

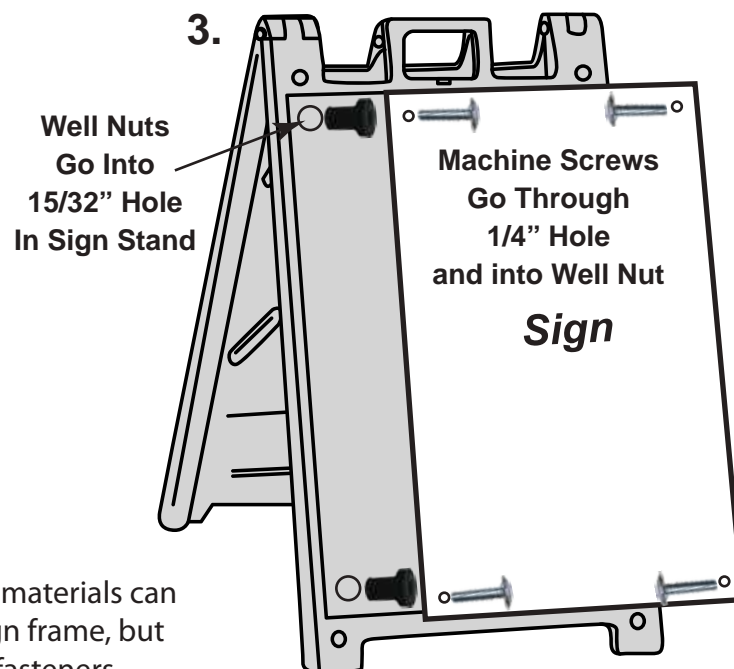
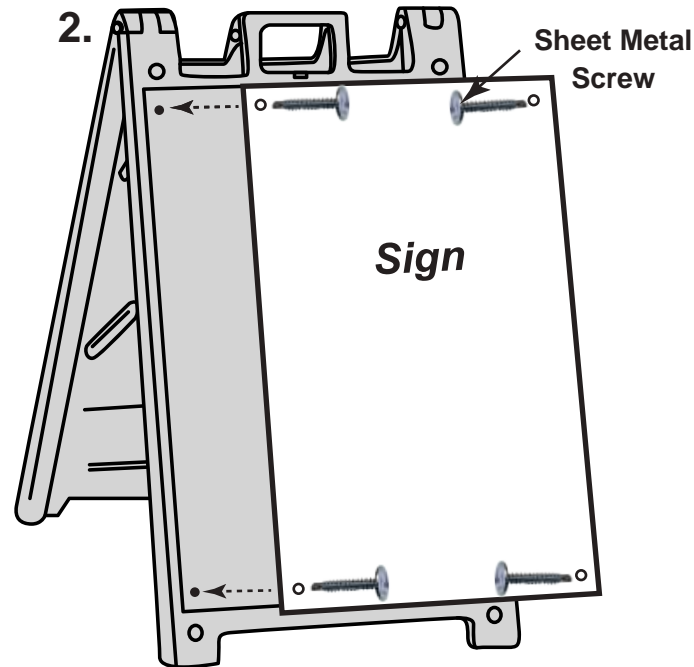
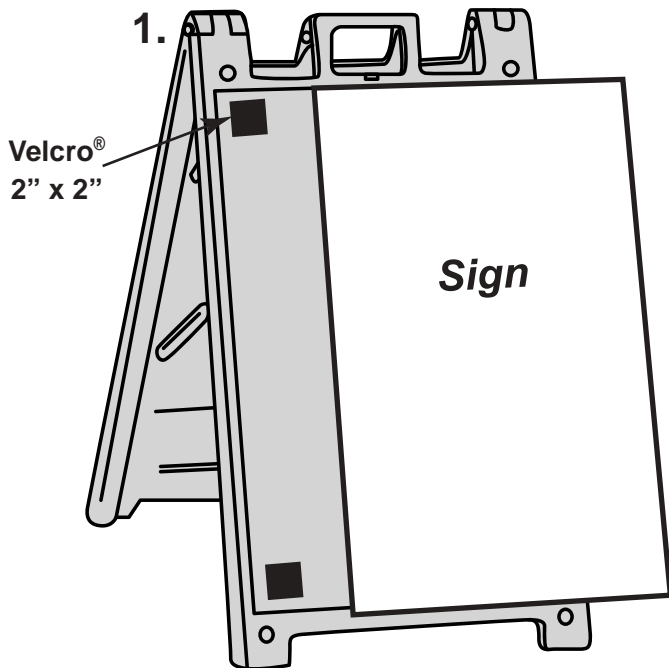
# Instructions For Attaching Signs To Signicade® Sign Frames

Same methods can be used for the Squarecade™, Narrowcade®, and Minicade® Sign Stands

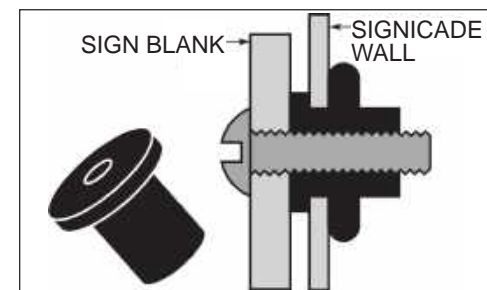
## Corrugated Plastic Sheet (4 mm\*)

Attach corrugated signs using one of the following three recommended methods:

1. **Velcro®** - Use 8 (4 per side) 2" x 2" squares of Velcro® Industrial Strength Fasteners. Clean both the recessed sign surface of the Signicade® and the back of the corrugated sign with rubbing alcohol. Place male (rough side) on the 4 corners of the sign frame. Allow 15 minutes for adhesive to cure, then adhere to sign substrate. Velcro® Part VEL-30703-USA
2. **Screws** - Use 8 (4 per side) wood or sheet metal screws to screw through both the corrugated sheet and the sign stand. #8 x 1" Phillips modified truss head zinc plated sheet metal screw is recommended. No drilling needed.
3. **Well Nuts & Screws** - The well nut becomes a permanent mounting hole making changing signs easier. Drill four 15/32" dia. holes, 2 1/4" in from the corner areas of the flat recess of the frame. Push the well nut into the hole until it is resting on the sign surface. Drill matching 1/4" holes in the sign substrate to align with the well nuts. Use the machine screw to screw through the sign into the well nut. Well Nut - MP neoprene with brass thread insert. Machine screws - Phillips pan head, zinc plated steel, 1/4"-20 x 1"



Recommended method for heavier substrates, such as, metal or aluminum composite.



\*other thicknesses or materials can be attached to the sign frame, but may need additional fasteners.



# Pressure Sensitive (Adhesive Backed) Vinyl Signs & Letters

## Short Term Sign Application (6 months or less)

1. Wipe recessed sign surface with isopropyl alcohol
2. Apply pressure sensitive vinyl to the surface by starting to peel down the backing of the top of the sign.
3. Line up the top of the sign with the top of the recessed sign surface.
4. Apply pressure and smooth any wrinkles as you slowly pull off the sign backing until you're at the sign bottom.
5. A squeegee can be used to help smooth the surface and remove any bubbles.

## Long Term Sign Application- Sign frame must be flame treated to ensure adherence

*We recommend you visit your local Sign Shop for the application of this type of sign.*

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) portion of the flame (see drawing).
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).
5. Treat the sign recess area with the tip of the secondary flame by passing it over the area in gentle sweeping strokes. Total exposure to the flame should be 2 - 3 seconds, 0.5 seconds per stroke. This light exposure should not deform or melt the plastic in any way.
6. Test the recess area for bonding 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.

## Safety Disclaimer for Flame Treating

*Flame treating a sign stand at home involves the use of open flames and can be hazardous if not performed correctly. To ensure your safety and the safety of others, please adhere to the following guidelines:*

*Work Area: Conduct the flame treatment in a well-ventilated outdoor area, away from flammable materials and substances.*

*Protective Gear: Wear appropriate personal protective equipment (PPE), including heat-resistant gloves, safety goggles, and a long-sleeved shirt to protect your skin.*

*Fire Safety: Keep a fire extinguisher or a bucket of water nearby in case of emergencies.*

*Equipment Check: Ensure that your torch or flame source is in good working condition and free from leaks or damage.*

*Flame Control: Use a controlled, moderate flame to treat the sign stand, avoiding excessive heat that could damage the material or cause unintended ignition.*

*Supervision: Never leave the flame unattended.*

*Cooling Period: Allow the treated area to cool completely before handling or applying the vinyl sign.*

*Dispose Properly: Safely dispose of any used materials and clean the work area to prevent accidental fires.*

*Always prioritize safety first.*

