



Sandblast Stencil – Computer-Cut

519 (Die Cut) • 519S (Slot Feed) (Tractor Feed)

519T

Technical Data

Product Description A tan rubber sandblast stencil with a double liner design featuring a film laminate and easy release film liner. This double liner feature helps prevent design distortion when transferring stencil to stone. Stencil 519 is a die-cuttable stencil for use with most stencil press equipment and 3M™ Scotchkut™ letters and designs. Product 519S is a slot feed format and 519T is a tractor feed format designed to be used with most computer plotters.

Product Construction	Product	Backing	Adhesive	Color	Liner	Standard Roll Length
	519	Rubber	Rubber	Tan	Double liner construction*	10 ½", 12 ½", 15", 18 ¾", 21", 25", 30" x 10 yds. (9.1m)**
	519S	Rubber	Rubber	Tan	Double liner construction*	15", 30" x 10 yds. (9.1m) 30" x 20 yds. (19.2m)**
	519T	Rubber	Rubber	Tan	Double liner construction*	15", 18 ¾", 25", 30 x 10 yds. (9.1m) 25", 30" x 20 yds. (19.2m)**

*1.5 mil (0.04mm) clear film laminate; 2.0 mil (0.5mm) translucent white easy-release film liner

**NOTE: Contact your local 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

Stencil Thickness:	48 mils (1.2mm)	D-3652
Adhesion to Granite:	30 oz./in. (33 N/100mm)	D-3330 (Granite)

- General Information**
- It is recommended that this stencil **should not be applied to cold stone** because of possible condensation forming on the surface when placed in warm areas. It should be applied to a warm, clean and dry surface.
 - Remove stencil scrap areas, leave the film laminate in place, than apply to stone or wood surface and use normal blasting procedures. When applying to stone or wood surfaces, rub stencil down firmly to achieve maximum adhesion.
 - A light coat of Sandblast Filler #2 **can be used on polished surfaces** if increased adhesion is desired.
 - Sandblast Filler #3 is **only used on axed or frosted surfaces** to help hold 3M™ Sandblast Stencils.

Shelf Life To obtain best performance, use this product within 12 months from date of manufacture and store under normal conditions of 60° to 80°F (16° to 27°C) and 40 to 60% R.H. in the original carton.

- Application Ideas**
- Can be used to help protect wood, granite, marble and other stone surfaces during sandblasting operations.
 - 519 Series is designed for use on most stencil press equipment and with 3M™ Scotchkut™ letters and designs
 - Products 519S and 519T are designed to be used with most computer plotters.

3M™ Sandblast Stencil – Computer-Cut

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Features	Features	Advantages	Benefits
	Tan rubber backing	Takes distinct carbon transfer Cut lines show up clearly Easy to cut Excellent blast resistance	Easy to see layout Reduces eye strain Helps reduce wear on knives and 3M™ Scotchkut™ letters and designs Provides clean, sharp letters and designs
	Film laminate	Supports centers of letters, numbers and designs Stretch and distortion are minimized One piece removal	Helps increase production output Reduces alignment defects Helps increase production output
	Rubber adhesive	Excellent adhesion to polished stone, wood and fillers	No lifting during blasting
	Easy-release translucent white liner	Less effort to remove after cutting Reduces stretch during liner removal	Helps increase production output Reduces letter and design distortion

Technical Information and Data The technical information and data, recommendations, and other statements provided in this document are based on tests or experience which 3M believes to be reliable, but the accuracy or completeness of such information is not guaranteed.

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This Industrial Tape and Specialties Division product was manufactured under a 3M quality system registered to ISO 9002 standards.



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