

PRESSURE SENSITIVE MARKINGS (DECALS) APPLICATION INFORMATION AND INSTRUCTIONS

1. SCOPE

1.1 This specification defines the proper equipment and application techniques used to apply pressure sensitive markings. In the remainder of this text, pressure sensitive markings will be referred to as markings. In many instances, pressure sensitive markings are referred to as decals and may be used interchangeably.

1.2 This specification was released originally for all markings applied to FNH agricultural, industrial tractor, and tractor related equipment.

2. RELATED SPECIFICATIONS

2.1 REFERENCE STANDARDS

86513232(FNHA-2-M-095.00) - Pressure Sensitive Markings Performance Requirements and Approved Suppliers

86513227(FNHA-2-M-095.10) - Pressure Sensitive Markings Selection Process

86513277(FNHA-2-M-096.00) - Pressure Sensitive Markings Test Index

86505483(FNHA-2-J-005.00) - Color Designation

86509254(FNHA-3-A-075.00) - Sign, Safety

86509255(FNHA-3-A-080.00) - Sign, Operational

86509256(FNHA-3-A-085.00) - Sign, Application

86509257(FNHA-3-A-090.00) - Serial Number Plate

3. DESIGNATION

3.1 The markings used by FNH are identified in the following list.

3.1.1 PATCH TYPE - These markings are the caution, danger, warning, and instructional type. They consist mostly of printed matter used with the appropriate ANSI safety color or black and white printed instructional items.

3.1.2 PRE-SPACED DIE CUT - These markings are used primarily for identification and consist of New Holland logos, model numbers, names, etc. In some cases, background or decorative stripes use the same material.

3.1.3 REFLECTIVE PATCHES - These markings are for night identification by headlights and are usually red or amber in color.

3.1.4 SLOW MOVING VEHICLE EMBLEMS (SMV) - They are triangular in shape and consist of a center triangle of fluorescent orange with three borders of reflective red material.

3.1.5 SPECIALTY ITEMS - The remaining markings are grouped in this category and consist of products such as anti-skid patches used on stepping areas.

4. MATERIALS AND EQUIPMENT

4.1 Double-edge hard polyethylene squeegees (4" or 6") with smooth straight edges.

NOTE: For small markings, the squeegees may be cut into smaller appropriate widths. The width of the squeegee should be no less than the width of the marking for which it is used to apply.

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MATERIALS / DECALS**FNHA-2-M-095.20**

4.2 A fine mist pump action spray bottle. Water alone may be used or a solution of three drops of liquid detergent (Ivory, Palmolive, etc.) per gallon of water is also acceptable.

The beads of water sprayed on the painted surface act as a lubricant to float or position the marking.

NOTE: This method is used primarily on larger markings or items made of thinner vinyl films, such as 2 mil cast (.002") films.

Items that fall in these categories are model numbers, logos, decorative striping, etc.

5. APPLICATION PREPARATION

The surface must be clean and at room temperature, $20^{\circ} \pm 5^{\circ}\text{C}$ (68-86°F) or warmer and dry unless the "wet application" in 5.2 is used. Introduction of parts or machines from outdoors in the winter may produce a film of condensing moisture or frost on the surface. Allow surface to warm to room temperature and make sure surface is wiped dry before applying markings. Failure to allow surface to warm may result in adhesive failure at a later date. Application of markings to units stored outside in warm weather may be done outdoors, providing there are provisions taken to clean the substrate.

6. APPLICATION INSTRUCTIONS

6.1 For use with most prespaced, die cut, and patch-type markings.

6.1.1 The backing paper shall be peeled from the marking carefully to prevent unnecessary stretching or pulling of the marking. In the case of prespaced, die cut markings, it is preferable to place the marking on a flat surface with the backing paper up and peel the backing paper back slowly at a 180° angle, but not directly over itself.

6.1.2 The markings shall be held near the substrate, without touching it, to get the proper alignment. When the marking is positioned correctly, it should be pressed to the substrate on one edge. The remainder of the marking shall be pressed to the substrate by drawing the squeegee across the portion of the marking that is being held away from the substrate until the squeegee is completely drawn across it. When the marking is in place and prior to removal of the premask (if present), firmly resqueegee the marking back and forth, working from one edge across to the other to prevent entrapment of air bubbles.

6.1.3 If a carrier paper is present, such as a premask in separate letters or numerals, it shall be removed by peeling back parallel to the surface.

6.2 Optional application of large prespaced die cut markings or decorative stripes.

6.2.1 This application pertains to some larger markings and/or thinner films (2 mils) where the possibility of air entrapment in the film is a problem. The painted surface may be sprayed with a fine mist of water prior to applying the marking.

6.2.2 The preparation and technique is similar to Section 6.1, except the entire markings may be placed on a water-misted surface and the marking may be squeegeed from one edge to the other or from the center to the edges.

6.2.3 Care must be taken to firmly squeegee the surface once the marking is in place to remove all traces of water between the substrate and the marking.

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