



# Thermal Transfer Polyester Label Material

7818

FOD# 1644

page 1 of 5

Technical Data

April 15, 1999

*Supersedes July 31, 1996*

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## Construction

(Calipers are nominal values.)

| Facestock                                     | Adhesive                            | Liner                                      |
|---|-------------------------------------|--|
| 3.3 mil (84 micron)<br>Matte silver polyester | 0.8 mil (20 micron)<br>#310 Acrylic | 3.2 mil (81 micron)<br>55# Densified kraft |

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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 resists degradation from scuffing, chemicals, moisture, and wide temperature fluctuations. The topcoat also provides improved ink anchorage for traditional forms of press printing.
- #310 adhesive is a firm adhesive which resists oozing and provides high strength on a variety of surfaces including high surface energy (HSE) plastics and metals.
- 55# densified kraft liner assures consistent die cutting.
- 3M™ Label Material 7818 is UL recognized (File MH16411) and CSA accepted (File 99316). See the UL and CSA listings for details.

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## Application Ideas

- Barcode labels and rating plates.
- Property identification and asset labeling.
- Warning, instruction, and service labels for durable goods.
- Nameplates for durable goods.
- Substitutes for stamped metal, riveted plates.

## Typical Physical Properties

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

Adhesion: 180° peel test procedure is ASTM D 3330.

90° peel test procedure is ASTM D 3330 modified for the angle change.

| Surface         | Initial<br>(10 Minute Dwell/RT) |          |          |          | Conditioned for 3 Days at Room<br>Temperature 72°F (22°C) |          |          |          |
|-----------------|---------------------------------|----------|----------|----------|---|----------|----------|----------|
|                 | 180° Peel                       |          | 90° Peel |          | 180° Peel   |          | 90° Peel |          |
|                 | Oz./In.                         | N/100 mm | Oz./In.  | N/100 mm | Oz./In.   | N/100 mm | Oz./In.  | N/100 mm |
| Stainless Steel | 43                              | 47       | 35       | 38       | 51  | 56       | 41       | 45       |
| Polycarbonate   | 47                              | 51       | 37       | 40       | 52  | 57       | 43       | 47       |
| Polypropylene   | 18                              | 20       | 16       | 18       | 18  | 20       | 24       | 26       |
| Glass           | 52                              | 57       | 34       | 37       | 68  | 74       | 47       | 51       |
| HD Polyethylene | 24                              | 26       | 16       | 18       | 33  | 36       | 20       | 22       |
| LD Polyethylene | 20                              | 22       | 12       | 13       | 32  | 35       | 22       | 24       |

| Surface         | Conditioned for 3 Days at<br>120°F (49°C) |          |          |          | Conditioned for 24 hours at 90°F<br>(32°C) at 90% Relative Humidity |          |          |          |
|-----------------|---|----------|----------|----------|---|----------|----------|----------|
|                 | 180° Peel                                 |          | 90° Peel |          | 180° Peel   |          | 90° Peel |          |
|                 | Oz./In.                                   | N/100 mm | Oz./In.  | N/100 mm | Oz./In.   | N/100 mm | Oz./In.  | N/100 mm |
| Stainless Steel | 60  | 66       | 46       | 50       | 74  | 81       | 46       | 50       |
| Polycarbonate   | 41  | 45       | 32       | 35       | 62  | 68       | 40       | 44       |
| Polypropylene   | 35  | 38       | 30       | 33       | 38  | 42       | 27       | 30       |
| Glass           | 68  | 74       | 42       | 46       | 66  | 72       | 32       | 35       |
| HD Polyethylene | 30  | 33       | 20       | 22       | 35  | 38       | 27       | 30       |
| LD Polyethylene | 5   | 4        | 8        | 9        | 20  | 22       | 24       | 26       |

Liner Release: 180° Removal of Liner from Facestock

| Rate of Removal   | Grams/Inch Width | N/100 mm |
|-------------------|------------------|----------|
| 90 inches/minute  | 11               | 0.42     |
| 300 inches/minute | 11               | 0.42     |

**Environmental Performance**

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.

**Chemical Resistance:**

| Chemical                           | Adhesion to Stainless Steel |          | Appearance               | Edge Penetration |
|------------------------------------|-----------------------------|----------|--------------------------|------------------|
|                                    | Oz./in.                     | N/100 mm | Visual                   | Millimeters      |
| Isopropyl Alcohol                  | 54                          | 59       | No change                | 1                |
| Detergent (1% Alconox®*)           | 66                          | 72       | No change                | 0                |
| Engine Oil (10W30) @ 250°F (121°C) | 70                          | 77       | No change                | 1.5              |
| Water for 48 hours                 | 72                          | 79       | No change                | 0                |
| pH 4                               | 70                          | 77       | No change                | 0                |
| pH 10                              | 66                          | 72       | No change                | 0                |
| 409®* Cleaning solution            | 65                          | 71       | No change                | 0                |
| Toluene                            | 29                          | 32       | Top coat damaged         | 6.3              |
| Acetone                            | 38                          | 42       | Top coat damaged or gone | 4.5              |
| Brake Fluid                        | 77                          | 84       | No change                | 0                |
| Gasoline                           | 32                          | 35       | No change                | 5.5              |
| Diesel Fuel                        | 55                          | 60       | No change                | 1                |
| Mineral Spirits                    | 48                          | 52       | No change                | 2.3              |
| Hydraulic Fluid                    | 58                          | 63       | No change                | 0                |

**Temperature Resistance:**

300°F (149°C) for 24 hours: no significant visual change  
 -40°F (-40°C) for 3 days: no significant visual change

**Humidity Resistance:**

24 hours at 100°F (38°C) and 100% relative humidity: no significant change in appearance or adhesion

**Accelerated Aging:**

ASTM D 3611: 96 hours at 150°F (65°C) and 80% relative humidity

|   | Rate of Removal  | Grams/In. Width | N/100 mm |
|---|------------------|-----------------|----------|
| 180° Removal of Liner from Facestock    | 90 inches/minute | 10              | 0.39     |
|   | Rate of Removal  | Oz./In. Width   | N/100 mm |
| 180° Peel Adhesion from Stainless Steel | 12 inches/minute | 49              | 54       |

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**Shelf Life** Two years from date of manufacture of product when properly stored at 72°F (22°C) and 50% relative humidity.

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**Agency Listing Information**

**Thermal Transfer Printing**

Printer: UL no longer requires evaluation and listing of specific printers.

\*Ink Ribbon/UL Recognized Components

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; GPR

ICS: ICS-CC-2000; ICS-CC-4099.1

Iimak™: SH-36; SP-330; PrimeMark

Intermec: 051864-3; 053258-2; 054048-4; 054195-2

Japan Pulp and Paper: JP Resin 1; JP Resin 2 Blue; JP Resin 2 Red;

JP Resin 2 Green

Kurz™: K501

Mid City Columbia™: CGL-80; CGL-80HE

Markem™: 716

NCR™: Matrix Resin; Matrix (suitable for indoor use only); PaceSetter;  
Promark II; Ultra V

Pelikan™: T016

Ricoh™: B110A; B110C; B110CS

Sato™: Premier 1

Sony™: 4050; 4051; 4070; 4072; 4075; 4085; 5070; Signature™ Series Resin;  
Signature™ Series Wax

UBI™: HR03; HR04

Zebra™: 5095; 5097; 5099; 5100; 5175; 5555

**Laser Toner Printing:**

UL recognized with the following printers and toners.

\* Toner and Printer/UL Recognized Components

Hitachi HMT 446 toner kit for producing finished printed labels with UL listed Synergystex CF-1000 laser printer

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**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. Refer to the Graphic Ink Selection Guide or call 3M Customer Service at 1-800-223-7427 for additional information.

**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 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.

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**Technical Information and Data**

The technical information and data, recommendations, and other statements provided are based on tests or experience which 3M believes to be reliable, but the accuracy or completeness of such information is not guaranteed.

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**Product Use**

Please remember that many factors can affect the use and performance of a 3M product in a particular application. The materials to be bonded with the product, the surface preparation of those materials, the product selected for use, the conditions in which the product is used, and the time and environmental conditions in which the product is expected to perform are among the many factors that can affect the use and performance of a 3M product. Given the variety of factors that can affect the use and performance of a 3M product, some of which are uniquely within the user's knowledge and control, it is essential that the user evaluate the 3M product to determine whether it is fit for a particular purpose and suitable for the user's method of application.

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**Warranty and Limited Remedy**

The 3M product will be free from defects in material and manufacture for a period of one (1) year from the date of manufacture. 3M MAKES NO OTHER WARRANTIES OR CONDITIONS, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE OR ANY IMPLIED WARRANTY ARISING OUT OF A COURSE OF DEALING, CUSTOM, OR USAGE OF TRADE. User is responsible for determining whether the 3M product is fit for a particular purpose and suitable for user's method of application. If the 3M product is defective within the warranty period stated above, your exclusive remedy and 3M's sole obligation shall be, at 3M's option, to replace or repair the 3M product or refund the purchase price of the 3M product.

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**Limitation of Liability**

Except where prohibited by law, 3M will not be liable for any loss or damage arising from the 3M product, whether direct, indirect, special, incidental, or consequential, regardless of the legal theory asserted, including contract, warranty, negligence, or strict liability.

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