

# Application & Care

## Reflexite® VC104 Curtain Grade HA

For trucks and trailers with curtain sides

Bulletin #APP-09

## Application Instructions

Reflexite® VC104 Curtain Grade HA can be applied to trucks and trailers with new PVC curtains. Application to old/used curtains is not recommended.

### 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 Reflexite® VC104 Curtain Grade HA adhesion. Reflexite 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 and to approve the process under his/her own converting parameters.

### Tools Required

- Clean cloths
- Craft knife
- Cleaner: Isopropyl alcohol (IPA)
- Hot air gun travelling rig or similar hot air welding equipment

### 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. NB! It is recommended that Reflexite® VC104 Curtain Grade HA is stored at temperatures between 18°C and 28°C.

### Where to apply

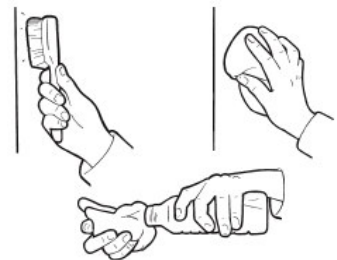
It is recommended to position the tape minimum 15 cm above the buckles. Use the guidelines provided in Regulation ECE 104 to ensure that the tape is in general positioned correctly on the vehicle. Check [www.ece104.com](http://www.ece104.com) for more information.

### Step 1: Initial Preparation

The tape should be applied on a flat surface, and lightly tensioned at either end ensuring that the curtain surface is flat. An example of how to do this is to place a weight at either end of the length of the curtain. It is recommended that the curtain is not over-tensioned during application.

### Step 2: 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. Ensure the surface is dry and the isopropyl alcohol has completely evaporated before commencing application.



### Step 3: Alignment

A pencil line or masking tape can be used if a straight line guide is required.

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### Step 4: Application - Hot Air Application Instructions

Always adhere to manufacturer's operating and safety instructions when using hot air application equipment.

Reflexite recommends hot air gun travelling rigs or hot air welding machines as the preferred application methods for Reflexite® VC104 Curtain Grade HA. Reflexite does not recommend the use of handheld hot air guns for application of Reflexite® VC104 Curtain Grade HA.

Three parameters play an important role when applying VC104 Curtain Grade HA: temperature, speed (or time) and pressure. Before applying the tape to the curtain, ensure that these parameters are giving the desired adhesion to the surface. On a spare piece of curtain test the strength of the bond after it has cooled down (approximately 5 minutes) and alter equipment settings if necessary to achieve a permanent bond. It is the applicator's responsibility to ensure the correct parameters are set to achieve a permanent bond between the tape and the curtain.

**Important:** Printed and/or coated curtains will typically require higher temperatures or lower speeds than those without any kind of coating. Do not overheat the tape, the heat applied should be the minimum necessary to achieve the desired adhesion.

Position the Reflexite® VC104 Curtain Grade HA in the equipment as per manufacturer's instructions, ensuring the adhesive side is in contact with the curtain. Heat the hot air equipment for one minute before introducing the heat to the exposed adhesive.

The width of the pressure roller and the heat nozzle on the hot air equipment should be equal or greater than the width of the material being applied (50 mm according to Regulation ECE104). The heat nozzle should be set up so that the hot air is blown towards the curtain material and the adhesive side of the tape.

Position the tape to be applied 20 mm from the edge of the curtain at the height recommended by Regulation ECE104 and commence application down the length of the curtain using the chosen parameters.

The typical temperature range, running speed, and distance of heat nozzle from material will vary from machine to machine depending on curtain type, but the following can be used as guide line parameters when working with hot air gun travelling rigs on uncoated/unprinted curtains:

- Typical heat of hot air may range from 100°C to 160°C.
- Typical running speed may range from 2-4 meters per minute
- Distance of nozzle can vary from 5mm to 30mm.

NB! All corners of the tape should be rounded using a pair of scissors or sharp blade. It is recommended that this is done before the tape is applied to the curtain.

### Step 5: Bonding Time

The bond is at its maximum strength as soon as the product cools. However care should be taken when rolling the curtain to ensure no sharp folds or bends are present. The curtain should be folded in such a way, that the tape is on the outside and not folded in.

### Step 6: After application

The tape has a transparent top clear polyester carrier attached to its surface which must be removed after the tape has been applied. When the sealing process is finished, care should be taken when rolling the curtain to ensure that no sharp folds or bends are present.



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### Manual Washing

Reflexite® VC104 Curtain Grade HA 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 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 Reflexite 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 Reflexite 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 Reflexite 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.

The manufacturing batch number stated in the core of each roll should be recorded with the Curtain ID to ensure that the warranty can be fully validated if required.

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