

Technical Data Sheet

3M™ Thermal Transfer Polyester Label Material 7868

Product Description

3M™ Thermal Transfer Polyester Label Material 7868 is a gloss white polyester label stock that offers premium durability and moisture resistance. This label product utilizes 3M™ High Holding Acrylic Adhesive 350, which is a universal adhesive for label material that offers excellent chemical resistance and holding strength even at high temperatures.

Product Features

- Adhesive can permanently bond to high surface energy (HSE) and low surface energy (LSE) plastics, textured and contoured surfaces, powder coatings, and slightly oily metals.
- Facestock is topcoated for thermal transfer printing. Resin ribbons are recommended for optimum durability. The topcoat also provides improved ink anchorage for traditional forms of press printing.
- 55# densified kraft liner assures consistent die cutting.
- UL recognized (File MH16411) and CSA accepted (File 99316). See the UL and CSA listings for details.
- UL listing includes approval for use on powder coated surfaces.
- Meets British Standard BS-5609.

Technical Information Note

The following technical information and data should be considered representative or typical only and should not be used for specification purposes.

Typical Physical Properties

Property	Values	Additional Information
Adhesive Type	#350 Acrylic	
Liner	55# Densified kraft	
Liner Thickness	0.081 mm	
Facestock	White Polyester Gloss TC	
Facestock Thickness	0.051 mm	
Adhesive Thickness	1.1 mil	

Adhesive Thickness	0.028 mm
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Facestock Thickness	2.1 mil
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Liner Thickness	3.2 mil
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Convertability	In order to capture the superior performance properties of 3M™ High Holding Acrylic Adhesive 350, thicker calipers are utilized for LSE or textured substrates. Its higher caliper, while desirable for the end use applications, may require extra care during processing. Please refer to the die cutting/converting section of this data page or the “Guide to Converting and Handling Label Products” technical bulletin for additional information.
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Adhesive Coat Weight	1.75 to 2.02 g/100 in²
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Typical Performance Characteristics

Property	Values	Additional Information
90° Peel Adhesion Polypropylene (PP)	2.2 N/cm	View 
Test Method: ASTM D3330 Test Name: 90° Peel Adhesion Dwell/Cure Time: 72.0 Dwell Time Units: hr Temp C: 23C Temp F: 72F Environmental Condition: 50%RH Substrate: Polypropylene (PP) Backing: 2 mil PET Notes: 12 in/min (300 mm/min)		
90° Peel Adhesion Stainless Steel	73 oz/in	View 
Test Method: ASTM D3330 Test Name: 90° Peel Adhesion Dwell/Cure Time: 72.0 Dwell Time Units: hr Temp C: 23C Temp F: 72F Environmental Condition: 50%RH Substrate: Stainless Steel Backing: 2 mil PET Notes: 12 in/min (300 mm/min)		
90° Peel Adhesion	2.1 N/cm	View 
Test Method: ASTM D3330		

Dwell/Cure Time: 72.0
Dwell Time Units: hr
Temp C: 23C
Temp F: 72F
Environmental Condition: 50%RH
Substrate: High Density Polyethylene (HDPE)
Backing: 2 mil PET

Notes: 12 in/min (300 mm/min)

90° Peel Adhesion	19 oz/in	View 
Test Method: ASTM D3330 Dwell/Cure Time: 72.0 Dwell Time Units: hr Temp C: 23C Temp F: 72F Environmental Condition: 50%RH Substrate: High Density Polyethylene (HDPE) Backing: 2 mil PET Notes: 12 in/min (300 mm/min)		
90° Peel Adhesion	31 oz/in	View 
Test Method: ASTM D3330 Dwell/Cure Time: 72.0 Dwell Time Units: hr Temp C: 23C Temp F: 72F Environmental Condition: 50%RH Substrate: Low Density Polyethylene (LDPE) Backing: 2 mil PET Notes: 12 in/min (300 mm/min)		
90° Peel Adhesion	9.1 N/cm	View 
Test Method: ASTM D3330 Dwell/Cure Time: 72.0 Dwell Time Units: hr Temp C: 49C Temp F: 120F Environmental Condition: 50%RH Substrate: Stainless Steel Notes: 12 in/min (300 mm/min)		
90° Peel Adhesion	83 oz/in	View 
Test Method: ASTM D3330 Dwell/Cure Time: 72.0 Dwell Time Units: hr Temp C: 49C Temp F: 120F Environmental Condition: 50%RH Substrate: Stainless Steel Notes: 12 in/min (300 mm/min)		
90° Peel Adhesion	2.7 N/cm	View 
Test Method: ASTM D3330 Dwell/Cure Time: 72.0 Dwell Time Units: hr Temp C: 49C Temp F: 120F Environmental Condition: 50%RH		

Substrate: Polycarbonate (PC)

Notes: 12 in/min (300 mm/min)

90° Peel Adhesion	25 oz/in	View 
Test Method: ASTM D3330 Dwell/Cure Time: 72.0 Dwell Time Units: hr Temp C: 49C Temp F: 120F Environmental Condition: 50%RH Substrate: Polycarbonate (PC) Notes: 12 in/min (300 mm/min)		
90° Peel Adhesion	2.4 N/cm	View 
Test Method: ASTM D3330 Dwell/Cure Time: 72.0 Dwell Time Units: hr Temp C: 49C Temp F: 120F Environmental Condition: 50%RH Substrate: Polypropylene (PP) Notes: 12 in/min (300 mm/min)		
90° Peel Adhesion	22 oz/in	View 
Test Method: ASTM D3330 Dwell/Cure Time: 72.0 Dwell Time Units: hr Temp C: 49C Temp F: 120F Environmental Condition: 50%RH Substrate: Polypropylene (PP) Notes: 12 in/min (300 mm/min)		
90° Peel Adhesion	8.1 N/cm	View 
Test Method: ASTM D3330 Dwell/Cure Time: 72.0 Dwell Time Units: hr Temp C: 49C Temp F: 120F Environmental Condition: 50%RH Substrate: Glass Notes: 12 in/min (300 mm/min)		
90° Peel Adhesion	74 oz/in	View 
Test Method: ASTM D3330 Dwell/Cure Time: 72.0 Dwell Time Units: hr Temp C: 49C Temp F: 120F Environmental Condition: 50%RH Substrate: Glass Notes: 12 in/min (300 mm/min)		
90° Peel Adhesion	2.4 N/cm	View 

Test Method: ASTM D3330

Dwell/Cure Time: 72.0
Dwell Time Units: hr
Temp C: 49C
Temp F: 120F
Environmental Condition: 50%RH
Substrate: High Density Polyethylene (HDPE)

Notes: 12 in/min (300 mm/min)

90° Peel Adhesion	22 oz/in	View 
Test Method: ASTM D3330 Dwell/Cure Time: 72.0 Dwell Time Units: hr Temp C: 49C Temp F: 120F Environmental Condition: 50%RH Substrate: High Density Polyethylene (HDPE) Notes: 12 in/min (300 mm/min)		
90° Peel Adhesion	1.2 N/cm	View 
Test Method: ASTM D3330 Dwell/Cure Time: 72.0 Dwell Time Units: hr Temp C: 49C Temp F: 120F Environmental Condition: 50%RH Substrate: Low Density Polyethylene (LDPE) Notes: 12 in/min (300 mm/min)		
90° Peel Adhesion	11 oz/in	View 
Test Method: ASTM D3330 Dwell/Cure Time: 72.0 Dwell Time Units: hr Temp C: 49C Temp F: 120F Environmental Condition: 50%RH Substrate: Low Density Polyethylene (LDPE) Notes: 12 in/min (300 mm/min)		
90° Peel Adhesion Stainless Steel	8 N/cm	View 
Notes: 12 in/min (300 mm/min) ASTM D3330 72 hour dwell on Stainless Steel at 23°C (72°F) and 50% RH Backing: 2 mil Polyester		
90° Peel Adhesion Glass	7.6 N/cm	View 
Test Method: ASTM D3330 Test Name: 90° Peel Adhesion Dwell/Cure Time: 72.0 Dwell Time Units: hr Temp C: 23C Temp F: 72F Environmental Condition: 50%RH Substrate: Glass Backing: 2 mil PET Notes: 12 in/min (300 mm/min)		
90° Peel Adhesion Glass	69 oz/in	View 

Test Method: ASTM D3330		
Test Name: 90° Peel Adhesion Dwell/Cure Time: 72.0 Dwell Time Units: hr Temp C: 23C Temp F: 72F Environmental Condition: 50%RH Substrate: Glass Backing: 2 mil PET		
Notes: 12 in/min (300 mm/min)		
90° Peel Adhesion Polycarbonate (PC)	5.7 N/cm	View 
Test Method: ASTM D3330		
Test Name: 90° Peel Adhesion Dwell/Cure Time: 72.0 Dwell Time Units: hr Temp C: 23C Temp F: 72F Environmental Condition: 50%RH Substrate: Polycarbonate (PC) Backing: 2 mil PET		
Notes: 12 in/min (300 mm/min)		
90° Peel Adhesion Polycarbonate (PC)	52 oz/in	View 
Test Method: ASTM D3330		
Test Name: 90° Peel Adhesion Dwell/Cure Time: 72.0 Dwell Time Units: hr Temp C: 23C Temp F: 72F Environmental Condition: 50%RH Substrate: Polycarbonate (PC) Backing: 2 mil PET		
Notes: 12 in/min (300 mm/min)		
90° Peel Adhesion Polypropylene (PP)	20 oz/in	View 
Test Method: ASTM D3330		
Test Name: 90° Peel Adhesion Dwell/Cure Time: 72.0 Dwell Time Units: hr Temp C: 23C Temp F: 72F Environmental Condition: 50%RH Substrate: Polypropylene (PP) Backing: 2 mil PET		
Notes: 12 in/min (300 mm/min)		
90° Peel Adhesion	8.9 N/cm	View 
Test Method: ASTM D3330		
Dwell/Cure Time: 24.0 Dwell Time Units: hr Temp C: 32C Temp F: 90F Environmental Condition: 90%RH Substrate: Stainless Steel		
Notes: 12 in/min (300 mm/min)		
90° Peel Adhesion	81 oz/in	View 

Test Method: ASTM D3330

Dwell/Cure Time: 24.0
Dwell Time Units: hr
Temp C: 32C
Temp F: 90F
Environmental Condition: 90%RH
Substrate: Stainless Steel

Notes: 12 in/min (300 mm/min)

90° Peel Adhesion	3.4 N/cm	View 
Test Method: ASTM D3330 Dwell/Cure Time: 24.0 Dwell Time Units: hr Temp C: 32C Temp F: 90F Environmental Condition: 90%RH Substrate: Polycarbonate (PC) Notes: 12 in/min (300 mm/min)		
90° Peel Adhesion	31 oz/in	View 
Test Method: ASTM D3330 Dwell/Cure Time: 24.0 Dwell Time Units: hr Temp C: 32C Temp F: 90F Environmental Condition: 90%RH Substrate: Polycarbonate (PC) Notes: 12 in/min (300 mm/min)		
90° Peel Adhesion	2.7 N/cm	View 
Test Method: ASTM D3330 Dwell/Cure Time: 24.0 Dwell Time Units: hr Temp C: 32C Temp F: 90F Environmental Condition: 90%RH Substrate: Polypropylene (PP) Notes: 12 in/min (300 mm/min)		
90° Peel Adhesion	25 oz/in	View 
Test Method: ASTM D3330 Dwell/Cure Time: 24.0 Dwell Time Units: hr Temp C: 32C Temp F: 90F Environmental Condition: 90%RH Substrate: Polypropylene (PP) Notes: 12 in/min (300 mm/min)		
90° Peel Adhesion	7.4 N/cm	View 
Test Method: ASTM D3330 Dwell/Cure Time: 24.0 Dwell Time Units: hr Temp C: 32C Temp F: 90F Environmental Condition: 90%RH Substrate: Glass		

Notes: 12 in/min (300 mm/min)

90° Peel Adhesion	68 oz/in	View 
Test Method: ASTM D3330 Dwell/Cure Time: 24.0 Dwell Time Units: hr Temp C: 32C Temp F: 90F Environmental Condition: 90%RH Substrate: Glass Notes: 12 in/min (300 mm/min)		
90° Peel Adhesion	2.8 N/cm	View 
Test Method: ASTM D3330 Dwell/Cure Time: 24.0 Dwell Time Units: hr Temp C: 32C Temp F: 90F Environmental Condition: 90%RH Substrate: High Density Polyethylene (HDPE) Notes: 12 in/min (300 mm/min)		
90° Peel Adhesion	26 oz/in	View 
Test Method: ASTM D3330 Dwell/Cure Time: 24.0 Dwell Time Units: hr Temp C: 32C Temp F: 90F Environmental Condition: 90%RH Substrate: High Density Polyethylene (HDPE) Notes: 12 in/min (300 mm/min)		
90° Peel Adhesion	3.6 N/cm	View 
Test Method: ASTM D3330 Dwell/Cure Time: 24.0 Dwell Time Units: hr Temp C: 32C Temp F: 90F Environmental Condition: 90%RH Substrate: Low Density Polyethylene (LDPE) Notes: 12 in/min (300 mm/min)		
90° Peel Adhesion	33 oz/in	View 
Test Method: ASTM D3330 Dwell/Cure Time: 24.0 Dwell Time Units: hr Temp C: 32C Temp F: 90F Environmental Condition: 90%RH Substrate: Low Density Polyethylene (LDPE) Notes: 12 in/min (300 mm/min)		
90° Peel Adhesion	5.1 N/cm	View 
Test Method: ASTM D3330		

Dwell/Cure Time: 10.0
Dwell Time Units: min
Temp C: 23C
Temp F: 72F
Environmental Condition: 50%RH
Substrate: Stainless Steel

Notes: 12 in/min (300 mm/min)

90° Peel Adhesion	47 oz/in	View 
Test Method: ASTM D3330 Dwell/Cure Time: 10.0 Dwell Time Units: min Temp C: 23C Temp F: 72F Environmental Condition: 50%RH Substrate: Stainless Steel Notes: 12 in/min (300 mm/min)		
90° Peel Adhesion	5 N/cm	View 
Test Method: ASTM D3330 Dwell/Cure Time: 10.0 Dwell Time Units: min Temp C: 23C Temp F: 72F Environmental Condition: 50%RH Substrate: Polycarbonate (PC) Notes: 12 in/min (300 mm/min)		
90° Peel Adhesion	46 oz/in	View 
Test Method: ASTM D3330 Dwell/Cure Time: 10.0 Dwell Time Units: min Temp C: 23C Temp F: 72F Environmental Condition: 50%RH Substrate: Polycarbonate (PC) Notes: 12 in/min (300 mm/min)		
90° Peel Adhesion	1.3 N/cm	View 
Test Method: ASTM D3330 Dwell/Cure Time: 10.0 Dwell Time Units: min Temp C: 23C Temp F: 72F Environmental Condition: 50%RH Substrate: Polypropylene (PP) Notes: 12 in/min (300 mm/min)		
90° Peel Adhesion	12 oz/in	View 
Test Method: ASTM D3330 Dwell/Cure Time: 10.0 Dwell Time Units: min Temp C: 23C Temp F: 72F Environmental Condition: 50%RH Substrate: Polypropylene (PP) Notes: 12 in/min (300 mm/min)		

90° Peel Adhesion	6.7 oz/in	View 
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Test Method: ASTM D3330

Dwell/Cure Time: 10.0
Dwell Time Units: min
Temp C: 23C
Temp F: 72F
Environmental Condition: 50%RH
Substrate: Glass

Notes: 12 in/min (300 mm/min)

90° Peel Adhesion	61 oz/in	View 
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Test Method: ASTM D3330

Dwell/Cure Time: 10.0
Dwell Time Units: min
Temp C: 23C
Temp F: 72F
Environmental Condition: 50%RH
Substrate: Glass

Notes: 12 in/min (300 mm/min)

90° Peel Adhesion	1.4 N/cm	View 
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Test Method: ASTM D3330

Dwell/Cure Time: 10.0
Dwell Time Units: min
Temp C: 23C
Temp F: 72F
Environmental Condition: 50%RH
Substrate: High Density Polyethylene (HDPE)

Notes: 12 in/min (300 mm/min)

90° Peel Adhesion	13 oz/in	View 
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Test Method: ASTM D3330

Dwell/Cure Time: 10.0
Dwell Time Units: min
Temp C: 23C
Temp F: 72F
Environmental Condition: 50%RH
Substrate: High Density Polyethylene (HDPE)

Notes: 12 in/min (300 mm/min)

90° Peel Adhesion	2.4 N/cm	View 
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Test Method: ASTM D3330

Dwell/Cure Time: 10.0
Dwell Time Units: min
Temp C: 23C
Temp F: 72F
Environmental Condition: 50%RH
Substrate: Low Density Polyethylene (LDPE)

Notes: 12 in/min (300 mm/min)

90° Peel Adhesion	22 oz/in	View 
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Test Method: ASTM D3330

Dwell/Cure Time: 10.0
Dwell Time Units: min
Temp C: 23C
Temp F: 72F

Environmental Condition: 50%RH
Substrate: Low Density Polyethylene (LDPE)

Notes: 12 in/min (300 mm/min)

90° Peel Adhesion	3.4 N/cm	View 
Test Method: ASTM D3330 Dwell/Cure Time: 72.0 Dwell Time Units: hr Temp C: 23C Temp F: 72F Environmental Condition: 50%RH Substrate: Low Density Polyethylene (LDPE) Backing: 2 mil PET Notes: 12 in/min (300 mm/min)		
180° Peel Adhesion	7.9 N/cm	View 
Test Method: ASTM D3330 Dwell/Cure Time: 10.0 Dwell Time Units: min Temp C: 23C Temp F: 72F Environmental Condition: 50%RH Substrate: Stainless Steel Notes: 12 in/min (300 mm/min)		
180° Peel Adhesion	72 oz/in	View 
Test Method: ASTM D3330 Dwell/Cure Time: 10.0 Dwell Time Units: min Temp C: 23C Temp F: 72F Environmental Condition: 50%RH Substrate: Stainless Steel Notes: 12 in/min (300 mm/min)		
180° Peel Adhesion	7.7 N/cm	View 
Test Method: ASTM D3330 Dwell/Cure Time: 10.0 Dwell Time Units: min Temp C: 23C Temp F: 72F Environmental Condition: 50%RH Substrate: Polycarbonate (PC) Notes: 12 in/min (300 mm/min)		
180° Peel Adhesion	70 oz/in	View 
Test Method: ASTM D3330 Dwell/Cure Time: 10.0 Dwell Time Units: min Temp C: 23C Temp F: 72F Environmental Condition: 50%RH Substrate: Polycarbonate (PC) Notes: 12 in/min (300 mm/min)		
180° Peel Adhesion	4.5 N/cm	View 

Test Method: ASTM D3330

Dwell/Cure Time: 10.0
Dwell Time Units: min
Temp C: 23C
Temp F: 72F
Environmental Condition: 50%RH
Substrate: Polypropylene (PP)

Notes: 12 in/min (300 mm/min)

180° Peel Adhesion	41 oz/in	View 
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Test Method: ASTM D3330

Dwell/Cure Time: 10.0
Dwell Time Units: min
Temp C: 23C
Temp F: 72F
Environmental Condition: 50%RH
Substrate: Polypropylene (PP)

Notes: 12 in/min (300 mm/min)

180° Peel Adhesion	8.2 N/cm	View 
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Test Method: ASTM D3330

Dwell/Cure Time: 10.0
Dwell Time Units: min
Temp C: 23C
Temp F: 72F
Environmental Condition: 50%RH
Substrate: Glass

Notes: 12 in/min (300 mm/min)

180° Peel Adhesion	75 oz/in	View 
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Test Method: ASTM D3330

Dwell/Cure Time: 10.0
Dwell Time Units: min
Temp C: 23C
Temp F: 72F
Environmental Condition: 50%RH
Substrate: Glass

Notes: 12 in/min (300 mm/min)

180° Peel Adhesion	7.1 N/cm	View 
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Test Method: ASTM D3330

Dwell/Cure Time: 10.0
Dwell Time Units: min
Temp C: 23C
Temp F: 72F
Environmental Condition: 50%RH
Substrate: **Smooth Powder Coating

Notes: 12 in/min (300 mm/min)

180° Peel Adhesion	65 oz/in	View 
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Test Method: ASTM D3330

Dwell/Cure Time: 10.0
Dwell Time Units: min
Temp C: 23C
Temp F: 72F
Environmental Condition: 50%RH
Substrate: **Smooth Powder Coating

Notes: 12 in/min (300 mm/min)

180° Peel Adhesion	3.8 N/cm	View 
Test Method: ASTM D3330 Dwell/Cure Time: 10.0 Dwell Time Units: min Temp C: 23C Temp F: 72F Environmental Condition: 50%RH Substrate: **Finely Textured Powder Coating Notes: 12 in/min (300 mm/min)		
180° Peel Adhesion	35 oz/in	View 
Test Method: ASTM D3330 Dwell/Cure Time: 10.0 Dwell Time Units: min Temp C: 23C Temp F: 72F Environmental Condition: 50%RH Substrate: **Finely Textured Powder Coating Notes: 12 in/min (300 mm/min)		
180° Peel Adhesion	8.2 N/cm	View 
Test Method: ASTM D3330 Dwell/Cure Time: 72.0 Dwell Time Units: hr Temp C: 23C Temp F: 72F Environmental Condition: 50%RH Substrate: Polycarbonate (PC) Notes: 12 in/min (300 mm/min)		
180° Peel Adhesion	75 oz/in	View 
Test Method: ASTM D3330 Dwell/Cure Time: 72.0 Dwell Time Units: hr Temp C: 23C Temp F: 72F Environmental Condition: 50%RH Substrate: Polycarbonate (PC) Notes: 12 in/min (300 mm/min)		
180° Peel Adhesion	5.5 N/cm	View 
Test Method: ASTM D3330 Dwell/Cure Time: 72.0 Dwell Time Units: hr Temp C: 23C Temp F: 72F Environmental Condition: 50%RH Substrate: Polypropylene (PP) Notes: 12 in/min (300 mm/min)		
180° Peel Adhesion	50 oz/in	View 
Test Method: ASTM D3330		

Dwell/Cure Time: 72.0
Dwell Time Units: hr
Temp C: 23C
Temp F: 72F
Environmental Condition: 50%RH
Substrate: Polypropylene (PP)

Notes: 12 in/min (300 mm/min)

180° Peel Adhesion	8.8 N/cm	View 
Test Method: ASTM D3330 Dwell/Cure Time: 72.0 Dwell Time Units: hr Temp C: 23C Temp F: 72F Environmental Condition: 50%RH Substrate: Glass Notes: 12 in/min (300 mm/min)		
180° Peel Adhesion	80 oz/in	View 
Test Method: ASTM D3330 Dwell/Cure Time: 72.0 Dwell Time Units: hr Temp C: 23C Temp F: 72F Environmental Condition: 50%RH Substrate: Glass Notes: 12 in/min (300 mm/min)		
180° Peel Adhesion	4.4 N/cm	View 
Test Method: ASTM D3330 Dwell/Cure Time: 72.0 Dwell Time Units: hr Temp C: 23C Temp F: 72F Environmental Condition: 50%RH Substrate: High Density Polyethylene (HDPE) Notes: 12 in/min (300 mm/min)		
180° Peel Adhesion	40 oz/in	View 
Test Method: ASTM D3330 Dwell/Cure Time: 72.0 Dwell Time Units: hr Temp C: 23C Temp F: 72F Environmental Condition: 50%RH Substrate: High Density Polyethylene (HDPE) Notes: 12 in/min (300 mm/min)		
180° Peel Adhesion	3.8 N/cm	View 
Test Method: ASTM D3330 Dwell/Cure Time: 72.0 Dwell Time Units: hr Temp C: 23C Temp F: 72F Environmental Condition: 50%RH Substrate: Low Density Polyethylene (LDPE) Notes: 12 in/min (300 mm/min)		

180° Peel Adhesion	35 oz/in	View 
Test Method: ASTM D3330 Dwell/Cure Time: 72.0 Dwell Time Units: hr Temp C: 23C Temp F: 72F Environmental Condition: 50%RH Substrate: Low Density Polyethylene (LDPE) Notes: 12 in/min (300 mm/min)		
180° Peel Adhesion	7.2 N/cm	View 
Test Method: ASTM D3330 Dwell/Cure Time: 72.0 Dwell Time Units: hr Temp C: 23C Temp F: 72F Environmental Condition: 50%RH Substrate: **Smooth Powder Coating Notes: 12 in/min (300 mm/min)		
180° Peel Adhesion	66 oz/in	View 
Test Method: ASTM D3330 Dwell/Cure Time: 72.0 Dwell Time Units: hr Temp C: 23C Temp F: 72F Environmental Condition: 50%RH Substrate: **Smooth Powder Coating Notes: 12 in/min (300 mm/min)		
180° Peel Adhesion	3.9 N/cm	View 
Test Method: ASTM D3330 Dwell/Cure Time: 72.0 Dwell Time Units: hr Temp C: 23C Temp F: 72F Environmental Condition: 50%RH Substrate: **Finely Textured Powder Coating Notes: 12 in/min (300 mm/min)		
180° Peel Adhesion	36 oz/in	View 
Test Method: ASTM D3330 Dwell/Cure Time: 72.0 Dwell Time Units: hr Temp C: 23C Temp F: 72F Environmental Condition: 50%RH Substrate: **Finely Textured Powder Coating Notes: 12 in/min (300 mm/min)		
180° Peel Adhesion	9.6 N/cm	View 
Test Method: ASTM D3330 Dwell/Cure Time: 72.0 Dwell Time Units: hr Temp C: 49C Temp F: 120F		

Environmental Condition: 50%RH
Substrate: Stainless Steel

Notes: 12 in/min (300 mm/min)

180° Peel Adhesion	88 oz/in	View 
Test Method: ASTM D3330 Dwell/Cure Time: 72.0 Dwell Time Units: hr Temp C: 49C Temp F: 120F Environmental Condition: 50%RH Substrate: Stainless Steel Notes: 12 in/min (300 mm/min)		
180° Peel Adhesion	5.9 N/cm	View 
Test Method: ASTM D3330 Dwell/Cure Time: 72.0 Dwell Time Units: hr Temp C: 49C Temp F: 120F Environmental Condition: 50%RH Substrate: Polycarbonate (PC) Notes: 12 in/min (300 mm/min)		
180° Peel Adhesion	54 oz/in	View 
Test Method: ASTM D3330 Dwell/Cure Time: 72.0 Dwell Time Units: hr Temp C: 49C Temp F: 120F Environmental Condition: 50%RH Substrate: Polycarbonate (PC) Notes: 12 in/min (300 mm/min)		
180° Peel Adhesion	5.5 N/cm	View 
Test Method: ASTM D3330 Dwell/Cure Time: 72.0 Dwell Time Units: hr Temp C: 49C Temp F: 120F Environmental Condition: 50%RH Substrate: Polypropylene (PP) Notes: 12 in/min (300 mm/min)		
180° Peel Adhesion	50 oz/in	View 
Test Method: ASTM D3330 Dwell/Cure Time: 72.0 Dwell Time Units: hr Temp C: 49C Temp F: 120F Environmental Condition: 50%RH Substrate: Polypropylene (PP) Notes: 12 in/min (300 mm/min)		
180° Peel Adhesion	4.3 N/cm	View 

Test Method: ASTM D3330

Dwell/Cure Time: 72.0
Dwell Time Units: hr
Temp C: 49C
Temp F: 120F
Environmental Condition: 50%RH
Substrate: High Density Polyethylene (HDPE)

Notes: 12 in/min (300 mm/min)

180° Peel Adhesion	39 oz/in	View 
Test Method: ASTM D3330 Dwell/Cure Time: 72.0 Dwell Time Units: hr Temp C: 49C Temp F: 120F Environmental Condition: 50%RH Substrate: High Density Polyethylene (HDPE) Notes: 12 in/min (300 mm/min)		
180° Peel Adhesion	1.2 N/cm	View 
Test Method: ASTM D3330 Dwell/Cure Time: 72.0 Dwell Time Units: hr Temp C: 49C Temp F: 120F Environmental Condition: 50%RH Substrate: Low Density Polyethylene (LDPE) Notes: 12 in/min (300 mm/min)		
180° Peel Adhesion	11 oz/in	View 
Test Method: ASTM D3330 Dwell/Cure Time: 72.0 Dwell Time Units: hr Temp C: 49C Temp F: 120F Environmental Condition: 50%RH Substrate: Low Density Polyethylene (LDPE) Notes: 12 in/min (300 mm/min)		
180° Peel Adhesion	7.8 N/cm	View 
Test Method: ASTM D3330 Dwell/Cure Time: 72.0 Dwell Time Units: hr Temp C: 49C Temp F: 120F Environmental Condition: 50%RH Substrate: **Smooth Powder Coating Notes: 12 in/min (300 mm/min)		
180° Peel Adhesion	71 oz/in	View 
Test Method: ASTM D3330 Dwell/Cure Time: 72.0 Dwell Time Units: hr Temp C: 49C Temp F: 120F Environmental Condition: 50%RH Substrate: **Smooth Powder Coating		

Notes: 12 in/min (300 mm/min)

180° Peel Adhesion	7 N/cm	View 
Test Method: ASTM D3330 Dwell/Cure Time: 72.0 Dwell Time Units: hr Temp C: 49C Temp F: 120F Environmental Condition: 50%RH Substrate: **Finely Textured Powder Coating Notes: 12 in/min (300 mm/min)		
180° Peel Adhesion	64 oz/in	View 
Test Method: ASTM D3330 Dwell/Cure Time: 72.0 Dwell Time Units: hr Temp C: 49C Temp F: 120F Environmental Condition: 50%RH Substrate: **Finely Textured Powder Coating Notes: 12 in/min (300 mm/min)		
180° Peel Adhesion	9.1 N/cm	View 
Test Method: ASTM D3330 Dwell/Cure Time: 72.0 Dwell Time Units: hr Temp C: 23C Temp F: 72F Environmental Condition: 50%RH Substrate: Stainless Steel Notes: 12 in/min (300 mm/min)		
180° Peel Adhesion	83 oz/in	View 
Test Method: ASTM D3330 Dwell/Cure Time: 72.0 Dwell Time Units: hr Temp C: 23C Temp F: 72F Environmental Condition: 50%RH Substrate: Stainless Steel Notes: 12 in/min (300 mm/min)		
180° Peel Adhesion	9.2 N/cm	View 
Test Method: ASTM D3330 Dwell/Cure Time: 72.0 Dwell Time Units: hr Temp C: 49C Temp F: 120F Environmental Condition: 50%RH Substrate: Glass Notes: 12 in/min (300 mm/min)		
180° Peel Adhesion	84 oz/in	View 

Test Method: ASTM D3330

Dwell/Cure Time: 72.0
Dwell Time Units: hr
Temp C: 49C
Temp F: 120F
Environmental Condition: 50%RH
Substrate: Glass

Notes: 12 in/min (300 mm/min)

180° Peel Adhesion	10.1 N/cm	View 
Test Method: ASTM D3330 Dwell/Cure Time: 24.0 Dwell Time Units: hr Temp C: 32C Temp F: 90F Environmental Condition: 90%RH Substrate: Stainless Steel Notes: 12 in/min (300 mm/min)		
180° Peel Adhesion	92 oz/in	View 
Test Method: ASTM D3330 Dwell/Cure Time: 24.0 Dwell Time Units: hr Temp C: 32C Temp F: 90F Environmental Condition: 90%RH Substrate: Stainless Steel Notes: 12 in/min (300 mm/min)		
180° Peel Adhesion	5.8 N/cm	View 
Test Method: ASTM D3330 Dwell/Cure Time: 24.0 Dwell Time Units: hr Temp C: 32C Temp F: 90F Environmental Condition: 90%RH Substrate: Polycarbonate (PC) Notes: 12 in/min (300 mm/min)		
180° Peel Adhesion	53 oz/in	View 
Test Method: ASTM D3330 Dwell/Cure Time: 24.0 Dwell Time Units: hr Temp C: 32C Temp F: 90F Environmental Condition: 90%RH Substrate: Polycarbonate (PC) Notes: 12 in/min (300 mm/min)		
180° Peel Adhesion	3.9 N/cm	View 
Test Method: ASTM D3330 Dwell/Cure Time: 24.0 Dwell Time Units: hr Temp C: 32C Temp F: 90F Environmental Condition: 90%RH Substrate: Polypropylene (PP) Notes: 12 in/min (300 mm/min)		

180° Peel Adhesion	36 oz/in	View 
Test Method: ASTM D3330 Dwell/Cure Time: 24.0 Dwell Time Units: hr Temp C: 32C Temp F: 90F Environmental Condition: 90%RH Substrate: Polypropylene (PP) Notes: 12 in/min (300 mm/min)		

180° Peel Adhesion	8.9 N/cm	View 
Test Method: ASTM D3330 Dwell/Cure Time: 24.0 Dwell Time Units: hr Temp C: 32C Temp F: 90F Environmental Condition: 90%RH Substrate: Glass Notes: 12 in/min (300 mm/min)		

180° Peel Adhesion	81 oz/in	View 
Test Method: ASTM D3330 Dwell/Cure Time: 24.0 Dwell Time Units: hr Temp C: 32C Temp F: 90F Environmental Condition: 90%RH Substrate: Glass Notes: 12 in/min (300 mm/min)		

180° Peel Adhesion	4.3 N/cm	View 
Test Method: ASTM D3330 Dwell/Cure Time: 24.0 Dwell Time Units: hr Temp C: 32C Temp F: 90F Environmental Condition: 90%RH Substrate: High Density Polyethylene (HDPE) Notes: 12 in/min (300 mm/min)		

180° Peel Adhesion	39 oz/in	View 
Test Method: ASTM D3330 Dwell/Cure Time: 24.0 Dwell Time Units: hr Temp C: 32C Temp F: 90F Environmental Condition: 90%RH Substrate: High Density Polyethylene (HDPE) Notes: 12 in/min (300 mm/min)		

180° Peel Adhesion	2.7 N/cm	View 
Test Method: ASTM D3330 Dwell/Cure Time: 24.0 Dwell Time Units: hr Temp C: 32C Temp F: 90F		

Environmental Condition: 90%RH
Substrate: Low Density Polyethylene (LDPE)

Notes: 12 in/min (300 mm/min)

180° Peel Adhesion	25 oz/in	View 
Test Method: ASTM D3330 Dwell/Cure Time: 24.0 Dwell Time Units: hr Temp C: 32C Temp F: 90F Environmental Condition: 90%RH Substrate: Low Density Polyethylene (LDPE) Notes: 12 in/min (300 mm/min)		
180° Peel Adhesion	3.7 N/cm	View 
Test Method: ASTM D3330 Dwell/Cure Time: 24.0 Dwell Time Units: hr Temp C: 32C Temp F: 90F Environmental Condition: 90%RH Substrate: **Smooth Powder Coating Notes: 12 in/min (300 mm/min)		
180° Peel Adhesion	34 oz/in	View 
Test Method: ASTM D3330 Dwell/Cure Time: 24.0 Dwell Time Units: hr Temp C: 32C Temp F: 90F Environmental Condition: 90%RH Substrate: **Smooth Powder Coating Notes: 12 in/min (300 mm/min)		
180° Peel Adhesion	3.7 N/cm	View 
Test Method: ASTM D3330 Dwell/Cure Time: 24.0 Dwell Time Units: hr Temp C: 32C Temp F: 90F Environmental Condition: 90%RH Substrate: **Finely Textured Powder Coating Notes: 12 in/min (300 mm/min)		
180° Peel Adhesion	34 oz/in	View 
Test Method: ASTM D3330 Dwell/Cure Time: 24.0 Dwell Time Units: hr Temp C: 32C Temp F: 90F Environmental Condition: 90%RH Substrate: **Finely Textured Powder Coating Notes: 12 in/min (300 mm/min)		
180° Peel Adhesion	4 N/cm	View 

Test Method: ASTM D3330
Dwell/Cure Time: 10.0
Dwell Time Units: min
Temp C: 23C
Temp F: 72F
Environmental Condition: 50%RH
Substrate: High Density Polyethylene (HDPE)
Notes: 12 in/min (300 mm/min)

180° Peel Adhesion	37 oz/in	View	^
Test Method: ASTM D3330			
Dwell/Cure Time: 10.0			
Dwell Time Units: min			
Temp C: 23C			
Temp F: 72F			
Environmental Condition: 50%RH			
Substrate: High Density Polyethylene (HDPE)			
Notes: 12 in/min (300 mm/min)			

180° Peel Adhesion	3.8 N/cm	View	^
Test Method: ASTM D3330			
Dwell/Cure Time: 10.0			
Dwell Time Units: min			
Temp C: 23C			
Temp F: 72F			
Environmental Condition: 50%RH			
Substrate: Low Density Polyethylene (LDPE)			
Notes: 12 in/min (300 mm/min)			

180° Peel Adhesion	35 oz/in	View	^
Test Method: ASTM D3330			
Dwell/Cure Time: 10.0			
Dwell Time Units: min			
Temp C: 23C			
Temp F: 72F			
Environmental Condition: 50%RH			
Substrate: Low Density Polyethylene (LDPE)			
Notes: 12 in/min (300 mm/min)			

Long Term Temp C	149 °C	View	^
Test Condition: Long Term (day, weeks)			
Minimum Long Term Temperature Resistance	-40 °C	View	^
Test Condition: Long Term (day, weeks)			
Long Term Temp F	300 °F	View	^
Test Condition: Long Term (day, weeks)			

Minimum Long Term Temperature Resistance	-40 °F	View	^
Test Condition: Long Term (day, weeks)			
Minimum Application Temperature	10 °C		

Minimum Application Temperature	50 °F
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Note	Calipers are nominal values
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Liner Release	5 to 70 g/2 in	View 
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Test Method: TLMI
Notes: 180° removal, 300 in/min

Available Sizes

Finished labels should be stored in plastic bags.

Typical Environmental Performance

Property	Values	Additional Information
Chemical and Environmental Exposure	The properties defined are based on four hour immersions at room temperature (72°F/22°C) unless otherwise noted. Samples were applied to stainless steel panels 24 hours prior to immersion and were evaluated one hour after removal from the solution for peel adhesion. Adhesion measured at 180° peel angle (ASTM D 3330) at 12 inches/minute. -	
Humidity Resistance	24 hours at 100°F (38°C) and 100% relative humidity: no significant change in appearance or adhesion	

Temperature Resistance	When applied to stainless steel. Other substrates should be tested per application. 300°F (149°C) for 24 hours: no significant visual change, 0.4% MD shrinkage, 0.6% CD shrinkage -40°F (-40°C) for 10 days: no significant visual change	
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Accelerated Aging	0.046 N/cm	View 
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Test Method: ASTM D3611
Dwell/Cure Time: 96.0 Dwell Time Units: hr Temp C: 65C Temp F: 150F Environmental Condition: 80%RH
Notes: 180° Removal of Liner from Facestock at 90 in/min

Accelerated Aging	12 g/in	View 
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Test Method: ASTM D3611

Dwell/Cure Time: 96.0
Dwell Time Units: hr
Temp C: 65C
Temp F: 150F
Environmental Condition: 80%RH

Notes: 180° Removal of Liner from Facestock at 90 in/min

Accelerated Aging	8.3 N/cm	View 
Test Method: ASTM D3611 Dwell/Cure Time: 96.0 Dwell Time Units: hr Temp C: 65C Temp F: 150F Environmental Condition: 80%RH Substrate: Stainless Steel Notes: 12 in/min (300 mm/min)		

Accelerated Aging	76 oz/in	View 
Test Method: ASTM D3611 Dwell/Cure Time: 96.0 Dwell Time Units: hr Temp C: 65C Temp F: 150F Environmental Condition: 80%RH Substrate: Stainless Steel Notes: 12 in/min (300 mm/min)		

Printing

Facestock is topcoated for improved ink receptivity and is designed for thermal transfer printing. It is printable by all standard roll processing methods including flexography, hot stamp, letterpress, and screen printing.

UL Recognized thermal transfer ribbons

Advent: 301 Black; 303 Black; 501 Black; 501 Red; 501 Blue; 501 Green

Armor: AXR-7; AXR-7+; AXR-600

Astromed: R5

CP: 5440 Red; 5640 Blue; 5940 Black

Dasco: DR-74; DR-84

Great Ribbon: SDR

ICS: ICS-CC-4099.1

Ilimak: SH-36; SP-330; PrimeMark Intermec: 053258-2; 054048-4

ITW: B324

Japan Pulp and Paper: JP Resin 1; JP Resin 2 Blue; JP Resin 2 Red (suitable for indoor use only); JP Resin 2 Green (suitable for indoor use only)

Kurz: K500; K501

Markem: 716 (suitable for indoor use only) Mid City Columbia: CGL-80; CGL-80HE

NCR: Matrix Resin; Matrix; PaceSetter; Promark II; Ultra V

Pelikan: T016

Ricoh: B110A; B110C; B110CX

Sato: Premier 1

Sony: 4070; 4072; 4075; 4085; 5070; Signature Series Resin; Signature Series Wax

UBI: HR03; HR04

Zebra: 5095; 5099; 5100; 5175

Converting

Rotary die cutting is recommended. Fanfolding of labels is not recommended. Small labels should be evaluated carefully. Winding tensions should be kept at a minimum to help prevent the adhesive from oozing.

Storage and Shelf Life

Store at room temperature conditions of 72°F (22°C) and 50% relative humidity.
If stored under proper conditions, product retains its performance and properties for 24 months from date of manufacture.

Industry Specifications

UL Recognized (File MH16411)
CSA Accepted (File 99316)

Trademarks

3M is a trademark of 3M Company.
Alconox is a registered trademark of Alconox, Inc.
409 is a registered trademark of Clorox.

Handling/Application Information

Application Examples

- Barcode labels and rating plates
- Property identification and asset labeling
- Warning, instruction, and service labels for durable goods
- Nameplates and durable goods

Application Techniques

For maximum bond strength, the surface should be clean and dry. Typical cleaning solvents are heptane and isopropyl alcohol.*

For best bonding conditions, application surface should be at room temperature or higher. Low temperature surfaces, below 50°F (10°C), can cause the adhesive to become so firm that it will not develop maximum contact with the substrate. Higher initial bonds can be achieved through increased rubdown pressure.

*When using solvents, read and follow the manufacturer’s precautions and directions for use.

References

Property	Values
3m.com Product Page	https://www.3m.com/3M/en_US/company-us/search/?Ntt=7868
Safety Data Sheet SDS	https://www.3m.com/3M/en_US/company-us/SDS-search/results/?gsaAction=msdsSRA&msdsLocale=en_US&co=ptn&q=7868

Family Group

Link Tags:

- 7868

Products	Liner	Facestock	Adhesive Thickness	Long Term Temp F
7868	55# Densified kraft	White Polyester Gloss TC	0.028 mm	300 °F

ISO Statement

This Industrial Adhesives and Tapes Division product was manufactured under a 3M quality system registered to ISO 9001 standards.

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