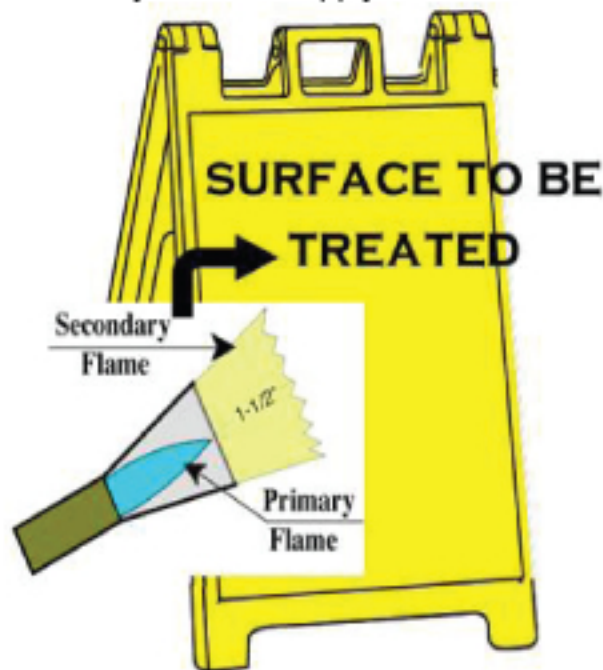


DIRECTIONS FOR PREPARING POLYETHYLENE USING FLAME TREATING

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 second 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.

Apply a FULL sheet of adhesive vinyl sheeting per the above directions within 1 hour after flame treating. In addition to flame treating, 3M recommends wiping the sign recess area with ISOPROPYL ALCOHOL within 20 minutes of flame treating to insure positive adhesion. If you wish to apply cut out letters or shapes to the sign, you would then apply them to the full sheet



HOW TO ATTACH A BLANK SIGN TO SIGN STAND

1. Any wood screw can be used to affix the sign blank to the sign stand. However, if the sign blank is going to be changed many times, we propose the Well-Nuts below.
2. Well -Nuts arrive in bags of 20 or 100 units with a corresponding number of bolts, so that each unit can be assembled in a matter of minutes.
3. Well-Nuts are like a molly for drywall. 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.

