Description

This Bulletin is specifically for the application of 3M recommended films to watercraft.
Watercraft intended for personal pleasure such as motor boats, sailing boats, catboats, mega yachts, jetskis, runabouts and speedboats having aluminum and/or smooth fiberglass/gel coat bodies, but no other boats used in connection with commercial or business enterprise. 3M specifically excludes all other recreational vehicles from this definition.
Be sure you obtain and use the most current supporting Product and Instruction Bulletins referenced in this Bulletin.
Make sure each applicator reads and understands this Bulletin before beginning.
Follow each step in the order given. Do not take short cuts.
3M requires that a properly executed and signed Pre-installation Inspection Record be completed before any 3M graphics are applied. This record, which identifies any potential problem areas, is mandatory if a warranty claim is made in the future. Make a copy of the appropriate record, located at the end of this Bulletin, and take pictures before and after the application for every watercraft.
3M recommends that graphics manufacturers clearly define mutual obligations between the watercraft graphics operating companies and themselves and strongly suggests that graphics manufacturers seek written limitations of claims or liabilities on individual watercraft for unsound paint.
Important Note: All graphics must be applied above the static water line. Graphics applied below the static water line are not warranted or recommended.
All cut seams and edges must be edge sealed or taped.

Do Not Apply Film to These Surfaces

- Textured plastic substrates. 3M does not warrant the application of film to textured plastic substrates under any circumstances. However, if you wish to try, using heat and a rivet brush to conform the film to the texture may be satisfactory for an unwarranted application.
- Substrates with poor bond between paint and boat. Substrates with multiple layers of paint may be even more susceptible to places of unsound paint. We do not warrant graphics applied to unsound paint
- Rubber, silicone or flexible plastics. The adhesive on the recommended films does not adhere to these materials.

Health and Safety

When handling any chemical products, read the manufacturer's container labels and the Safety Data Sheets (SDS) for important health, safety and environmental information.
Follow the link to obtain SDS sheets for 3M products on 3M.com/SDS.
IMPORTANT! When using any equipment, always follow the manufacturer's instructions for safe operation.
Please dispose of cleaning cloths and paper toweling in a responsible manner. Since regulations vary, consult applicable regulations or authorities before disposal.
Refer also to the Product Bulletins for each product in your graphic construction for specific details that may influence the information in this Bulletin.

Ventilation

Always provide adequate ventilation to remove emissions that may result from the use of heat. Failure to provide adequate ventilation can result in operator exposure.

Air Quality Regulations

Country Volatile Organic Compound (VOC) regulations may prohibit the use of certain cleaning chemicals with VOC's in graphic arts coatings and printing operations. Check with your country environmental authorities to determine whether use of this solution may be restricted or prohibited.

Films and Inks

Films for Piezo Inkjet Printing

- 3M™ Print Wrap Film IJ180mC-10
- 3M™ Print Wrap Film IJ180mC-114
- 3M™ Print Wrap Film IJ180mC-120
- 3M™ Controltac™ Graphic Film IJ180-10
- 3M™ Controltac™ Graphic Film with Comply™ Adhesive IJ180C-10
- 3M™ Controltac™ Graphic Film with Comply™ v3 Adhesive IJ180Cv3-10
- 3M™ Envision™ Print Wrap Film LX480mC
- 3M™ Envision™ Print Wrap Film SV480mC

Use the inks and printers recommended in the film's Product Bulletin.

Electronically Cut Film

- 3M™ Scotchcal™ Electrocut Graphic Film Series 100

Interior Application

- 3M™ DI-NOC™ Architectural Finishes
- 3M™ Scotchcal™ Dusted/Frosted Crystal Special Effects Graphic Film Series 7725-300
- 3M™ Scotchcal™ Special Effects Graphic Film Series with Comply™ 5525C-300
- 3M™ Fasara™ Glass Finishes

Wrap Film for Interior and Exterior Application

- 3M™ Wrap Film 2080
  Important Notice: All 2080 gloss films have a clear protective film layer to prevent scratching; this protective film layer must be removed after installation.
- 3M™ Wrap Film 1080

Film has a memory for its original shape. Consequently, stretching the film does result in some shrinkage as it attempts to return to its original dimensions. As it shrinks, you can expect minor tenting and lifting. Heating the film helps reduce its memory, which reduces tenting and lifting around sharp changes in contour. This is discussed more later in this Bulletin.

Important Note: Film with carbon, brushed or matte film surface can be susceptible to dirt. In addition, due to the film roughness it is almost impossible to clean these films. Please inform your customer before the application.

Limited Remedy

Unsuitable End Uses

3M recommended product end uses are listed in each 3M graphics product bulletin. End uses not listed in the applicable 3M Graphics Product Bulletins are typically not eligible for 3M Graphics Warranties. For non-recommended and/or non-warranted end uses or applications, users must test and approve the end uses or applications, assume any associated risks, and acknowledge that 3M has no liability for such end uses or applications. Please contact your 3M representative with any questions about graphic applications, end uses, and warranties.

Limitations of Liability

All questions of warranty and liability relating to this product are governed by the terms and conditions of the sale, subject, where applicable, to the prevailing law.

About Applying Film to Contoured Surfaces of Watercraft

Covering complex curves and contours requires special techniques, including heating and stretching the film. The specific characteristics of a film and the inks with which it is printed, as well as whether the shape is concave or convex, determine how well the film stays bonded to the curved substrate. 3M recommends and warrants only the above listed films for watercraft graphics. These films are two-mil cast films and have less tendency to lift from contoured surfaces.

Adhesive Considerations

The recommended 3M films have pressure-activated adhesive that is slideable, positionable and repositionable until film application pressure is applied. Comply™ adhesive, available on some of the films, has been proven to improve speed and ease of application with virtually no trapped air bubbles.

3M™ Controltac™ minimizes the initial contact area of the adhesive and allows the applicator to reposition the graphic during application. This means that when only light finger pressure is applied to “tack” the film in place, you can still slide it around to position it as needed and even reposition it if it isn't quite right. However, as soon as firm pressure is applied, these features are no longer functional. These features are also affected if you apply the film to a substrate that is too warm.

Films with Comply™ adhesive (for example, film 180C) have a grid of air release channels that provide a fast and easy way for air to escape which reduces the risk of air bubbles developing. However, be careful not to randomly close off these channels.

Unprinted films have the least stretch and solvent piezo printed films have the most stretch, although UV piezo inkjet inks may also inhibit the stretchiness of the film. Also read about the effect of using application heat with UV piezo inkjet inks on page 6. Refer to the specific ink and film Product Bulletins for comments on special application techniques or limitations of use.

Tools

These tools are recommended for a successful application. 3M does not endorse any particular brand of tools that we do not sell ourselves.

- 3M™ Gold Squeegee (PA1-G)
- 3M™ Scotchmate™ Reclosable Fastener - Loop portion SJ-35231
- 3M™ Rivet Brush RBA-1 or RBA-3
- 3M™ Air Release Tool
- 3M™ Primer 94
- 3M™ Edge Tape 8914i
- 3M™ Edge Sealer 3950 (Edge Sealing)
- 3M™ Roller S
- 3M™ Roller M
- 3M™ Masking Tape 3434 or 3M™ Masking Tape 2328
- 3M™ Knifeless Tape
- Infrared pyrometer
- Snap-off cutting knives or razor blades in safety holder
- Industrial heat-gun, or an equivalent, that attains at least +260°C
- Textile gloves

Cleaning Products

This list of tools and cleaners is provided for your convenience; other acceptable cleaners may be available. 3M does not endorse any particular chemical manufacturer or supplier.

Always obtain, read and observe the information in the appropriate SDS sheet for the chemicals you are using.

Solvent-Free General Cleaner

3M™ Citrus Base Industrial Cleaner

Lower Solvent Content Cleaner
3M™ Surface Preparation System

Adhesive Remover
3M™ Citrus Base Industrial Cleaner

Surface Preparation

Clean the Surface

All substrates must be considered contaminated. Clean the substrate immediately before applying the film. Dust and other contaminants can collect quickly on the substrate and prevent the film from adhering properly. Even a freshly painted substrate can collect dust before graphics can be applied.

- Use a solution of 30 ml of a good quality liquid dish detergent per 3.5 liter lukewarm water to thoroughly clean the watercraft. Rinse with water.
  Avoid soaps or preparations that contain waxes, oils or lotions; some window cleaners contain waxes!
  Be aware that the chemicals used in some automated washing equipment may prevent good film adhesion.
  Pay particular attention to cleaning the front and rear of the watercraft, which tends to have more oily residue.
- Dry the surface thoroughly with clean, lint-free paper towels. A heat-gun may be used to apply moderate heat and accelerate the drying.
  Moisture prevents the adhesive from adhering correctly, can cause bubbles, and can freeze in cold environments. Any moisture trapped beneath the graphic will cause the graphic to fail prematurely.
  Moisture on the substrate results from:
  - Inadequate drying after cleaning as well as from application solutions.
  - Condensation at low temperatures (< +4°C).
  - High humidity environments (60% rH).
- Wipe the surface again with a solvent-based cleaner. Refer to the list of cleaners above mentioned. Be sure that the cleaner does not damage the watercraft's paint.

Note: Wax can greatly reduce graphic adhesion. Solvent-based cleaners must be used to thoroughly remove any wax residue. Alcohol-based cleaners do not remove wax as effectively.

- Saturate a clean paper towel with a solvent.
  Wipe with a lint-free paper towel before the solvent evaporates from the substrate. As the paper towel becomes dirty, discard it. A dirty towel will simply move the dirt around, rather than remove it.
  Make sure the substrate is completely dry. If necessary, use a heat-gun to dry any retained solvents.

Application Temperature and Environment

Best Application Temperature

For the best success with the films recommended for watercraft graphics, always apply the graphics when the air and watercraft surface are both above +16°C but no more than +32°C.

Cool Application Conditions

If the temperature is too cool, move the watercraft indoors to bring its surface temperature up to at least the minimum application temperature of +16°C. Temperature control must be done with an infrared pyrometer.

Below the recommended minimum application temperature:

- In very humid conditions, it may be difficult to keep the substrate dry.
- Films are not able to maintain the elevated temperatures required for stretching; films will cool too quickly.
- The initial bond of the adhesive may be insufficient to ensure the film stays adhered.
- Moisture may condense on the watercraft surface if the temperature of the watercraft surface is below the dew point.

Very Warm Application Conditions

If the temperature is too warm, move the watercraft indoors or into the shade and be sure the watercraft surface cools to below +32°C before beginning the installation.
Above the recommended maximum application temperature:

- Graphics may pre-adhere thereby trapping air.
- The adhesive will be more aggressive.
- Controltac™ films may lose their positionability feature.
- The film may become too stretchy.

Post Application Conditions

After application of the graphic, keep the watercraft surface temperature above +16°C for at least 12 hours before exposing the watercraft to either cold or wet climate; this strengthens the graphic's bond to the contoured areas.

How to Reduce or Avoid Film Lifting

Identify all areas on the watercraft where the graphics may tend to lift such as in concave channels. Mark all difficult areas in the Pre-Installation Bulletin at the end of this Instruction Bulletin.

Use Tape Primer 94

Use 3M's tape primer 94 to promote better film adhesion where the film will be stretched.

- In concave channels, apply a thin layer of primer over most of the concave area. Allow the primer to dry for five minutes.
- When going around convex areas, apply a thin layer of primer 94 at the outer edges of the curve to prevent film edge lifting. Allow the primer 94 to dry for five minutes.

Flat Areas First

Apply the film to flat areas of the watercraft first.

Soften Film with Heat

Use heat to soften the film when stretching it around and into complex curves.

- Use as much heat as possible to soften the film without burning it. Typically, heat the film to about +30°C up to +40°C, IJ180mC and 2080 to about +40°C up to 50°C and LX480mC/SV480mC to +50°C up to 60°C for convex and concave areas including ridges and channels.
- Film cools within seconds so gently stretch the film immediately after the heat source is removed. The film should be too hot to touch with unprotected hands; be sure to wear gloves.
- To apply film into concave channels, use nylon gloves or use a squeegee with a low friction sleeve or Scotchmate™ loop material. Press the heated and softened film into the middle of the channel first so that the film is stretched evenly across the channel.

Application to Recesses

Heat the film to about +30°C up to +40°C, IJ180mC and 2080 to about +40°C up to 50°C and LX480mC/SV480mC to +50°C up to 60°C. To minimize the risk of lifting, it is essential, to have sufficient amount of material left. Do not apply the film closer than 20 cm to the recess. Applying heat to areas of film 20 cm beyond the recess area will reduce the tension of the film when being applied in the recess area.

All 2080 gloss films have a clear protective film layer to prevent scratching. Leave on the protective film layer for the entire installation. The use of a wetting solution on top of the film layer may provide some slip resistance for the squeegee. Remove the protective film layer before post-heating film edges and recesses.

Adjust the heat source according to the heating table below.

480	+50°C to +60°C
100	+30°C to +40°C
180	+40°C to +50°C
2080	+40°C to +50°C

Graphics Printed with UV Piezo

Please follow the instruction of each product bulletin and its instruction bulletin.

Application Tape

The use of application tape is not recommended for laminated graphics, Wrap Film 1080 and Wrap Film 2080. However, the use of application tape may ease the film application depending on climate conditions (high temperatures).
The use of application tape is recommended for clear-coated graphics. For large format graphics you may use 3M™ Application Tape SCPM-9 and 3M™ Application Tape SCPM-44X. 3M™ Prespacing Tape SCPS-100 is recommended for prespacing graphics or logos.

Preparation of Application

- air and watercraft surface be both above +16°C but no more than +32°C
- the environment and the working area must be clean, free of dust and dirt and illuminated
- place the films and graphics on a clean table – do not place films and graphics on the floor
- clean the watercraft not using wax
- the watercraft must be completely dry before application

Application Tool

Beside manual application, specially developed hand-rollers can be used for the application of the film into recessed areas. The hand-rollers (3M™ Roller S and L) allow the film to be applied with uniform, continuous pressure and low friction.

(3M™ Roller S and L)

When applying manually, wear textile gloves to lower the friction between finger and film.

Application to Single Recess

Position the film with application tape from the top and fix the edges of the contours.
In case of applying the graphic within the recess area, do not apply closer than 20 cm to the recess. To minimize the risk of lifting, it is essential, to have sufficient amount of material left.

Use firm, even application pressure. The use of 3M™ Gold Squeegee with thin and soft sleeve (e.g. microfibre) is recommended. Wetting of sleeves helps to avoid scratches on film surface during application.
All 2080 gloss films have a clear protective film layer to prevent scratching. Leave on the protective film layer for the entire installation. The use of a wetting solution on top of the film layer may provide some slip resistance for the squeegee. Remove the protective film layer before post-heating film edges and recesses.
Heat the film around the recess with a professional heat-gun.
Adjust the heat-gun according to the heating table below.

480	+50°C to +60°C
100	+30°C to +40°C
180	+40°C to +50°C
2080	+40°C to +50°C

Applying heat to areas of film 20 cm beyond the recess area will reduce the tension of the film when being applied in the recess area.
Apply the film into the recess either with your thumb or with the hand roller (3M™ Roller L or S).
After the film is completely applied into the recess, apply the film on the remaining area within the recess.
Due to the 3M™ Comply™, trapped air can easily be removed without causing air bubbles.

Application to U-Shape Recess
When planning the film application in the recess area, make sure you leave a path for the air to escape.

- Position the panel onto the substrate and fix the panel with magnets or masking tape on the top.
- Roll the panel up to the top.
- Remove the liner carefully from the film.
- Start the application on the flat part of the substrate and bridge the film over the recess (deep channel).

Films require high squeegee pressure to avoid air entrapment between film and substrate. Therefore, the use of 3M™ Gold Squeegee with thin and soft sleeve (e.g. microfibre) is recommended. Wetting of sleeves helps to avoid scratches on film surface during application.

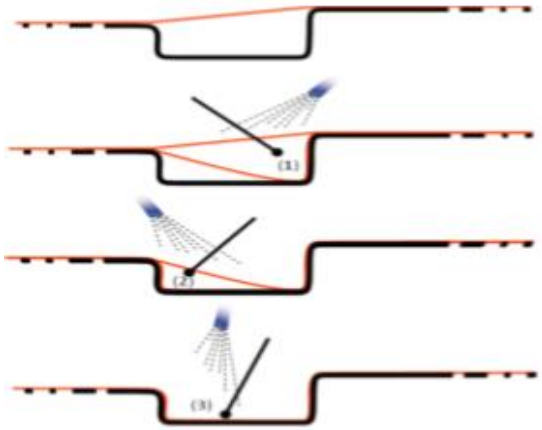
Apply the film into the recess either with your thumb or with the hand roller (3M™ Roller L or S).

When applying manually, wear textile gloves to lower the friction between finger and film.
Heat the film around the recess area with a professional heat-gun.
Adjust the heat-gun according to the heating table below.

480	+50°C to +60°C
100	+30°C to +40°C
180	+40°C to +50°C
2080	+40°C to +50°C

Start film application in the recess in the deepest point first (1). Then continue at the opposite point of the recess (2). Last apply the film in the middle part of the recess (3) (see Figure 1).

Figure 1
Application to recess



Use Heat in Post-Application

For application on recesses, post-heating is required. Ensure that no air bubbles are left trapped between the substrate and the film by re-heating the film in the recessed areas and deep channels with a hot-air gun. By doing this, overlooked air bubbles can be detected. Air bubbles between the film and the substrate must be removed with the air release tool.
After checking air bubbles, the film should be heated.
Adjust the heat-gun according to the post-heating table below.

480	+100°C to +120°C
100	+50°C to + 55°C
180	+80°C to +95°C
2080	+80°C to +95°C

Re-roll immediately the film with the small hand-roller in the recessed areas and deep channels. This softens the adhesive, closes remaining air channels and ensures good final adhesion.
The hand-rollers (3M™ Roller S and L) allow the film to be applied with uniform, continuous pressure and low friction.
Important: All 3M™ Wrap Film 2080 gloss have a clear protective film layer to prevent scratching; this protective film layer must be removed before post heating.

Post-Heating of Overlaps

Post-heating of overlaps with the heat-gun of at least +100°C to +120°C and re-squeegeeing is necessary to avoid lifting at the overlaps of the panels.
Important: All 3M™ Wrap Film 2080 gloss have a clear protective film layer to prevent scratching; this protective film layer must be removed before post heating.

Post-Heating of Film Edges

Post-heating of film edges with the heat-gun of at least +40°C to +60°C and re-squeegeeing is necessary to avoid lifting at the film edges of the panels.
Post-heating of all film edges is required at a minimum temperature as above. Stretching of films of Carbon fiber looks and brushed looks at the edges should be avoided due to possible color fading and cracking.
Important: All 3M™ Wrap Film 2080 gloss have a clear protective film layer to prevent scratching; this protective film layer must be removed before post heating.

Finishing the Installation

To finish the installation re-heat all edges to check film stays free of tension at +40°C to +60°C. Maintain the watercraft at an ambient temperature above +16°C for at least 12 hours. The watercraft

may be washed by hand after more than 24 hours. Dry the graphics to prevent hard water stains. Do not use high pressure spray directed at the edges of the film, which can degrade and lift the edges of the film.

For fast heating of larger film areas the use of Infrared heater (2000 W, e.g. TERM 2000 CVH from company Burda Worldwide Technologies GmbH) is another option.
Important: All 3M™ Wrap Film 2080 gloss have a clear protective film layer to prevent scratching; this protective film layer must be removed before re-heating all edges.

All film edges, overlaps and cuts in channels must be sealed with edge tape 8914i or edge sealer 3950 to avoid lifting of the film. Cut the film in channels only after application and heating of the film.

Application Sequence

Remove the rub-rail and as much additional hardware from the body as possible.
A clean application surface is critical for a good application to watercraft. Clean the surface as instructed on page 4 immediately before applying the film, and apply the film in a clean, dust-free environment.

Apply Primer

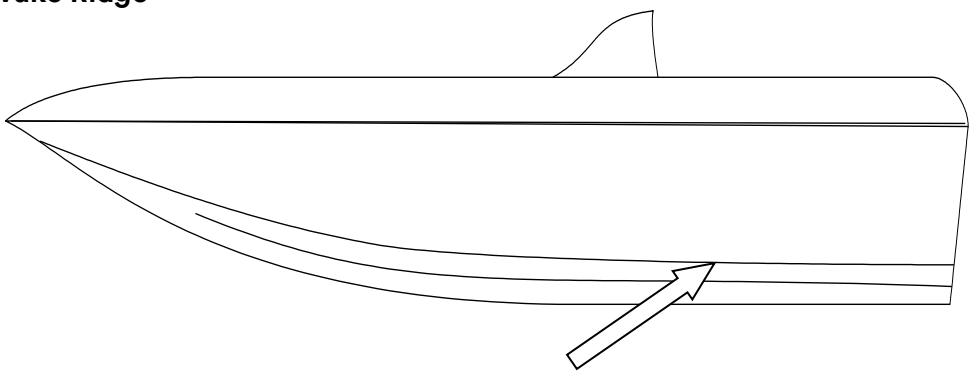
Apply 3M tape primer 94 to all concave or convex surfaces and around any hardware that could not be removed.

- Shake Primer 94 well before using.
- Apply the primer 94 1.2 cm above the “wake ridge” line of the boat. The film will be trimmed or cut a minimum of 1.2 cm above the wake ridge line. See Figure 2.
- Apply a thin, uniform coating to the bonding surface using the minimum amount that will fully coat the surface. Use a brush to apply Primer 94.
- Porous surfaces may require two coats of Primer 94 for uniform coverage and good adhesion. Allow the first coat to dry thoroughly before applying a second coat. Apply the film within one hour.
- Use isopropyl alcohol for cleaning.

Removal of Primer 94

Primer 94 can be removed using 3M™ Citrus Base Industrial Cleaner.

Figure 2
Wake Ridge



Apply 3M™ Knifeless Tape

One of the finishing touches in the application will be to cut the film at all seams in the watercraft panels. 3M™ Knifeless Tape for fast, clean and accurate cutting without any risk of damage to the watercraft. Apply Knifeless Tape to the watercraft seams before applying film to the watercraft. See 3M product and instruction bulletin Knifeless tape for details.

Apply First Film Panel to Length of Watercraft

If the film wraps entirely around the watercraft, plan for only one seam at the middle of the back behind the motor, and one seam just off center of the leading edge of the front. Apply one horizontal film panel to the entire length of the watercraft, making sure there is enough film to apply at least 75 mm beyond the center front over the front and the center rear.

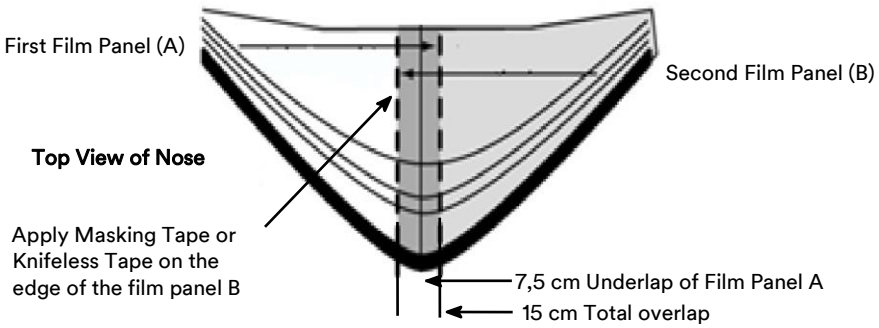
- If installed as shown figure 3, apply Panel A at least 75 mm past the center line (indicated by the right side dotted line).
- Apply 3M™ Knifeless Tape or 3M™ Masking Tape 3434 over Panel A film, 75 mm to the left of the center line (indicated by the left side dotted line).
- Apply Panel B so it extends over 3M™ Knifeless Tape.
- Be sure the film is well squeegeed, and then pull the filament in the Knifeless Tape to trim Panel B. Re-squeegee.

Overlaps on Center of Nose

On the nose of the watercraft you need to create a total film overlap of about 150 mm (see Figure 3). To do this

- Apply 3M™ Masking Tape 3434 or 3M™ Masking Tape 2328 or 3M™ Knifeless Tape on the center of the nose.
- Position the edge of the first film panel (A) so it extends about 75 mm past the center of the nose. Squeegee this film as instructed.
- Overlap the next film panel (B) so it extends about 75 mm past the center of the nose, going the other direction.
- Cut through film panels A + B and remove the unwanted film.
- Remove the masking tape and complete the application.
- To secure the edges use edge sealer 3950 or edge tape 8914i.

Figure 3
Overlap on Nose



Application Techniques

General Technique

- Apply 3M™ Scotchmate™ loop portion SJ-35231 on the plastic applicator 3M™ Gold Squeegee to minimize the possibility of surface scratching.
- Use firm, even application pressure.
- Stroke from the center of the film panel to the nearest edges (usually vertically). This reduces

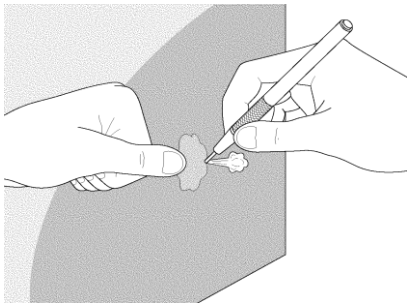
the chance of trapping air and forming air bubbles.
Use overlapping squeegee strokes to be sure you do not miss any areas that could trap air.

- If air is trapped use an air release tool to aid in removing air bubbles. A missed area leaves wrinkles and bubbles in the applied film. These are areas where premature film failures may occur.
- Seams on a watercraft flex as the craft moves. If they are not cut, the graphics will pull away from the seam, resulting in premature failure. If you applied Knifeless tape to all seams before applying the film, simply pull the filament in the tape to cut the film. Gently lift the film at the cut and remove the Knifeless tape. Use a squeegee to firmly adhere the film to the substrate. Edge finishing will be required at these cut seams.

Puncturing and Rubbing Out an Air Bubble

- Puncture the bubble at one end with a pin or 3M™ Air Release Tool. Do NOT use a razor blade or knife.
- Press out the entrapped air by moving your thumb toward the puncture. See figure 4. Post-heat the punctured spot at a temperature of more than +85°C using a heat-gun.

Figure 4



Application of 3M™ Controltac™ Films

3M™ Controltac™ minimizes the initial contact area of the adhesive for easy sliding, tacking, snap-up and repositioning.
Comply™ technology allows air to exit through air release channels to the edge of the graphic.

Final Squeegee and Edge Finishing Required!

After the graphic installation is complete, re-squeegee all film edges, overlaps and cuts in channels. Then apply edge tape 8914i or edge sealer 3950 to these edges. This step is required for warranted watercraft graphics.

Figure 5

Applying Edge Tape 8914i

This tape is 12 mm wide. Apply it so it straddles the edge of the film evenly (6 mm on the film, and 6 mm on the watercraft). See figure 5.

- Overlap the corners
- Squeegee firmly, once again

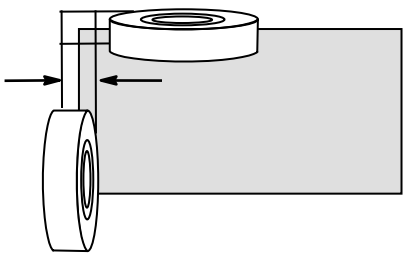
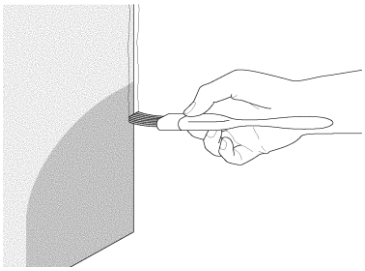


Figure 6
Applying Edge Sealer 3950

- Apply the edge sealer when the substrate temperature is +10°C to+38°C.
- Use the felt dauber supplied or a 1.2 cm brush.
- Hold the brush or flat edge of the dauber so it straddles the film and the substrate.
- Pull the dauber or brush along the edge in a smooth, continuous motion. Make sure the entire length is covered, with no gaps (see figure 6). Edge sealer dries in about 15 minutes at +15°C.
- Edge sealer can be removed using 3M™ Citrus Base Industrial Cleaner.



- Replace the watercraft's hardware and seal all edges with silicone.

Removal

Refer to the film's Product Bulletin for information on its removal, and Instruction Bulletin 6.5 for additional details on film removal.

You are required to complete the 3M Watercraft Pre-Installation Inspection Record on the following pages before applying 3M film.

Watercraft Graphics Pre-installation Inspection Record

Note: Complete both pages of this Pre-installation Inspection Record, using a separate record for each vehicle, before each new graphic installation and between subsequent graphic installations on the same vehicle. Watercraft is intended for personal pleasure such as runabouts and speedboats having aluminum and/or smooth fiberglass/gel coat bodies, including boats used in fishing tournaments and off-shore racing boats.

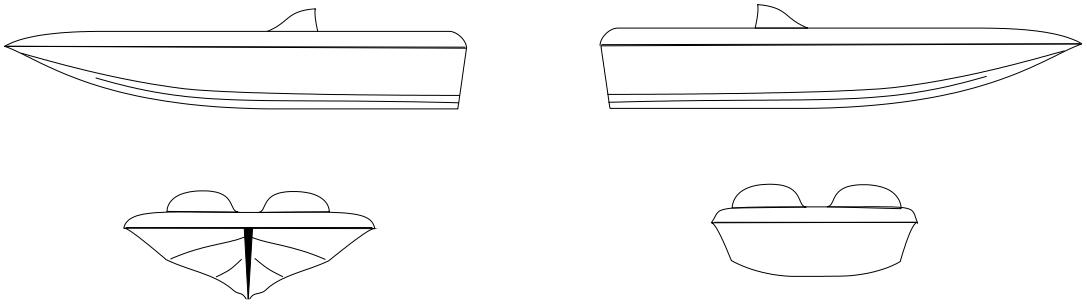
Installer Requirements

Carefully and thoroughly examine each watercraft and record all potential problem areas prior to installing the film. We recommend washing the watercraft so that potential problem areas are easily seen.

- Ensure that the paint is sound so that the film will have good adhesion to the paint. For the purpose of this program, “sound paint" is defined as paint that is free of defects (see the “Defects" bullet below). Note, however, there is no paint refurbishment warranty offered.
- Circle all areas on the following diagram where your inspection shows that the paint may be unsound, the graphic may to be able to adhere well, or graphic removal may damage the watercraft paint. This includes:
    - Defect: paint that is not well bonded over the entire application surface, including multiple layers of paint being well bonded to one another; loose paint, dents and surface damage; rough surface; fillers used for damage, rust or blistered paint.
    - Areas where water can collect, which are more likely to rust, resulting in paint adhesion problems.

Note: Primer, which does not outgas, may be applied to bad paint spots on the watercraft to prepare it for film application. However, the use of primer on bad paint spots does not guarantee success or a warranty; this must still be considered a problem area and must be documented on the Pre-installation Inspection Record.

Circle all areas where the paint may be unsound:



Further Remarks on the condition of the watercraft

3M Watercraft Pre-installation Inspection Record

COMPLETE THIS FORM, PROVIDE A COPY FOR EACH SIGNER AND RETAIN WITH PHOTOGRAPHS IN CASE OF A CLAIM.

Please print except in signature boxes.

WATERCRAFT OWNER/OPERATOR
COMPANY NAME
CONTACT NAME
STREET ADDRESS
CITY / STATE / ZIP
AREA CODE / PHONE NUMBER
GRAPHICS PRINTER
COMPANY NAME
CONTACT NAME
STREET ADDRESS
CITY / STATE / ZIP
AREA CODE / PHONE NUMBER
GRAPHICS INSTALLER
COMPANY NAME
CONTACT NAME
STREET ADDRESS
CITY / STATE / ZIP
AREA CODE / PHONE NUMBER

WATERCRAFT INFORMATION	
LICENSE NUMBER	STATE
WATERCRAFT YEAR, MAKE AND MODEL	
VIN NUMBER	
WATERCRAFT OWNER/OPERATOR	
PRE-INSPECTION: (see the previous page of this bulletin for inspection requirements) - PASSED (DATE: _____ BY: _____) - FAILED (Owner waives all product warranties if graphics are applied)	
PHOTOGRAPHS OF POTENTIAL PROBLEM AREAS: - YES (DATE: _____ BY: _____) - NO	
GRAPHIC CONSTRUCTION AND INSTALLATION INFORMATION	
INSTALLATION DATE	
GRAPHIC COVERAGE - FULL - PARTIAL	
SUBSTRATE CLEANED AND PREPARED ACCORDING TO 3M RECOMMENDATIONS: - YES (DATE: _____ BY: _____)	
FILM USED	
LOT NUMBERS ☐ _____ BASE FILM _____ _____	
☐ _____ INK _____ _____	
☐ _____ OVRLAMINATE _____ _____	
SIGNATURES OF ALL PARTIES	
INSTALLER / DATE	
AGENCY REPRESENTATIVE / DATE	
WATERCRAFT OWNER/OPERATOR / DATE	

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