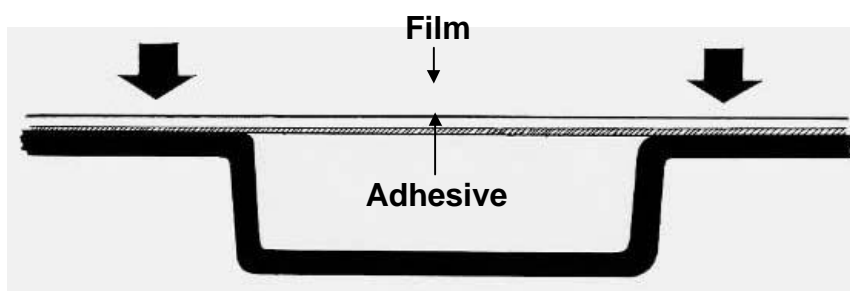


# Inlay Method for Applications to Recessed Panels and Recessed Areas

---

## Description

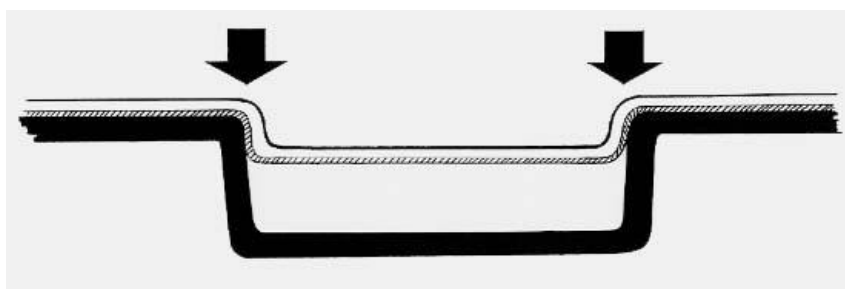
This bulletin gives 3M™ recommended guidelines for applications to recessed panels and recessed areas using, 3M™ Controltac™ Plus Graphic Film Series 180, 3M™ Controltac™ Plus Conformable Graphic Film 8620 (ES) and 3M™ Scotchcal™ ElectroCut™ Film Series 100.



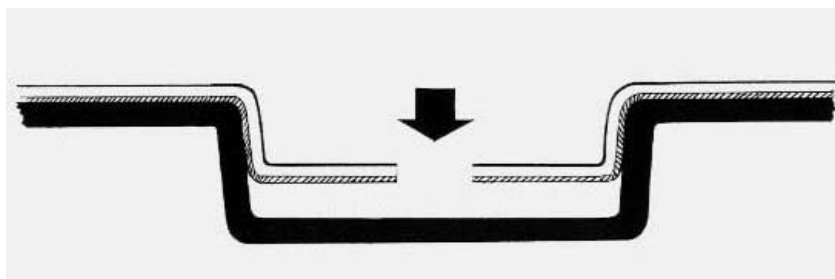
1. The surface must be degreased with Prepsol 3919S (or a good wax/silicone degreaser). It is very important that the whole recessed area is thoroughly degreased.

After application of the film to the flat surfaces, the application tape is removed.

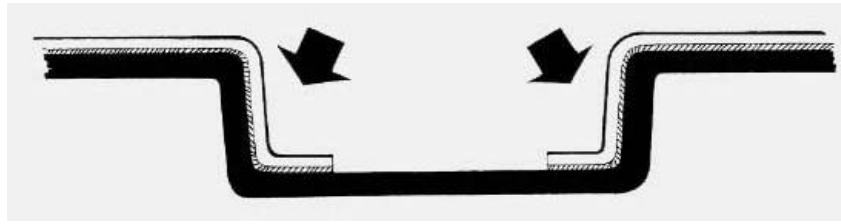
Ensure the application surface temperature is at least 10°C.



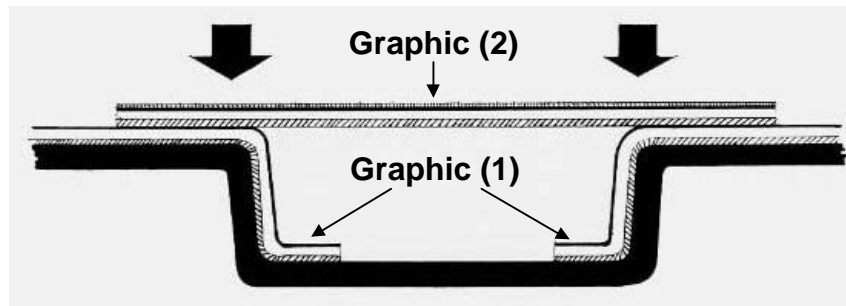
2. The film is warmed with a heat gun and formed to the radiused edge using a soft cloth or cotton glove. It is important that the temperature of the film does not exceed 55-60°C.



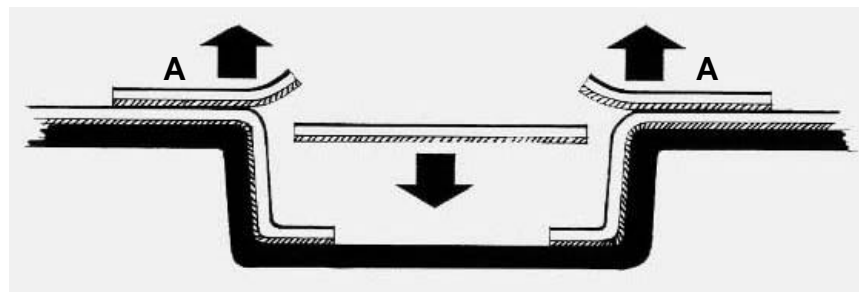
3. The film is cut in the middle of the recessed panels.



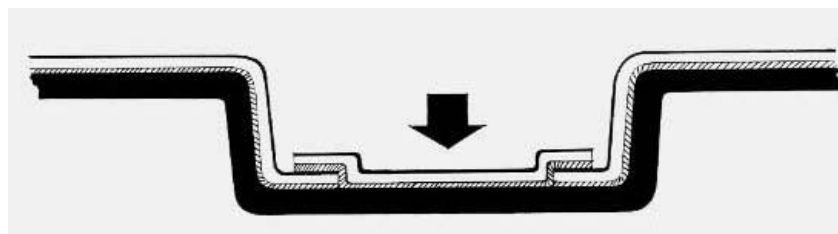
- The film is applied into the recess following the profile without stretching or stressing the film. Carefully degrease the floor of the recess and the surface of the graphic applied in this area with isopropyl alcohol.



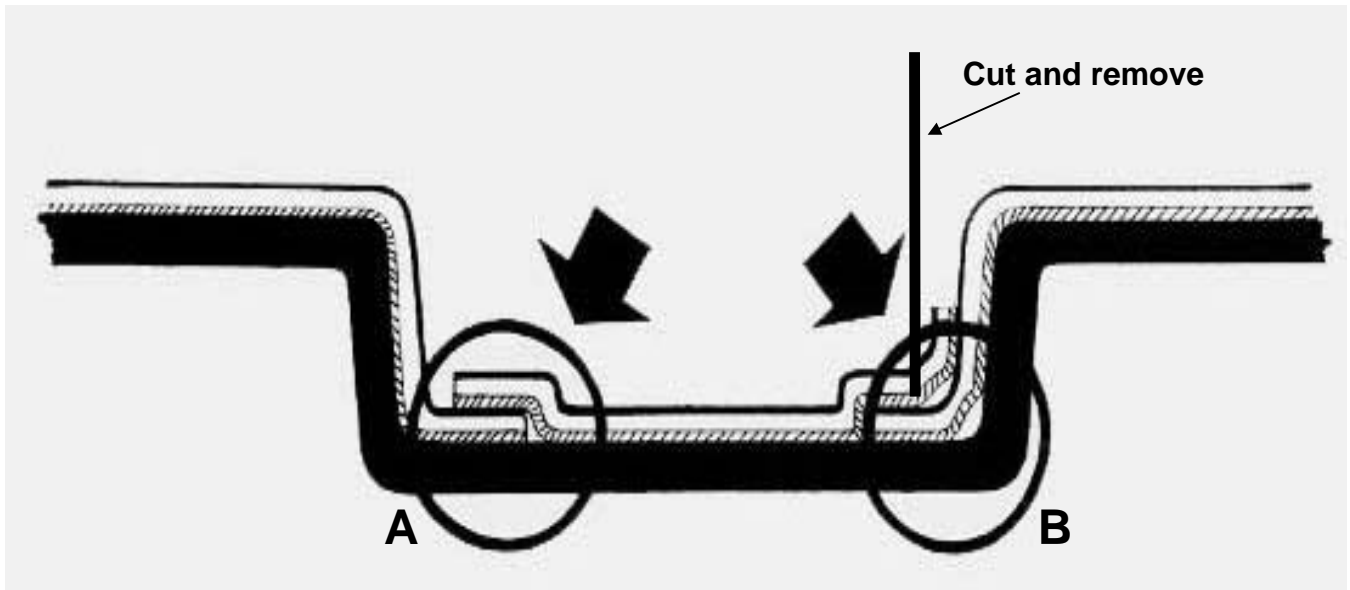
- The fillet of film to be inlayed is registered exactly on top of the first graphic. The application tape is removed after application.



- The inlay strip is now cut free and adjusted on both sides of the profile to register with the graphic previously applied. The excess film (A) is removed.



- The inlay strip is applied with an overlap onto Graphic (1). All the edges are rebrushed firmly with a 3M™ Rivet Brush Applicator, RBA-1 and heated with a hairdryer (55-60°C). Please use a soft cloth on the rivet brush in order to protect the 3M graphic.



8. Please note:

It is essential that all the film overlaps are reapplied/rebrushed so that there are no air pockets (A) and (B).

It is also important that the inlay film overlaps **ONLY** on the floor of the recess. It must not overlap onto the sides of the recess.

We recommend that applications of this type are carried out by experienced applicators.

---

## Health & Safety

Refer to the package label and the Material Safety Data Sheet for health, safety, and handling information on the products referenced in this bulletin. For 3M products, if necessary, you may contact our Toxicology/Product Responsibility Department on 01344 858000.

## Important Notice to Purchaser

The 3M products described in this publication are covered by a 3M warranty and limitation of liability.

3M's warranty provides that if 3M finds that goods are defective in material or workmanship they will be replaced or the price refunded at 3M's option but note that 3M does not accept liability for other direct losses (except for personal injury or death) or consequential losses relating to defective products or from information supplied by 3M.

Purchasers and users of 3M products, and not 3M supplying companies, are always solely responsible for deciding on the suitability of the 3M product for their required or intended use.

## Technical Assistance

For help on specific questions relating to 3M Commercial Graphics Division Products, contact your local Technical Service Representative.

Commercial Graphics Department  
3M United Kingdom PLC  
Customer Technical Centre  
Easthampstead Road  
Bracknell  
Berkshire RG12 1JE

Tel: 01344 866328  
Fax: 01344 866301