



# Label Material 7868

## Thermal Transfer Polyester Label Material

---

### Product Data Sheet

---

Updated : May 2000

Supersedes : June 1999

---

#### Physical Properties

Not for specification purposes  
(Calipers are nominal values)

<b>Facestock</b>	51 micron (2.0 thou) Gloss Radiant White Polyester
<b>Adhesive</b>	28 micron (1.1 thou) #350 Acrylic
<b>Liner</b>	81 micron (3.2 thou), 90 g/m <sup>2</sup> 55# Densified Kraft
<b>Shelf Life</b>	24 months from date of manufacture of product when properly stored between 22°C and 50% relative humidity.

---

#### Features:

- Facestock is topcoated for thermal transfer printing. Resin ribbons are recommended for optimum durability. The topcoat also provides improved ink anchorage for traditional forms of press printing.
- #350 adhesive is 3M's most universal adhesive for label materials. It can permanently bond to high surface energy (HSE) and low surface energy (LSE) plastics, textured and contoured surfaces, powder coatings, and slightly oily metals. It has excellent chemical resistance and holding strength even at high temperatures.
- 55# densified kraft liner assures consistent die cutting.
- 3M™ Label Material 7868 is UL recognised (File MH16411) and CSA accepted (File 99316). See the UL and CSA listings for details.
- UL listing includes approval for use on powder coated surfaces.

---

#### Application Ideas:

- Barcode labels and rating plates.
- Property identification and asset labelling.
- Warning, instruction, and service labels for durable goods.
- Nameplates for durable goods.

Date : May 2000  
 Label Material 7868  
 Thermal Transfer Polyester  
 Label Material

**Performance Characteristics**  
 Not for specification purposes

Surface	Initial (10 Minute Dwell/RT)			
	180° Peel		90° Peel	
	N/10mm	Oz/In	N/10mm	Oz/In
Adhesion	180° peel test procedure is ASTM D 3330 90° peel test procedure is ASTM D 3330 modified for the angle change			
Stainless Steel	7.9	72	5.1	47
Polycarbonate	7.7	70	5.0	46
Polypropylene	4.5	41	1.3	12
Glass	8.2	75	6.7	61
HD Polyethylene	4.0	37	1.4	13
LD Polyethylene	3.8	35	2.4	22
Smooth Powder Coating	7.1	65		
Finely Textured Powder Coating	3.8	35		

Surface	Conditioned for 3 Days at Room Temperature 22°C			
	180° Peel		90° Peel	
	N/10mm	Oz/In	N/10mm	Oz/In
Stainless Steel	9.1	83	8.0	73
Polycarbonate	8.2	75	5.7	52
Polypropylene	5.5	50	2.2	20
Glass	8.8	80	7.6	69
HD Polyethylene	4.4	40	2.1	19
LD Polyethylene	3.8	35	3.4	31
Smooth Powder Coating	7.2	66		
Finely Textured Powder Coating	3.9	36		

Surface	Conditioned for 3 Days at 49°C			
	180° Peel		90° Peel	
	N/10mm	Oz/In	N/10mm	Oz/In
Stainless Steel	9.6	88	9.1	83
Polycarbonate	5.9	54	2.7	25
Polypropylene	5.5	50	2.4	22
Glass	9.2	84	8.1	74
HD Polyethylene	4.3	39	2.4	22
LD Polyethylene	1.2	11	1.2	11
Smooth Powder Coating	7.8	71		
Finely Textured Powder Coating	3.7	34		

Date : May 2000  
 Label Material 7868  
 Thermal Transfer Polyester  
 Label Material

Surface	Conditioned for 24 hours at 32°C At 90% Relative Humidity			
	180° Peel		90° Peel	
	N/10mm	Oz/In	N/10mm	Oz/In
<b>Stainless Steel</b>	10.1	92	8.9	81
<b>Polycarbonate</b>	5.8	53	3.4	31
<b>Polypropylene</b>	3.9	36	2.7	25
<b>Glass</b>	8.9	81	7.4	68
<b>HD Polyethylene</b>	4.3	39	2.8	26
<b>LD Polyethylene</b>	2.7	25	3.6	33
<b>Smooth Powder Coating</b>	7.0	64		
<b>Finely Textured Powder Coating</b>	3.7	34		

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

Liner Release	180° Removal of Liner from Facestock		
	Rate of Removal	N/10mm	Gms/25mm Width
	2.3 m / min	0.062	16
7.6 m / min	0.085	22	

Environmental Performance	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 180° peel angle (ASTM D3330) at 305 mm/min.			
Chemical Resistance	Adhesion to Stainless Steel		Appearance	Edge Penetration
Chemical	N/10mm	Oz/In	Visual	Millimetres
<b>Isopropyl Alcohol</b>	7.8	71	No change	0.5
<b>Detergent (1% Alconox®*)</b>	9.0	82	No change	1.6
<b>Engine Oil (10W30) @ 250°F (121°C)</b>	9.0	82	No change	1.4
<b>Water for 48 hours</b>	9.1	83	No change	1.2
<b>pH 4</b>	8.4	77	No change	5.0
<b>PH10</b>	8.4	77	No change	5.0
<b>409<sup>®</sup>* Cleaning solution</b>	9.2	84	No change	3.0
<b>Toluene</b>	4.2	38	No change	5.0
<b>Acetone</b>	5.8	53	No change	5.0
<b>Brake Fluid</b>	10.2	93	No change	0.6
<b>Gasoline</b>	5.2	48	No change	5.0
<b>Diesel Fuel</b>	8.8	80	No change	1.0
<b>Mineral Spirits</b>	7.6	69	No change	3.0
<b>Hydraulic Fluid</b>	9.6	88	No change	0.0

Date : May 2000  
 Label Material 7868  
 Thermal Transfer Polyester  
 Label Material

<b>Temperature Resistance</b>	149°C for 24 hours:	no significant visual change 0.4% MD shrinkage 0.6% 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

<b>Accelerated Ageing</b> ASTM D3611 : 96 hours at 65°C & 80% relative humidity			
	<b>Rate of Removal</b>	<b>N/10mm</b>	<b>Oz / Inch Width</b>
180° Peel Adhesion from Stainless Steel	305 mm / minute	8.3	76
180° Liner Peel from Facestock	Rate of Removal 2.3m / minute	N/10mm 0.046	Grams / 25mm 12

## 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.

## Agency Listing Information

### Thermal Transfer Printing:

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

\*Ink Ribbon/UL Recognised 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; GRP

ICS: ICS-CC-2000; ICS-4099.1

limak™: 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 suitable for indoor use only); JP Resin 2 Green (suitable for indoor use only)

Kurz™: K501

Markem™: 716 (suitable for indoor use only)

Mid City Columbia™: CGL-80; CGL-80HE

NCR™: Matrix Resin; Matrix (suitable for indoor use only); Pace Setter;

Promark II; Ultra V

Pelikan™: T016

Ricoh™: B110A, B110C, B110CX

Sato™: Premier 1

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

UBI™: HR03; HR04

Zebra™: 5095, 5097, 5099, 5100, 5175

Date : May 2000  
Label Material 7868  
Thermal Transfer Polyester  
Label Material

---

**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 pressure with the substrate. Higher initial bonds can be achieved through increased rubdown pressure.

3M is a trademark of the 3M Company.

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.

**3M**

**Tapes & Adhesives Group**

© 3M United Kingdom PLC 2000

3M United Kingdom PLC  
3M House, PO Box 1,  
Market Place,  
Bracknell, Berkshire,  
RG12 1JU

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