



GRAPHICS MEDIA

PRODUCT DATA SHEET

Product Code: 180MC

Issued September 2017

3M™ Controltac™ Graphic Film

Product Bulletin 180mC

Revision C, January 2017 (Replaces B, Nov '16)

with Comply™ Adhesive Series 180mC

Product Description

- 2-mil cast, vinyl film

Product Features

- Excellent hiding power
- Pressure-activated adhesive for easy sliding, tacking, snap-up and repositioning
- Features non-visible air release channels for fast and easy, bubble-free graphic installations
- Conforms to flat surfaces, with and without rivets, simple curves, compound curves and corrugations
- Expected Performance Life of 10 years (unwarranted period for unprinted film with no graphic protection, applied to a flat, vertical, outdoor surface)

Recommended Types of Graphics and End Uses

See 3Mgraphics.com/warranties for a complete list of compatible products that are approved by 3M for use with the base film covered in this Bulletin and used for the creation of a graphic that may be eligible for the 3M™ MCS™ Warranty.

- Indoor and outdoor graphics and signs, including point-of-purchase and displays
- Commercial vehicles, straight trucks, semi-trucks and semi-trailers, emblems or striping
- Bus graphics
- Rail car graphics
- Transparent film color 114 can be used for two-way emblems for windows, except on buses or other vehicles
- Small format original equipment manufacturer's (OEM) decorative and identification graphics, cautionary and safety labeling

Recommended Compatible Products

See 3Mgraphics.com/warranties for a complete list of compatible products that are approved by 3M for use with the base film covered in this Bulletin and used for the creation of a graphic that may be eligible for the 3M™ MCS™ Warranty.

Screen Printing Inks for 3M™ MCS™ Warranty

- [3M™ Screen Printing Ink Series 1900 \(Solvent\)](#), line color and four color
- [3M™ Screen Printing UV Ink Series 9800](#), line color and four color
- Sericol™ Duracal™ UV Screen Print Ink* (approved for OEM applications only)
- Sericol™ Duracal™ Screen Print Clear* (approved for OEM applications only)

* To identify a Sericol inks distributor, contact FUJIFILM North America Corporation, Graphic 1101 W. Cambridge Drive, Kansas City, KS 66103; Tel: 1-800-255-4562 or 913-342-4060.

Graphic Protection

- [3M™ Screen Print Gloss Clear 1920DR](#)
- [3M™ Screen Print Matte Clear 1930](#)
- [3M™ Screen Print UV Gloss Clear 9800CL](#)
- [3M™ Screen Print Matte Clear 9730UV](#)
- [3M™ Screen Print UV Gloss Clear 9740i](#)
- [3M™ Wrap Overlaminate Series 8900](#)

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Quick Links

- [3M Graphics Warranties](#)
- [Technical Information Selector](#)
- [Safety Data Sheets \(SDS\)](#)
- [Flammability \(ASTM E84 Reports\)](#)
- [Videos](#)

Some of these links lead to web-based resources that are not product-specific.

3M™ Controltac™ Graphic Film

Application Tapes

See [3M Instruction Bulletin AT-1](#) to determine what application tape is recommend for your film or finished graphic.

Other Products

- [3M™ Edge Sealer 3950](#)
- [3M™ Edge Sealer Tape 8914](#)

Characteristics

These are typical values for unprocessed product. Processing may change the values.

Physical Characteristics

Characteristic	Value
Material	Cast vinyl
Film Color	See "Colors" on page 3
Thickness	Without adhesive: 2 mil (0.05 mm) With adhesive: 3 – 4 mils (0.08 – 0.10 mm)
Adhesive	Pressure-activated (slide, tack, snap-up, reposition) with air release channels
Adhesive Color	Gray or clear, see "Colors" on page 3
Liner	Polyethylene-coated paper
Adhesion, Typical 24 hours after application	<div> <div> ABS Acrylic enamel Aluminum, anodized Aluminum, etched Chrome Fruehauf pre-painted panels cm) </div> <div> 4-5 pounds/inch (0.72-0.89 kg/cm) 3-4 pounds/inch (0.54-0.72 kg/cm) 7-8 pounds/inch (1.26-1.43 kg/cm) 5-6 pounds/inch (0.89-1.08 kg/cm) 4-5 pounds/inch (0.72-0.89 kg/cm) 3-5 pounds/inch (0.54-0.89 kg/cm) </div> </div>
Tensile Strength	5 pounds/inch at 73 °F (0.9 kg/cm at 23 °C)
Chemical Resistance	<ul style="list-style-type: none"> • Resists mild alkalis, mild acids, and salt • Excellent resistance to water (does not include immersion) • Resists occasional fuel spills
Flammability	ASTM E84 test report: go to the On-line Catalog at 3Mgraphics.com All available test reports: call 1-800-328-3908

Application Characteristics

Characteristic	Value
Finished Graphic Application Recommendation	Surface type: Flat, with and without rivets, simple curves, compound curves, and corrugations Substrate type: ABS resins, aluminum, chrome, glass, fiber-glass reinforced plastics, paint (check adhesion to powder-coated or water-based paints) Application method: Dry Application temperature: (air and substrate) <ul style="list-style-type: none"> • Flat without rivets: 50–100 °F (10–38 °C) • Curves or corrugations with rivets: 50–100 °F (10–38 °C) • Compound curves: 60–90 °F (16–32 °C)
Applied Shrinkage	0.015 inches (0.4 mm)

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Characteristic	Value
Temperature Range After Application	-65 to +225 °F (-60 to +107 °C) (not for extended periods of time at the extremes)
Graphic Removal	Removable with heat and/or chemicals from most substrates within the Warranty Period at 50 °F (10 °C) minimum (air and substrate)

Colors

Solid Colors			Metallic and Transparent
10 White ³	53 Cardinal Red ³	101 Nimbus Gray ¹	201 Slate ¹
11 Pearl gray ¹	54 Light Orange	103 Magenta ¹	211 Charcoal ¹
12 Black ³	56 Dark Green	105 Harvest Gold ¹	217 Dark Blue ¹
13 Tomato Red ³	57 Olympic Blue ³	107 Light Blue ¹	227 Bright Blue ¹
14 Bright Orange	58 Burgundy ¹	117 Persian Blue	229 Copper ¹
15 Bright Yellow ^{1, 2, 3}	59 Putty ¹	120 Satin Aluminum ³	239 Chocolate Brown ¹
16 Khaki Green	61 Mid Gray	121 Light Gray	241 Gold ¹
17 Vivid Blue	63 Geranium ¹	127 Boat Blue	243 Steampunk Red
19 Deep Mahogany Brown	64 Apricot ¹	131 Satin Gold ¹	247 Petroleum Blue ¹
20 Matte White ^{1, 2}	65 Light Lemon Yellow ¹	136 Lime Green ¹	249 Champagne
22 Matte Black ¹	66 Forest Green ¹	151 Traffic Gray ^{1, 3}	114 Transparent ^{1, 2, 3}
23 Deep Red	69 Duranodic ¹	177 Shadow Blue ¹	
24 Terra Cotta ¹	74 Red Orange ¹	186 Bright Green ^{1, 3}	
25 Sunflower ^{1, 2}	77 Peacock Blue	187 Wedgewood Blue ¹	
27 Indigo (Navy)	78 Plum ¹	196 Apple Green ¹	
29 Russet Brown	81 Stone Gray	197 Light Navy ¹	
31 Medium Gray ¹	86 Robin Egg Blue ¹	263 Perfect match Red	
37 Sapphire Blue ³	89 Sandstone ¹	273 Process Magenta ²	
38 Royal Purple ¹	90 Antique White	276 Bottle Green ¹	
39 Tan	91 Dove gray ¹	293 Atomic Red ^{1, 2}	
41 Dark Gray ¹	93 Imperial Red	307 Dark Aqua ¹	
46 Kelly Green	96 Teal ¹	357 Bermuda Blue ¹	
47 Intense Blue	97 Soft Blue	397 Dark Blue ¹	
48 Purple ¹	98 Dark Violet ¹		
49 Beige	99 Fawn ¹		

1. Indicates clear adhesive; all other adhesive is gray-pigmented

2. Indicates minimal or no hiding power

3. Indicates 60" wide material

3M™ Controltac™ Graphic Film

Warranty Information

IMPORTANT NOTE

Warranty information including limitations and exceptions and warranty periods for this product can be found at 3MGraphics.com/warranties.

Warranty Coverage Overview

The warranty coverage for eligible graphics is based on the user both reading and following all applicable and current 3M Graphics Product and Instruction Bulletins. The warranty period for eligible graphics is as stated in the 3M Graphics Warranties Matrices at the time that the film was purchased. Information found at 3MGraphics.com/warranties includes:

- [3M Graphics Warranties Bulletin](#)
 - This bulletin contains information on limitations and exceptions, and warranty period reductions for 3M Graphics Warranties. The warranty period may be reduced and stipulations may apply for certain constructions, applications, and graphic exposures as covered in this Bulletin.
- [3M Graphics Warranties Selector](#)
 - Use this selector to search for your vertical warranty period by product type, ink type, film name, and/or ink/printer platform.
- [U.S. Desert Southwest Region Map](#)
 - Use this map of hot, arid desert areas to determine if you are subject to reduced warranted durabilities.

The warranties set forth in this Bulletin are made in lieu of all other express or implied warranties, including any implied warranty of merchantability, fitness for a particular purpose, or arising out of a course of dealing, custom, or usage of trade.

3M Basic Product Warranty

3M Graphics Products are warranted to be free of defects in materials and manufacture at the time of shipment and to meet the specifications stated in its applicable 3M Graphics Product Bulletin and as further set forth in the [3M Graphics Warranties Bulletin](#).

Limited Remedy

The limited remedy applicable to each warranty is addressed in the 3M Graphics Warranties Bulletin found at 3MGraphics.com/warranties.

Limitation of Liability

Except to the extent prohibited by law, 3M SHALL NOT UNDER ANY CIRCUMSTANCES BE LIABLE TO PURCHASER OR USER FOR ANY DIRECT (EXCEPT FOR THE LIMITED REMEDY PROVIDED HEREIN), INDIRECT, SPECIAL, INCIDENTAL, OR CONSEQUENTIAL DAMAGES (INCLUDING, BUT NOT LIMITED TO, LABOR, NON-3M MATERIAL CHARGES, LOSS OF PROFITS, REVENUE, BUSINESS, OPPORTUNITY, OR GOODWILL) RESULTING FROM OR IN ANY WAY RELATED TO 3M'S GRAPHICS PRODUCTS, SERVICES, OR THIS BULLETIN. This limitation of liability applies regardless of the legal or equitable theory under which such losses or damages are sought.

3M™ Controltac™ Graphic Film

Warranty Period Matrices (Film Colors 10^{1,2}, 12², 13¹, 14¹, 15¹, 19, 20, 22, 23, 27, 29, 31, 38, 39, 41, 49, 58, 63, 96, 98, 103, 186, 196, 307)

Table A. Warranty Period for Finished Graphics in a Standard U.S. Vertical Exposure.

Graphic Protection	No Printing				SOLVENT Ink Series 1900				UV Ink Series 9800				UV Ink Series 9800 Metallic			
	VEH	RAIL	OUT /IN	OEM	VEH	RAIL	OUT /IN	OEM	VEH	RAIL	OUT /IN	OEM	VEH	RAIL	OUT /IN	OEM
1920DR air dry	—	—	—	—	5	5 ¹	5	5	—	—	—	—	—	—	—	—
1920DR oven dry	—	—	—	—	6 ³	6 ^{1,3}	5 ³	5 ³	—	—	—	—	—	—	—	—
1930	—	—	—	—	2	2 ¹	2	2	—	—	—	—	—	—	—	—
9740i	—	—	—	—	6	6 ¹	5	5	7	7 ¹	5	5	5	—	5	5
9730UV	—	—	—	—	3	3 ¹	3	3	3	3 ¹	3	3	—	—	—	—
9800CL	—	—	—	—	—	—	—	—	5	5 ¹	5	5	5	—	5	5
8900	3/1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
None	7, LT	8	6	5	—	—	—	—	—	—	2	—	—	—	—	—

Warranty Period Matrices (Film Colors 11, 16, 17, 24, 25, 37, 46, 47, 48, 53, 54, 56, 57, 59, 61, 64, 65, 66, 69, 74, 77, 78, 81, 86, 89, 90, 91, 93, 97, 99, 101, 105, 107, 117, 121, 127, 136, 151, 177, 187, 197, 263, 273, 276, 293, 357, 397)

Table B. Warranty Period for Finished Graphics in a Standard U.S. Vertical Exposure.

Graphic Protection	No Printing				SOLVENT Ink Series 1900				UV Ink Series 9800				UV Ink Series 9800 Metallic			
	VEH	RAIL	OUT /IN	OEM	VEH	RAIL	OUT /IN	OEM	VEH	RAIL	OUT /IN	OEM	VEH	RAIL	OUT /IN	OEM
1920DR air dry	—	—	—	—	5	5 ¹	5	5	—	—	—	—	—	—	—	—
1920DR oven dry	—	—	—	—	6 ³	6 ^{1,3}	5 ³	5 ³	—	—	—	—	—	—	—	—
1930	—	—	—	—	2	2 ¹	2	2	—	—	—	—	—	—	—	—
9740i	—	—	—	—	6	6 ¹	5	5	6	6 ¹	5	5	5	—	5	5
9730UV	—	—	—	—	3	3 ¹	3	3	3	3 ¹	3	3	—	—	—	—
9800CL	—	—	—	—	—	—	—	—	5	5 ¹	5	5	5	—	5	5
8900	3/1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
None	6, LT	6 ¹	6	5	—	—	—	—	—	—	2	—	—	—	—	—

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3M™ Controltac™ Graphic Film**Warranty Period Matrices (Film Colors 114, 120, 131, 201, 211, 217, 227, 229, 239, 241, 243, 247, 249)****Table C.** Warranty Period for Finished Graphics in a Standard U.S. Vertical Exposure.

	No Printing				SOLVENT Ink Series 1900				UV Ink Series 9800				UV Ink Series 9800 Metallic			
Graphic Protection	VEH	RAIL	OUT /IN	OEM	VEH	RAIL	OUT /IN	OEM	VEH	RAIL	OUT /IN	OEM	VEH	RAIL	OUT /IN	OEM
1920DR air dry	—	—	—	—	5	5 ¹	5	5	—	—	—	—	—	—	—	—
1920DR oven dry	—	—	—	—	6 ³	6 ^{1,3}	5 ³	5	—	—	—	—	—	—	—	—
1930	—	—	—	—	2	2 ¹	2	2	—	—	—	—	—	—	—	—
9740i	—	—	—	—	6	6 ¹	5	5	5	5 ¹	5	5	5	—	5	5
9730UV	—	—	—	—	3	3 ¹	3	3	3	3 ¹	3	3	—	—	—	—
9800CL	—	—	—	—	—	—	—	—	5	5 ¹	5	5	5	—	5	5
8900	3/1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
None	6	—	5	5	—	—	—	—	—	—	2	—	—	—	—	—

LT= Lifetime

1. Warranty for vertical railroad applications for colors 10, 12, 13, 14, 15, 23, and 53 only and printed with line color inks.

2. Warranty for vertical railroad applications, unprinted colors 10 and 12 have 2 additional years for legibility only.

3. Warranty requires oven drying the last color of ink series 1900 and screen print 1920DR for 2 hours at 150 °F (65 °C).

Warranty Period Using Sericol Inks

Application: OEM graphics only

Ink and Graphic Protection: Sericol Duracal UV Screen Print Ink and Clear

Warranty Period: 3 years in a vertical exposure

Finished Graphics Warranty for Straight Trucks, Semi-Tractors and Semi-Trailers

The following three provisions and remedies, apply only to straight-truck, semi-tractor, and semi-trailer finished graphics and are in addition to the terms of the 3M™ MCS™ Warranty for the vehicle constructions indicated in the tables above.

Lifetime Warranty

The Lifetime Warranty is extended to the original graphics purchaser who still owns the straight truck, semi-tractor or semi-trailer for which any claim is submitted. The additional Labor Reimbursement Remedy, described below, is a pro-rated material replacement and labor reimbursement.

U.S. Exposure		U.S. Desert Southwest Exposure		Percentage of Replacement/Reimbursement	
6 year, LT	7 year, LT	6 year, LT	7 year, LT	Material	Labor
Failure occurs during year:					
6	7	4	5	100%	100%
7	8	5	6	80%	50%
8	9	6	7	60%	25%
9	10	7	8	40%	10%
10	11	8	9	20%	0%
11	12	9	10	10%	0%
12-14	13-15	N/A	N/A	10%	0%

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Labor Reimbursement Remedy

3M will reimburse up to 100% of the labor costs for the removal, remanufacture and reapplication of a graphic for a straight truck, semi-tractor or semi-trailer only to the extent that 3M determines such amount is reasonable and necessary in the circumstances. This labor cost reimbursement will be determined by 3M on a case-by-case basis taking into account the expected amount of labor needed to make such repairs and other considerations.

Legibility Warranty - Only for Finished Graphics with Horizontal Exposure and Selected Constructions

Applications subjected to maximum sunlight and environmental conditions used on rooftops of straight trucks, semi-tractors and semi-trailers where identification from the air is needed are warranted for legibility only for the following constructions. The finished graphic will change color, lose gloss and chalk.

Film Colors: 10, 12, 13, 14, 15, 25, 53, 54		Horizontal Exposure	
Ink Series	Clear	U.S.	U.S. Desert Southwest
No printing	None	5	3
1900	1920DR, oven dry	5	3
9800	9740i	5	3

Reduced Warranty Period for Other Graphic Exposures

For other graphic exposures, determine the applicable reduced warranty period by multiplying the standard warranty period (in years) for your graphic construction as shown in the applicable warranty period tables by the percentage shown for the intended graphic exposure. See "Exposure Types" on page 3 of the 3M Graphics Warranties Bulletin for graphic exposure definitions.

Table D. Reduced Warranty Period for Other Graphic Exposures

If the Graphic Exposure is:	Use this Percentage of Vertical Exposure, Warranty Period	Calculation Examples
Desert Southwest Vertical	70%	0.7 x 7 years = 4.9 years
U.S. Horizontal (without Overlamine 8900 Series)	0%	0 x 4 years = 0 years
U.S. Horizontal (with Overlamine 8900 Series)	35% (0.35)	0.35 x 3 years = 1.05 years

Additional Limitations

See the 3M Graphics Warranties Bulletin at 3MGraphics.com/warranties, for terms, additional limitations of your warranty, if any, information on reduced warranties for different exposures, and limitations of liability.

Factors that Affect Graphic Performance Life

The actual performance life of a graphic is affected by:

- the combinations of graphics materials used.
- complete ink drying or curing.
- selection, condition and preparation of the substrate.
- surface texture.
- application methods.
- angle and direction of sun exposure.
- environmental conditions.
- cleaning or maintenance methods.

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Graphics Manufacturing



CAUTION

Before using any equipment, always read the manufacturer's instructions for safe operation.

Screen Printing

Formulations and processing conditions can affect ink durability. Refer to the Product and Instruction Bulletins for your ink for limitations and proper usage.

Whether you apply screen print clears with traditional screening methods or roller coating, use equipment designed to handle high viscosity materials and make sure the coating is evenly applied to the specifications in the clear's 3M Instruction Bulletin.

Cutting

See [3M Instruction Bulletin 4.1](#) for Sheeting, Scoring and Film Cutting details.

Graphic Protection

Graphic protection may improve the appearance, performance and durability of the graphic. Click on the graphic protection options listed in Product Bulletin or see the [3M Graphics Market Product Catalog](#), for more information.



IMPORTANT NOTE

During installation, scratches may occur on films without graphic protection.

Application Tapes

There are two types of application tapes. See [3M Instruction Bulletin AT-1](#) to determine what application tape is recommended for your film or finished graphic.

Premasking Tape

Increases stiffness during application while preventing stretching and damage. Use when little or no liner is exposed. See [3M Instruction Bulletin 4.3](#) for complete details.

Prespacing Tape

Holds cut and weeded letters or graphics in place during application and after removing the film liner, while preventing stretching and damage. Use when large amounts of liner are exposed. See [3M Instruction Bulletin 4.3](#) for complete details.

Application and Installation

In addition to other 3M Bulletins specified in this document, the following Bulletins provide details that you may need to successfully apply a graphic.

- [3M Instruction Bulletin 5.37](#) A Guide to Understanding and Applying Graphics to Common Smooth and Textured Wall Surfaces
- [3M Instruction Bulletin 5.4](#). Application, Fleet Trucks.
- [3M Instruction Bulletin 5.5](#) Application, General Procedures for Interior and Exterior Dry Application
- [3M Product and Instruction Bulletin V-Tools](#). 3M™ Vehicle Channel Applicator Tools.

3M™ Controltac™ Graphic Film

Pressure-activated Adhesive

The pressure activated adhesive on this film offers:

- smooth sliding into position on a substrate;
- fast finger tacking to check position; and
- easy snap-up and repositioning when you need it.

The **snap-up and reposition feature is lost:**

- when firm pressure with a squeegee or other application tool is applied.
- at application temperatures above 100° F (38° C) even if only light finger pressure was used for tacking.
- if any part of the film is removed from the original liner and reapplied to the same or another liner.
- solvent from inkjet ink has not completely dried or cured, which affects both slideability and snap-up.

Working with Non-Visible Air Release Channels

Air release channels are a characteristic of films with Comply™ adhesive that allow trapped air to exit through the edges of the graphic.

- The channels will be damaged and effective air removal affected if you remove and attempt to change liners or reapply the same liner.
- For the best results, always work from the center out to the edges of the graphic to allow trapped air to exit through the air release channels. If the channels are closed off by firm pressure and air is trapped, use an air release tool to aid in removing air bubbles. See [3M Instruction Bulletin 5.4](#) for details.

3M™ Tape Primer 94

3M recommends that where the film will be stretched, particularly on the edges of the film, use primer to maximize a graphic's bond to its substrate.

Maintenance and Cleaning

Use a cleaner designed for high-quality painted surfaces. The cleaner must be wet, non-abrasive, without solvents, and have a pH value between 3 and 11 (neither strongly acidic nor strongly alkaline). See [3M Instruction Bulletin 6.5](#) for details.

Removal

Removal requires heat and/or chemicals. The ease and rate of removal depends on a number of factors. See [3M Instruction Bulletin 6.5](#) for details.

Shelf Life, Storage and Shipping

Shelf Life

The shelf life is **never more than 3 years** from the date of manufacture on the original box.

If you process the film, the shelf life is changed to **1 year** from the processing date, but not later than the 3 year maximum from the manufacturing date.

Storage Conditions

- 40° to 100 °F (4° to 38 °C)
- Out of sunlight
- Clean, dry area
- Original container
- Bring the film to room temperature before use

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3M™ Controltac™ Graphic Film

Shipping Finished Graphics

Flat, or rolled printed side out on 6 inch (15 cm) or larger core. This helps prevent the application tape, if used, from popping off.

Health and Safety



CAUTION

When handling any chemical products, read the manufacturer's container labels and the Safety Data Sheets (SDS) for important health, safety and environmental information. To obtain SDS sheets for 3M products go to 3M.com/SDS, 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 manufacturer's instructions for safe operation.

Bulletin Change Summary

For the most current 3M Technical Information available to successfully use this product, please view this Bulletin electronically and click on the blue underlined links to view the relevant documents. Please read the entire Bulletin thoroughly.

Release C JAN-2017:

- Added information related to 8900 in warranty tables.

Release B AUG-2016:

- Add footnote to list 60" wide availability to "Colors" on page 3.

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