



Sandblast Stencil

520 • 520ETL • 520S • 520T

Technical Data

May, 2007

Product Description

3M™ Sandblast Stencil 520 Series, also known as computer cut, is a tan rubber sandblast stencil featuring three different liner designs.

- 3M™ Sandblast Stencil 520ETL has a 4 mil polyester liner.
- 3M™ Sandblast Stencil 520S and 520T has a 2 mil polyester liner.

Computer cuttable 3M sandblast stencil 520S is a slot feed format designed to be used with most computer plotter and can also be used as a friction feed format when liner separation during computer cutting is a concern.

Product Construction

Product Number	Backing	Rubber Color	Liner	Standard Roll Sizes*
520	Tan rubber	Grey	2 mil polyester	10 ¹ / ₂ ", 12 ¹ / ₂ ", 15", 18 ³ / ₄ ", 21", 25", 30" x 10 yds. (9 m)
520ETL			4 mil polyester	15", 30" x 10 yds. (9 m)
520S			2 mil polyester	15", 30" x 10 yds. (9 m) 30" x 20 yds. (19 m)
520T			2 mil polyester	15", 25", 30" x 10 yds. (9 m)

*Note: Contact your 3M sales representative for non-standard size information.

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.

		ASTM Test Method
Adhesion to Granite:	36 oz./in. width (39 N/100 mm)	D-3330
Total Thickness:	45 mils (1.1 mm)	D-3652

Features

- 3M sandblast stencil 520 and 520ETL are ideal for hand and die-cutting and can be used with most stencil press equipment and plastic letters and designs.
- Tan rubber backing that takes distinct carbon transfer so cut lines show up clearly.
- Rubber adhesive for excellent adhesion to polished stone, wood and fillers.

Application Techniques

- It is recommended that this stencil **not be applied to cold stone surfaces** because of possible condensation forming on the surface when placed in warm areas. Apply to a warm, clean and dry surface.
- Remove stencil scrap areas, allow stencil to relax to minimize shrinkage, then apply to stone or wood surfaces and use normal blasting procedures. When applying to stone or wood surfaces, rub stencil down firmly to achieve maximum adhesion.
- A light coat of 3M™ Sandblast Filler #2 **can be used on polished surfaces** if increased adhesion is desired. The filler is **only used on axed or frost surfaces** to help hold 3M sandblast stencils.

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Application Ideas

- Can be used to help protect wood, granite, marble and other stone surfaces during sandblasting operations.
- 3M™ Sandblast Stencil 520 is ideal for hand and/or die-cutting and is designed for most stencil press equipment.
- 3M™ Sandblast Stencil 520S is a slot fed format compatible with Gerber plotters.
- 3M™ Sandblast Stencil 520T is a tractor fed format compatible with IBM plotters.

Storage

Store under normal conditions of 60° to 80°F (16° to 27°C) and 40 to 60% R.H. in the original carton.

Shelf Life

To obtain best performance, use this product within 12 months from date of manufacture.

Product Use

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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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