

**Commercial Solutions Division**

# 3M™ Scotchcal™ Perforated Film IJ67

## Product Description

This perforated film is white on the image side and black on the adhesive side. This allows printing graphics to be seen on one side and still allows viewing through the window from the other side.

3M™ Scotchcal™ Perforated Film IJ67 is using an unperforated liner with good layflat performance designed for use with solvent or latex inkjet printing.

To protect graphics 3M recommends using the overlamine 3M™ Scotchcal™ Gloss Overlamine 8518.

**Product Line** Screen and inkjet printing IJ67 white, perforated, glossy, removable adhesive.

## Product Characteristics

These are indicative values for unprocessed products.  
Contact your 3M representative for a custom specification.

### Physical & Application

Material	calendered vinyl	
Surface finish	glossy	
Thickness (film)	150 µm (0.15 mm)	
Notice!	40% open area	
Adhesive type	solvent acrylic, pressure-sensitive	
Adhesive appearance	black	
Liner	double-sided polycoated paper	
Application method	dry only!	
Application temperature (minimum air and substrate)	+10°C	for flat surfaces
Service temperature (after application)	-25°C to +65°C	(not for extended periods of time at the extremes)
Surface type	flat	
Substrate type	glass, PMMA, PC*, PETG*, ABS	
	*Might require drying with heat before use	
Graphic removal	Up to 6 months removable without heat and/or chemicals from supported substrates.	
	Depending on the substrate, adhesive residues can remain after removing the film. The film removing angle can influence the result.	
	No liability is given for ease or speed of removal of any graphic. Pay attention to adequate air and substrate temperature.	

The values above are the results of illustrative lab test measurements and shall not be considered as a commitment from 3M.

**Storage** Shelf life Use within two years from the date of manufacture on the sealed original box.  
Use within one year after opening the box.

Storage conditions +4°C to +40°C, out of sunlight, original container in clean and dry area.

The shelf life as defined above remains an indicative and maximum data, subject to many external and non-controllable factors. It may never be interpreted as warranty.

**Flammability** Flammability standards are different from country to country. Ask your local 3M contact for details, please.

## Durability

The durabilities mentioned in the table below are the results of illustrative lab tests. The values show the best performance expected from these products, provided that the film will be processed and applied professionally according to 3M's recommendations.

The durability statements do not constitute warranties of quality, life and characteristics.

The durability of products is also influenced by:

- the type of substrate and thorough preparation of the surface (with 3M™ Surface Preparation System)
- application procedures
- environmental factors
- the method and the frequency of cleaning

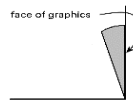
Unprocessed film                      The following durability data are given for unprocessed film only!

Climatic zones                      Graphic durability is largely determined by the climate and the angle of exposure. Find below a table showing the durability of a product according to the angle of exposure and the geographical location of the application.

- Zone 1      Northern Europe, Italy (north of Rome), Russia
- Zone 2      Mediterranean area without North Africa, South Africa
- Zone 3      Gulf area, Africa

Exposure types

Vertical:



The face of the graphic is  $\pm 10^\circ$  from vertical.

### Vertical outdoor exposure

white

#### Zone 1

12 months

#### Zone 2

12 months

#### Zone 3

12 months

3M™ Performance Guarantee and MCS™ Warranty

In addition, 3M provides a guarantee/warranty on a finished applied graphic within the framework of 3M™ Performance Guarantee and/or 3M™ MCS™ warranty programs.

For detailed graphic construction and application options along with specific Warranty periods, please see the Warranty matrices and Warranty information on [3M Graphic Solutions/Warranties](#).

Visit [www.3mgraphics.com](http://www.3mgraphics.com) for getting more details about 3M's comprehensive graphic solutions.

## Limitations of End Uses

3M specifically does not recommend or warrant the following uses, but please contact us to discuss your needs to recommend other products.

- Graphics applied to
  - applications other than window surfaces.
  - low surface energy substrates or substrates with low surface energy coating.
  - other than flat surfaces.
- Graphic removal from
  - substrates with coatings (i.e.: anti-reflection, anti-scratch); coatings may be damaged during film removal.
- Graphics subjected to Important Notice
  - gasoline vapors or spills.
  - 3M Commercial Solutions products are not tested against automotive manufacturer specifications!
  - Applications that require an optical clear view should be protected with the recommended overlamine.
  - Wet application method is not recommended for this film.
  - Do not obstruct (drivers) view!
  - Non vertical applications will have a significant decrease in durability!
  - The user is responsible for determining and complying to laws and standards!

## Graphics Manufacturing

Graphic protection can improve the appearance, performance and durability of printed graphics. Any printed graphic exposed to abrasive conditions (including vehicles), harsh cleaners or chemicals must include graphic protection in order to be warranted.

When to use an overprint clear or overlamine      See instruction bulletin GPO 'graphic protection options' for further information about selection and use of protective overlaminates and printable clears.

[> Product Bulletin Graphic Protection Options <](#)

Shipping finished graphics Flat, or rolled film side out on 130 mm (5 inch) or larger core. These methods help to prevent the liner from wrinkling or application tape, if used, from popping off.

## Converting Information

### Inkjet Printing

#### Adequately Dry Graphics

A too high total physical ink amount on the film results in media characteristic changes, inadequate drying, overlamine lifting, and/or poor graphic performance. The maximum recommended total ink coverage for this film is 270%.

Inadequate drying can result in graphic failure including curling, increased shrinkage and adhesion failure, which are not covered under any 3M warranty.

Poorly dried film becomes soft and stretchy, and the adhesive becomes too aggressive.

Even if your printer has a dryer, it may not adequately dry latex and solvent inks in the short period of time it spends passing through the heater.

Recommendations to improve the drying of solvent inks

Dry the graphic unrolled or at least as a loose wound roll standing upright. To further increase air circulation place the spooled film roll on a grid, and place a fan beneath the grid.

If you only spool open the film, adequate drying could still take a week, depending on the environment.

Build enough time into your process to ensure adequate drying of the graphic. 3M recommends at least a minimum drying time of 24 hrs before further processing. Test: Fold a piece of film with maximum ink laydown of the graphic onto itself. Apply 140 g/cm<sup>2</sup> for 15 minutes, release and check for effects like sticking or dull spots. These are clear indications that further curing or drying is needed.

Notice: Latex inks are different

Unlike solvent inks, spooling and letting latex printed graphics sit does not help to cure the ink, but does allow the graphic manufacturer to see if any oily spots are generated which may interfere with proper adhesion of overlaminates.

To ensure proper latex ink drying, use the following recommendations:

Media Presets: HP media presets contain all the needed settings to print on a specific media.

Download and use media presets from the following page: [www.hp.com/go/mediasolutionslocator](http://www.hp.com/go/mediasolutionslocator).

Environmental Conditions: HP media presets have been specially designed and tested for each printer-media combination. Recommended environmental conditions: +20°C to +25°C, Humidity 40% - 60% RH

Important notice for HP 831/871 and HP 881/891

The amount of ink printed is the main key for proper overlamine adhesion. Select a media preset using 100% or less ink density.

Post-processing of latex printed graphics immediately after printing

Latex inks should emerge from the printer fully dried. Post-air drying of a wet print will not enable drying, since latex ink drying requires that the dried ink is heated above the film formation temperature of the latex inside the printer.

For immediately post-processing of latex printed graphics follow strictly the recommendations given above (Section: Latex inks are different) and test the proper drying with the following performance tests:

Visual Test: Check the image immediately after printing. The sample should not be wet or sticky to the touch, or have an 'oily' feel when it emerges from the printer.

Rubbing Test: After the visual inspection, wipe the printed sample with a white wet paper towel. Fully-dried ink should resist wiping and should not show any stains on the white cloth. If the ink is easily removed by wet rubbing, then it is not dried.

Stacking Test: In some cases, the top surface will appear dry after printing but within a few minutes ink may migrate to the surface leaving an oily aspect. To ensure proper drying, stack at least 12 sheets liner to printed side and let sit for one hour.

After 1 hour, remove the stack and check for "oily" stains, wet surfaces or glossiness changes on high ink laydown areas on each sheet. If any of these occur, then the ink is not properly dried.

If a sample is not properly dried on the printer, reprint the image under a condition that allows complete drying. Common improvement steps are:

- Increasing the drying temperature in 5 degree steps.
- Increasing the number of passes to slow down printing.
- Reducing the amount of ink printed (media preset with lower ink densities).

Allow the converted graphic to build sufficient bond prior to application/installation

Give laminated samples time before applying them. The adhesion bond between the laminate and the printed base film will increase with time. 24 hours minimum for room temperature laminated graphics.

8 hours minimum for graphics laminated with heated rolls (one or two). Lamination temperature: +40°C to +60°C. Lamination speed: maximum 2 meter/minute.

## Converting Information

### Screen Printing

Formulations and processing conditions can affect ink durability. Refer to the 3M Product and Instruction Bulletins for your ink for limitations and proper usage. Graphic protection can improve the appearance, performance and durability of your graphic.

A clear coat also prevents chalking on unprinted films. Use equipment designed to handle high viscosity materials and make sure the coating is evenly applied to the specifications given in the clear's Instruction Bulletin.

Abrasion and Loss of Gloss Abrasion damage and loss of gloss are not covered by any 3M warranty. This is considered normal wear and tear.

## Application

Perforated Window Graphics	Multipanel	If two graphic panels meet side by side on a window, carefully trim the film that the panels meet and form a butt seam. Do not overlap the panels!
	Edge sealing	The use of edge sealing tape (strips of overlamine) or oversized overlamine improves the resistance of the graphic to environmental damage. IJ67 can be used without edge sealing.
	Avoid Lifting	The film must not touch the window molding. It does not stick on the molding so that lifting will occur. Keep a small distance of a few mm, the small distance minimizes the chance of the graphic absorbing water that may collect at the window edge.

Refer to Instruction Bulletin 5.1 'select and prepare substrates for graphic application', for general application information.

[>Instruction Bulletin 5.1 'select and prepare substrates for graphic application'<](#)

## Maintenance and Cleaning

Use a cleaner designed for high-quality painted surfaces. The cleaner must be wet, non-abrasive, without strong solvents, and have a pH value between 3 and 11 (neither strongly acidic nor strongly alkaline).

Refer to Instruction Bulletin 6.5 'storage, handling, maintenance and removal of films and sheetings', for general maintenance and cleaning information.

[>Instruction Bulletin 6.5 'Storage, Handling, Maintenance and Removal of Films and Sheetings'<](#)

## Important Safety Remark

### Application to glass

The application of colored or printed film onto glass with sunlight exposure can lead to glass breakage through thermal expansion of the glass. The local conditions must be examined for the danger of glass break by uneven heat absorption through sun exposure. Type of glass (insulation glass, float glass, LSG, toughened safety glass, semi-tempered glass, etc.), glass dimension, joint condition, flexibility of the sealant, quality of the edge finishing, geographical orientation and partial shadow during sun exposure are the determining factors. Light color designs and application on the outside of the window are to be preferred. A free non-applied framework of 4 mm around the entire window front can help to dissipate the absorbed warmth. According to common knowledge a thermal crack can occur at temperature differences of approx. 130°C (toughened safety glass), approx. 40°C (float glass) or approx. 110°C (semi-tempered glass). Coldest place is usually under the framework in the embedded joined window part, the warmest place is typically on the darkest place in the format. Because of the many above mentioned factors, glass breakage cannot be fully predicted, therefore 3M does not accept liability for glass breakage when using this film for window graphics.

## Remarks

Important notice	This bulletin provides technical information only.
	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.
	Before using, the user must determine the suitability of the product for its required or intended use, and the user assumes all risk and liability whatsoever in connection therewith.
	As outdoor graphics age, natural weathering occurs causing a gradual reduction in gloss, slight color changes, some lifting of the graphic at the edges or around rivets, and ultimately a minor amount of cracking.
	These changes are not evidence of product failure and are not covered by a 3M warranty.

Additional information	Visit the web site of your local subsidiary at <a href="http://www.3Mgraphics.com">www.3Mgraphics.com</a> for getting: <ul style="list-style-type: none"><li>- more details about 3M™ MCS™ Warranty and 3M™ Performance Guarantee</li><li>- additional instruction bulletins</li><li>- a complete product overview about materials 3M is offering</li></ul>
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