Commercial Solutions Division

3M™ Scotchcal™ Opaque Graphic Film
Series 80

Product Description

These excellent cast films are a range of colored films that have been specially developed to be knife cut on electronic systems. The film range is available in 84 colors including 8 metallic tones.

3M™ Scotchcal™ Opaque Graphic Film Series 80 have good conformability for application on flat or moderate curved surfaces, with or without rivets. They are excellent for easy cutting of small letters or complex graphics.

Product Line

Electrocet 80-X  X = color code, opaque, glossy (and few matte), permanent adhesive.

Important Notice!

Some colors are less opaque than other colors. Before using, the user must determine the suitability of the film for its required or intended use.

Product Characteristics

Physical & Application

<table>
<thead>
<tr>
<th>Material</th>
<th>cast vinyl</th>
</tr>
</thead>
<tbody>
<tr>
<td>Surface finish</td>
<td>glossy and matte (see product line)</td>
</tr>
<tr>
<td>Thickness (film)</td>
<td>50 µm (0.05 mm)</td>
</tr>
<tr>
<td>Adhesive type</td>
<td>solvent acrylic, pressure-sensitive</td>
</tr>
<tr>
<td>Adhesive appearance</td>
<td>clear</td>
</tr>
<tr>
<td>Liner</td>
<td>glassine paper</td>
</tr>
<tr>
<td>Adhesion</td>
<td>20 N/25 mm FTM 1:180° peel, substrate: glass; cond: 24 h 23°C/50%RH</td>
</tr>
<tr>
<td>Application method</td>
<td>wet or dry</td>
</tr>
<tr>
<td>Applied shrinkage</td>
<td>&lt; 0.2 mm FTM 14</td>
</tr>
<tr>
<td>Application temperature</td>
<td>+8°C for flat surfaces</td>
</tr>
<tr>
<td>(minimum air and substrate)</td>
<td>+10°C for curved to corrugated surfaces, with and without rivets</td>
</tr>
<tr>
<td>Service temperature</td>
<td>-40°C to +95°C (not for extended periods of time at the extremes)</td>
</tr>
<tr>
<td>Surface type</td>
<td>flat to curved, incl. rivets</td>
</tr>
<tr>
<td>Substrate type</td>
<td>aluminum, glass, PMMA, PC*, ABS, paint</td>
</tr>
<tr>
<td>* Might require drying with heat before use</td>
<td></td>
</tr>
<tr>
<td>Graphic removal</td>
<td>Fair to remove with heat and/or chemicals from supported substrates. No liability is given for ease or speed of removal of any graphic. Pay attention to adequate air and substrate temperature.</td>
</tr>
</tbody>
</table>

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 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.

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

**Exposure types**

Vertical: The face of the graphic is ±10° from vertical.

Interior: Interior means an application inside a building without direct exposure to sunlight.

**Vertical outdoor exposure**

<table>
<thead>
<tr>
<th></th>
<th>Zone 1</th>
<th>Zone 2</th>
<th>Zone 3</th>
</tr>
</thead>
<tbody>
<tr>
<td>white/black</td>
<td>10 years</td>
<td>8 years</td>
<td>6 years</td>
</tr>
<tr>
<td>colors</td>
<td>8 years</td>
<td>6 years</td>
<td>4 years</td>
</tr>
<tr>
<td>transparent</td>
<td>5 years</td>
<td>4 years</td>
<td>3 years</td>
</tr>
<tr>
<td>metallics</td>
<td>3 years</td>
<td>2 years</td>
<td>1,5 years</td>
</tr>
</tbody>
</table>

**Interior application**

<table>
<thead>
<tr>
<th></th>
<th>Zone 1</th>
<th>Zone 2</th>
<th>Zone 3</th>
</tr>
</thead>
<tbody>
<tr>
<td>interior</td>
<td>10 years</td>
<td>10 years</td>
<td>10 years</td>
</tr>
</tbody>
</table>

**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.

- flexible substrates incl. 3M™ Envision™ Flexible Substrate FS-1 and 3M™ Panagraphics™ III Wide Width Flexible Substrate.
- low surface energy substrates or substrates with low surface energy coating.
- other than flat or moderate curved/corrugated surfaces.
- painted or unpainted rough wallboards, gypsum boards and wallpapers.
- stainless steel.
- surfaces that are not clean and more than moderate textured.
- surfaces with poor paint to substrate adhesion.
- signs or existing graphics that must remain intact.
- gasoline vapors or spills.
- 3M Commercial Solutions products are not tested against automotive manufacturer specifications!
- Non vertical applications will have a significant decrease in durability!
- Thermoforming of applied film is not recommended!
- 3M accepts no liability for glass breakage when using this film for window graphics.
- The color appearance of metallic film is dependent on the viewing angle to the product! Therefore the job design should be done that all parts of metallic film are applied the same orientation.
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.

Shipping finished graphics

Based upon cutting evaluations the minimum height for text is 25 mm using upper and lowercase Helvetica Medium. The stroke width should not be lower than 1 mm.

Converting Information

Electronic Cutting

The variable characteristics of electronically controlled cutting equipment require users to verify their specific requirements.

Electronic Cutting

Sharpness of knife blade

Dull blades impart a serrated look to the edge of the cut film.

Weight of knife blade

The ideal weight slightly scores the liner. Too little weight does not cut completely through the film and the adhesive. Excessive weight cuts the liner and causes the blade to drag, accelerating wear and creating a serrated cut edge on the film.

Weeding

The excess film should be weed (removed) as soon after cutting as practical. This is to minimize the effect of possible adhesive flow.

Temperature and relative humidity

Temperature and relative humidity are minor considerations, but avoid extreme or rapid fluctuating conditions.

Roll storage

Store the film in the same environment as the cutting equipment.

Further information

For more details refer to our instruction bulletin 4.1 'Sheeting, Scoring, Film cutting', please.

Application

See product bulletin ATR 'application tape recommendations' for information about selection and use of suitable application tapes for this product, please.

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

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.

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
This bulletin provides technical information only.

Important notice
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 www.3Mgraphics.com for getting:
- additional instruction bulletins
- a complete product overview about materials 3M is offering

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Responsible for this technical bulletin

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