



Scotchlite™ Reflective Graphic Film

Series 680
680-10

for Screen Printing
for Electrostatic or Screen Printing

1. Product Description

A. Product Features and Advantages

- 7-mil, enclosed lens, retroreflective, engineer grade films that offer flexibility and versatility
- Available in 11 colors, including black (which reflects white)
- Similar daytime and nighttime appearance that retains most of its reflectivity when wet
- Excellent angularity
- Pressure-activated adhesive for easy sliding and tacking
- Permanent
- For vertical, flat, curved or corrugated surfaces, with or without rivets

B. Recommended Types of Graphics and End Uses

When constructed and used as described in this Bulletin, these types of graphics and end uses may be warranted by the [3M™ MCS™ Warranty](#). Please read the entire Bulletin for details.

- Vertical commercial vehicle, railcar and bus graphics
- Vertical non-regulated signs and striping
- Vertical indoor and outdoor signage

C. Performance Overview

3M tests the performance of both individual products and finished graphic constructions. This table shows the best performance expected from this product both without a Warranty Period and with a Warranty Period.

For detailed graphic construction and application options along with specific Warranty Periods, please see the Warranty Information, Section 5.

	Vehicle	Rail
Expected Performance Life. This is the estimated period of time the product should perform satisfactorily.		
Unprinted film with no graphic protection, applied to a flat vertical outdoor surface.	9 years Unwarranted Period	7 years Unwarranted Period
3M™ MCS™ Warranty. This is the maximum period of time 3M will warrant the finished graphic performance.		
Printed film with the best 3M ink and graphic protection option, applied to a flat, vertical, vehicle type surface.	7 years Warranty Period	5 years Warranty Period

D. Limitations of End Uses

This 3M product is not designed or recommended for the following uses. Please contact us to discuss other options.

(1) Unsuitable End Uses for This Film

- Do not apply this film on:
 - walls.
 - substrates with compound curves.
 - substrates without a clean, smooth surface or poor paint-to-substrate adhesion.
 - stainless steel.
 - unpainted metal other than aluminum: contact 3M Technical Service for details.
 - paint that is not fully cured.
 - FRP with a Tedlar® coating.
 - flexible substrates.
- Paint that is not thoroughly cured or dried. *Read the Important Note for **Substrate Consideration** on page 8!*
- Low surface energy substrates (some plastics, powder-coated paints, etc.)

2. Compatible Products

This section provides a list of 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 is covered by the 3M™ MCS™ Warranty or 3M Performance Guarantee. Refer to the Product and Instruction Bulletins listed in 3M Related Literature at the end of this Bulletin for more information about the compatible products.

See the **Warranty Information** section to determine which compatible products are approved for your graphic construction.

E. Screen Printing

- 3M™ Screen Printing Ink Series 1900
- 3M™ Screen Printing UV Ink Series 9800
- 3M™ Scotchlite™ Screen Printing Ink Series 2900

F. Electrostatic Printing

- Scotchprint® Toner Series 8700/8800
- 3M™ Trident Transfer Paper

G. Graphic Protection

- 3M™ Screen Print Gloss Clear 1920DR
- 3M™ Screen Print UV Gloss Clear 9740i
- 3M™ Scotchcal™ Luster Overlamine 8519
- 3M™ Screen Printing Gloss Clear 9800CL
- 3M™ High Gloss Graffiti Resistant Overlamine 8912 *not for use on rivets*

H. Other Products

- 3M™ Prespacing Tape SCPS-2
- 3M™ Prespacing Tape SCPM-53X
- 3M™ Premasking Tape SCPM-3
- 3M™ Premasking Tape SCPM-44X
- 3M™ Edge Sealer 3950

3. Characteristics

These are typical values for unprocessed product; processing may change the values. Contact your 3M representative for a custom specification.

A. Physical Characteristics

Characteristic	Value																																				
Material	Vinyl																																				
Thickness	With adhesive: 7 to 8 mils (0.18 to 0.20 mm)																																				
Film colors & typical retroreflection	<div>At -4° entrance angle and 0.2° observation angle.</div> <table><thead><tr><th>Film Number</th><th>Color Name</th><th>Typical Coefficient of Retroreflection</th></tr></thead><tbody><tr><td>680-10</td><td>White</td><td>100</td></tr><tr><td>680-14</td><td>Orange</td><td>20</td></tr><tr><td>680-64</td><td>Gold</td><td>70</td></tr><tr><td>680-71</td><td>Yellow</td><td>65</td></tr><tr><td>680-72</td><td>Red</td><td>20</td></tr><tr><td>680-75</td><td>Blue</td><td>10</td></tr><tr><td>680-76</td><td>Light blue</td><td>10</td></tr><tr><td>680-77</td><td>Green</td><td>20</td></tr><tr><td>680-81</td><td>Lemon yellow</td><td>75</td></tr><tr><td>680-82</td><td>Ruby red</td><td>15</td></tr><tr><td>680-85</td><td>Black</td><td>30</td></tr></tbody></table>	Film Number	Color Name	Typical Coefficient of Retroreflection	680-10	White	100	680-14	Orange	20	680-64	Gold	70	680-71	Yellow	65	680-72	Red	20	680-75	Blue	10	680-76	Light blue	10	680-77	Green	20	680-81	Lemon yellow	75	680-82	Ruby red	15	680-85	Black	30
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680-81	Lemon yellow	75																																			
680-82	Ruby red	15																																			
680-85	Black	30																																			
Retroreflection Definition	<div>The typical coefficient of retroreflection defined is measured at a -4° entrance angle and a 0.2° observation angle. It is expressed in candlepower per foot-candle per square foot (candela/lux/square meter) per ASTM E810.</div> <div>The entrance angle is formed by a light beam striking the surface at a point and a line that is perpendicular to the surface at the same point.</div> <div>An observation angle is formed by the light beam striking the reflective surface and returning to the observer. From 800 feet (249 meters), a motorist normally views a graphic at a 0.2° angle.</div>																																				
Adhesive type	Pressure-activated, slideable																																				
Adhesive color	Clear with silver underneath																																				
Liner	Polyethylene-coated paper																																				
Safety Standards	See Section 13 for ASTM, NFPA and AAR information.																																				
Chemical resistance	<ul style="list-style-type: none">Resists mild alkalis, mild acids, and saltExcellent resistance to rain (<i>not immersion</i>)Resists occasional fuel spills																																				
Flammability	Call 1-800-328-3908 for information																																				

B. Application Characteristics

Characteristic	Value
Finished graphic application recommendation	<p>Surface type: Flat, with or without rivets; moderate curves, corrugations</p> <p>Substrate type: Aluminum, FRP, paint</p> <p>Graphic orientation: Vertical only</p> <p>Application method: Dry</p> <p>Application temperature: <i>air and substrate</i></p> <ul style="list-style-type: none"> 50° – 100°F (10° – 38°C) flat surfaces without rivets 55° – 100°F (13° – 38°C) flat, curved or corrugated surfaces with rivets

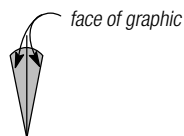
Continued on the next page.

Characteristic	Value
Adhesion 24 hours after application	Aluminum: 6.0 pounds/inch (1.1 kg/cm) FRP (Fiberglass Reinforced Plywood): 3.0 lb/inch (0.5 kg/cm) Painted aluminum panels: 4.5 pounds/inch (0.8 kg/cm)
Temperature range after application	-30° – +200°F (-34° – +93°C)

4. Definitions

A. Exposure

U.S. Vertical Exposure

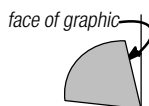


The face of the graphic is +/- 10° from vertical.

U.S. Desert Southwest Exposure

Any outdoor graphic exposed to solar energy more than half of the daylight hours in Arizona, New Mexico and the desert areas of California, Nevada, Utah and Texas is subject to reduced warranties. Click here for a [detailed map](#).

U.S. Non-vertical Exposure



For reflective films only: The face of the graphic is greater than 10° from vertical and greater than 45° from horizontal. This includes non-vertical surfaces of vehicle or fleet graphics.

B. Graphic Construction

The products used to make a graphic, which may include film and/or flexible substrate, graphic protection, ink, printer and application tape.

C. Graphic Protection

Overlamine films or clear coats used to protect the graphic and/or change gloss.

D. Graphic Types

As identified in Product Warranty Matrices

Indoor Signs

Stationary graphics applied indoors and *not* exposed to the elements.

Outdoor Signs

Stationary graphics applied outdoors and exposed to the elements.

OEM

Labels and decorative graphics produced for and used by original equipment manufacturers. May also be called decals.

Vehicle Types

Vehicle. Buses, vans, passenger vehicles, delivery trucks, pickup trucks, enclosed trailers.

Straight Trucks. Semi-Tractors and Semi-Trailers. Straight trucks, semi-tractors and semi-trailers used for commercial business purposes. Excludes air shields.

Rail. Rail cars and lead cars of trains, light rail and subways, but not locomotives or engines.

5. Warranty Information

A. Warranty Coverage Overview

The warranty coverage for each graphic is based on the user(s) both reading and following all applicable and current 3M Product and Instruction Bulletins. 3M will honor the Warranty Period stated in the base film's Product Bulletin that is current when the film was purchased. The Warranty Period may be reduced and stipulations may apply for certain constructions and applications, as covered in this Bulletin.

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

B. 3M Basic Product Warranty

This product is warranted to be free of defects in materials and manufacture at the time of shipment and to meet the specifications stated in this Product Bulletin and as further set forth in the [3M Commercial Graphics Warranty Brochure](#).

C. Limited Remedy

3M will replace or refund the price of any 3M materials that do not meet this warranty within the specified time periods. These remedies are exclusive.

D. Limitation of Liability

Except where prohibited by law, 3M SHALL NOT UNDER ANY CIRCUMSTANCES BE LIABLE TO PURCHASER OR USER FOR ANY DIRECT (EXCEPT FOR THE LIMITED REMEDY PROVIDED ABOVE), 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 SELLER'S 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 including breach of contract, breach of warranty, negligence, strict liability, or any other legal or equitable theory.

E. Additional Limitations

See the [3M Commercial Graphics Warranty Brochure](#) at 3Mgraphics.com, which gives the terms, additional limitations of the warranty, if any, and limitations of liability.

F. 3M™ MCS™ Warranty

Subject to Stipulations set forth in Section G.

Finished graphics constructed with the materials specified and the exposure specified in the Warranty Period, Section F.(1), are eligible for the 3M™ MCS™ Warranty. For warranties for other exposures, see Section G.(1).

(1) Warranty Period

for Finished Graphics
in a Standard U.S. Vertical
Exposure

VEH = Vehicles
RAIL = Rail Car and Lead Car Graphics
OUT = Indoor and Outdoor Signs
See Section 4.D. for further definition.

a. Screen Printing

Warranty Period for Vertical Finished Graphics, In Years

3M Ink	SOLVENT 3M Ink Series 2900					SOLVENT 3M Ink Series 1900			UV 3M Ink Series 9800				
	line color			4-color		line color			line color			4-color	
Graphic Protection	VEH	RAIL	OUT	VEH	OUT	VEH	RAIL	OUT	VEH	RAIL	OUT	VEH	OUT
1920DR	7	5	5	5	5	7	7	7	—	—	—	—	—
9740i	7	5	5	5	5	7	5	5	7	5	5	5	5
9800CL	—	—	—	—	—	—	—	—	5	5	5	5	5

b. Electrostatic Printing

Warranty Period for Vertical Finished Graphics, In Years

	3M Toner Series 8700	
Graphic Protection	VEH	OUT
8519	5	4
8912	5	4
1920DR	5	4

(2) Labor Reimbursement Remedy for Semi-Trucks, Semi-Tractors and Semi-Trailers

3M will reimburse up to 100% of the labor costs for the removal, remanufacture and reapplication of a graphic for *commercial semi-trucks, semi-tractors and semi-trailers (fleet vehicles) 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.

**G. General Warranty
Stipulations for 3M™
MCS™ Warranty**

These stipulations apply to the 3M™ MCS™ Warranty. General provisions for these stipulations are covered in the [3M Commercial Graphics Warranty Brochure](#).

**(1) Reduced Warranty Period for
Selected Graphic Exposures**

For each exposure shown below, multiply the Warranty Period (in years) in the applicable warranty, Section F.(1), for your graphic construction by the percentage shown for the intended graphic exposure. This is the reduced warranty.

If the Outdoor Graphic Exposure is:	Multiply Warranty Period by this Percentage:	Examples
Desert Southwest Vertical	70% (0.7)	0.7 x 7 years = 4.9 years
Non-vertical	0	0

**(2) Reduced Warranty Period for
Graphics Exposed to Heat**

Long exposure to continuous high heat decreases the Warranty Period of this film by 2 years. High heat is a temperature above 150°F (65°C). It may occur in areas such as railroad locomotives, vehicle engine compartments, non-insulated tankers exposed to frequent internal steam cleaning, or compartments that carry hot cargo.

(3) Application to Glass

3M accepts no liability for glass breakage when using this film for window graphics. See [Instruction Bulletin 5.1](#) for details.

(4) Application Outside the U.S.

Contact the 3M organization for that country.

**(5) Graphics Made with
Components Not Sold or
Recommended by 3M**

The 3M™ MCS™ Warranty does not cover finished graphics made with inks, film, graphic protection and/or application tapes that are not sold or recommended by 3M. The user is solely responsible for the graphic appearance and performance of graphic constructions that include any other products.

(6) Graphic Protection

- Graphic protection can improve the appearance, performance and durability of your graphics. It is required for many warranted constructions. Refer to the Warranty Period tables for details.
- Any printed graphic exposed to abrasive conditions (including vehicles), harsh cleaners or chemicals must include graphic protection in order to be warranted. Abrasion damage and gloss loss are not covered.

(7) Rivets

This film may tent when applied over rivets. If the rivets are closely spaced, the film will likely bridge between rivets. Tented or bridged film may fail prematurely, which is not covered by any 3M warranty.

**6. Factors that Affect Graphic
Performance Life**

The actual performance life of a graphic is affected by all of the following.

- The combination of graphics materials used
- Ink formulation
- Adequate 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

7. Graphics Manufacturing



CAUTION

Before using any equipment, always follow the manufacturers' instructions for safe operation.

A. Screen Printing

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

- Ink series 1900 and some colors in ink series 9800 are opaque. Be aware that opaque ink can prevent the film from retroreflecting in the screen printed areas. Ink series 2900 and the transparent colors from ink series 9800 are good choices when retroreflection is important in the screen printed areas.
- For graphics subjected to fuel vapors or occasional spills, use screen printing ink series 2900 and clear 1920DR.
- Oven dry the last color and the clear when using solvent-based inks on graphics needed for any corrugated application.

B. Electrostatic Printing

An image is printed on electrostatic paper and transferred with heat and pressure to the film. Graphic protection is required.

Refer to the 3M Related Literature section for Instruction Bulletins that discuss electrostatic printing methods.

C. Cutting

(1) Methods

The following are common cutting methods for this film. See [Instruction Bulletin 4.1](#) for details.

- Cold and hot steel-ruled die cutting
- Hot kiss cutting
- Drum-type electronic cutting
- Flat-bed electronic cutting
- Guillotine
- Hand cut
- Knifeless™ Tape (<http://knifelesstechsystems.com/Home.aspx> for details)

(2) Minimum Cutting Sizes

- Use a minimum letter height of 1 inch (2.5 cm).
- Use a minimum stroke width of 3/8 inch (1.0 cm).
- Use a minimum radius for a point of 1/16 inch (1.6 mm).
- For uniform color and brightness when making a graphic with multiple pieces of the film together, be sure the pieces are properly color matched. See [Instruction Bulletin 2.1](#) for details. Color-matched white film is available by special order at no extra charge. Contact your 3M sales representative.
- Order "roll applicator splices" for roll striping. Butt splices may have a small gap.

(3) Weeding Considerations

- For the best results, weed the film within 24 hours of cutting it.
- Perform weeding carefully. Removing the film from the liner reduces or may eliminate the slideability feature.
- Refer to [Instruction Bulletin 4.1](#) for more details.

D. Liner Exchanging

Do not attempt to exchange the liner. This will compromise the slideability of the film, and could negatively impact adhesion or appearance of the applied graphic, which is not covered by any 3M warranty.

E. Application Tapes

(1) When to Use Premasking Tape

- As an application aid to increase stiffness, and prevent stretching and damage during application.
- Graphics larger than 4 square feet (0.4 m²).
- Striping greater than 4 inches (10 cm) wide.

(2) When NOT to Use Premasking Tape

- Continuous rolls or striping wider than 12 inches (31 cm).
- Rolls wider than 12 inches (31 cm) that will be slit.

(3) **When to Use
Prespacing Tape**

- Hold cut and weeded letters or graphics in registration after removing the film liner.
- Protect cut graphic parts from scratching or damage during application.
- Use when large amounts of liner are exposed.

(4) **How to Select an
Application Tape**

Determine whether you want to premask the graphic or prespace cut graphics. Then select the application tape that corresponds to the graphic protection used. See [Instruction Bulletin 4.3](#) for complete details.

a. **Screen Printing**

Select the tape based on what is on top of the graphic

Application Tape	Screen Print Inks	1920DR	9740i, 9800CL
Premasking SCPM-3	1900 2900	■	—
Premasking SCPM-44X	9800	—	■

— = Use of application tape not recommended for this construction

b. **Electrostatic Printing**

Select the tape based on what is on top of the graphic

Application Tape	Electrostatic Toners	1920DR	8914	8519, 8912
Premasking SCPM-3	8700	■	—	■
Prespacing SCPS-2		■	—	■

— = Use of application tape not recommended for this construction

c. **No Printing or Graphic
Protection**

- Premasking Tape SCPM-3
- Prespacing Tape SCPS-2

8. **Application and Installation**

Install the film using the dry application method.

Refer to the 3M Related Literature section, located at the end of this bulletin, for a list of the Instruction Bulletins that may be needed to apply or install this film.

A. **Adhesive**

This film has a pressure-activated adhesive that allows the film to slide easily on the substrate. Any pressure applied by hand, squeegee or application tool immediately bonds the film to the substrate and the slideability feature is lost. The film cannot be lifted and repositioned without damage.

B. **Substrate Considerations**

Important Note!

Some substrates such as under-cured polyurethane paint, fiberglass and some paint systems may continue to outgas for some time. Two-part polyurethane paints and screen print clears may stop curing when the air and surface temperatures are lower than 75°F (24°C).

This film is not recommended for use on low surface energy substrates such as some plastics, powder-coated paint, etc. The user must assume responsibility for testing and approving these substrates.

C. Edge Sealing

- If needed or recommended, use edge sealer 3950.
- Most graphics made with these films do not require an edge sealer, although certain applications may benefit from its use.
- All processed and unprocessed graphics subjected to fuel vapors or occasional fuel spills do require edge sealer.
- Edge sealing in the following applications is not required, but it may help keep the edges adhered when subjected to external sources such as abrasion and/or high pressure washing.
 - Graphics exposed to severe abrasion or high pressure washing.
 - Graphics applied to locomotives and rolling railroad stock.
 - Graphics applied to truck rollup doors.

9. Maintenance and Cleaning

Use a cleaner designed for high-quality painted surfaces. The cleaner must be wet, non-abrasive, without strong solvents, and have a pH value between 3 and 11 (neither strongly acidic nor strongly alkaline.)

Refer to [Instruction Bulletin 6.5](#) for details on pressure cleaning. Exceeding 3M's recommendations will void the warranty whether or not an edge sealer was properly used.

10. Removal

This film is a permanent film, which is not removable. Refer to [Instruction Bulletin 6.5](#) for more information about permanent films.

11. Shelf Life, Storage and Shipping

A. Shelf Life

Total shelf life: 3 years from the date of manufacture on the original box.

If you do process the film, do so within 2 years and apply within 1 year.

If you do not process the film, apply it within 3 years.

B. Storage Conditions

for Unprocessed Film or
Unapplied Finished Graphics

- 40° to 100°F (4° to 38°C)
- Out of sunlight
- Clean dry area
- Store unprocessed film in original container
- Cut sheets must lie flat
- Bring the film to print room temperature before using

C. 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.

See [Instruction Bulletin 6.5](#) for details.

12. Health and Safety



CAUTION

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

A. Standards

This information is important for applications that are regulated by ASTM or NFPA® standards, for example, traffic control signs, emergency vehicles and certain railroad graphics. The user is solely responsible for determining and complying with all current and applicable local, state and federal regulations regarding the use and application of graphics materials.

C. NFPA® 1901: Standard for Automotive Fire Apparatus (2009 Edition)

According to NFPA® 1901, section 15.9.3.3 specifies that all retroreflective materials required by section 15.9.3.1 and 15.9.3.2 shall conform to the requirements of ASTM D 4956, *Standard Specification for Retroreflective Sheeting for Traffic Control*, Section 6.1.1 for Type I sheeting. Section 15.9.3.3.1 specifies that colors not listed in ASTM D-4956 can be used on the front and sides of the fire apparatus as long as the sheeting has a minimum coefficient of retroreflection of 10 when measured with an observation angle of 0.2° and an entrance angle of -4°.

D. AAR: Standard and Recommended Practices

13. 3M Related Literature

The information in 3M Product and Instruction Bulletins is subject to change. [Current Bulletins](#) are available at 3Mgraphics.com. The following applicable Bulletins provide information and processes you need to properly make the graphics described in this Bulletin. Additional Bulletins may be needed as indicated in the 3M Related Literature section of other 3M components you use.

Bulletin types: PB = Product Bulletin; PB-IB = Product & Instruction Bulletin; IB = Instruction Bulletin

Continued on the next page.

Subject	Type	Bulletin No.
Application, substrate selection, preparation, substrate-specific techniques	IB	5.1
Application, special applications and vehicles	IB	5.4
Transferring and laminating electrostatically printed images	IB	4.7
Application, general procedures for indoor and outdoor dry applications	IB	5.5
Storage, handling, maintenance, removal	IB	6.5

[3M Commercial Graphics Warranty Brochure](#)

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14. Bulletin Change Summary

3M™ Screen Print UV Clear 9740i directly replaces 3M™ Screen Print UV Gloss Clear 9720i and 9720UV. Added a Performance Overview, which includes an Effective Performance Life value of 2 years. Reformatted the Warranty Information and Stipulations sections for better understanding of important terms used in Commercial Graphics Technical Literature. The Graphic Types definitions have been updated to align with the 3M Commercial Graphics Warranty Brochure. In Section 13.B., references to the ASTM standard have all been updated to say ASTM D4596-11a.



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