

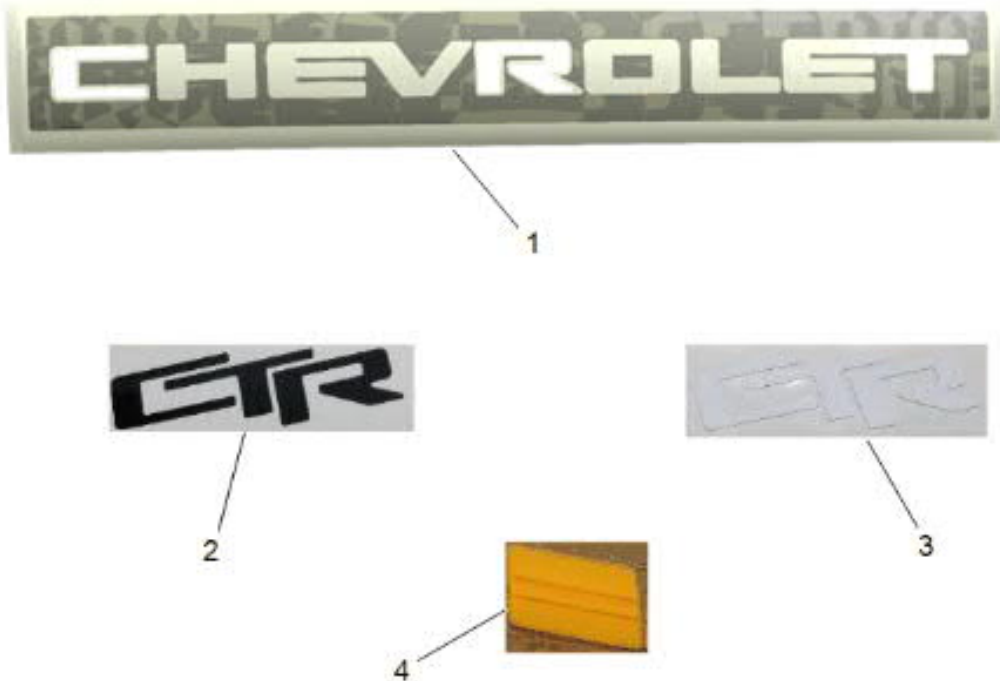
# Rear Decal Package Installation

## Installation Instructions Part Number

85160135

To enable a successful installation of decals please refer to 52524.01V Accessory Decal Installation Tips and Tricks at <https://techtube.gallery.video/detail/video/5991123051001/52524.01v-accessory-decal-installation-tips-and-tricks?autoStart=true&q=decals>

**Note:** Video is referenced from the GM Tech Tube in Center of Learning.



## Kit Contents

Item	Qty	Description
1	1	Decal-Endgate
2	1	Accessory Tool-"CTR" Letters (Black)
3	1	Accessory Tool-"CTR" Letters (White)
4	1	Plastic Squeegee
-	1	Installation Instructions

## Tools Required

- 70% Isopropyl Alcohol
- Lint-free cloth
- Sewing Needle or Thin Pin  
**Note:** Do NOT use a razor blade.
- Plastic Squeegee (included in kit)  
**Note:** Only use a plastic squeegee provided to work the decals. Using the incorrect squeegee will damage the decals.
- Spray bottle that contains a wetting solution (3 or more drops of unscented liquid detergent mixed with 24 oz. of water)  
**Note:** The decal needs to float on the painted surface for easy positioning, if the adhesive is sticking to the painted surface then add more drops of soap to the spray bottle. Do NOT use Commercial premixed soap solution.
- Unscented Liquid Dish Soap

## Important Considerations

Attempting to install a decal dry (without the use of a surfactant) can result in bubbles that will be difficult to remove.

## Preparation - Before Installation

1. After opening the kit, check to see if any parts are missing and that the product is not damaged.
2. This product should be installed with proper installation tools.
3. Install this product while observing all warnings and precautions stated in this instruction booklet.
4. **IMPORTANT: Begin with a thoroughly washed vehicle.**
5. Ambient temperature of decals and vehicle must be 70°F / 21°C to 90°F / 32°C at the time of installation and for a minimum of 30 minutes and up to two hours after.
6. Thoroughly clean vehicle surface with 70% isopropyl alcohol and follow with a dry wipe.
7. To ensure bubble-free application, put three or four tiny drops of liquid detergent into a 24 oz. / 750 ml trigger-type spray bottle and fill with water. Replace the top and shake to mix the soap and water "surfactant." Set nozzle for a fine mist.

**Note:** It is strongly recommended not to use professional premixed surfactant, but to mix your own soap and water surfactant to control the how the part floats on the panel for positioning before activating the adhesion with the squeegee.

**Note:** See "Accessory Decal Installation Tips and Tricks" video for demonstration.

## Installation Notes

1. All of the decals include premask carrier extensions and notches that allow the installer to accurately align the decal to the body panel.
2. The soap / water "surfactant" is intended to allow the installer the opportunity to position the stripe before any pre-adhesion can occur. If the decal sticks prematurely and does not easily "glide" across the surface of a body panel, increase the amount of surfactant that has been applied to the body panel and/or place additional soap into the spray bottle and re-spray.
3. The adhesive is activated by pressure. Be sure to use firm, overlapping strokes, beginning at the center of the decal and working toward the edges of the decal.

**Note:** Squeegee shown in pictures has a protective cloth attached to the squeegee. Installer must use a lint free towel to cover edge of squeegee to prevent damage to decal once the blue premask is removed.

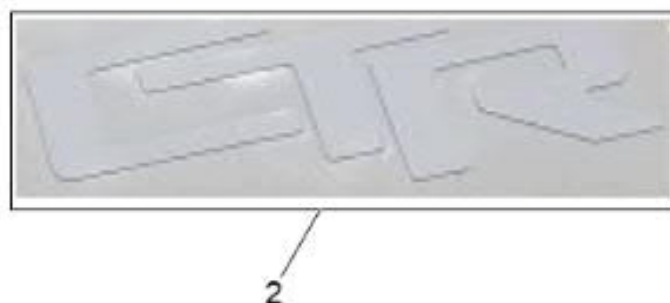
4. When using the squeegee, be careful not to drag the squeegee onto the painted body panel.
5. After premask removal, never use an uncovered squeegee to re-press a decal into place. Wrap the squeegee with a lint-free towel and re-spray the decal with surfactant before applying additional pressure.
6. The decals have a paper-premask carrier. Should this carrier be difficult to remove, spray the carrier paper with the surfactant and wait 10 seconds for the carrier to soften and release from the decal.
7. If bubbles are present after premask carrier removal, wrap a towel around the squeegee and carefully attempt to push bubble to the side of the decal. If the bubble cannot be moved, use a sewing needle to pierce the bubble and press the remaining solution from beneath the decal.

**Note:** The pin must be inserted in the side of the bubble, not the top to prevent the pin from breaking the paint and cause corrosion.

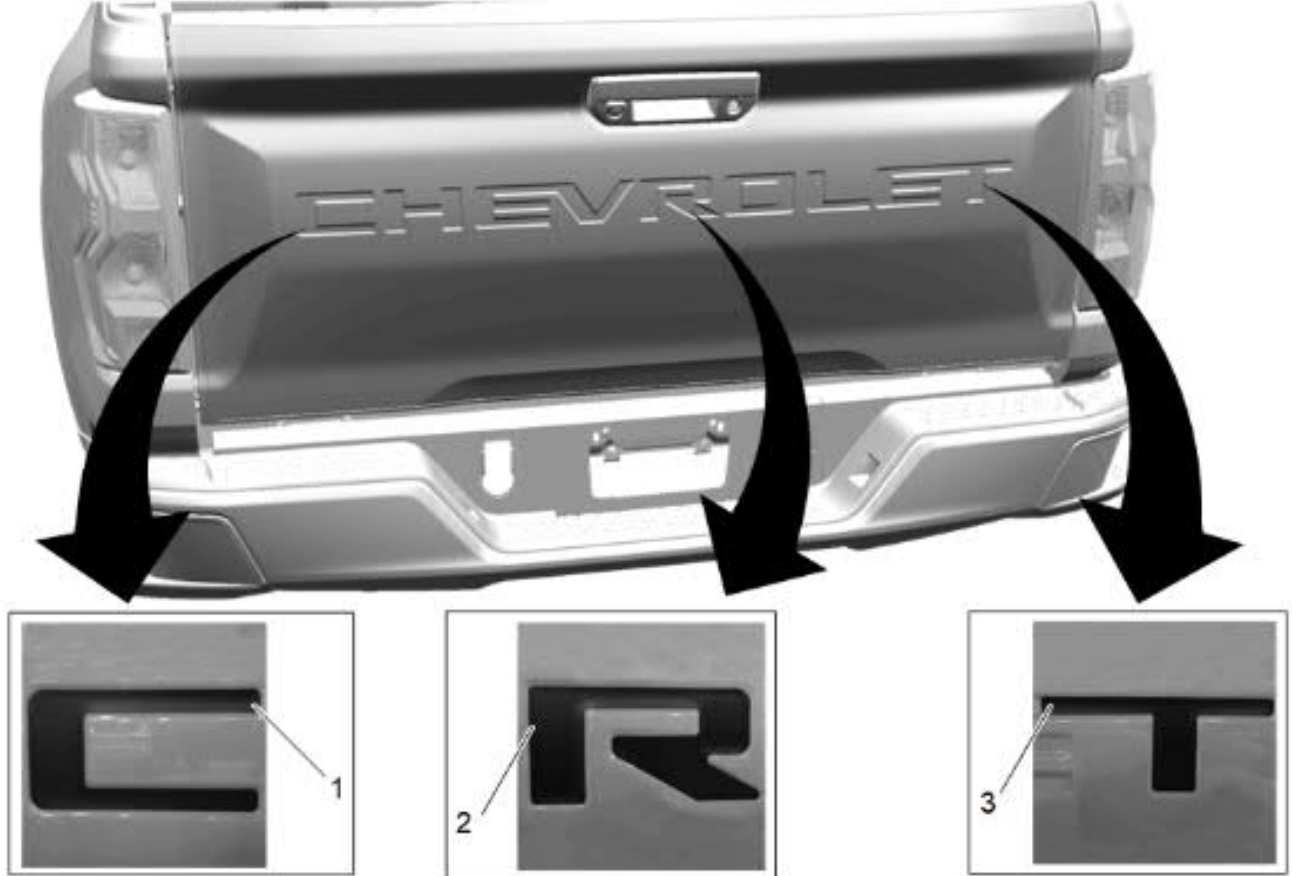
**Note:** See "Accessory Decal Installation Tips and Tricks" video for demonstration.

**Note:** After a decal installation has been completed, do not high pressure wash the vehicle for 72 hours.

## Installation Procedure



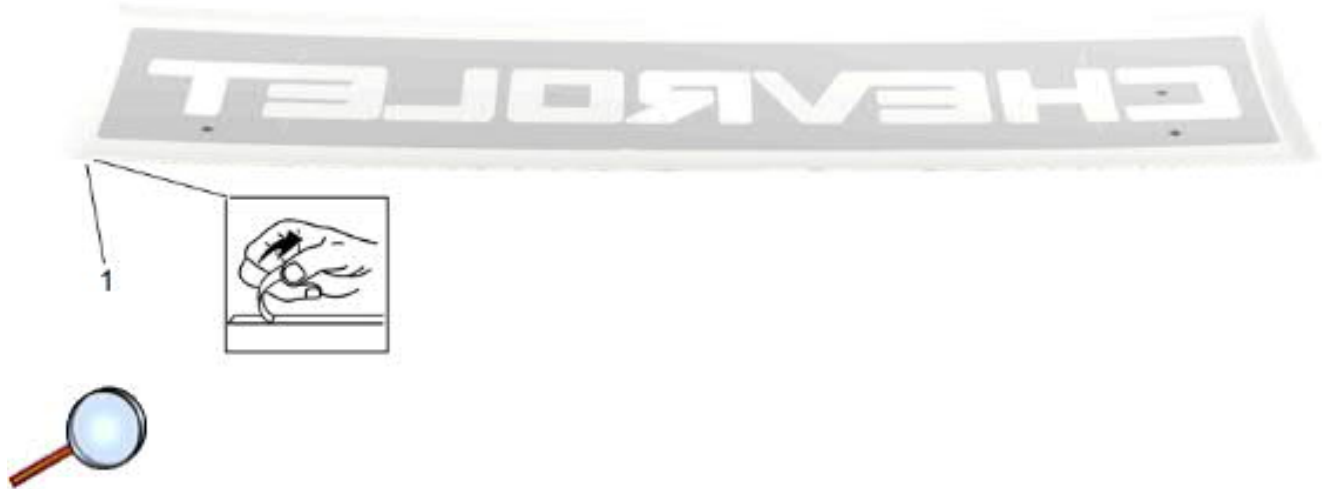
1. Select either the Black (1) or White (2) "CTR" letters for best contrast to the body color as an installation aid.



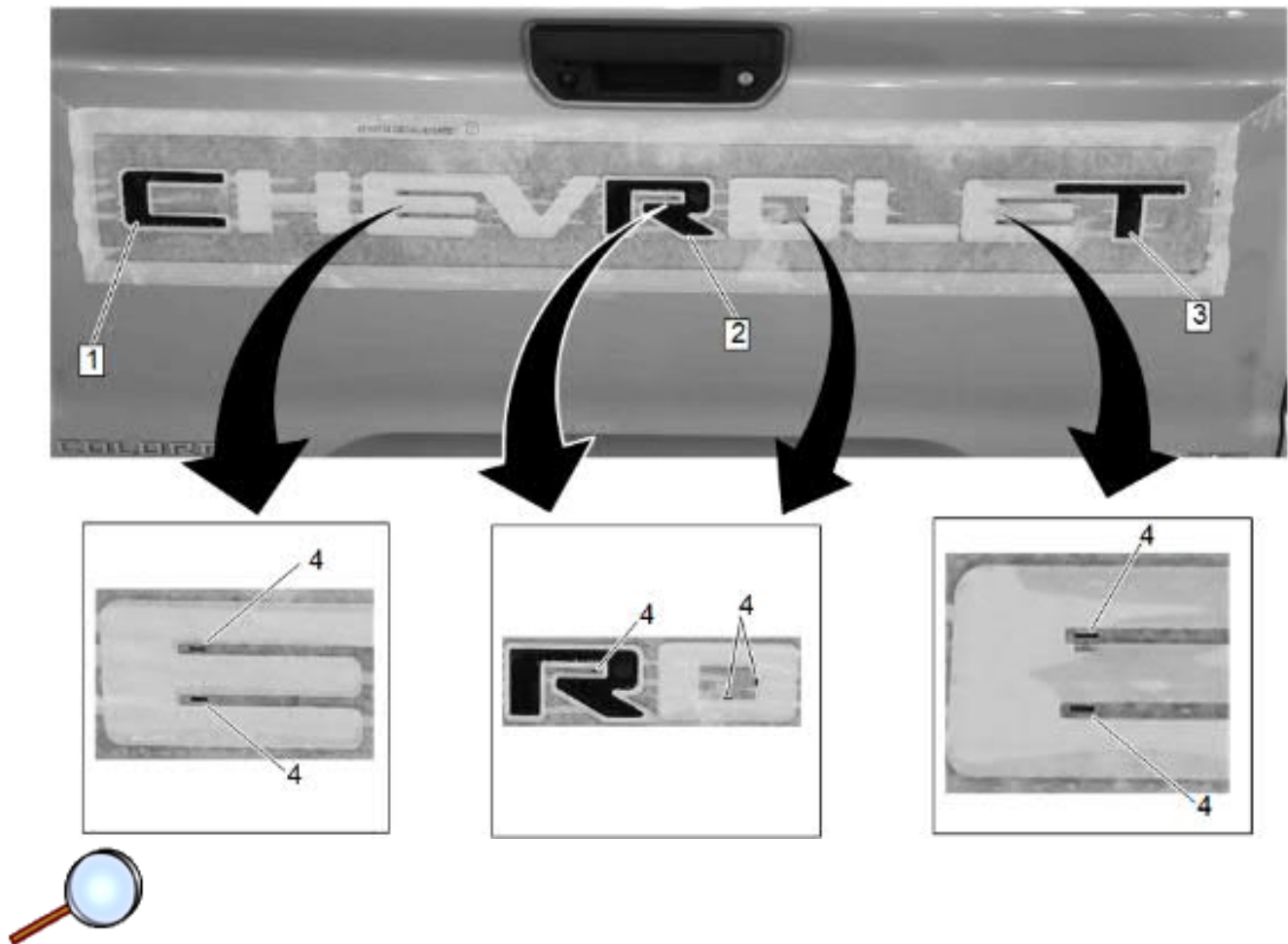
2. Carefully remove the "C" from the kiss cut sheet.
3. Carefully align the letter into the recessed "C" (1) in the tailgate panel. These letters are dry installation, nosurfactant is used until the larger decal installation later in the steps.  
**Note:** This letter should be on the flat section of the recess and not roll up the side.  
 Reposition as necessary.
4. Use finger-pressure to secure the letter into place.
5. Repeat steps 2 thru 4 for "R" (2) and "T" (3) letters.



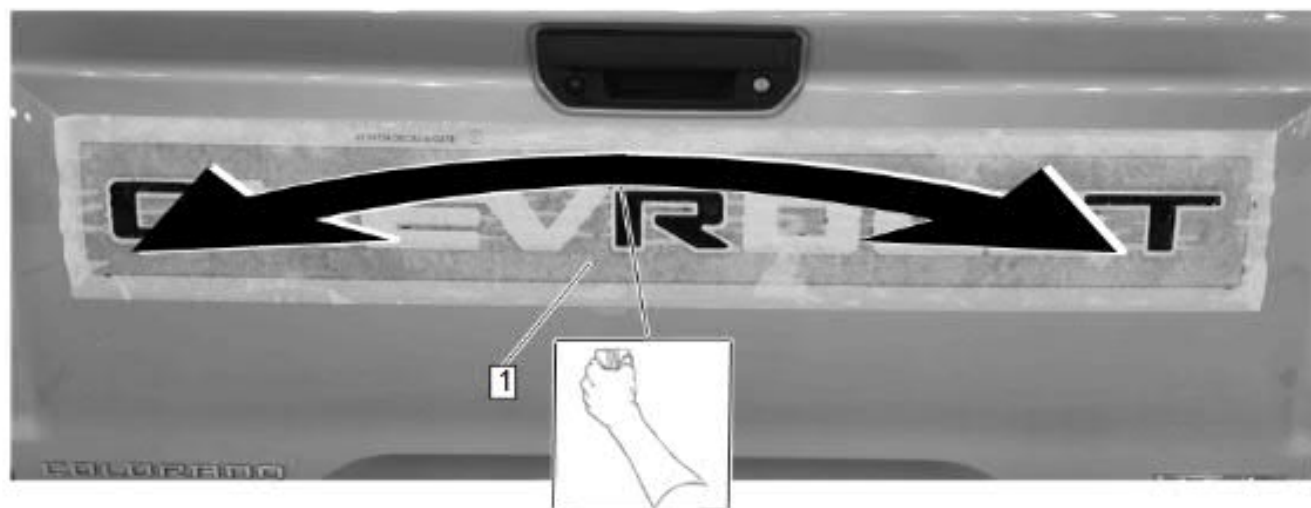
6. Reclean the surface (1) with 70% Isopropyl Alcohol and lint-free cloth to remove any fingertip oils and residue from the "CRT" letter install.
7. Use the surfactant to saturate the area where the decal is to be applied.



8. Lay the decal upside down on a flat surface and slowly remove the liner (1) from the decal without bending the decal, the adhesive side of the decal will now be exposed.
9. Saturate the adhesive side of the decal.



- Carefully lift the decal from the surface and lay the adhesive side onto the tailgate panel.
- Align the cutout letters premask carrier to the Installed "C" (1) "R" (2) and "T" (3) letters installed on the tailgate.
- Check the alignment to the cutout lettering and overall placement. There are black markings (4) on the premask to indicate where it should align to in the sheet metal. Run your fingers along the areas to check the sheet metal alignment underneath the carrier.

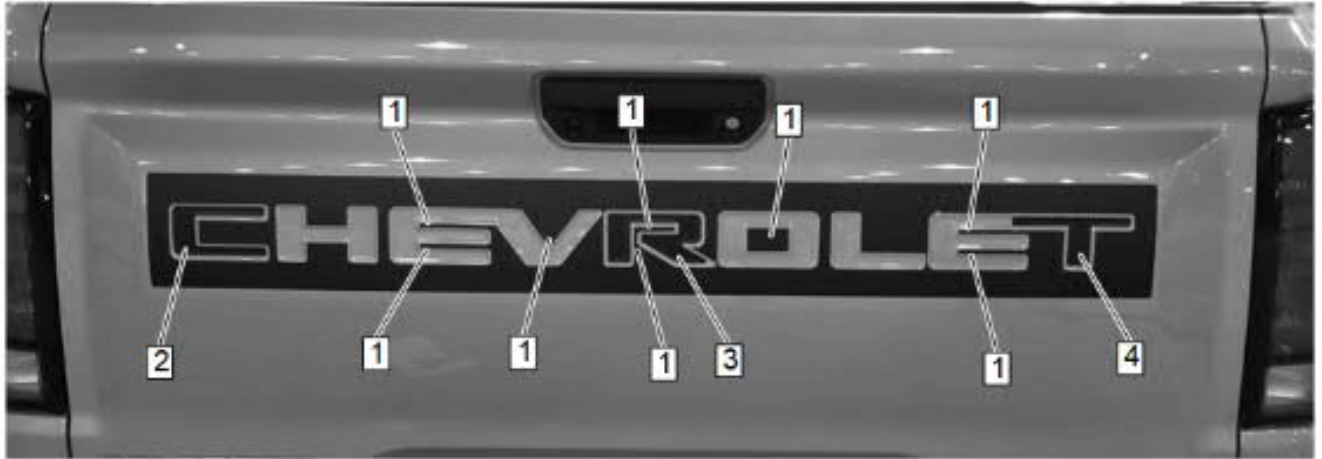


- Use the plastic squeegee to press the decal (1) into place beginning at the center and working towards the sides using firm overlapping strokes. Use the squeegee to work around the lettering and wet out in the direction of the premask being careful not to catch the premask edge and lift/tear decal. If necessary, slightly lift the decal when approaching the ends (to minimize wrinkling). Use the squeegee to work around the lettering and wetout in the direction of the premask being careful not to catch the premask edge and lift/tear decal.



- Spray surfactant onto the premask to ease in removal.

15. Slowly remove the top premask carrier (1) by pulling it off at 180 degrees, being careful not to tear the decal. Starting from the "T" end of the premask pulling horizontally towards the "C". This is going in the natural direction of the fingers of the "E", however, take extra care for the "R" thin areas so it does not tear (decal may lift, so gently reposition in the center of the "R" and press into place with your finger).



16. Inspect decal for bubbles, raised edges, and make sure critical areas (1) are straight and in proper placement as they could have moved/lifted during the premask removal.
17. Due to the texture of this decal the wrapped squeegee will not glide easily on the surface, use fingers to push bubbles to the edges of the decal. It is advised on the thin areas to use fingers only to ensure proper placement while pressing down to get out the extra surfactant to promote adhesion. If bubbles still remain and need more force applied, then wrap the squeegee with a lint-free cloth, re-spray decal with surfactant and re-press decal into place while checking alignment.
18. Carefully remove the "C" (2), "R" (3) and "T" (4) letters while not disturbing the surrounding decal.



19. Clean off residual surfactant with lint-free cloth and do a final inspection the decal (1) with a flashlight or lamp. **Tip:** Due to the pattern and low gloss, use a flashlight to look for bubbles and express using fingers.

20. Installation Complete.

**Note:** After a decal installation has been completed, do not high pressure wash the vehicle for 72 hours.