



# 76500 3M TT1 MC PET 25-310E-65WG

## Thermal Transfer Polyester Label Material

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### Product Data Sheet

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Issued : June 2004  
Supersedes : June 2003

#### Physical Properties

Not for specification purposes  
(Calipers are nominal values)

<b>Facestock</b>	31 micron Matte clear polyester
<b>Adhesive</b>	20 micron #310 E Acrylic
<b>Liner</b>	56 micron, 62 g/m <sup>2</sup> White Densified Glassine
<b>Shelf Life</b>	24 months from date of manufacture of product when properly stored between 22°C and 50% relative humidity.

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#### Features:

- Matte 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 is extremely resistant to degradation from scuffing, chemicals, moisture, and wide temperature fluctuations. The topcoat also provides improved ink anchorage for traditional forms of press printing.
- 310E is a firm adhesive, which resists oozing and provides high strength on a variety of surfaces including high surface energy (HSE) plastics and metals. It additionally has improved chemical and U.V resistance.
- 62 g/m<sup>2</sup> densified glassine liner assures consistent die cutting.
- UL and cUL approved (File Number MH18072)

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#### Application Ideas:

- Thermal Transfer Printable Overlaminates.
  - Protective overlaminates for label and nameplate graphics can be used on appliances, industrial equipment, tools etc.
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**Performance Characteristics**  
 Not for specification purposes

Adhesion	90°Peel Adhesion, Test procedure FTM 2			
	Initial (20 Minute Dwell/RT)		Ultimate Adhesion 72 Hours Dwell at Maximum UL Temperature rating	
	N/10mm	Oz/In	N/10mm	Oz/In
Aluminium	3.1	28	6.4	58
Stainless Steel	4.7	43	6.8	62
Phenolic	3.1	28	4.7	43
ABS	3.4	31	3.2	29
Polycarbonate	2.5	23	3.1	28
Polystyrene	3.7	34	4.5	41
Polypropylene	0.5	4.6	1.8	16
HD Polyethylene	1.8	16	3.2	29
LD Polyethylene	0.9	8.2	1.3	12
Powder Coating	3.7	34	6.4	31

Surface	Conditioned for 3 Days at - 40°C	
	90° Peel	
	N/10mm	Oz/In
Aluminium	2.8	25
Stainless Steel	5.9	54
Phenolic	4.0	36
ABS	4.6	42
Polycarbonate	3.3	42
Polystyrene	4.5	41
Polypropylene	1.1	10
HD Polyethylene	2.0	18
LD Polyethylene	1.3	12
Powder Coating	3.3	30

**Performance Characteristics Contd.**  
 Not for specification purposes

	<b>180°Peel Adhesion, Test procedure FTM 1</b>			
	<b>Initial (20 Minute Dwell/RT)</b>		<b>Ultimate Adhesion 72 Hours Dwell at Maximum UL Temperature rating</b>	
	<b>N/10mm</b>	<b>Oz/In</b>	<b>N/10mm</b>	<b>Oz/In</b>
<b>Aluminium</b>	4.2	38	6.7	61
<b>Stainless Steel</b>	4.5	41	8.7	80
<b>Phenolic</b>	4.8	44	8.7	80
<b>ABS</b>	5.2	47	6.0	55
<b>Polycarbonate</b>	5.1	46	4.2	38
<b>Polystyrene</b>	4.8	44	4.8	44
<b>Polypropylene</b>	0.4	3.6	3.1	28
<b>HD Polyethylene</b>	0.4	3.6	3.0	27
<b>LD Polyethylene</b>	0.4	3.6	0.8	7.5

	<b>Conditioned for 3 Days at - 40°C</b>	
<b>Surface</b>	<b>180° Peel (FTM 1)</b>	
	<b>N/10mm</b>	<b>Oz/In</b>
<b>Aluminium</b>	4.7	43
<b>Stainless Steel</b>	7.0	64
<b>Phenolic</b>	5.0	46
<b>ABS</b>	4.9	45
<b>Polycarbonate</b>	5.8	53
<b>Polystyrene</b>	4.8	44
<b>Polypropylene</b>	0.6	5.5
<b>HD Polyethylene</b>	0.4	3.6
<b>LD Polyethylene</b>	0.4	3.6

**Performance Characteristics Contd...**  
 Not for specification purposes

<b>Liner Release</b>	<b>FTM 3 180° Removal of Liner from Facestock</b>		
	<b>Rate of Removal</b>	<b>N/10mm</b>	<b>Gms/50mm Width</b>
	2.3 m / min	0.025	13

<b>Environmental Performance</b>	The properties defined are based on four hour immersions at room temperature 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 90° peel angle (FTM 2 at 305 mm/min).				
<b>Chemical Resistance</b>	<b>Adhesion to Stainless Steel</b>			<b>Appearance</b>	<b>Edge Penetration</b>
<b>Chemical</b>	<b>N/10mm</b>	<b>Oz/In</b>	<b>% Change</b>	<b>Visual</b>	<b>Millimetres</b>
Isopropyl Alcohol	5.4	49	90	No change	1
Detergent (1% Alconox®*)	5.5	51	104	No change	1
Engine Oil (10W30) @ 250°F (121°C)	5.7	52	106	No change	1
Water for 48 hours	5.7	52	106	No change	0
pH 4	5.8	53	107	No change	0
PH10	5.8	53	107	No change	0
Toluene	3.1	28	57	Topcoat Damaged	5.0
Acetone	3.0	27	56	Topcoat Damaged	6.0
Brake Fluid	5.3	48	98	Slight Damage	1
Gasoline	3.8	35	70	No change	5.0
Diesel Fuel	4.6	42	85	No change	0
Naphtha	3.2	29	59	No change	3.0
Hydraulic Fluid	5.6	51	103	No change	0

<b>Temperature Resistance</b>	149°C for 24 hours:	no significant visual change 0.7% MD shrinkage 0.9% CD shrinkage
	-40°C for 3 days:	no significant visual change
<b>Humidity Resistance</b>	24 hours at 38°C and 100% relative humidity	no significant changes in appearance or adhesion

## Agency Listing Information

### Thermal Transfer Printing:

UL and cUL approved with the following thermal transfer ribbons

Armor: AXR7+(indoor only for UL), AXR-8, AXR600  
Ricoh™: B110C, B110CX, B110CR, B120EC  
Sony™: TR4070, TR5070, TR4570  
Astromed: RY, R5(UL only)  
Kurz: 501  
limak SP-330 (indoor only for UL)  
Keymax Alpha

## Processing

### 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.

### Die Cutting:

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.

### Packaging:

Finished labels should be stored in plastic bags.

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## Special Considerations

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

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

For best bonding conditions, application surface should be at room temperature or higher. Low temperature surfaces, below 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.

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Values presented have been determined by standard test methods and are average values not to be used for specification purposes. Our recommendations on the use of our products are based on tests believed to be reliable but we would ask that you conduct your own tests to determine their suitability for your applications. This is because 3M cannot accept any responsibility or liability direct or consequential for loss or damage caused as a result of our recommendations.

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## Tapes & Adhesives Group

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3M United Kingdom PLC  
3M Centre, Cain Road,  
Bracknell, Berkshire,  
RG12 8HT

Product Information :  
Tel 0870 60 800 50  
Fax 0870 60 700 99

3M Ireland  
3M House, Adelphi Centre,  
Upper Georges Street,  
Dun Laoghaire, Co. Dublin,  
Ireland

Customer Service :  
Tel (01) 280 3555  
Fax (01) 280 3509