

Commercial Branding and Transportation Division

3M™ Diamond Grade™ Fluorescent Work Zone Digital Sheeting Series 3924SUDS

Product Bulletin Series 3924SUDS
July 2023

Replaces Product Bulletin Series 3924SUDS Dated March 2023

1 Description

3M™ Diamond Grade™ Fluorescent Work Zone Digital Sheeting Series 3924SUDS (“**Sheeting**”) is a retroreflective prismatic digital sheeting that has been designed to optimize digital imaging of traffic control signs that are exposed vertically in service, when imaged with ultraviolet ink jet (UVIJ) inks, or latex ink jet inks.

For details of the features and benefits of Series 3924SUDS sheeting, please refer to the 3M Transportation Safety Division website (<http://www.3M.com/roadsafety>).

The Sheeting is available in the following colors.

Table 1. Product codes by color.

Color	Product Code
Fluorescent Orange	3924SUDS

2 Specifications

Sheeting conforms to all current performance requirements of ASTM D4956 for Type VIII retroreflective sheeting. Refer to section 7 for information regarding imaging of Sheeting.

3 System of Matched Components

Sheeting is compatible with all 3M qualified printer and ink systems. The resulting sign performance is considered to be commensurate with typically expected sign life. However, this imaging system is not covered as part of the 3M™ MCS™ Warranty or 3M™ MCS™ Warranty for Traffic.

4 Physical Properties

4.1 Adhesive

Sheeting has a pressure-sensitive adhesive that is recommended for application at temperatures of 65 °F (18 °C) and higher. Meets ASTM D4956 Class I adhesive requirement.

4.2 Entrance Angularity Performance with Respect to Orientation

Sheeting has been designed to be an effective wide angle reflective sheeting, regardless of its orientation, on the substrate or the ultimate orientation of the Sign after installation. However, because the efficiency of light return from cube corner reflectors is not equal at all application orientations, especially at higher entrance angles, it is possible to get the widest entrance angle light return when the Sheeting is oriented in a particular manner. Sheeting orientation can be used to easily optimize high entrance angle (>50°) performance when it is required for a given Sign (e.g. “keep right” symbols). In such situations, the completed Sign should have the Sheeting positioned at the 0° orientation (downweb direction perpendicular to the road). When the “primary groove line” (which is oriented parallel to the flat sides of the diamond chain links) is vertical on the completed Sign, Sheeting is said to be in a 0° orientation. When the “primary groove line” is horizontal on the completed Sign, the Sheeting is said to be in a 90° orientation. See Figure 1 for details.

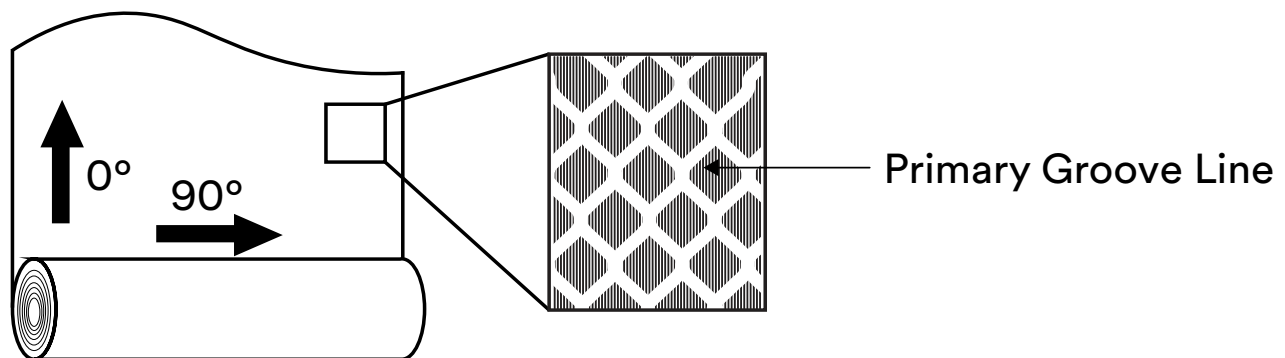


Figure 1. Primary groove lines used to define Sheeting orientation.

Unless a Sign’s location and/or position calls for extra-wide entrance angularity performance or a specific installation direction is required in a customer specification, Signs and applied copy (letters, arrows, borders, and shields) can be fabricated and installed using the application orientation that most efficiently utilizes the reflective Sheeting.

Note: For multi-panel Signs, it is recommended that all background panels be applied with the Sheeting oriented in the same direction.

Sheeting may be processed into traffic Signs using any of the imaging methods described below. 3M assumes no responsibility for the failures of Sign face legends or backgrounds that have been processed with non-3M process colors or with matched component imaging materials other than those listed below.

5 Substrates

Refer to [3M Information Folder 1.7](#) for surface preparation recommendations.

Sheeting has been designed primarily for application to flat substrates. Any application to a substrate with a radius of curvature of less than five inches should also be supported by rivets or bolts. Plastic substrates are not recommended where cold shock performance is required. **Sign failures caused by substrate failures or improper surface preparations are not the responsibility of 3M.**

6 Sign Fabrication Methods

6.1 Squeeze Roll Application

Sheeting should be applied to Sign substrates at temperatures of 65 °F (18 °C) and higher using either of the following methods:

Mechanical squeeze roll applicator – refer to [3M Information Folder 1.4](#). Applications to extrusions that are edge wrapped require sufficient softening of the Sheeting prior to edge wrapping. Softening can be accomplished by directing additional heat to the “next to last” edge roller. This practice may increase productivity and minimize cracking.

Hand squeeze roll applicator – refer to [3M Information Folder 1.6](#) for details.

Background and complete Sign applications of Sheeting must be performed using a roll laminator, either mechanical or hand driven.

6.2 Splices

Sheeting must be butt spliced when more than one piece of Sheeting is used on a single piece of substrate. Sheeting pieces should not touch one another. Avoiding overlap prevents the buckling that can occur as Sheeting expands under extreme temperature and humidity conditions.

6.3 Double Faced Signs

The Sheeting on the bottom side of a double faced Sign can be damaged if rolled through a squeeze roll applicator using an unprotected steel bottom roller. The use of a semi-soft flat sheet between the steel roller and the applied Sign face will protect the Sign face from damage. Use of a rubber mat, tag board, or cardboard is recommended.

7 Imaging

Sheeting may be processed into traffic Signs using the imaging methods described below.

7.1 Digital Imaging

Sheeting is compatible with all 3M qualified digital printers and ink systems. Refer to [3M Information Folder 1.19](#), [3M Information Folder 1.20](#), [3M Information Folder 1.17](#) and [HP Large Format Printing Knowledge Center](#) for details.

8 Cutting

Sheeting may be cut. Sealing the cut edges of Sheeting is not required.

8.1 Plotter Cutting

Flat bed plotters can be used to cut Sheeting and offer the most consistent and reliable performance.

8.2 Other Cutting Methods

Sheeting may be hand cut or die cut one sheet at a time. Cutting procedures can be found in [3M Information Folder 1.10](#).

9 Installation

Nylon washers are required when twist style fasteners are used to mount Signs.

10 Shelf-Life, Processing, Storage, Packaging, and Cleaning

Please refer to [3M Information Folder 1.11](#).

11 Durability

Please refer to [3M Information Folder 1.7](#). Periodic Sign inspection and regular Sign replacement are strongly recommended in order to help Sign owners establish their own effective service life expectations.

12 Health and Safety Information

Read all health hazard, precautionary, and first aid statements found in the Safety Data Sheets (SDS), Article Information Sheets, and products labels of any materials for important health, safety, and environmental information prior to handling or use. To obtain SDSs and Article Information Sheets for 3M products, go to [3M.com/SDS](https://www.3m.com/SDS), contact 3M by mail, or for urgent requests call 1-800-364-3577.

13 Warranty Information

13.1 3M Standard Product Warranty

The Sheeting is warranted (“**3M Standard Warranty**”) to be free of defects in materials and manufacture at the time of shipment and to meet the specifications stated in this product bulletin. If the Sheeting is proven not to have met the 3M Standard Warranty on their shipment date, then a buyer's exclusive remedy, and 3M's sole obligation, at 3M's option, will be refund or replacement of the Sheeting.

13.2 3M™ MCS™ Warranty and 3M™ MCS™ Warranty for Traffic

The Sheeting is not qualified for 3M™ MCS™ Warranty nor 3M™ MCS™ Warranty for Traffic.

13.3 Disclaimer

THE 3M WARRANTY IS MADE IN LIEU OF ALL OTHER WARRANTIES OR CONDITIONS, EXPRESS OR IMPLIED, INCLUDING BUT NOT LIMITED TO ANY IMPLIED WARRANTY OR CONDITION OF MERCHANTABILITY, OR FITNESS FOR A PARTICULAR PURPOSE, OR ANY IMPLIED WARRANTY ARISING OUT OF A COURSE OF DEALING OR OF PERFORMANCE, CUSTOM, OR USAGE OF TRADE.

13.4 Limitation of Liability

Except for the limited remedy stated above, and except where prohibited by law, 3M will not be liable for any loss or damage arising from the Signs or any 3M product, whether direct, indirect, special, incidental, or consequential damages (including but not limited to lost profits, business, or revenue in any way), regardless of the legal theory asserted including warranty, contract, negligence, or strict liability.

14 Other Product Information

Always confirm that you have the most current version of the applicable product bulletin, information folder, or other product information from 3M's Website at <http://www.3M.com/roadsafety>.

15 Literature References

3M IF 1.4	Instructions for Interstate Squeeze Roll Applicator
3M IF 1.5	Hand Application Instructions
3M IF 1.6	Hand Squeeze Roll Applicator
3M IF 1.7	Sign Base Surface Preparation
3M IF 1.10	Cutting, Premasking, and Prespacing
3M IF 1.11	Sign Maintenance Management
3M IF 1.17	User Guide 3M™ Reflective Sheeting and HP Latex 360/365 Printers
3M IF 1.19	Digital Imaging with Durst 163TS Printers on 3M™ Reflective Sheeting
3M IF 1.20	Digital Imaging with EFI H1625 RS Printer on 3M™ Reflective Sheeting
3M PB 1160i	3M™ Premium Protective Overlay Film 1160i
3M PB Slipsheeting	3M™ Slipsheeting

[HP Large Format Printing Knowledge Center](#)

ASTM Test Methods are available from ASTM International, West Conshohocken, PA.

For Information or Assistance

Call: 1-800-553-1380

In Canada Call:

1-800-3M HELPS (1-800-364-3577)

Internet:

<http://www.3M.com/roadsafety>

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

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