

Description

This Customer Information details the procedure for liquid edge sealing of films manufactured or sold by 3M Commercial Solutions Division for the use in rail applications. This procedure helps maximize the life of the graphic. Refer also to the Product and Instruction Bulletins for each product in your graphic construction for specific details that may influence the information in this Customer Information.

Note: This document uses hyperlinks. Please follow the links for additional information.

All edges must be sealed. For exposed leading edges on railcars, stairs at entrance cabins with abrasion or moisture areas (rain gutters) 3M recommends edge sealing of 3M™ Graphics using liquid 3M™ Edge Sealer 3950, 3M™ Edge Sealer 4150s or 3M™ Edge Sealer ES2000. The substrate and the film must be clean, dry and free of contaminants (incl. fingerprints).

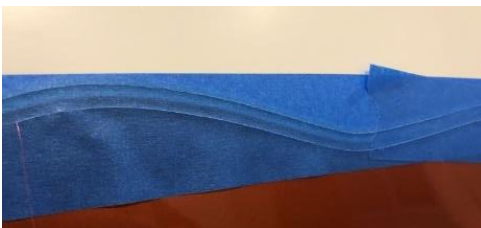
Instructions

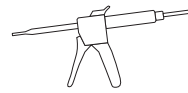


- Clean the surface
- Apply Tri Line Knifeless Tape along the seam or butt joint (choose appropriate width of Knifeless Tape by selecting the lines to pull)



- Clean the surface again including tape surface (IPA 70/30)
- Use masking tape overlapping/exceeding the area you want to seal
- Apply masking tape firmly and ensure you see the lines contour clearly, pull the two lines to open the area

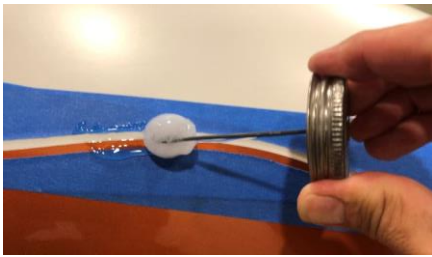




- Re-apply masking tape firmly and ensure 100% surface contact
- Clean the sealing area and surface (IPA 70/30)



- Apply the liquid with brush, felt dauber or 3M™ Scotch-Weld™ EPX Applicator (3950, ES2000), evenly distribute as needed



- Remove masking tape prior to the full curing of the liquid. Make sure there is a flow out (shoulder) build and not a firm rectangular edge!
- Use heat to enhance curing of the sealing liquid



See 3M Instruction Bulletins for further information:
5.45, 'Application and Maintenance of 3M™ Graphics for Rail Application'

[3M Product/Instruction Bulletin 3M™ Knifeless Tape](#)

Limited Remedy

Unsuitable End Uses

This bulletin provides technical information only. 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.

Limitations of liability

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.

Health and Safety

When handling any chemical products, read the manufacturer's container labels and the Safety Data Sheets (SDS) for important health, safety and environmental information.

Follow the link to obtain SDS sheets for 3M products on 3M.com/SDS.

IMPORTANT! When using any equipment, always follow the manufacturer's instructions for safe operation.

Air Quality Regulations

Local Volatile Organic Compound (VOC) regulations may prohibit the use of certain cleaning chemicals with VOC's in graphic arts coatings and printing operations. Check with local environmental authorities to determine whether use of any solutions may be restricted or prohibited.

3M and Scotch-Weld are trademarks of 3M. All other trademarks are the property of their respective owners.

3M United Kingdom PLC
Commercial Solutions Division
Cain Road
Bracknell, RG12 8HT
UK
www.3m.co.uk/graphics-and-signage-uk/

3M Ireland (Dublin)
The Iveagh Building
The Park, Carrickmines
Dublin 18
Ireland
www.3m.couk/graphics-and-signage-uk/

© 3M 2020. All rights reserved.