



Traffic Safety and Security Division

# 3M™ ElectroCut™ Film Series 1170

Product Bulletin 1170  
October 2016

Replaces PB 1170 dated July 2007

## Description

3M™ ElectroCut™ Film Series 1170 is a durable, transparent, acrylic film coated with a transparent, pressure-sensitive adhesive that is protected by a removable liner, available in the colors in Table 1.

**Table 1. Product Codes by Color**

Color	Product Code
Clear	1170C
Yellow	1171
Red	1172
Orange	1174
Blue	1175
Worboy Green*	1176
Green	1177
Black (Opaque)	1178
Brown	1179

\*Standard green color for U.K., Australia, and New Zealand

Series 1170 is intended for use on 3M Reflective Sheeting as part of 3M's system of matched components for signing. Series 1170 has a clear pressure-sensitive adhesive compatible with all the following 3M reflective sheetings used in permanent signing:

- 3M Advanced Engineer Grade Prismatic Series 7930
- 3M Engineer Grade Prismatic Series 3430
- 3M Engineer Grade Series 3290
- 3M High Intensity Prismatic Series 3930 and 3930TT
- 3M Diamond Grade™ Series 3990 and 3990TT
- 3M Diamond Grade™ DG<sup>3</sup> Series 4000 and 4000TT
- 3M Diamond Grade™ Translucent DG<sup>3</sup> Reflective Sheeting 4090T



Additionally, 3M™ ElectroCut Film 1170C Clear must be used with the following 3M reflective sheetings:  
 3M Diamond Grade DG<sup>3</sup> Prismatic Digital Sheeting 4090DS (White)  
 3M High Intensity Prismatic Digital Sheeting 3930DS (White)

Series 1170 is designed with a special film liner for kiss-cutting on electronic cutting machines. Rolls are available prepunched for sprocket fed cutters or unpunched for flatbed or friction fed cutters. The colored films in the Series 1170 are often used instead of silk screened inks to provide transparent colored background copy for retroreflective street name signs and other traffic control signs. Various film widths are available to fabricate single sign panels up to 48 inches wide. For single panel signs requiring more than a single piece of sheeting or for multipanel signs such as guide signs, be sure to follow 3M color matching procedures in [Information Folder 1.10](#) to achieve satisfactory results. For best color uniformity on a colored multipanel sign, all panels must be made from the same lot of Series 1170.

## Properties

Transparent clear, yellow, red, orange, blue, worboy green, green, black (opaque), and brown versions of the Series 1170 applied to compatible 3M retroreflective sheetings listed in the above section can be expected to provide performance comparable to the integrally colored version of the same reflective sheeting. The coefficient of retroreflection of a white sheeting overlaid with the Series 1170 depends primarily on the overlay film transparency and the coefficient of retroreflection of the white base sheeting. Series 1170 applied on the compatible microprismatic 3M retroreflective sheetings listed in the above section according to 3M recommendations will yield chromaticity values within the chromaticity limits given in ASTM D4956-16.

Table 1 gives the resultant minimum and maximum coefficient of retroreflection ( $R_A$ ) values for each transparent Series 1170 film as a percentage of the  $R_A$  of the white reflective base sheeting on which it is applied.

**Table 2. Coefficient of retroreflection\* ( $R_A$ ) after application of colored film Series 1170 versus the  $R_A$  of the white base sheeting (expressed as %)**

Film	Minimum (% of base sheeting)	Maximum (% of base sheeting)
1171 (Yellow)	60	80
1172 (Red)	14	24
1174 (Orange)	30	--
1175 (Blue)	6.5	20
1176 (Worboy Green)	8	14
1177 (Green)	13	20
1179 (Brown)	5	--

\* $R_A$  measurements shall be made at 0.2° observation angle, -4° entrance angle, and 0° rotation, per ASTM E810.

## Film Liner

Series 1170 films have a transparent film release liner designed to aid the cutting process and the removal of the film weed after cutting.

## Storage

Store in a cool, dry area 65-75° F (18-24° C), 30-50% relative humidity, and use within one year from date of receipt.

## Fabrication – Cutting and Application Procedures

Important Note: Read and follow the manufacturer's operating manual carefully for proper use of cutting equipment.

1. Adjust knife pressure to cut cleanly through the film and slightly score the liner. A 30° blade works best.
2. A clean cutting blade is required. To remove adhesive build-up use a soft cloth dampened with mineral spirits, isopropyl alcohol or 3M™ Citrus Base Cleaner.
3. Avoid excessive flexing when handling film as this may cause film to release from the liner.
4. After cutting is complete, lay sheets flat, face to face, back to back. Always store sheets in this manner until the sheeting has been weeded and transfer tape has been applied to sheeting.
5. Use a stripping tool designed for weeding films that has a blunt (not a sharp) edge.
6. After weeding is completed, also store sheets flat, face to face and back to back, until transfer tape is applied.
7. TPM-5 Clear Transfer Tape is recommended for best results. SCPM-3 Application Tape is also satisfactory for use on small signs. Other transfer tapes are not recommended.
8. Transfer tape can be applied either by hand using a plastic squeegee or through a hand squeeze roll applicator (HSRA). If applying the transfer tape by hand, care must be taken to always squeegee from the center to the outside in both directions. If applying the transfer tape through the HSRA the air pressure must be at 30 psi to avoid stretching the premask during application, and the “lead” edge must be cut square and fed into the nip very carefully to avoid wrinkles in the Series 1170.
9. Film Series 1170 may be applied to the sheeting either before or after the sheeting has been applied to the substrate. Use of an HSRA is recommended to ensure satisfactory results. Use the “split liner method” – start in the middle of the sheet and remove half the liner to ensure proper alignment.
10. After film Series 1170 and sheeting have been applied, remove the transfer tape by carefully removing the tape at as low an angle as possible.
11. IMPORTANT! When the transfer tape has been removed, reroll the sign through the laminator to ensure good adhesion.
12. Excess or overhanging film Series 1170 should be trimmed using a sharp utility knife held at a 30° angle with the substrate.

## Health and Safety Information

Read all health hazard, precautionary, and first aid statements found in the Safety Data Sheets (SDS) and Article Information Sheets for important health, safety and environmental information. To obtain SDSs and Article Information Sheets for 3M products, go to [3M.com/SDS](http://3M.com/SDS), or by mail, or in case of an emergency, call 1-800-364-3577.

## Warranty

For detailed warranty information, please refer to the sheeting product bulletins and the [3M™ MCS™ Warranty for Traffic](#) and [MCS Warranty Bulletins](#).

## For Information or Assistance

Call: 1-800-553-1380

In Canada Call:

1-800-265-1840

Internet:

[www.3M.com/roadwaysafety](http://www.3M.com/roadwaysafety)

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