



PROCESS SPECIFICATION: L-3 GCS PSA APPLICATION

1.0 SCOPE:

This specification details the specifications and expectations for applying decals and pressure sensitive adhesives. This specification also implies post application curing techniques.

2.0 ORDER OF PRECEDENCE:

In the event of a conflict between the text of this document and the references cited herein, the text of this document takes precedence. Nothing in this document, however, supersedes applicable laws and regulations unless a specific exemption has been obtained.

Additionally, any application or process notes or references on the print supersede the contents of this document.

3.0 DECALS:

3.1 CAST 3M™ CONTROLTAC VINYL - 180C INCLUDING ADHESIVE:

Entire location to be prepared and the decal to be applied per “3M™ Instruction Bulletin 5.5”, *Application: General Procedures for Interior and Exterior Dry Application*.

4.0 VHB™:

For any VHB™ tape and VHB™ backed materials the entire location to be prepared and the VHB™ applied per “3M™ Surface Preparation for 3M™ VHB™ Tape Applications”, *Technical Bulletin*.

5.0 GENERIC PSA:

Wipe down surface with isopropyl alcohol, be sure the area is dry before applying the PSA. Surfaces that have been exposed to the elements, or to some form of prior use, must be wiped down with a hard surface cleaner such as *Sea Brite – Glass and Surface Cleaner*. After the surface has been cleaned and dried, follow by wiping the area again with isopropyl alcohol.