



HOW TO APPLY - MOLD ON GRAPHICS®

Application Instructions: Ensure that the part surface is completely free of mold release or any other contaminants. **NOTE:** To ensure optimum performance, Mold In Graphics must be stored in a clean protective storage container at a temperature between 10° C - 35° C (50° F - 95° F), should not be pressed or stacked upon and kept away from direct sunlight during storage.



With an Infrared pyrometer, verify the part surface temperature is **within 80° - 105° (27° - 41° C)**.



Clean the part surface with 99% isopropyl alcohol and ensure the part has no dust or debris.



Apply a light coat of Mold On Graphics Adhesive spraying directly onto the printed surface of graphic.



Place graphic onto the part surface. **Tip:** Bend back a corner of the film to help facilitate film removal after the following step.



With the burnishing pad, apply moderate pressure in vertical and horizontal directions to transfer the graphic from the carrier film. Once graphic transfer is complete, peel back the carrier film from the bent corner, at a steep angle. Remove the film from the part surface.



With approved heat source (Shrinkfast gun) apply heat to thermfuse the graphic onto the part. **Tip:** Start heat at ten inches away from surface to check for trapped air bubbles. If bubbles are present, allow to cool for a couple moments before continuing to heat. While heating, verify the surface temperature reaches minimum of 275° F (135° C) with the infrared pyrometer.