

1. Scope

This specification applies to flat-surfaced, pressure-sensitive, adhesive-backed decal manufacturing materials designed for application on flat and moderately curved high-density polyethylene substrate surfaces.

2. Reference Standards

Where applicable and unless otherwise stated, decals shall comply with the latest revisions of the following industry standards:

ANSI Z535.1 *Safety Color Code*

ANSI Z535.2 *Environmental and Facility Safety Signs*

ANSI Z535.3 *Criteria for Safety Symbols*

ANSI Z535.5 *Safety Color Code for Marking Physical Hazards*

ANSI C2 *NESCA Handbook, Appendix B—Safety Signs*

3. Font

Font shall be Helvetica-Narrow Bold, or District approved equivalent.

4. Material

Decal printing material shall be 3M 680CR Scotchlite Removable Graphic Film; color will be specified by the District.

5. Thickness

Decal printing material thickness shall be 7-8 mils, with adhesive.

6. Adhesive

Adhesive shall be pressure-activated, positionable, and channelled removable.

7. Liner

Finished decals shall include a polyethylene-coated paper liner, which shall be back scored for easy removal.

8. Adhesion

Finished decals shall include a high tack pressure sensitive adhesive backing. Decals must be suitable for application without the necessity of additional adhesive coats on the label or application surface and without the use of water, solvents, or heat.

The protective liner attached to the adhesive shall be an easy release type. It shall be removable by peeling without soaking

in water or other solvents. The protective liner shall be easily removed after accelerated storage of the decal for four hours at 180 °F. Removal shall require a maximum pull of 0.25 pounds per lineal inch of width.

The precoated pressure sensitive adhesive shall adhere by pressing it in contact with a clean, dry surface. It shall form a durable bond to clean, well painted surfaces, plastic surfaces, or unpainted corrosion-proof metals. The adhesion after 24 hours shall be a minimum of 10 lb/inch at 73°F. The precoated adhesive, after 48 hours of aging at 75°F, shall have no appreciable effect on the decal material. The precoated adhesive shall have no staining effect on the decal material. The adhesive shall be mildew resistant.

9. Minimum Application Temperature of Decal

The material shall have an application temperature range of 40°F to 100°F.

10. Applied Performance Range

Materials shall have a performance range of -30°F to +200°F unless otherwise specified by the District.

11. Outdoor Durability

Material shall have an outdoor life of 7 years minimum, with vertical exterior exposure.

12. Humidity Resistance

Materials shall be resistant to 500 hours at 90% relative humidity.

13. Chemical Resistance

Material shall be resistant to degradation by petroleum solvents and greases. Material shall have excellent water resistance. Material shall resist occasional fuel spills in addition to mild alkalis, acids, and salts.

14. Film Flammability

Material shall be self-extinguishing.

15. Shelf Life

Material shall have a minimum processed shelf life of 2 years in a clean area, free from excessive moisture and direct sunlight with ambient temperatures of 100°F or less.

16. Packaging

Finished decals shall be packaged to protect them from moisture and dirt in Zip-Lock type resealable, clear polyethylene bags (25 decals per bag). Each bag shall be marked with the date of production and the manufacturer's name or logo.

17. Proof Drawing

When requested, the supplier of the decal shall provide a proof drawing for approval by the District's Standards Group before proceeding to produce the first order.