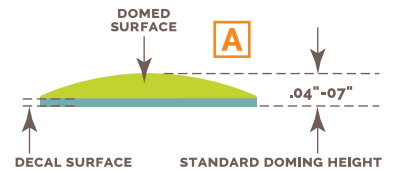




Add dimension and durability to your decals with doming. Doming is a process that creates a lens-like appearance over the part's surface. To achieve this, we flood the decal with doming liquid and let it dry into its final shape. Doming is a unique manufacturing process that requires specific design requirements.



ART SPECIFICATIONS NEEDED FOR DOMING:

Standard Doming Height (see Fig. A) ----- .04" -.07"

*Doming height varies based on decal size, shape & construction. If customer blueprint calls out a specific height, it must be reviewed.

Domed Decals Fitting in a Fixture/Recessed Area/Size-Sensitive ----- **MUST RUN ON MYLAR MATERIAL ONLY**

Maximum/Minimum Sizes for Doming:

- » Maximum IMAGE SIZE that can be domed ----- 19.00" x 26.00"
- » Maximum SHEET SIZE that can be domed ----- 20.00" x 27.00"
- » **Fig. B** Minimum THICKNESS/SIZE of art ----- .100"
- » **Fig. B** Minimum DISTANCE between doming ----- .100"

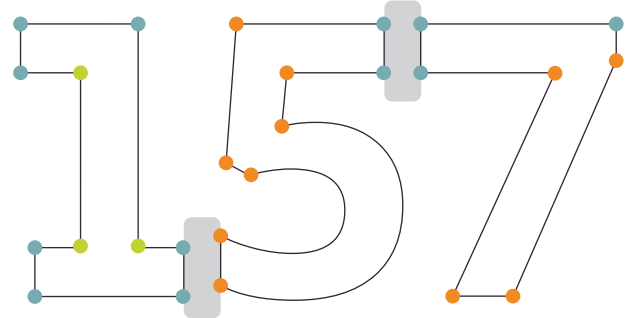
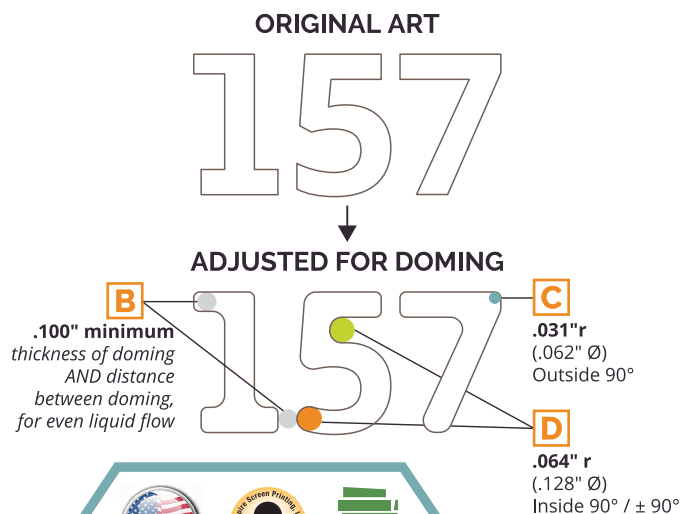
Decal Radius Corners (see EXAMPLE 1)

- » **Fig. C** All outside 90° angle corners ----- .031" min. radius
- » **Fig. D** All inside 90° angle corners ----- .064" min. radius
- » **Fig. D** Any angle ± 90° ----- .064" min. radius

Example 1:

No square/sharp corners: The doming liquid will not flow to a point, so radius corners are needed.

Minimum spacing: Doming liquid will want to pull towards itself, a .100" is the minimum size and distance in order to maintain even flow of liquid.



OUTSIDE 90° ANGLES .031" min. radius (.062" diameter)	± 90° ANGLES .064" min. radius (.128" diameter)
INSIDE 90° ANGLES .064" min. radius (.128" diameter)	.100" thickness & distance of doming



ART SPECIFICATIONS WHEN SUPPLYING PRINTED SHEETS FOR DOMING ONLY:

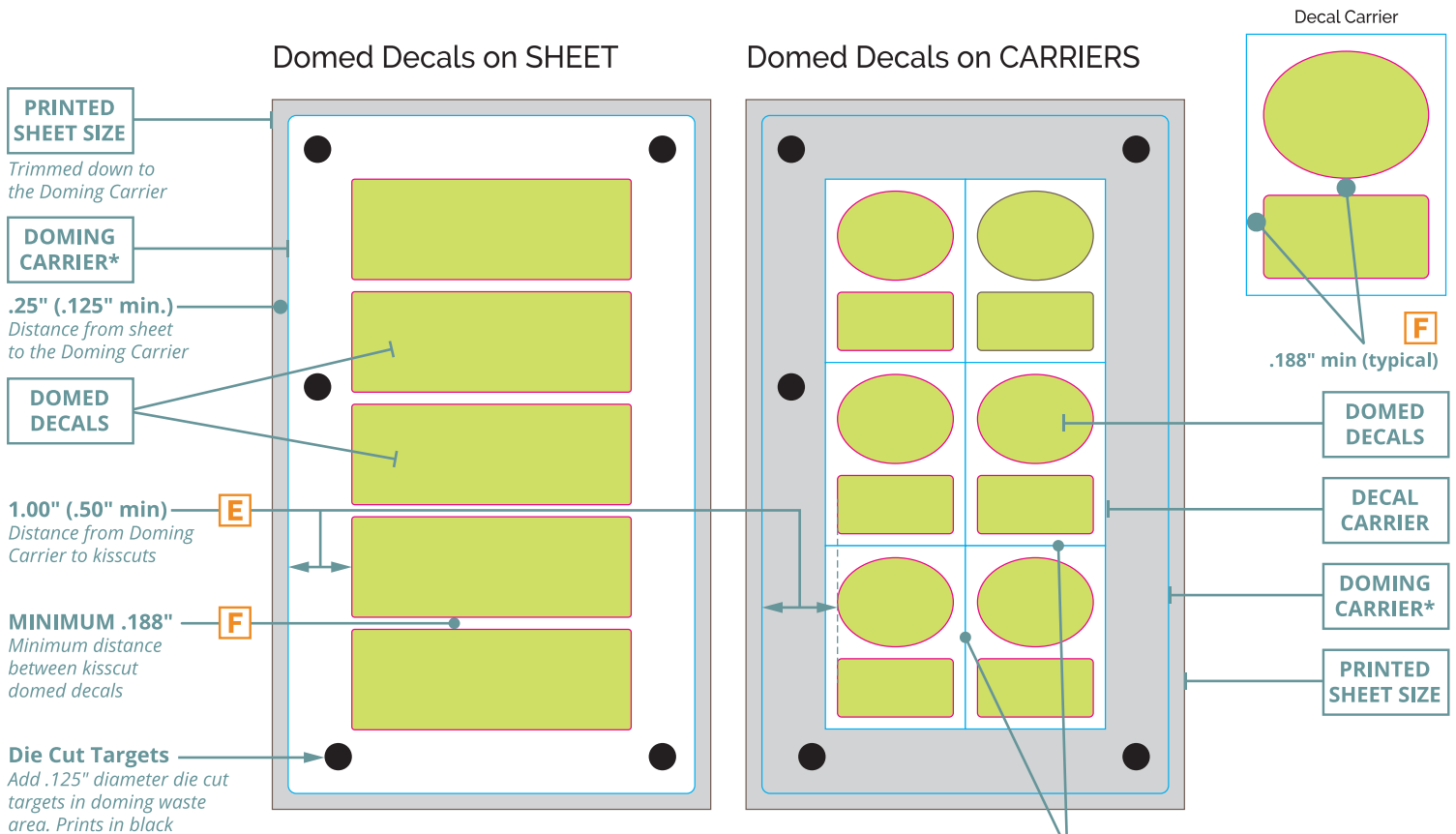
Standard Distances

- » **Fig. E** Kisscut decals to the DOMING Carrier----- 1.00"
- » **Fig. E** Kisscut decals to DECAL Carrier ----- .188"
- » **Fig. F** Standard distance between kisscut parts----- .188"
- » If decals are domed AND embossed: Embossing must be away from edge of decal----- .125" (1/8") min.

Additional Information

In order to verify that the job meets doming requirements, Empire must review and approve the layout prior to sending the printed sheets - please contact a Sales Representative or Account Manager:

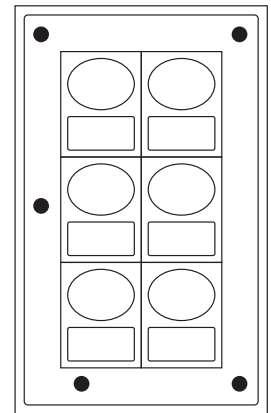
- » **Fig. G** Supply the layout, including the die line (pdf/AI format) - see layouts below for additional information.
- » If you need a template from Empire, please contact a Sales Representative or Account Manager.



*Doming Carrier: The overall sheet is trimmed down prior to going through the Doming machine. This provides a consistent straight-edge sheet for accurate liquid dispersion.

- KISSCUT DECALS**
to be domed
- WASTE AREA OF SHEET**
to be stripped away by customer or at Empire
- FINISHED PART SENT TO CUSTOMER**
Waste to be stripped away by customer or at Empire

Decal Carriers can bump



G
Die Line Layout File
(Illustrator or PDF)

We accept the following file formats:

