



# Velvet Lexan™ Overlaminating Film

## 7737FL • 7738FL

Technical Data

August, 2007

### Product Description

3M™ Overlaminating Films 7737FL and 7738FL utilize Velvet Lexan™ polycarbonate film to achieve a decorative velvet appearance. 3M™ Adhesive 400 offers excellent low temperature performance and long term aging for resistance to yellowing in outdoor applications.

### Construction

Product Number	Facestock	Adhesive	Liner
<b>3M overlaminating film 7737FL</b>	.003 in. Lexan™ matte velvet polycarbonate (76 micron)	#400 Acrylic 0.8 mil (20 micron)	.0015 in. Clear Polyester Liner (38 micron)
<b>3M overlaminating film 7738FL</b>	.005 in. Lexan™ matte velvet polycarbonate (127 micron)	#400 Acrylic 0.8 mil (20 micron)	.0015 in. Clear Polyester Liner (38 micron)

(Calipers are nominal values.)

### Features

- Velvet Lexan™ polycarbonate overlam offers the opportunity to achieve the attractive appearance of a subsurface screen printed Lexan™ nameplate with an economical overlamine construction which can create looks that are unique.
- Film liner offers superior graphic appearance when overlaminating metallized or darker surfaces.
- UL recognized (File MH11410) for overlamination of polyester labelstocks.
- CSA Accepted (File 99316) for overlamination of both polyester and vinyl labelstocks.

### Application Ideas

- Decorative, protective overlamine on pressure sensitive labels and tags
- Overlamine on appliques and decorative trim strips
- Economical method of achieving the look of a Lexan™ nameplate – recommend 3M printable polyesters as a basestock

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## 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.**

<b>Adhesive Coat Weight</b>	1.05 to 1.65 g/100 in. <sup>2</sup>	TM-2279
<b>Release Range</b>	5 to 55 g/2 in.	TLMI Method, 180° removal, 300 in./min.
<b>Service Temperature</b>	-40°F to 250°F (-40°C to 121°C)	
<b>Minimum Application Temperature</b>	10°F (-12°C)	
<b>Convertability</b>	Low temperature, high clarity 3M™ Acrylic Adhesive 400 is specifically designed to be compatible with a variety of print methods and overlamine applications. When converting labels for thermal transfer applications, care should be taken with regard to proper roll tensions, handling and storage conditions. Please refer to the die cutting/converting section of this data page or the "Guide to Converting and Handling Label Products" technical bulletin for additional information.	

## Typical Peel Adhesion Properties

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Peel test procedure is ASTM D-3330

	Initial (10 Minute Dwell/RT)	
	180° Peel	
Surface	oz/in	N/100 mm
Stainless Steel	38	42

## Environmental Performance

Samples were applied to stainless steel panels and allowed to dwell for 24 hours prior to exposures.

Liquid	Dwell Time/Exposure Condition	Results
Isopropyl Alcohol @ Room Temperature	4 hours	Good appearance – 1/16" edge penetration
5% Sulfuric Acid @ Room Temperature	4 hours	Good appearance – no edge penetration
Engine Oil @ 250°F (121°C)	4 hours	Good appearance – no edge penetration
Water @ Room Temperature	24 hours	Good appearance – no edge penetration

### Temperature Resistance:

-40°F (-40°C) to 250°F (121°C) for 1 day: no change

### Humidity Resistance:

1 day at 95°F (35°C) and 95% relative humidity: no change

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**Application Techniques** For maximum bond strength, the surface should be clean and dry. A typical cleaning solvent is heptane or isopropyl alcohol.\*

For best bonding conditions, application surfaces should be at room temperature or slightly higher. Low temperature surfaces, below 50°F (10°C), cause the adhesive to become firm and will not allow the adhesive to flow and develop intimate contact with the substrate.

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

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**Printing** This film is not treated for printability.

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**Storage** Store at room temperature conditions of 72°F (22°C) and 50% relative humidity.

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**Shelf Life** If stored under proper conditions, product retains its performance and properties for two years from date of manufacture.

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**Product Use** All statements, technical information and recommendations contained in this document are based upon tests or experience that 3M believes are reliable. However, many factors beyond 3M's control can affect the use and performance of a 3M product in a particular application, including the conditions under which the product is used and the time and environmental conditions in which the product is expected to perform. Since these factors 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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**ISO 9001:2000**

This Industrial Adhesives and Tapes Division product was manufactured under a 3M quality system registered to ISO 9001:2000 standards.



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