



TH11 Decal

**Uniform
Procedures For
Collision Repair
UPCR**

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v.4.0



1. Description

This procedure describes methods for removing and applying decals. Inspection and evaluation requirements are also included.



2. Purpose

The purpose of this procedure is to provide industry-accepted requirements for performing high-quality replacement of decals. This procedure is intended for use by professionals who are qualified through training and experience.



3. Referenced Documents

The following documents are considered part of this procedure by reference.

3.1 Procedures

PS01 Personnel Safety
RF01P Surface Preparation
RF01S Surface Preparation
TH21 Pinstripe

3.2 Other Information

Equipment-specific information
Product-specific information
Vehicle-specific repair information



4. Equipment And Material Requirements

4.1 Equipment

The use of this equipment is included in this procedure:

- heat gun
- steamer
- razor knife
- plastic squeegee
- plastic razor blades

4.2 Materials

The use of these materials is included in this procedure:

- adhesive remover
- chemical stripe remover
- non-abrasive stripe remover disc
- glass cleaner



5. Damage Analysis

5.1 General Damage

Inspect decals for these conditions:

- visible damage
- missing sections
- peeling
- bubbling
- fading

Determine whether the decal will be replaced or removed. If it is to be replaced, determine if the repair will be sublet to a specialty facility. Verify the availability of replacement materials.

Note: Some decals are available only in a kit, for application to either the entire vehicle or one side of the vehicle.



6. Personnel Safety

6.1 General Safety

General safety information is in **PS01**.

Do not use chemical decal removers and a heat gun simultaneously.



7. Environmental Safety

Does not apply.



8. Vehicle Protection

8.1 Decal Application

To protect the vehicle when applying a decal:

- Follow the vehicle and paint makers' recommendations for the amount of time to wait before applying a decal to a newly applied finish.
- For proper performance, do not apply a decal when the temperature is below 16° C (60° F). Ideally, the surface temperature should be 16–27° C (60–80° F).
- When trimming, splicing, or separating an applied decal, lightly drag a razor knife over the cut line. Do not cut into the finish.

8.2 Decal Removal

To protect the vehicle when removing decals:

- Do not overheat the area if using a heat gun.
- Use a plastic-bladed tool or a non-abrasive disc.
- Test a small, hidden area before applying chemical removers to a panel that is not to be refinished.



9. Repair Procedure

9.1 Removing A Decal

To remove a decal:

- 1. Remove exterior trim and hardware along the line of the decal, if required to access the full decal.
- 2. Remove the decal, using a heat gun, steamer, plastic disc, plastic razor blade, or any combination.
- 3. Clean the repair area with the proper surface cleaner. Make sure all the original adhesive is removed.

9.2 Applying A Replacement Decal

To apply a replacement decal:

- 1. Clean the area where the decal will be applied, using the proper wax and grease remover. Wipe dry.
Note: This may not be required on newly refinished panels.
- 2. Align the decal to the panel. Use body lines, or masking tape if required, for alignment marks. Take note of areas where the decal will have to be trimmed or separated, such as a panel gap.
- 3. Spray or sponge water on the application area. For large decals use a pH-neutral soap and water solution, or glass cleaner, to allow easier positioning. Follow the product or vehicle maker's recommendations for the type of lubricating liquid to use.
- 4. Start removing the paper backing from one end of the decal.
- 5. Position the decal on the panel. Continue removing the paper backing, while smoothing the decal with a plastic squeegee.
- 6. Press out water bubbles. Work from the center to the edge.
- 7. Remove the protective cover sheet from the decal.
- 8. Wipe the decal gently to remove excess water.
- 9. If any bubbles cannot be smoothed with just the squeegee, slit the bubble with a razor knife and flatten it out with the squeegee.
- 10. Separate or trim any parts of the decal, if required, by lightly dragging a razor knife over the cut line. Do not cut into the finish.



10. Use Of Recycled (Salvage) Parts

Does not apply.



11. Inspection And Testing

11.1 Inspection Of An Applied Decal

Inspect an applied decal for these conditions:

- proper position and alignment
- proper adhesion
- no bubbles or folds
- properly trimmed or spliced
- proper color and design match with existing decals

Correct any defects.