



SignGold 23.5KT GOLD 1st & 2nd SURFACE

PRELIMINARY

SignGold 23.5kt has a 10 year warranty as long as all technical information is followed. This product is **REVERSIBLE**...and can be cut in reverse and used on the inside of windows.

*This is a **NON-PRINTABLE** product.

PLOTTER CUTTING

Always make a "test cut" before cutting, at least until you have become familiar with SignGold 23.5kt product properties. A 45 degree blade is recommended to help eliminate drag on the material as it is being cut. **ALWAYS USE A SHARP BLADE.** Cutting an upper case Helvetica "A" or "N" serves as a great test for blade sharpness.

A standard angle blade used for cutting standard PVC vinyl is fine; no special blade is needed...cuts like butter.

SIGNGOLD 23.5kt product cuts as good as or better than a high performance cast vinyl. Never cut SignGold products too deep...Just enough pressure to kiss-cut the material so weeding is easy. Cutting too deep into the poly-liner can cause the adhesive to settle into the cuts thus causing difficulty in getting the 23.5kt to release from the liner.

Never allow the 23.5kt to be rolled backwards (with the release liner to the outside). Try to keep the material flat as it goes through your cutter to minimize the chance of tunneling. Always cut material at room temperature and do not cut material during cold temperatures (below 50 °F) as premature release from the liner resulting in tunneling may occur.

WEEDING

Weeding the 23.5kt is actually easier than weeding many high performance vinyls. It is recommended that you weed your job immediately after cutting. Do not leave weeding for the next day. Pre-mask and install the job as soon as possible.

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APPLICATION

The 23.5kt should be applied dry, as the preferred method. However, light spray of application fluid is okay. Never use application fluid with ammonia. Be sure to squeegee out all fluid under the 23.5kt film. **DRY APPLICATION ONLY FOR 2ND SURFACE WORK.**

Use a "medium to high" tack application tape. On letters or graphics taller than 8 inches, a "high" tack tape is recommended. Using a translucent application tape with medium tack will make registration to your outline easier.

SEE REVERSE SIDE

APPLICATION (Continued)

To insure good adhesion on vehicles, 23.5kt Gold is best applied over high performance cast vinyl like Gerber/3M 220 series vinyl. On dark colored vehicles, high performance cast vinyl is highly suggested under 23.5kt Gold. If it is necessary to remove 23.5kt later for some reason, it comes off much easier because the high performance cast material is underneath it.

NEVER APPLY 23.5kt QUICK-SIGN GOLD MATERIAL OVER WATER-BASED OR LATEX FINISHES. When applying 23.5kt Gold to acrylic or polycarbonate sheets, remove substrate protective sheeting and allow surface to outgas at least 24 hours before applying any SignGold product.

When applying 23.5kt Gold over wood or HDU (high-density urethane), the surface must be sealed using an oil-based or epoxy coating to restrict moisture exposure from behind the goldleaf vinyl. We recommend West Systems Epoxy #105 Resin with the appropriate hardener.

REVERSE APPLICATION STEPS TO SUCCESS

1. In your sign software, do the layout in reverse.
2. Cut black outline and shade in reverse. 23.5kt Gold looks best with an outline and/or shade.
3. Cut 23.5kt Gold vinyl film in reverse and cut it so it fits halfway into the black outline. Make sure not to go over the outside of the black outline. You are essentially covering the open space within the outline with the 23.5kt gold.
 - i. Apply the black outline and shade FIRST to the glass. Because 23.5kt vinyl shows gold on the reverse side, you may want to cover the gold with high performance black vinyl cut in reverse to go over the gold....just cut it larger than the gold itself. This effect would then look closer to the back-up black used by hand gilders when they were done gilding windows.
 - ii. Next, register the 23.5kt gold so it overlaps into the middle of the black outline and fills the open spaces of the lettering or design.
 - iii. Use a soft squeegee (applicator) when applying the 23.5kt gold. When applying lettering under 4 inches tall, just use your thumb as the applicator as the gold goes down very well and you can get more air out of the overlap area.
 - iv. Application fluid is not recommended as many times it gets trapped where the gold meets the outline. The preferred procedure is by using the hinge/dry application method.

SEALING & FINISHING

SEALING AND FINISHING are extremely important processes to keep this authentic gold staying nice for years.

EDGE SEALING WITH ONE SHOT 4005 or 3M Edge Sealer 3950 keeps the 10 YEAR WARRANTY VALID; edge seal using a traditional brush application to achieve best coverage and protection. Use a liberal coating to insure the 23.5kt gold vinyl edge is sealed to the vehicle background or vinyl if an outline is used.

Quick Clear Tedlar® Laminate, 3M 8519, 3M 8528 and OraCal 290 CLEAR LAMINATES can be used by overlapping edge 1/4" to act as an edge seal. Other laminates may be fine, but test them first. Note that some laminates are 5 year products and some 8-9 year products--Choose wisely for your expected durability requirements. Do not use calendered laminates with SignGold Products. Use only high performance clear laminates.

Limited Warranty: Quick Roll Leaf Mfg., Co. SignGold products are sold with the understanding that the buyer determines product adaptability for the intended use and test prior to actual use. Quick Roll Leaf Mfg., Co.'s obligation under this warranty is limited to the replacement of SignGold products solely, and will not be liable for any expense, damage, loss or consequential damages of any kind from use or inability to use SignGold products. THIS WARRANTY IS VOID IF THE PRODUCT HAS BEEN SUBJECTED TO ABUSE OR IMPROPER CARE.

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