

Badge Installation

Prod Phase:

Final Assembly

Applicable Models:

LX 21, LX 20

iKON



Revision History

Rev	Author	Date	Changes
0	A. Clements	2-15-2023	Initial Release.
1	D. Douglas	5-8-2023	Updated to new format. Combined hull badge and seat badge into one instruction.
2	D. Douglas	9-27-2023	Updated for Mylar Templates.

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Tools and Supplies

Parts Needed

Tools and Supplies	Parts Needed		
	P/N	Description	QTY
Isopropyl Alcohol	0016144	Badge, iKon Hull Side Chromax, 17" x 3.75" (OPTION)	2
Masking Tape	0016663	Badge, iKon Hull Side - Black, 17" x 3.75"(OPTION)	2
	0016143	Badge, iKon 4" Oval Seatback Chromax, Black Fill	2

Symbols

Safety Glasses: Required anywhere except office and designated break areas.		CTQ SYMBOL: Indicates items that are critical to safety/quality	
Respirator: Required when symbol is present.			
Gloves: Required when symbol is present.			

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Section 1: Hull Side Badges

Step 1.1
Clean hull surface with Isopropyl alcohol and rag and let sit for 30 seconds (or until it evaporates).

1.2
Tape the Mylar Templates along the style lines in the hull as shown.

- **T001674 Jig, 21 STRB Hull Decal**
- **T001675 Jig, 21 PRT Hull Decal**

Note: STRB Decal Shown. Instructions are same for Port (different mylar).



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Section 1: Hull Side Badges

1.3

Install the badges.

1. Remove the backing paper from the sticky side of decal
2. Start decal installation in the location marked on the mylars
3. Firmly press decals into place.
4. Remove protective film from front of decals.
5. Remove the mylar jigs.
6. Lightly tap decals with rubber mallet to ensure full contact.



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Section 2: Seat Badges

Step 2.1
Clean the seat surface with Isopropyl alcohol and rag and let sit for 30 seconds (or until it evaporates).

2.2
Tape a reference line that is level with the top of the stripe measuring down 3-1/2" above (this sets the bottom "level" line for alignment).



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Section 2: Seat Badges

- 2.3
1. Install the badges.
 2. Remove white backing to expose adhesive (be careful not to touch the adhesive).
 3. Line up the badge so that the badge is centered on the stripe and level.

Note: there should be an even reveal on top and both sides.
 4. Press badge into place, apply firm pressure for 30sec.
 5. Installation is complete.



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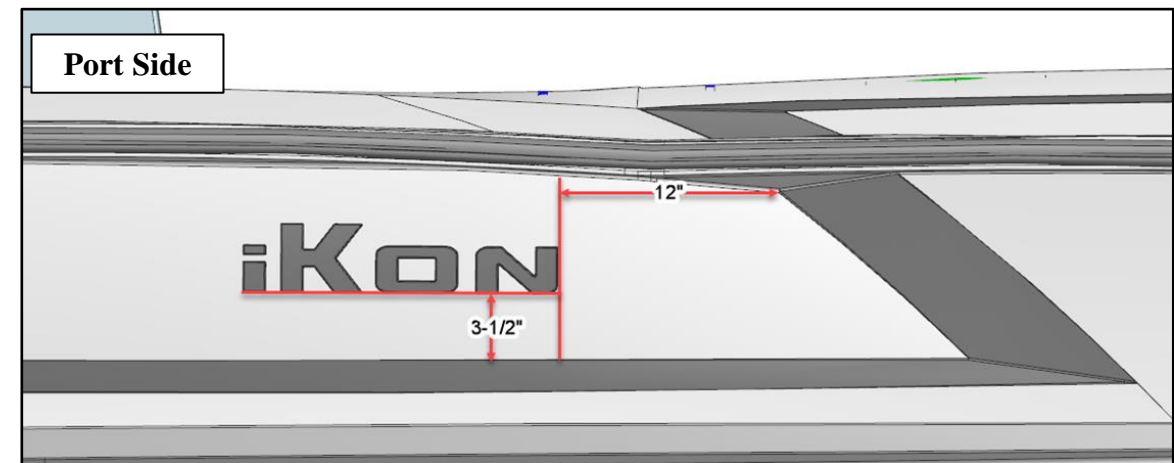
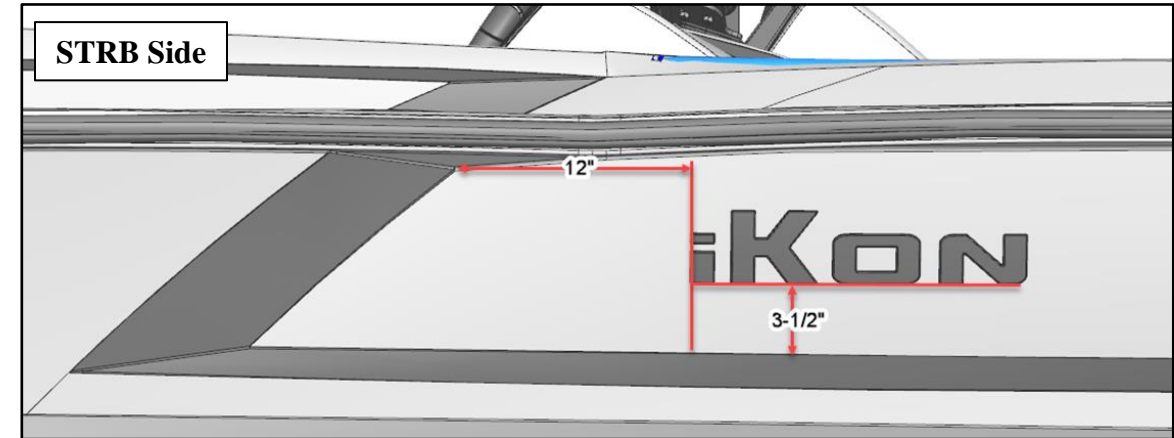


Section 3: Alternate Instruction

Step 1.1
Incase mylar templates are damaged or lost, see the following alternate instructions.

1.2
Tape reference lines for badge installation.

1. Tape a reference line that is level with the bottom stripe of the Z running towards the bow and 3-1/2" above (this sets the bottom "level" line for letter alignment).
2. Tape a perpendicular reference line to the level line that is 12" from the corner of the Z just below the knuckle (this sets the vertical reference line for the letter alignment).
3. Repeat this step for the until both sides are prepared with tape reference lines.



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Section 3: Alternate Instruction

1.3

Install the badges.

1. Remove white backing to expose adhesive on letters (be careful not to touch the adhesive).
2. Line up the “n” so that the vertical edge of the letter is aligned with the vertical tape reference line.
3. Line up the “n” so that bottom of the letter is aligned with the “level” tape reference line.
4. With one hand pulling the clear plastic/letters away from the hull, press the “n” to the hull.
 - Note: Be careful not to accidentally stick the other letters to the hull.
5. Pull the edge of the clear plastic so the lettering is tight (sets the spacing) and line up remaining letters so that the bottom edges are aligned with the “level” tape reference and press into place.
6. Apply firm pressure to all letters for 30 sec.
7. Remove clear film, installation is complete.
8. Repeat for opposite side

