



Scotchcal™ General Purpose Graphic Film

Series 30

Product Bulletin

Product Description

These monomeric calendered films are a range of 39 glossy and 35 matte colored films that have been specially developed to be knife cut on electronic systems.

Product Line Electrocut 30-X X = color code, opaque, glossy and matte, removable adhesive. Wide selection out of large color range.

Product Characteristics

These are typical values for unprocessed products.
Contact your 3M representative for a custom specification.

Physical & Application

Material	calendered vinyl (monomeric)	
Surface finish	glossy and matte (see product line)	
Thickness (film)	70 µm (0.07 mm)	
Adhesive type	waterbased acrylic: pressure-sensitive	
Adhesive appearance	clear	
Liner	Kraft paper	
Adhesion	approx. 7 N/25 mm	FTM 1: 180° peel, substrate: glass; cond: 24 h 23°C/50%RH

Application method	dry only!	
Applied shrinkage	< 0.6 mm	FTM 14
Application temperature	+10°C	minimum (air and substrate)
Service temperature	-40°C to +80°C	
Surface type	flat	
Substrate type	aluminum, glass, PMMA, PC*, ABS, paint	

PC*, PETG*: Might require drying with heat before use

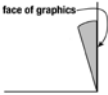
Graphic removal Removable with heat and/or chemicals from supported substrates.
No liability is given for ease or speed of removal of any graphic. Pay attention to adequate air and substrate temperature.

Notice! Adhesive residue has to be expected!

Storage	Shelf life	Use within 2 years from the date of manufacture on the sealed original box. Use within 1 year after opening the box.
	Storage conditions	+4°C to +40°C, out of sunlight, original container in clean and dry area.

Flammability Flammability standards are different from country to country. Ask your local 3M contact for details, please.

Durability

Unprocessed film	The following durability data are given for unprocessed film only!
3M™ MCS™ Warranty	In addition, 3M provides a warranty on a finished applied graphic within the framework of 3M™ MCS™ warranty program.
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. Zone 1 Northern Europe, Italy (north of Rome), Russia Zone 2 Mediterranean area without North Africa, South Africa Zone 3 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 elements.

Vertical outdoor exposure	Zone 1	Zone 2	Zone 3
white/black colors	3 years	2 years	12 months
transparent	2 years	12 months	12 months
metallics	12 months	12 months	12 months
12 months	12 months	12 months	12 months
Interior application	Zone 1	Zone 2	Zone 3
interior	5 years	5 years	5 years

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.

- Graphics applied to
- flexible substrates incl. 3M™ Panaflex™ Awning and Sign Facing 945GPS and 3M™ Panagraphics™ III Wide Width Flexible Substrate.
 - low surface energy substrates or substrates with low surface energy coating.
 - other than flat surfaces.
 - painted or unpainted wallboards, gypsum boards and wallpapers.
 - stainless steel.
 - surfaces that are not clean and smooth.
 - surfaces with poor paint to substrate adhesion.
 - water-based paint

Graphic removal from - signs or existing graphics that must remain intact.

Graphics subjected to - gasoline vapors or spills.

Important Notice - 3M Commercial Graphics Division products are not tested against automotive manufacturer specifications!

- Application on top of vinyls and film to film.
- Wet application method is not recommended for this film.
- Non vertical applications will have a significant decrease in durability!
- To avoid color variations all pieces of applied film of one colored area should be processed out of one lot of material.
- 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.

Graphics Manufacturing

Shipping finished graphics

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.

Converting Information Electronic Cutting

Based upon cutting evaluations the minimum height for text is 10 mm using upper and lowercase Helvetica Medium. The stroke width should not be lower than 1 mm.

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

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 weeded (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.

[>Instruction Bulletin 4.1'Sheeting, Scoring, Film cutting'<](#)

Application

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

[> Product Bulletin Application Tape Recommendations <](#)

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

[>Instruction Bulletin 5.1 'select and prepare substrates for graphic application'<](#)

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.

[>Instruction Bulletin 6.5 'Storage, Handling, Maintenance and Removal of Films and Sheetings'<](#)

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.

Additional Information Visit the web site of your local subsidiary at www.3Mgraphics.com for getting more:

- details about 3M™ MCS™ Warranty and 3M Performance Guarantee
- additional instruction bulletins
- a complete product overview about materials 3M is offering



Commercial Solutions Division

Hermeslaan 7

1831 Diegem, Belgium

Responsible for this technical bulletin

3M Deutschland GmbH | Safety & Graphics Laboratory

Carl-Schurz-Str. 1 | 41453 Neuss, Germany

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