



Controltac™ Graphic Film Series 180 Graphic Film With Comply™ Adhesive Series 180C Graphic Film With Comply™ Adhesive 180Cv2-10

For Screen Printing Only

Product Description

These 2-mil films offer great versatility along with slideable, repositionable, pressure-activated adhesive. These long-term durable and removable films have excellent hiding power and stability, making them perfect for indoor and outdoor signs and fleet graphics, including surfaces with corrugations and rivets. Film series 180C with Comply adhesive also have air release channels for fast and easy, bubble-free graphic installations. Film 180Cv2-10 (white only) features invisible air release channels. Use for screen printing.

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.

- Indoor and outdoor graphics and signs, including point-of-purchase and displays
- Commercial vehicle and fleet graphics, emblems or striping
- Bus graphics
- Standard vehicle graphics
- Transparent film color 114 can be used for two-way emblems for windows, except on buses or other vehicles

Limitations of End Uses

3M specifically does not recommend or warrant the following uses, but please contact us to discuss your needs or recommend other products.

Unsuitable End Uses for This Film

- Graphics applied to:
 - stainless steel
 - non-3M films (see Removal Warranty)
 - painted substrates with poor paint to substrate, or paint-to-paint bond
 - substrate surfaces that are not clean and smooth (little or no variation in texture)
- Film without graphic protection under these conditions:
 - vehicle graphics
 - exposure to abrasive conditions, harsh cleaners or chemicals
- Graphic removal from:
 - applications with poor paint-to-substrate adhesion
 - existing graphics that must remain intact; damage may occur during removal of film
 - outdoor, horizontal applications
- Graphics subjected to gasoline vapors or spills, including those at or on gas pumps, automobile fuel-tank ports, or top-feeding, petroleum tankers
- Graphics made for automotive Original Equipment Manufacturers (OEM); contact 3M Automotive Division at 1-800-328-1684 for alternatives.

Wall Graphics

Two-mil cast films are typically the best choice for indoor smooth surface wall graphics. However, the user is responsible for determining the product's suitability, including adhesion and, if required, removal characteristics. Due to the wide variability of smooth indoor walls, neither finished graphics nor removal is warranted, even for removable or changeable films. Instruction Bulletin 5.37 provides comprehensive information for the most successful wall graphics film selection and application.

Important Information About Bus Applications

Film used on buses must not be applied so as to restrict the safe use of emergency window exits. See the most current version of Instruction Bulletin 5.4 for details.

Compatible Products

3M Graphic Materials

This Bulletin provides details about the base film and construction options and warranty. Additional specific information about compatible products can be found in the Product and Instruction Bulletins listed in **3M Related Literature** at the end of this bulletin.

Screen Printing Inks

- 3M™ Screen Printing Ink Series 1900 *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*)

Graphic Protection Options

- 3M™ Screen Print Gloss Clear 1920DR
- 3M™ Screen Print UV Gloss Clear 9720i
- 3M™ Screen Print Clear 9720UV
- 3M™ Screen Printing Gloss Clear 9800CL
- 3M™ Screen Print Gloss Clear 9720UV
- 3M™ Screen Print Low Gloss Clear 9730UV

Other Products

- 3M™ Premasking Tape SCPM-3
- 3M™ Premasking Tape SCPM-44X
- 3M™ Prespacing Tape SCPS-55
- 3M™ Edge Sealer 3950
- 3M™ Edge Tape 8914

Sericol Inks

Please top go www.sericol.com/Distributors/distribFR.htm for order details, or contact Sericol Inc. Corporate Office, 1101 W. Cambridge Drive, Kansas City, KS 66103
Tel: 913-342-4060, Fax: 913-342-4752.

Characteristics

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

Physical Characteristics

Characteristic	Value
Film	Vinyl, cast
Film color	See Color Table, below
Thickness	Without adhesive: 2 mil (0.05 mm) With adhesive: 3-4 mil (0.08-0.10 mm)
Adhesive	Film series 180: Pressure-activated, slideable, repositionable Film series 180C, 180Cv2-10: Pressure-activated, slideable, repositionable, air release channels
Adhesive color	Gray
Liner	Polyethylene-coated paper

Continued on the next page.

Adhesion, Typical 24 hours after application	Substrate	Adhesion
	ABS	4.2 pounds/inch (0.75 kg/cm)
	Acrylic enamel	3.5 pounds/inch (0.63 kg/cm)
	Aluminum, anodized	7.9 pounds/inch (1.42 kg/cm)
	Aluminum, etched	5.2 pounds/inch (0.93 kg/cm)
	Chrome	4.8 pounds/inch (0.87 kg/cm)
	Fruehauf pre-painted panels	4.0 pounds/inch (0.7 kg/cm)
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 (<i>does not include immersion</i>) Resists occasional fuel spills 	
Flammability	Call 1-800-328-3908 for information	

Application Characteristics

Characteristic	Value
Finished graphic application recommendation	<p>Surface type: Flat, with and without rivets, simple curves, moderate compound curves, and corrugations</p> <p>Substrate type: ABS resins, aluminum, chrome, glass, fiberglass reinforced plastics, paint (check adhesion to powder-coated or water-based paints)</p> <p>Application temperature:</p> <ul style="list-style-type: none"> Flat without rivets: 40°-100°F (4°-38°C) Curves or corrugations with rivets: 50°-100°F (10°-38°C) Compound curves: 60°-90°F (16°-32°C) <p>Application method: Dry</p>
Applied shrinkage	0.015 inches (0.4 mm)
Temperature range after application	-65° to +225°F (-60° to +107°C)
Graphic removal	Removable with heat and/or chemicals from most substrates within the warranty period at 50°F (10°C) minimum (air and substrate)

Color Table

Solid Colors				Metallic and Transparent			
10	White	38	Royal Purple*	88	Violet*	201	Slate*
12	Black	39	Tan	96	Teal*	203	Red*
13	Tomato Red	41	Dark Gray*	98	Dark Violet*	211	Charcoal*
14	Bright Orange	46	Kelly Green	103	Magenta*	216	Sage Green*
15	Bright Yellow*†	47	Intense Blue	120	Satin Aluminum	217	Dark Blue*
17	Vivid Blue	49	Beige	131	Satin Gold*	220	Light Silver*
19	Deep Mahogany	53	Cardinal Red	173	Salmon Pink*	221	Grey*
22	Matte Black*	54	Light Orange	176	Aqua*	227	Bright Blue*
23	Deep Red	56	Dark Green	186	Bright Green*	228	Dark Burgundy*
25	Sunflower*†	57	Olympic Blue	196	Apple Green*	229	Copper*
27	Indigo (Navy)	58	Burgundy*	307	Dark Aqua*	237	Silver Blue*
29	Russet Brown	63	Geranium *			239	Chocolate
31	Medium Grey*	77	Peacock Blue				Brown*
37	Sapphire Blue					241	Gold*
						114	Transparent*†

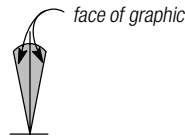
* Indicates clear adhesive; all other adhesive is gray-pigmented

† Indicates minimal or no hiding power

Definitions

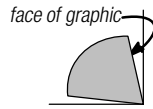
Exposure Types

U.S. Vertical Exposure



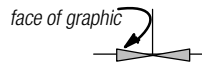
The face of the graphic is +/- 10° from vertical.

U.S. Non-vertical Exposure



The face of the graphic is greater than 10° from vertical and greater than 5° from horizontal. This includes non-vertical surfaces of vehicle wraps or fleet graphics.

U.S. Horizontal Exposure



The face of the graphic is +/- 5° from horizontal.

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. A detailed map is available at 3Mgraphics.com under Warranties.

Warranty Information

Warranty and Limited Remedy

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: all 3M products are 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. 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. **In no case shall 3M be liable for any direct, indirect, or consequential damages, including any labor (except for certain fleet vehicles as described later in this Bulletin) or non-3M materials charges.**

See the *3M Graphics Market Center Warranty Brochure* at 3Mgraphics.com, which gives the terms, additional limitations of the warranty, if any, and limitations of liability.

Warranty Coverage Overview

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

3M™ MCS™ Warranty

Warranted Durability Table for Finished Graphics in a Standard U.S. Vertical Exposure

Finished graphics constructed as shown in the tables below are eligible for the MCS Warranty. For warranties for other exposures, see page 6.

- Veh = Fleet, Standard and Recreational Vehicle Graphics
- Rail = Railroad Graphics
- Sign = General Indoor and Outdoor Signs
- OEM = OEM Graphics

Ink Series	No Printing				Ink Series 1900				Ink Series 9800				Ink Series 9800 Metallic			
	Veh	Rail	Sign	OEM	Veh	Rail	Sign	OEM	Veh	Rail	Sign	OEM	Veh	Rail	Sign	OEM
Film Colors	10◆●, 12●, 13◆, 14◆, 15◆, 19, 22, 23, 27, 29, 31, 38, 39, 41, 49, 58, 63, 88, 96, 98, 103, 173, 176, 186, 196, 307															
Graphic Protection																
1920DR, air dry	—	—	—	—	5	5◆	5	5	—	—	—	—	—	—	—	—
1920DR, oven dry	—	—	—	—	6■	6◆■	5■	5■	—	—	—	—	—	—	—	—
1930	—	—	—	—	2	2◆	2	2	—	—	—	—	—	—	—	—
9720i, 9720UV	—	—	—	—	6	6◆	5	5	7	7◆	5	5	5	—	5	5
9730UV	—	—	—	—	3	3◆	3	3	3	3◆	3	3	—	—	—	—
9800CL	—	—	—	—	—	—	—	—	5	5◆	5	5	5	—	5	5
None	7, LT	8◆	6	5	—	—	—	—	—	—	2	—	—	—	—	—

Film Colors	17, 25◆, 37, 46, 47, 53◆, 54, 56, 57, 77															
1920DR, air dry	—	—	—	—	5	5◆	5	5	—	—	—	—	—	—	—	—
1920DR, oven dry	—	—	—	—	6■	6◆■	5■	5■	—	—	—	—	—	—	—	—
1930	—	—	—	—	2	2◆	2	2	—	—	—	—	—	—	—	—
9720i, 9720UV	—	—	—	—	6	6◆	5	5	6	6◆	5	5	5	—	5	5
9730UV	—	—	—	—	3	3◆	3	3	3	3◆	3	3	—	—	—	—
9800CL	—	—	—	—	—	—	—	—	5	5◆	5	5	5	—	5	5
None	6, LT	6◆	6	5	—	—	—	—	—	—	2	—	—	—	—	—

Film Colors	120, 131															
1920DR, air dry	—	—	—	—	5	5◆	5	5	—	—	—	—	—	—	—	—
1920DR, oven dry	—	—	—	—	6■	6◆■	5■	5■	—	—	—	—	—	—	—	—
1930	—	—	—	—	2	2◆	2	2	—	—	—	—	—	—	—	—
9720i, 9720UV	—	—	—	—	6	6◆	5	5	5	5◆	5	5	5	—	5	5
9730UV	—	—	—	—	3	3◆	3	3	3	3◆	3	3	—	—	—	—
9800CL	—	—	—	—	—	—	—	—	5	5◆	5	5	5	—	5	5
None	6	6◆	5	5	—	—	—	—	—	—	2	—	—	—	—	—

Film Colors	114, 201, 203, 211, 217, 220, 221, 227, 228, 229, 237, 239, 241															
1920DR, air dry	—	—	—	—	5	5◆	5	5	—	—	—	—	—	—	—	—
1920DR, oven dry	—	—	—	—	6■	6◆■	5■	5	—	—	—	—	—	—	—	—
1930	—	—	—	—	2	2◆	2	2	—	—	—	—	—	—	—	—
9720i, 9720UV	—	—	—	—	6	6◆	5	5	5	5◆	5	5	5	—	5	5
9730UV	—	—	—	—	3	3◆	3	3	3	3◆	3	3	—	—	—	—
9800CL	—	—	—	—	—	—	—	—	5	5◆	5	5	5	—	5	5
None	6	6◆	5	5	—	—	—	—	—	—	2	—	—	—	—	—

LT = Lifetime

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

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

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

3M™ MCS™ Warranty Using Sericol Inks

Application: OEM graphics only

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

Warranty: 3 years in a vertical exposure

Removal Warranty

For Films that Are Removable
with Heat and/or Chemicals

Within the stated warranted durability period of each graphic construction in this Bulletin, if this film cannot be removed with heat and/or chemicals, or if more than 30% of the adhesive residue remains on the substrate, 3M will reimburse a reasonable portion of extra removal costs.

Removal Warranty Exceptions

The following exceptions are not covered by the Removal Warranty.

- Substrate damage due to:
 - removing film from a pre-existing graphic
 - removing film that was applied to painted wallboard
 - removing film from paint that is not firmly bonded to the substrate
- No guarantee is made for:
 - ease or speed of removal of any graphic
 - removal from paint that is improperly cured
 - removal from aged paint or metals, surface oxidation or chalking; user must test, approve and accept liability for such applications
 - removal from horizontally-exposed outdoor applications

Fleet Graphic Warranty Stipulations

Lifetime Warranty for Trailers Only

For Fleet Graphics Covered by the 3M™ MCST™ Warranty Only

The following three provisions shown below (Lifetime Warranty for Trailers, Labor Reimbursement Remedy, and Legibility Warranty) apply only to fleet graphics.

This provision and remedy is in addition to the terms of the MCS Warranty for the constructions indicated in the Warranted Durability Table, page 4, for fleet vehicles only. The Lifetime Warranty is extended to the original graphics purchaser who still owns the fleet vehicle 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	
		Material	Labor
<i>Failure occurs during year:</i>			
8	5	100%	100%
9	6	80%	50%
10	7	60%	25%
11	8	40%	10%
12	9	20%	0%
13	10	10%	0%
14-16	N/A	10%	0%

Labor Reimbursement Remedy

For Fleet Graphics ONLY Covered by the 3M™ MCST™ Warranty

3M will reimburse up to 100% of the labor costs for the removal, remanufacture and reapplication of a graphic for *commercial 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.

Legibility Warranty

For Fleet Graphics ONLY for Horizontal Exposure and Selected Constructions

Applications subjected to maximum sunlight and environmental conditions used on rooftops of commercially-owned fleet vehicles where identification from the air is needed are warranted for legibility only for the following constructions. The graphic will change color, lose gloss and chalk.

Values in Years

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	9720i	5	3

General Warranty Stipulations

These stipulations apply to graphics covered by the 3M™ MCST™ Warranty. Specific provisions of these stipulations are found in the *3M Graphics Market Center Warranty Brochure* at 3Mgraphics.com.

Reduced Warranted Durability

For Graphics NOT in a U.S. Vertical Exposure

Use the years indicated in the applicable Warranted Durability Table, page 4, for your graphic construction and these formulas to determine reduced durabilities for the following graphic exposures.

If the Graphic Exposure is:	Use this Percentage of U.S. Vertical Exposure, Warranted Durability	Examples
U.S. Non-vertical	50% (0.5)	0.5 x 5 years = 2.5 years
Desert Southwest Vertical	70% (0.7)	0.7 x 5 years = 3.5 years
Desert Southwest Non-vertical	35% (0.35)	0.35 x 5 years = 1.75 years
Horizontal	0%	0
U.S. Horizontal, Commercial Fleet Vehicle only	Warranted for legibility only for the stated durability. See the Legibility Warranty, above.	

Paint Refurbishing Reimbursement

For Graphics Covered by the 3M™ MCS™ Warranty Only

This applies to automobiles, vans, buses, and recreational vehicles only, and specifically does not include Watercraft. Refer to Instruction Bulletin 5.36 for complete details.

- A *Pre-Installation and Inspection Report* (in Bulletin 5.36) must be completed prior to graphic installation and submitted with any claim for paint damage sustained during the removal of 3M removable or changeable graphic film from vehicles.
- A separate report for each vehicle involved in a claim is required.

Abrasion and Loss of Gloss

Abrasion damage and loss of gloss are not covered by any 3M warranty. This is considered normal wear and tear.

Application Outside the U.S.

Contact the 3M organization for that country.

Application to Glass

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

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, performance and durability of graphic constructions that include any other products.

Printed Vehicle Graphics

Any printed graphic applied to vehicles that are exposed to abrasive conditions, harsh cleaners or chemicals must include graphic protection in order to be warranted.

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

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.

Graphic protection can improve the appearance, performance and durability of your graphic. A clear coat also prevents chalking on unprinted films.

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 Instruction Bulletin.

Graphics Manufacturing



CAUTION

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

Cutting

The following are common cutting methods for this film. See Instruction Bulletin 4.1 for details.

- Bandsawing
- Hot kiss cutting
- Hot and cold steel rule
- Drum-type electronic cutting
- Flat-bed electronic cutting
- Guillotine
- Hand cut
- Cold and hot steel-rule die cutting

Size of Cut Text

These values are based on upper case Helvetica medium type. Weeding can be more difficult with smaller text.

Minimum stroke width: 0.25 inch (6.35 mm)
Minimum height: 3.0 inch (76.2 mm)
Minimum radius for end of stripe: 0.125 inch (3.18 mm)

Graphic Protection

Graphic protection may improve the appearance, performance and durability of the graphic.

Application Tapes

When to Use Premasking Tape

- As an application aid to increase stiffness, and prevent stretching and damage during application.
- When little or no liner is exposed.

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.

How to Select a Tape

Determine whether you want to premask the graphic or prespace cut pieces of film such as letters. Then locate the graphic protection used on your graphic in the table below, and use the corresponding tape. See Instruction Bulletin 4.3 for complete details.

EXAMPLE: To premask a film that includes clear 1920DR, use premasking tape SCPM-3.

Tape	No Graphic Protection		Graphic Protection			
	Unprinted	Ink Series 9800 only	1920DR	1930	9720i 9720UV 9730UV	9800CL
Premasking SCPM-3	■	—	■	■	—	—
Premasking SCPM-44X	—	■	—	—	■	■
Prespacing SCPS-2 <i>film 180 only</i>	■	—	■	■	—	—
Prespacing SCPS-55 <i>Films 180C, 180Cv2 only</i>	■	■	■	■	■	■
Prespacing SCPS-53X	—	■	—	—	■	■



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.

3M Related Literature

Before starting any job, be sure you have the most current Product and Instruction Bulletins.

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

Subject	Type	Bulletin No.
3M™ Screen Print UV Gloss Clear 9720i	PB-IB	9720i
3M™ Screen Print Gloss Clear 9720UV and Matte Clear 9730UV -Applying screen printing clear 9720UV or 9730UV	PB IB	9700 3.4
3M™ Screen Printing Ink Series 1900 and Overprint Clear VIO402 - Screen printing with ink series 1900 - line color - Screen printing with ink series 1900 - 4-color	PB IB IB	1900 3.12 3.11
3M™ Screen Printing UV Ink Series 9800 - Screen printing with UV ink series 9800 - line color - Screen printing with UV ink series 9800 4-color	PB IB IB	9800 3.20 3.21
Design of graphics	IB	2.1
Scoring and cutting	IB	4.1
Using 3M application tapes; premasking and prespacing for films	IB	4.3
Application, substrate selection, preparation and substrate-specific application techniques	IB	5.1
Application, special applications and vehicles	IB	5.4
Application, general procedures for indoor and outdoor dry applications	IB	5.5
Applicator's quick reference guide for vehicle film	IB	5.35
Application techniques for automobiles, vans and buses, and inspection forms	IB	5.36
A guide to understanding and applying graphics to common indoor and outdoor wall surfaces	IB	5.37
Storage, handling, maintenance, removal	IB	6.5
3M Graphics Center Warranty Brochure	www.3Mgraphics.com, Warranties	

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Bulletin Change Summary

Film 180-193 and 180C-193, Mauve, have been discontinued. Film 180-63 and 180C-63, Geranium, should have had an asterisk following it, indicating it has a clear adhesive.



Commercial Graphics Division
3M Center, Building 220-12E-04
PO Box 33220
St. Paul, MN 55144-3220 USA
General Info. 1-800-374-6772
Technical Info. 1-800-328-3908
Fax 1-651-736-4233

3M Canada
P.O. Box 5757
London, Ontario
Canada N6A 4T1
1-800-265-1840
Fax 519-452-6245

3M México, S.A. de C.V
Av. Santa Fe No. 55
Col. Santa Fe, Del. Alvaro Obregón
México, D.F. 01210
52-55-52-70-04-00
Fax 52-55-52-70-22-77

3M Puerto Rico, Inc.
Puerto Rico Industrial Park
350 Chardon Avenue, Suite 1100
San Juan PR 00918
787-620-3000
Fax 787-620-3018

www.3Mgraphics.com

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