

Technical Data Sheet

3M™ Thermal Transfer Polyester Label Material 7874

Product Description

3M™ Thermal Transfer Polyester Label Material 7874 is a white polyester matte label stock that is designed for use in demanding applications that require the use of thermal transfer printing. This label product utilizes 3M™ High Performance Acrylic Adhesive 350, it 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.
- Thick adhesive caliper provides for stronger bond on textured surface.
- Topcoat provides the advantages of matte coating combined with a surface that is smooth enough for thermal transfer printing. Resin ribbons are recommended for optimum durability. The matte coating resists degradation from scuffing, chemicals, moisture, and wide temperature fluctuations. 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.

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 Matte TT TC	
Facestock Thickness	0.058 mm	
Adhesive Thickness	1.8 mil	

Liner Thickness	3.2 mil
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Adhesive Coat Weight	2.70 to 3.24 g/100 in ²
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Property	Values	Additional Information
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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)

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)

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)

90° Peel Adhesion	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: **Finely Textured Powder Coating Notes: 12 in/min (300 mm/min)		
90° Peel Adhesion	27 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)		
90° Peel Adhesion Stainless Steel	78 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	3.5 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: High Density Polyethylene (HDPE) Backing: 2 mil PET Notes: 12 in/min (300 mm/min)		
90° Peel Adhesion	32 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	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) Backing: 2 mil PET Notes: 12 in/min (300 mm/min)		
90° 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: **Smooth Powder Coating		
90° 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: **Smooth Powder Coating		
90° Peel Adhesion	2.8 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: **Finely Textured Powder Coating		
90° Peel Adhesion	26 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		
90° Peel Adhesion	10.3 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: Stainless Steel

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

90° Peel Adhesion	94 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	3.6 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: Polycarbonate (PC) Notes: 12 in/min (300 mm/min)		
90° Peel Adhesion	33 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	3.7 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: Polypropylene (PP) Notes: 12 in/min (300 mm/min)		
90° Peel Adhesion	34 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	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: Glass

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: Glass Notes: 12 in/min (300 mm/min)		
90° Peel Adhesion	3.3 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)		
90° Peel Adhesion	30 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	1.4 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: Low Density Polyethylene (LDPE) Notes: 12 in/min (300 mm/min)		
90° Peel Adhesion	13 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	6.6 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: **Smooth Powder Coating Notes: 12 in/min (300 mm/min)		
90° Peel Adhesion	60 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)		
90° Peel Adhesion	3.6 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: **Finely Textured Powder Coating Notes: 12 in/min (300 mm/min)		
90° Peel Adhesion	33 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)		
90° Peel Adhesion Stainless Steel	8.5 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	8.2 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: Glass Backing: 2 mil PET		

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

90° Peel Adhesion Glass	75 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)	7.3 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)	67 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)	29 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	8.8 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: Stainless Steel		

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

90° Peel Adhesion	80 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	6.2 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	57 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	4.6 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: Polypropylene (PP) Notes: 12 in/min (300 mm/min)		
90° Peel Adhesion	42 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	7.7 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: Glass

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

90° Peel Adhesion	70 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	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: High Density Polyethylene (HDPE) Notes: 12 in/min (300 mm/min)		
90° Peel Adhesion	37 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	4.2 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	38 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	6.3 N/cm	View 
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Test Method: ASTM D3330		
Dwell/Cure Time: 24.0 Dwell Time Units: hr Temp C: 32C Temp F: 90F Environmental Condition: 50%RH Substrate: **Smooth Powder Coating		
Notes: 12 in/min (300 mm/min)		

90° Peel Adhesion	58 oz/in	View 
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Test Method: ASTM D3330		
Dwell/Cure Time: 24.0 Dwell Time Units: hr Temp C: 32C Temp F: 90F Environmental Condition: 50%RH Substrate: **Smooth Powder Coating		
Notes: 12 in/min (300 mm/min)		

90° Peel Adhesion	3.1 N/cm	View 
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Test Method: ASTM D3330		
Dwell/Cure Time: 24.0 Dwell Time Units: hr Temp C: 32C Temp F: 90F Environmental Condition: 50%RH Substrate: **Finely Textured Powder Coating		
Notes: 12 in/min (300 mm/min)		

90° Peel Adhesion	28 oz/in	View 
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Test Method: ASTM D3330		
Dwell/Cure Time: 24.0 Dwell Time Units: hr Temp C: 32C Temp F: 90F Environmental Condition: 50%RH Substrate: **Finely Textured Powder Coating		
Notes: 12 in/min (300 mm/min)		

90° Peel Adhesion	6.1 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: Stainless Steel		
Notes: 12 in/min (300 mm/min)		

90° Peel Adhesion	56 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: Stainless Steel

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

90° Peel Adhesion	6.7 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)		
90° Peel Adhesion	61 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	3.3 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	30 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	7.1 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: Glass Notes: 12 in/min (300 mm/min)		
90° Peel Adhesion	65 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: Glass

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

90° Peel Adhesion	3.1 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: High Density Polyethylene (HDPE) Notes: 12 in/min (300 mm/min)		
90° Peel Adhesion	28 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)		
90° Peel Adhesion	3.2 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)		
90° Peel Adhesion	29 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)		
90° 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)		

Backing: 2 mil PET

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

180° Peel Adhesion	8.6 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	79 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	8.9 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: Polycarbonate (PC) Notes: 12 in/min (300 mm/min)		
180° Peel Adhesion	81 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	7.1 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: Polypropylene (PP) Notes: 12 in/min (300 mm/min)		
180° Peel Adhesion	65 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)

180° Peel Adhesion	9.1 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: Glass Notes: 12 in/min (300 mm/min)		
180° Peel Adhesion	83 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: Glass Notes: 12 in/min (300 mm/min)		
180° Peel Adhesion	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: **Smooth Powder Coating Notes: 12 in/min (300 mm/min)		
180° Peel Adhesion	73 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: **Smooth Powder Coating Notes: 12 in/min (300 mm/min)		
180° Peel Adhesion	4.6 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	42 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	9.4 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: Polycarbonate (PC) Notes: 12 in/min (300 mm/min)		
180° Peel Adhesion	86 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	8.1 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: Polypropylene (PP) Notes: 12 in/min (300 mm/min)		
180° Peel Adhesion	74 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	9.7 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	89 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	5.6 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	51 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	5.4 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) Notes: 12 in/min (300 mm/min)		
180° Peel Adhesion	49 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	8.4 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: **Smooth Powder Coating		
Notes: 12 in/min (300 mm/min)		

180° Peel Adhesion	77 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	4.8 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: **Finely Textured Powder Coating		
Notes: 12 in/min (300 mm/min)		

180° Peel Adhesion	44 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	10.6 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	97 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	6.9 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	63 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	8.6 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: Polypropylene (PP) Notes: 12 in/min (300 mm/min)		
180° Peel Adhesion	79 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	5.2 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: High Density Polyethylene (HDPE) Notes: 12 in/min (300 mm/min)		
180° Peel Adhesion	48 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	1.5 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: Low Density Polyethylene (LDPE) Notes: 12 in/min (300 mm/min)		
180° Peel Adhesion	14 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	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: **Smooth Powder Coating 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: 49C Temp F: 120F Environmental Condition: 50%RH Substrate: **Smooth Powder Coating Notes: 12 in/min (300 mm/min)		
180° Peel Adhesion	5.4 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: **Finely Textured Powder Coating		

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

180° Peel Adhesion	49 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	9.8 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: Stainless Steel Notes: 12 in/min (300 mm/min)		
180° Peel Adhesion	90 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	10.5 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: Glass Notes: 12 in/min (300 mm/min)		
180° Peel Adhesion	96 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	10.2 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	93 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	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: Polycarbonate (PC) Notes: 12 in/min (300 mm/min)		
180° 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: Polycarbonate (PC) Notes: 12 in/min (300 mm/min)		
180° 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: Polypropylene (PP) Notes: 12 in/min (300 mm/min)		
180° 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: Polypropylene (PP) Notes: 12 in/min (300 mm/min)		

180° Peel Adhesion	8.8 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: Glass Notes: 12 in/min (300 mm/min)		

180° Peel Adhesion	80 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	4.6 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: High Density Polyethylene (HDPE) Notes: 12 in/min (300 mm/min)		

180° Peel Adhesion	42 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	4.2 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	38 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	8.4 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: **Smooth Powder Coating Notes: 12 in/min (300 mm/min)		
180° Peel Adhesion	77 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	4.9 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: **Finely Textured Powder Coating Notes: 12 in/min (300 mm/min)		
180° Peel Adhesion	45 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	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: High Density Polyethylene (HDPE) Notes: 12 in/min (300 mm/min)		
180° 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: High Density Polyethylene (HDPE)
Notes: 12 in/min (300 mm/min)

180° Peel Adhesion	5 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)

180° Peel Adhesion	46 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)

Long Term Temp C	149 °C	View	^
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Test Condition: Long Term (day, weeks)
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Minimum Long Term Temperature Resistance	-40 °C	View	^
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Test Condition: Long Term (day, weeks)
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Long Term Temp F	300 °F	View	^
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Test Condition: Long Term (day, weeks)
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Minimum Long Term Temperature Resistance	-40 °F	View	^
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Test Condition: Long Term (day, weeks)
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Minimum Application Temperature	10 °C
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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 
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	0.05 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		
Notes: 180° Removal of Liner from Facestock at 90 in/min		

Accelerated Aging	13 g/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		
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. Refer to UL listing for specific ribbons.

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)

Bottom Matter

3M
Industrial Adhesives and Tapes Division
3M Center, Building 225-3S-06
St. Paul, MN 55144-1000
800-362-3550

Trademarks

3M is a trademark of 3M Company.
Alconox is a registered trademark of Alconox, Inc. Formula
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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/p/d/b5005329083/
Safety Data Sheet SDS	https://www.3m.com/3M/en_US/company-us/SDS-search/results/?gsaAction=msdsSRA&msdsLocale=en_US&co=ptn&q=7874

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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