

Product Description

3M™ Diamond Grade™ Fluorescent Work Zone Sheeting Series 3924S (the “Sheeting”) is a fluorescent orange retroreflective prismatic sheeting designed for the production of durable traffic control signs for the work zone.

Table A. Color

Color	Product Code
Fluorescent Orange	3924S

Specifications

Sheeting conforms to all current performance requirements of ASTM D4956 for Type VIII retroreflective sheeting.

Physical Properties

Adhesive

Sheeting has a pressure-sensitive adhesive that is recommended for application at temperatures of 65°F (18°C) and higher. Meets ASTM D4956 Class I adhesive requirement.

Orientation

The Sheeting is designed to be an effective wide angle reflective sheeting regardless of the orientation on the substrate or ultimate application orientation after installation. However, because the efficiency of light return from cube corner reflectors is not equal at all rotation angles, the sheeting should be positioned in 0° or 90° application orientation on the completed sign when wide entrance angle performance is important for a given sign type or situation.

NOTE

For multi-panel Signs, 3M recommends that all background panels be applied with the Sheeting oriented in the same direction.

Sheeting may be processed into traffic Signs using any of the imaging methods described below. 3M assumes no responsibility for the failures of Sign face legends or backgrounds that have been processed with non-3M process colors or with matched component imaging materials other than those listed below.

Substrates

Refer to [3M Information Folder 1.7](#) for surface preparation recommendations.

Sheeting has been designed primarily for application to flat substrates. Any application to a substrate with a radius of curvature of less than five inches should also be supported by rivets or bolts. Plastic substrates are NOT recommended where cold shock performance is required.

Sign failures caused by substrate failures or improper surface preparations are NOT the responsibility of 3M.

Sign Fabrication Methods

Squeeze Roll Application

The Sheeting should be applied to sign substrates at temperatures of 65°F (18°C) and higher using a hand squeeze roll applicator. See [3M Information Folder 1.6](#) for details.

Background and complete sign applications of the Sheeting must be performed using a roll laminator, either mechanical or hand driven.

Splices

The Sheeting must be butt spliced when more than one piece of Sheeting is used on a single piece of substrate. Sheeting pieces should not touch one another. Avoiding overlaps prevents the buckling that can occur as the Sheeting expands under extreme temperature and humidity conditions.

Double Faced Signs

Sheeting on the bottom side of a double faced Sign can be damaged if rolled through a squeeze roll applicator using an unprotected steel bottom roller. The use of a semi-soft flat sheet between the steel roller and the applied Sign face will protect the Sign face from damage. Use of a rubber mat, tag board, or cardboard is recommended.

Imaging

The sheeting may be processed into traffic signs by any of the imaging methods described below. 3M assumes no responsibility for failure of sign face legends or backgrounds that have been processed with non-3M process colors or imaging materials other than those listed below.

Screen Processing

The sheeting may be screen processed into traffic signs before or after mounting on a sign substrate, using 3M™ Process Colors Series 880I or Series 880N. See [3M Information Folder 1.8](#) for details.

3M™ ElectroCut™ Overlay Film Series

3M™ ElectroCut™ Overlay Film 1178 black may be used to provide copy for traffic control signs on the Sheeting. Refer to [Product Bulletin 1170](#) for fabrication procedures.

Vinyl Graphic Films

Scotchcal™ Vinyl Series 3650, Series 7720, and Series 7725 may be used to provide copy for traffic control signs on the Sheeting. Refer to Scotchcal™ product literature for more information.

Digital Imaging

The Sheeting is compatible with 3M qualified HP Latex Digital printer systems. See [3M Information Folder 1.17](#) and HP Large Format Printing Knowledge Center for details.

Cutting

Sheeting may be cut. Sealing the cut edges of Sheeting is not required.

Plotter Cutting

Flat bed plotters can be used to cut the Sheeting and offer the most consistent and reliable performance.

Other Cutting Methods

The Sheeting may be hand cut or die cut one sheet at a time. See [3M Information Folder 1.10](#) for details.

Shelf Life, Processing, Storage, Packaging, and Cleaning

See [3M Information Folder 1.11](#) for details.

Installation

Nylon washers are required when twist style fasteners are used to mount the sign.

3M Related Literature

Always confirm that you have the most current version of the applicable product bulletins, information folders, and other product information.

- [3M Information Folder 1.10](#) Cutting, Premasking, and Prespacing of 3M™ Reflective Sheatings
- [3M Information Folder 1.11](#) Sign Maintenance Management
- [3M Information Folder 1.17](#) User Guide 3M™ Reflective Sheeting and HP Latex 360/365 Printers
- [3M Information Folder 1.4](#) Instructions for Interstate Squeeze Roll Applicator
- [3M Information Folder 1.5](#) Hand Application Instructions
- [3M Information Folder 1.6](#) 3M™ Hand Squeeze Roll Applicators HSRA-48, HSRA-36, and HSRA-12
- [3M Information Folder 1.7](#) Sign Base Surface Preparation
- [3M Information Folder 1.8](#) Process Colors Series 880 and 900 Instructions for Use
- [3M Product Bulletin 880I](#) 3M™ Process Color Series 880I
- [3M Product Bulletin 880N](#) 3M™ Process Color Series 880N

Health and Safety

Chemicals

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

[Follow this link to obtain SDS sheets for 3M products.](#)

[Follow this link to obtain information about substances of very high concern \(SVHC\) for EU products.](#)

Tools and Equipment Usage

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

Warranty Information

Technical Information

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Commercial Branding and Transportation

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