If the exposed adhesive touches the surface without uniform squeegee pressure, air can be trapped under the film and bubbles may occur. The application liner facing the reflective side should be left on to keep the pieces in place. Repeat the process for the length of the vehicle.



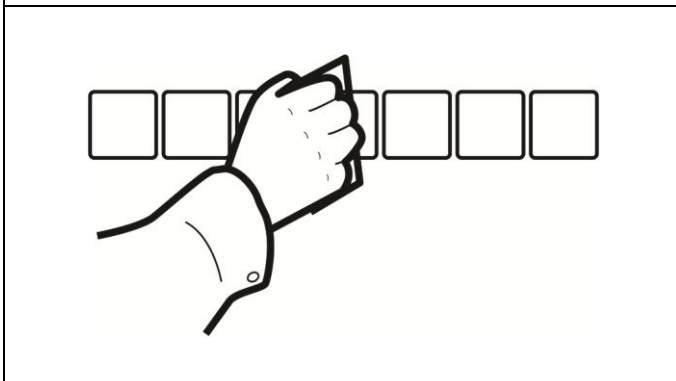
**STEP 6:**

Afterwards, re-squeegee the whole length of the vehicle.



**STEP 7:**

After completing this process, remove the application liner by peeling it back from the reflective side and re-apply pressure using a squeegee along the length of the tape, to ensure that the edges of the tape have been properly adhered to the curtain.



**STEP 8:**

Re-squeegee. Upon inspection of the application there should be no visual air bubbles. If air bubbles occur, use a pin to puncture the bubble and a squeegee to push the air towards the pin hole.

## 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 27° C and higher, longer periods for lower temperatures). If applied directly on the truck, it is recommended that the vehicle is not moved and/or the curtain not folded or opened during this period.

## After application

When the application process is finished, care should be taken when rolling the curtain to ensure that no sharp folds or bends are present.

## 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.

## Care Instructions

### Manual Washing:

ORALITE® VC 104+ Curtain Grade Segmented can be washed manually by brush, cloth or sponge using water, soap or detergent followed by a clean water rinse.

### Power Washing:

Automatic truck / car wash or standard high-pressure hand spray:

- Maximum pressure – 1200 PSI / 80 bar
- Maximum water / wash solution 60° C
- 40° Nozzle cone opening size should be used
- Cleaning wand or jets to be at no greater angle than 45 degrees from perpendicular to the marking surface
- Hold the cleaning jet a minimum of 60cm away from the material

When using cleaners, follow the manufacturer's recommendations for dilution. Thoroughly rinse after soaking vehicle.

Important: Do not use solvents to clean the tape, as they can adversely affect the product. If soap or detergent does not sufficiently clean the film, gently rub a cloth soaked in isopropyl alcohol to remove the stains.

## 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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