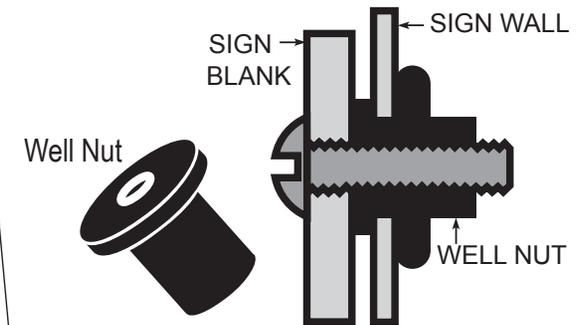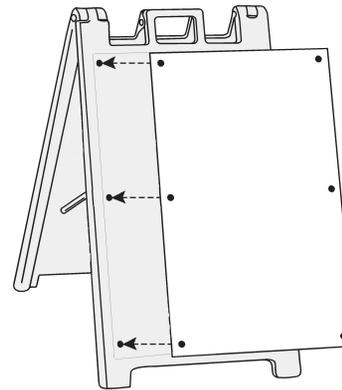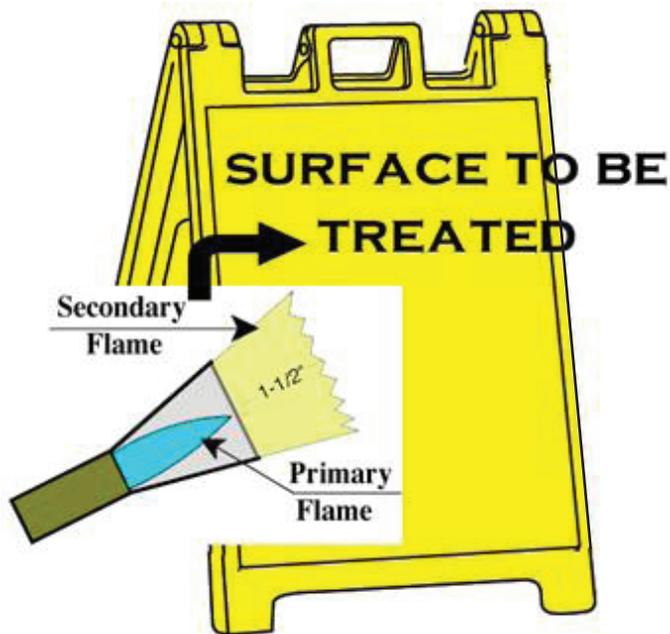# DIRECTIONS FOR PREPARING POLYETHYLENE USING FLAME TREATING

1. Fit a propane torch with a flame spreader.

2. Following the operating cautions of the propane torch, ignite the flame.

3. Observe the flame in a darkened room, noting the primary (bright blue) and secondary (faint yellow) portions of the flame (see drawing below).

4. Adjust the flame so that the primary flame is contained within the spreader, and the secondary flame is 1-1/2" beyond the spreader (see drawing below).

5. Treat the polyethylene recess area with the tip of the secondary flame by passing it over the polyethylene in gentle sweeping strokes. Total exposure to the flame should be 2-3 seconds, .5 seconds per stroke. This light exposure should not deform or melt the polyethylene in any way.

6. Test the polyethylene for bond readiness by wetting it with water. If the water runs off immediately, the treatment was not effective. If the water sheets on the surface, the surface is ready for bonding. If unsure, compare the water's action on treated area with the untreated area.

7. We also recommend wiping the sign recess area with isopropyl alcohol within 20 minutes of flame treating to insure positive adhesion.

8. Apply a FULL sheet of adhesive vinyl sheeting within 1 hour after flame treating. If you wish to apply cut out letters or shapes to the sign, you would then apply them to the full sheet.

SURFACE TO BE TREATED

Secondary Flame

1-1/2"

Primary Flame

SIGN WALL

SIGN BLANK

Well Nut

WELL NUT

Well Nut: ¼-20 MP Neoprene w/brass thread insert

Screw for Well Nut: ¼-20 x 1 Phillip head screw

HOW TO ATTACH A BLANK SIGN TO A SIGN FRAME

1. Any wood screw can be used to affix the sign blank to the sign frame. However, if the sign blank is going to be changed many times, we propose using well nuts.

2. Well nuts with screws can be purchased in packs of 20 or 100 units.

3. A hole is drilled and the well nut inserted. Then screw a bolt into it and it expands like a molly in drywall. When the bolt is unscrewed you have a permanent screw receptacle enabling the user to change signs indefinitely.

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