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**Objective:** Applying SATCap To Faces

**Required PPE:** Safety Glasses, clean towels, primer 94 or Primer 111, and Nitrile gloves

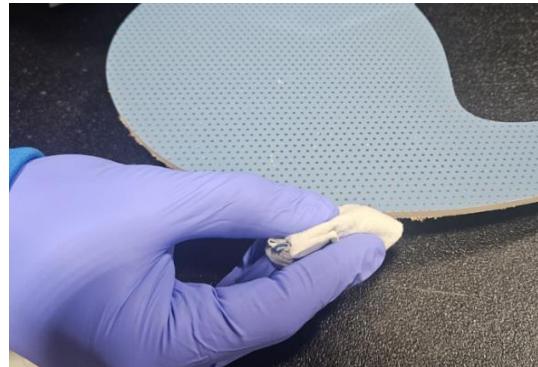
Instructional Video



**Maximum Size:** The maximum recommended size is 25 square feet

## Preparing the surface

1. All product must be at room temperature 60 F or greater for a minimum of 24 hours prior to installation.
2. Application must be done at a temperature of 60 F or greater.
3. Nitrile gloves or equivalent must be worn at all times while applying primer and SATCap to prevent contamination of the bonding surfaces.
4. With a damp Primer 94 soaked rag apply primer 94 to the perimeter side of the Face where the SATcap will be applied.
5. Allow the primer/adhesion promoter to dry completely.

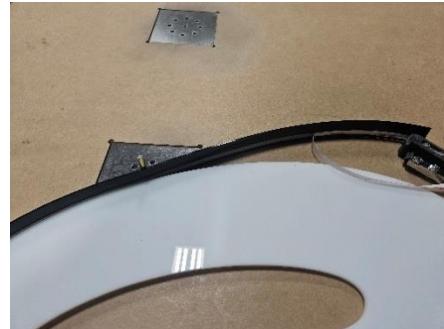


## Applying SATcap:

1. Place the face on the table.
2. Peel backer from the tape off the end of the trim cap, about 4" - 6" and start adhering the trim cap to the edge of the letter. Make sure the lip of the trim cap is resting against the face of the letter and doesn't walk up or down.
3. Press the trim cap to the letter using the brass roller/pin or the hand roller. Apply a minimum of 10 pounds of force. Its best to remove a few inches of tape backer at a time rather than all at once. This prevents the tape from sticking to unintended areas/items.



4. Continue to apply the trim cap to the letter working around the perimeter of the letter.

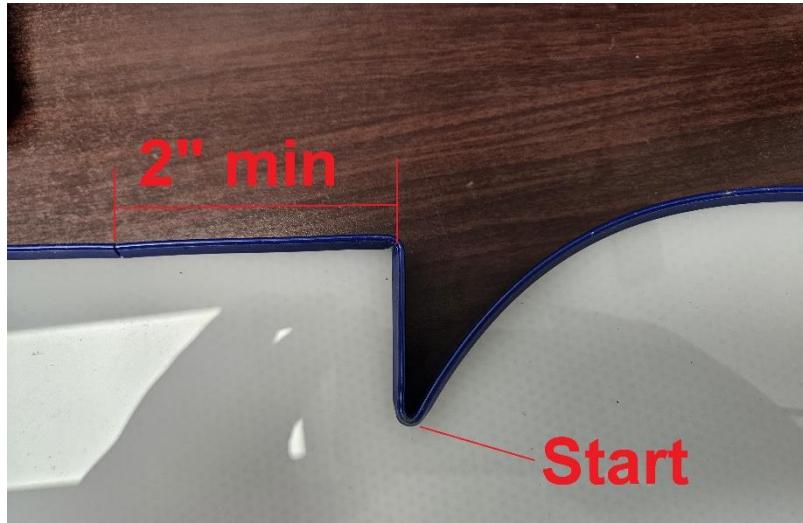


5. At corners stop applying approximately 2-3 inches before the corner, line up the trim cap with the corner, mark it, then notch the trim cap to bend it around the corner.
6. In tight creases stop approximately 6-12 inches away from the tight area. Pre-fit the trim cap by marking and bending it then test fit. If it needs adjustment, make the necessary adjustments so it will fit tightly in place. Once the fitment is acceptable remove the tape backing and apply the trim cap.
7. At seams mark the end of the trim cap after installing, where the ends will come together, cut along the mark, and fit ends snug together.
8. Cut a 1.5" – 2" piece of trim cap and apply a small piece of VHB tape to it. Tape a small piece to every area where the trim cap ends meet.
9. The tape bond increases with time at room temperature approximately 50% of ultimate bond strength will be achieved after 20 minutes full bond strength achieved after 72 hours at room temp. The finished product must sit at room temperature for a minimum of 24 hours before being subjected to colder temperatures.

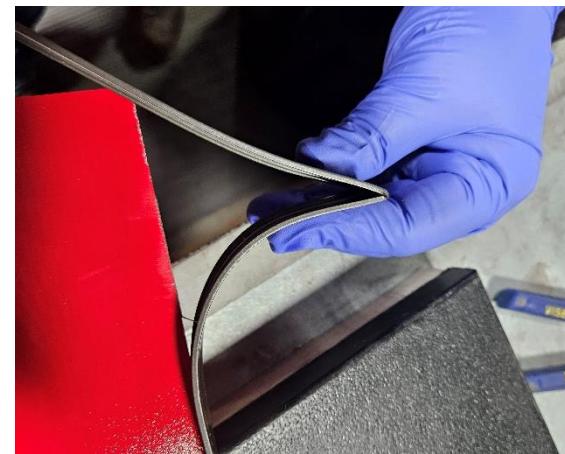


Tips/Tricks:

- It is best to start at the most difficult point of the character such as a crotch of a letter by pre-fitting the SATcap and pre-forming using a crimping tool prior to applying SATcap to the character.
- It is recommended place the seam of SATcap on straight side of a character, if possible, at least 2" from a corner or sharp radius.



- Pre-bend the SATcap at inside and outside corners to reshape the SATcap to conform to the shape of the character face make application easier.



- On inside radius roll the SATcap back on itself in the shape of a balloon to form it to fit the radius.



- Don't apply SATcap from point to point along the curve, follow the curve as a continuous path.



- If SATcap pulls away from the character edge after the application of pressure that typically means the SATcap wasn't shaped to fit the profile. A heat gun can be used to heat the plastic then re-apply pressure to reshape the SATcap and re-adhere the tape.
- Tight areas can be more easily shaped by heating SATCap with a heat gun to make it more pliable **Note: Use caution when applying heat as too much heat can damage the trimcap.**



**Revisions:**

Revision	Date	Person Responsible	Description of Change
0	02/03/25	MNR	Document Creation
1	4/17/25	MNR	Added Maximum Size
2	5/2/25	MNR	Added contact information
3	9/23/25	MNR	Added tips and tricks section