



Graphic Protection Options

Overlaminates and Clears for All Imaging Methods

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1. Graphic Protection Options

Most options are approved for most digitally imaged or unprinted film. See the notes for additional uses and exceptions.

- a. Approved for selected screen print or electronically cut graphics.
- b. Not approved for digitally imaged film or with 3M™ Panagraphics™ Substrates

A. Standard Overlaminates

(1) High Gloss Overlamine

- 3M™ Scotchcal™ High Gloss Overlamine 639
- 3M™ Scotchcal™ High Gloss Overlamine 3648 ^a
- 3M™ Scotchcal™ High Gloss Graffiti-Resistant Overlamine 8912

(2) Gloss

- 3M™ Scotchcal™ Gloss Overlamine 3640GPS ^{a,b}
- 3M™ Scotchcal™ Gloss Overlamine 8508
- 3M™ Scotchcal™ Gloss Overlamine 8518
- 3M™ Scotchcal™ Gloss Overlamine 8528
- 3M™ Scotchcal™ Gloss Overlamine 8580
- 3M™ Scotchcal™ Optically Clear Overlamine 8914 ^a

(3) Luster

- 3M™ Scotchcal™ Luster Overlamine 3619 ^a
- 3M™ Scotchcal™ Luster Overlamine 3645 ^a
- 3M™ Scotchcal™ Luster Overlamine 8509
- 3M™ Scotchcal™ Luster Overlamine 8519
- 3M™ Scotchcal™ Luster Overlamine 8524
- 3M™ Scotchcal™ Luster Overlamine 8908

(4) Matte & Ultra-Matte

- 3M™ Scotchcal™ Matte Overlamine 3620 ^a
- 3M™ Scotchcal™ Matte Overlamine 3642GPS ^{a,b}
- 3M™ Scotchcal™ Matte Overlamine 3647 ^a
- 3M™ Scotchcal™ Matte Overlamine 8520
- 3M™ Scotchcal™ Matte Overlamine 8909
- 3M™ Scotchcal™ Ultra-Matte Overlamine 8915
- 3M™ Interior Matte Overlamine 8931

B. Graphic and Surface Protection Films

- Scotchgard™ Graphic and Surface Protection Film 8991
- Scotchgard™ Removable Graphic and Surface Protection Film 8991R

C. Screen Print Liquid Clears

(1) Gloss

Most options approved for most types of graphics, regardless of imaging platform

- 3M™ Screen Print Dirt Resistant Gloss Clear 1920DR
- 3M™ Scotchlite™ Screen Printing Gloss Clear 4430R
- 3M™ Screen Print Gloss Clear 9720UV
- 3M™ Screen Print Gloss Clear 9720i
- 3M™ Screen Print UV Gloss Clear 9800CL
- 3M™ Screen Print Clear VI0402

(2) Matte

- 3M™ Screen Print Matte Clear 1930
- 3M™ Screen Print Low Gloss Clear 9730UV

D. Digital Liquid Clears

- 3M™ Screen Print High Luster Protective Clear 8920 ES
- 3M™ Inkjet Protective Clear 8530

2. Health and Safety



CAUTION

When handling any chemical products, read the manufacturers' container labels and the Material Safety Data Sheets (MSDS) for important health, safety and environmental information. To obtain MSDS sheets for 3M products go to 3M.com/MSDS, or by mail or in case of an emergency, call 1-800-364-3577 or 1-651-737-6501.

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

A. Air Quality Regulations

State Volatile Organic Compound (VOC) regulations may prohibit the use of certain cleaning chemicals with VOC's in graphic arts coatings and printing operations. For example, the California South Coast Air Quality Management District prohibits use of certain solvent-based solutions without a permit and other California AQMD's prohibit use of certain solutions without a permit or a regulatory exemption. Check with your State environmental authorities to determine whether use of this solution may be restricted or prohibited.

3. Warranty Information

All graphic protection options are covered by the 3M Basic Warranty.

A warranted durability period may be offered based on the graphic construction. Always refer to the Product Bulletin for the 3M base film or flexible substrate you are using to determine if the graphic protection option you want to use is recommended and what, if any, warranted durability period is offered. The only exception is for Scotchgard™ Graphic and Surface Protection Film 8991 and 8991R, which have warranted durability periods given in Product Bulletin 8991.

4. Product Applications, Descriptions and Limitations of Use

Product Number	Applications											Description	Limitations of Use		
	Fleet/Vehicle	Vehicle Wraps	Watercraft	Transit	Labels	Signage - Backlit	Signage - Backlit or Thermoformed	Signage - Non-backlit (Opaque)	Awning	Smooth Walls	Textured Walls and Surfaces			Windows and Glass	Floor or Sidewalk
A. Standard Overlamines															
639	■			■	■	■	■		■					Graffiti-resistant	Flat only; Not good for dry erase marker graffiti; not for plastics, glass, flexible substrates; Test and approve (no warranty) before using on solvent inkjet graphics, thoroughly dry to avoid outgassing and lifting issues
3619						■	■	■						Flexible, conformable, more durable	Not for plastics, glass or flexible substrates; Test and approve (no warranty) before using for solvent inkjet printed graphics, thoroughly dry to avoid outgassing and lifting issues
3620						■	■	■						Matte version of 3619	
3640GPS						■	■	■	■					Highest protection from UV fading, dirt, graffiti; easy clean; thermoformable on plastic substrates	Not for application to other 3M brand GPS films, digital films, Panagraphics III substrate or for graphics subjected to intentional or accidental abrasion
3642GPS						■	■	■	■					Matte version of 3640GPS	
3645													■	For floor and table and some vertical graphics; provides slip- and scuff-resistance Scrubable, waxable; see IB 5.19	Indoors only, has a warranted durability
3647													■	For sidewalk signs; provides slip-, scuff- and foot traffic-resistance Cut radii on sharp corners to help prevent premature lifting of applied graphics. Cut by hand, guillotine and cold steel rule die. Clean the graphics periodically for optimum skid resistance and appearance. See Instruction Bulletin 5.33.	No exposure to vehicle traffic, snowplows, snow shovels, heavy equipment; no warranted durability
3648													■	For floor graphics; provides slip-, scuff- and foot traffic-resistance Scrubable, waxable; see IB 5.19	Indoor only; no durability warranty
8508				■	■	■	■		■				■	For intermediate graphics Apply at room temperature. Cut by hand, or cold or hot steel rule die.	No durability warranty. Heat and tension cause curling Excessive stretching causes a white appearance
8509				■	■	■	■		■				■	Matte version of 8508	Not for use on applications that must be stretched during application Not for warranted graphics

Continued on the next page

Product Number	Applications										Description	Limitations of Use
	Fleet/Vehicle	Vehicle Wraps	Watercraft	Transit	Labels	Signage - Backlit	Signage - Backlit or Thermoformed	Signage - Non-backlit (Opaque)	Awning	Smooth Walls		

- All Products:
- Not for automotive OEM graphics.
 - Not for graphics subjected to gasoline vapors, spills, such as gas pumps, automobile fuel tank ports, or top-feeding petroleum tankers
 - Do not print on graphic protection

A. Standard Overlamines, continued

8518	■	■	■	■	■	■	■	■	■	■	■	■	Highly conformable, provides wet paint look; resists fuel vapors	
8519	■	■	■	■	■	■	■	■	■	■	■	■	Flexible and conformable; resists fuel vapors	
8520	■	■	■	■	■	■	■	■	■	■	■	■	Matte version of 8519	
8524												■	For textured surfaces; conformable with high heat	Use with film 8624 of IJ8624 only. See additional details in Section 9; no durability warranty
8528	■	■		■									Superior UV protection; longer term vertical durability; horizontal warranty	For inkjet printed vehicle wrap films IJ170Cv3, IJ180, IJ180C, IJ180Cv3, IJ680, IJ680CR
8580		■											Unrivaled conformability and lifting resistance Handles differently: very stretchy for excellent conformability over complex contours. Cold roll lamination methods are critical.	For inkjet printed film IJ380Cv3 and used only on vehicle wraps
8908	■			■				■		■		■	Non-vinyl: ecologically good choice. Ideal for films 3545C and IJ35E; specialty graphics	No application to vinyl film applied to fleet, truck or vehicle graphics, reflective graphic film
8909	■			■				■		■		■	Matte version of 8908	Use no application heat for premasked graphics
8912	■			■	■			■		■			Flexible, graffiti-resistant	Flat only; Not good for dry erase marker graffiti; not for plastics, glass, flexible substrates; Test and approve (no warranty) before using on solvent inkjet graphics, thoroughly dry to avoid outgassing and lifting issues
8914												■	Optically clear primarily for perforated window graphic film to protect and prevent moisture and contaminant collecting in film perforations, conformable	
8915	■	■	■	■		■		■		■			Ultra-matte finish reduces glare	
8931								■					High strength acrylic adhesive	For electrostatically printed graphics, Interior, flat surfaces only

Continued on the next page

Product Number	Applications										Description	Limitations of Use			
	Fleet/Vehicle	Vehicle Wraps	Watercraft	Transit	Labels	Signage - Backlit	Signage - Backlit or Thermoformed	Signage - Non-backlit (Opaque)	Awning	Smooth Walls			Textured Walls and Surfaces	Windows and Glass	Floor or Sidewalk
															All Products: <ul style="list-style-type: none"> • Not for automotive OEM graphics. • Not for graphics subjected to gasoline vapors, spills, such as gas pumps, automobile fuel tank ports, or top-feeding petroleum tankers • Do not print on graphic protection

B. Graphic and Surface Protection Film

8991	■			■	■		■		■				Extra thickness and special hardcoat provide superior substrate and surface protection from stains, abrasion, gouges, UV light, graffiti; easy to clean	Not for cut film applications, flexible substrates, gypsum wallboard, poor paint adhesion, graphics printed with solvent based inks, porous or unsealed surfaces. Not for vandalism or excessive product misuse that damages the substrate
8991R	■			■	■		■		■				Removable version of 8991 May be used on as glass for general protection	Not for gasoline vapors and spills that penetrate the edges of the film. 8991R is not removable from printed or unprinted graphic film

C. Screen Print Liquid Clears - (also Roller Coated)

1920DR	■	■	■	■	■	■	■	■	■	■	■	■	Gloss, with dirt resistance; Good choice for frequently washed vehicles	Not for thermoforming
1930	■	■	■	■	■	■	■	■	■	■	■	■	Matte	
VI0402	■				■								Gloss, gasoline resistance	
9720i	■	■	■	■	■	■	■	■	■	■	■	■	UV-cured gloss; Suitable for petroleum environments if staining is not a concern.	Not for thermoforming
9720UV	■	■	■	■	■	■	■	■	■	■	■	■	UV-cured, gloss	Not for thermoforming
9730UV	■	■	■	■	■	■	■	■	■	■	■	■	UV-cured, matte	
9800CL	■	■	■	■	■	■	■	■	■	■	■	■	UV-cured, gloss. Suitable for petroleum environments if staining is not a concern.	Use with ink series 9800 only. Not for graphics made of multiple layers of ink that must be stretched during installation.

D. Digital Liquid Clears

8920	■	■		■	■	■	■	■					Screen printed or roller coated on electrostatically imaged graphics, economical alternative to outdoor overlaminates	No exposure to gasoline spills, splashing, harsh cleaning chemicals or solvents No thermoforming
8530	■	■		■	■	■	■	■					Water-based clear, high luster gloss for inkjet printed graphics; apply with liquid laminator	Not for full bus wraps. No exposure to Isopropyl alcohol or harsh cleaning chemicals or solvents No thermoforming

5. Application Surfaces, Physical and Performance Characteristics

Number	Expected Performance Life <i>in years</i>	Application Surfaces						Physical Characteristics					Performance Characteristics <i>See Conversion Values, page 9.</i>	
		Flat	Flat with rivets	Corrugated	Simple Curves	Compound Curves	Deep Channels & Concave Surfaces	Flexible Substrates	Material	Cast or non-Cast	Mils	Gloss	Liner	Lamination Temperature A 50-100°F B 50-90°F C 60-100°F

A. Standard Overlamines

639	5	■						Polyester	n/a	1	High gloss	Kraft paper	A	D
3619	9	■						Vinyl	Cast	2	Luster	Kraft paper	A	D
3620	9	■						Vinyl	Cast	2	Matte	Kraft paper	A	D
3640GPS	9	■			■		■	PVDF	n/a	1	Gloss	Kraft paper	C	D
3642GPS	9	■			■		■	PVDF	n/a	1	Matte	Kraft paper	C	D
3645	2	■						Vinyl	Cast	8	Luster	Kraft paper	A	D
3647	2	■						Vinyl	Cast	19	Matte	Kraft paper	A	D
3648	0.25	■						Vinyl	Non-Cast	6	Gloss	Kraft paper	A	D
8508	3	■			■			Vinyl	Cast	2.5	Gloss	Kraft paper	A	D
8509	3	■			■			Vinyl	Non-Cast	3	Luster	Kraft paper	A	D
8518	3	■	■	■	■	■		Vinyl	Cast	2	Gloss	Polyester	A	D
8519	5	■	■	■	■	■	■	Vinyl	Cast	2	Luster	Kraft paper	A	D
8520	5	■	■	■	■	■	■	Vinyl	Cast	2	Matte	Kraft paper	A	D
8524	1	■			■			Plastic	n/a	2	Luster	Kraft paper	A	D
8528	5	■	■	■	■	■	■	Vinyl	Cast	2	Gloss	Kraft paper	A	D
8580	3	■	■	■	■	■	■	Vinyl	Cast	1	Gloss	Kraft paper	A	D
8908	1	■	■		■			Polyolefin	Non-Cast	2.5	Luster	Kraft paper	B	E
8909	1	■	■		■			Polyolefin	Non-Cast	2.5	Matte	Kraft paper	B	E
8912	5	■						Polyester	n/a	1	High gloss	Kraft paper	C	D
8914	3	■			■			Vinyl	Cast	1	Gloss	Polyester	A	D
8915	5	■	■	■	■	■		Vinyl	Cast	2	Ultra Matte	Kraft paper	C	D
8931	1	■						Polyester	Non-Cast	4	Matte	Kraft paper	B	E

B. Graphic and Surface Protection

8991	3	■			■			Polyester	n/a	4	High gloss	Polyester	C	D
8991R	3	■			■			Polyester	n/a	4	High gloss	Kraft Paper	C	D

C. Screen Print Clear Coats

Number	Application Surfaces						Physical Characteristics				
	Flat	Flat with rivets	Corrugated	Simple Curves	Compound Curves	Deep Channels & Concave Surfaces	Flexible Substrates	Face Finish	Solvent or UV	Recommended Coating Thickness	Typical Coverage per U.S. gallon <i>See Conversion Values, page 9.</i>
1920DR	■	■	■	■	■			Luster	Solvent	6 to 12 microns	2500 feet ²
1930	■	■	■	■	■			Matte	Solvent	6 to 12 microns	2500 feet ²
VI0402	■	■	■	■	■			Luster	Solvent	6 to 12 microns	2500-3000 feet ²
9720i	■	■	■	■	■			Luster	UV	6 to 12 microns	2500-3500 feet ²
9720UV	■	■	■	■	■			Luster	UV	6 to 12 microns	2500-3500 feet ²
9730UV	■	■	■	■	■			Matte	UV	6 to 12 microns	2500-3500 feet ²
9800CL	■	■	■	■	■		■	Luster	UV	6 to 12 microns	2500-3500 feet ²

Continued on the next page

Number	Application Surfaces							Physical Characteristics			
	Flat	Flat with rivets	Corrugated	Simple Curves	Compound Curves	Deep Channels & Concave Surfaces	Flexible Substrates	Face Finish	Solvent or UV	Recommended Coating Thickness	Typical Coverage per U.S. gallon <i>See Conversion Values, page 9.</i>

D. Digital Clear Coats

8920	■	■	■	■	■	■	■	High luster	Solvent	3 to 6 microns	1000 -1200 feet ²
8530	■	■	■	■	■	■	■	High luster	Water base	6 to 20 microns	800 feet ²

Additional Physical Characteristics, continued in Sections E, F, G.

Product

E. Flammability

3645

Average Critical Radiant Flux (W/cm): 1.09. Overlamine 3645 laminated to film series 162 has been tested to ASTM E 648, "Standard Test Method for Critical Radiant Flux of Floor-Covering Systems Using a Radiant Heat Energy Source." The results show that the composite meets the requirement of the National Fire Protection Association, Class I Interior Floor Finish as defined in NFPA 101, "Life Safety Code."

F. Chemical Resistance

8991, 8991R

See Product Bulletin 8991 for complete details on the unique uses and application methods for this product.

**9720i
9720UV
9800CL
VI0402**

- Resists gasoline spills

All Others (including clears above)

- Resists mild alkalis, mild acids and salt
- Excellent resistance to water
- Resists petroleum vapors

G. Skid Resistance for Floor or Sidewalk Sign Graphics

3645

UL 410 - Slip Resistance of Floor Surface Materials covers the testing of floor and finishing materials to determine if their minimum average and minimum individual static coefficients of friction (COF) meet or exceed the specified requirements with respect to slip resistance. The standard requires an average slip resistance characteristic of at least 0.50, which overlamine 3645 exceeds.

3647

Overlamine 3647 has been tested per ASTM E303, "Standard Test Method for Measuring Frictional Properties Using the British Pendulum Tester", and meets the requirements of the skid resistance values, or British Pendulum Number (BPN), as set forth in the proposed European norms prEN1341 and prEN1342 for pedestrian surfaces.
Dry Surface: BPN = 95; Wet Surface: BPN = 40.

6. Important Note for all Solvent Inkjet Printed Graphics!

Adequately Dry Graphics

Inadequate drying can result in graphic failure including curling, increased outgassing, increased shrinkage and adhesion failure, which are not covered under warranty.

Always build enough time into your process to ensure adequate drying of the graphic. Poorly dried film may become soft and stretchy, and the adhesive may become too aggressive. This can cause difficulty when applying an overlamine, rolling the graphic, and applying the film. See the ink's Instruction Bulletin for more details.

7. How to Apply Overlaminates

Product

3640GPS 3642GPS

Overlaminates 3640GPS or 3642GPS can be applied with a hand or power drive roll laminator.

For backlit applications, these overlaminates are commonly applied using the wet (detergent and water) application method. See Instruction Bulletin 5.7 for details.

All UV Inkjet Graphics (except 8580)

Using a hot roll laminator (set to 115°F maximum) and increasing roll pressure (100 p.s.i.) will reduce silvering. When applying the overlaminate in this manner, use the minimum amount of unwind tension on the overlaminate to reduce stretching during application.

Do not use this technique on overlaminate 8580.

All Others

All other overlaminates in this Bulletin must be applied with the cold roll methods. This is also referred to as squeeze roll or power drive roll. Use the minimum amount of pressure needed and unwind tension to obtain good results. This helps reduce the chance of the overlaminate tunneling as it is applied to the base film.

Also see *Unique Usage Details* in the following section.

Refer to 3M Instruction Bulletin 4.22 for cold roll lamination procedures.

8. Application Tape

All

May be used to add stiffness for easier application, hold cut graphics together while applying, or to protect graphics from scratching and other damage during application. May graphics with an overlaminate do not require application tape. See the Product Bulletin for the base film or flexible substrate you are using for additional recommendations

When winding processed graphics, do not wind too tightly or the film may block.

When finishing rivets, do not apply heat to the graphic until the premasking tape is removed and then heat only enough to soften the film; too much heat will cause the overlaminate to lose gloss. Excessive heat will cause the overlaminate to curl.

3645 3648

Overlaminates 3645 and 3648, when used as recommended, do not require a premasking or prespacing tape for application.

3647

Overlaminate 3647 does not generally require an application tape. For die cut, prespaced graphics, 3M™ Prespacing Tape SCPS 53-X may be used.

8518 8528

Some higher gloss overlaminates are more susceptible to scratching during application. Using an application tape protects against scratching but the adhesive may dull the gloss somewhat. When the graphic is not protected by an application tape, always use edge protection on the squeegee, such as a paper liner or soft PTFE tape.

8914

Do not use application tape for any graphics made with overlaminate 8914.

8908 8909

Overlaminates 8908 and 8909 generally do not need an application tape, although 3M™ Premasking Tape SCPM-3 may be used.

9. Unique Usage Details

8524

Overlaminate 8524 is designed for use only with 3M™ Scotchcal™ Graphic Film IJ8624 or 8624 for Textured Surfaces.

When applying the overlaminate, use the minimum amount of pressure needed and unwind tension to obtain good results. This helps reduce the chance of the overlaminate tunneling as it is applied to the base film. If tunneling does occur, it will disappear when the graphic is applied with heat and pressure to a textured surface.

Product

10. Maintenance and Cleaning

All Use a cleaner such as the kind used for high-quality painted surfaces. The cleaner must be wet, non-abrasive, without strong solvents or alcohol, and have a pH value between 3.0 and 11.0 (neither strongly acidic nor strongly alkaline). Also see Instruction Bulletin 6.5.

11. Shelf Life, Storage and Shipping of Films

Also see Instruction Bulletin 6.5

A. Shelf Life

8908
8909 **Total shelf life: 2 years** from the date of manufacture on the original box. Up to 2 years unprocessed, **OR** process within 1 years **and** then apply within 1 year of processing.

8931 **Total shelf life: 1 year** from the date on the original box

All Others **Total shelf life: 3 years** from the date of manufacture on the original box. Up to 3 years unprocessed, **OR** process within 2 years **and** then apply within 1 year of processing.

B. Storage Temperature

8509
8518
8912
8914
8915
639 40° to 86°F (4° to 30°C)

All Others 40° to 100°F (4° to 38°C)

C. Storage Conditions

- All**
- Out of sunlight
 - Clean dry area
 - Original container
 - Bring the film to print room temperature before using

D. Shipping Finished Graphics

8524
639 Flat and racked is preferred, or rolled printed-side-out on the largest core available (at least 6 inches/15 mm diameter). All graphics with reflective base films must use this large a core.

All Others Flat, or rolled printed-side-out on 5 inch (13 cm) or larger core. This helps prevent the liner and, if used, the application tape from popping off.

12. Conversion Values

Temperature	Length
50-100°F (10-38°C)	1000 -1200 feet ² (92-111 m ²)
50-90°F (10-32°C)	800 feet ² (75 m ²)
60-100°F (15-38°C)	2500 feet ² (232 m ²)
-65 – +225°F (-54 – +107°C)	2500-3000 feet ² (232-279 m ²)
-40 – +150°F (-40 – +66°C)	1200-1600 feet ² (92-149 m ²)
	750-800 feet ² (70-75 m ²)
	2500-3500 feet ² (232-325 m ²)

13. 3M Related Literature

Before starting any job, be sure you have the most current Product and Instruction Bulletins.

The information in 3M Product and Instruction Bulletins is subject to change. Current Bulletins are available at 3Mgraphics.com. The techniques described in these Bulletins are required when applying a 3M warranted graphic, but are also practical recommendations when using promotional materials for non-warranted graphics. Additional Bulletins may be needed as indicated in the 3M Related Literature section of other 3M components you use.

Bulletin types: PB = Product Bulletin; PB-IB = Product & Instruction Bulletin; IB = Instruction Bulletin

Subject	Type	Bulletin No.
Base Films and Substrates Please visit our website for the Product Bulletins: www.3Mgraphics.com		
Scotchgard™ Graphic and Surface Protection Film 8991 or 8991R	PB	8991
3M™ Screen Print Gloss Clear 1920DR, 1930 and V10402 - Applying screen printing clear 1920DR, 1930 and V10402	PB IB	1900 3.12
3M™ Screen Print UV Gloss Clear 9720i , 9720UV, 9730UV	PB-IB	Clears 9720
3M™ Screen Printing UV Ink Series 9800 - Screen printing with UV ink series 9800 - line color	PB IB	9800 3.20
3M™ Inkjet Protective Clear 8530	PB	8530
3M™ Screen Print Clear 8920 ES	PB-IB	8920
Cold roll lamination	IB	4.22
Application, wet method for translucent screen printed, thermal mass transfer and cut graphics	IB	5.7
Floor graphics	IB	5.19
Storage, handling, maintenance, removal	IB	6.5
Application and maintenance of sidewalk signs	IB	5.33
3M Graphics Market Center Warranty Brochure	go to www.3Mgraphics.com , Warranties	

3M, Scotchcal, Scotchgard and Scotchlite are trademarks of 3M Company.

14. Bulletin Change Summary

8518 is now approved and warranted for the 3M™ MCST™ Warranty and 3M Performance Guarantee. 8528 for use on films IJ170Cv3, IJ180, IJ180C, IJ180Cv3, IJ680, IJ680CR has been added. Gloss overlamine 8508 added for use on intermediate graphics. Reference to banner materials removed from 8908/8909 as 3M no longer sells such materials. Clear 2920DR removed; replaced directly by clear 1920DR with no change in performance or use. Recommended coating thickness for clears 1920DR, 1930 and V10402 has been changed from 6 microns minimum to 6 to 12 microns. Most Unique Usage details were added to description column of table in Section 5.



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