Flexographic Mounting Systems
Selection Guide

Balancing solids and dots for customer satisfaction
### 3M™ Solid Printing Tapes

<table>
<thead>
<tr>
<th>Product Number</th>
<th>Application Thickness Inches</th>
<th>Manufactured Target Thickness Inches</th>
<th>Description</th>
<th>Plates</th>
<th>Cylinders/Sleeves</th>
<th>Color</th>
<th>Features</th>
</tr>
</thead>
<tbody>
<tr>
<td>411DL</td>
<td>0.015 0.38</td>
<td>0.015 0.38</td>
<td>Gray double coated tape with a soft rubber adhesive on each side of a vinyl carrier. Available in single and double liner.</td>
<td>P/R</td>
<td>SS/S/K</td>
<td>Gray</td>
<td>Gray vinyl products with a high adhesion. Helps reduce edge lifting. Helps minimize pin holing on solid work.</td>
</tr>
<tr>
<td>412DL</td>
<td>0.020 0.51</td>
<td>0.020 0.51</td>
<td>Black double coated tape with a firm rubber adhesive on each side of a vinyl carrier. Available in double liner only.</td>
<td>P/R</td>
<td>SS/S/K</td>
<td>Black</td>
<td>Black vinyl - lower adhesion. Higher temperature and solvent resistance. Helps minimize pin holing on solids.</td>
</tr>
</tbody>
</table>

### 3M™ Cushion-Mount™ Solid Printing Tapes

<table>
<thead>
<tr>
<th>Number</th>
<th>Thickness</th>
<th>Description</th>
<th>Plates</th>
<th>Cylinders/Sleeves</th>
<th>Color</th>
<th>Features</th>
</tr>
</thead>
<tbody>
<tr>
<td>929</td>
<td>0.060 1.52</td>
<td>Rubber adhesive on each side of a high density elastomeric foam.</td>
<td>P</td>
<td>SS/S/K</td>
<td>Tan</td>
<td>Highest density 3M™ Cushion-Mount™ products.</td>
</tr>
<tr>
<td>933</td>
<td>0.015 0.38</td>
<td>Differential adhesive with a high density elastomeric foam.</td>
<td>P</td>
<td>SS/S/K</td>
<td>Tan</td>
<td>Use for solid and bold line work. Helps reduce cylinder bounce at higher speeds.</td>
</tr>
</tbody>
</table>

### 3M™ Combination Printing Tapes

#### 3M™ Cushion-Mount™ Plus Firm Combination Printing Tapes

| E1815 & 1815M | 0.015 0.38 | 0.017 0.43 | Differential acrylate adhesive system on each side of a foam carrier, protected by a release liner on one side. | P      | SS/S/K           | Blue  | Better solid ink density than the standard combination printing tapes. Clean removal from plate and print cylinder. |

#### 3M™ Cushion-Mount™ Plus Medium Firm Combination Printing Tapes

| E1715 & 1715M | 0.015 0.38 | 0.017 0.43 | Differential acrylate adhesive system on each side of a foam carrier, protected by a release liner on one side. | P      | SS/S/K           | Teal  | Quality results when plate contains slightly more solids in a combination of solid and halftone images. |

#### 3M™ Cushion-Mount™ Plus Standard Combination Printing Tapes

| E1015,1015 & 1015M | 0.015 0.38 | 0.017 0.43 | Differential acrylate adhesive system on polyethylene foam. | P      | SS/S/K           | White | Most versatile 3M™ Cushion-Mount™ tape products. Effectively prints most types of flexographic printing. |

#### 3M™ Cushion-Mount™ Plus Soft Combination Printing Tapes

| E1915 & 1915M | 0.015 0.38 | 0.017 0.43 | Differential acrylate adhesive system on each side of a foam carrier, protected by a release liner on one side. | P      | SS/S             | Pink Berry | Most versatile 3M™ Cushion-Mount™ tape products. Effectively prints most types of flexographic printing. |

### 3M™ Process Printing Tapes

| E115 & 115 | 0.015 0.38 | 0.017 0.43 | Differential acrylate adhesive system on low-density polyethylene foam. | P      | SS/S             | Tan   | Better tone reproduction than the standard combination printing tapes. Clean removal from plate and print cylinder. |

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*E - Air Release Liner  M - Modified Plate Side Adhesion  DL - Double Liner  K - Composite Sleeve  S - Urethane Sleeve  SS - Stainless Steel Cylinder  R - Rubber Plates  P - Photopolymeric Plates*
A wide choice of adhesives, foams, and thickness for the results your customers demand

When your customer wants solid ink and crisp lines, you’ll want firm, high density mounting tape. For halftone work where dot gain is a concern, a softer tape optimizes reproduction. And when solids and dots share the plate, a combination tape can properly balance the result. From the 3M selection at right, you can find exactly what you need for the quality customers expect. And you’ll find choices for meeting your handling and production requirements:

- Mounting ease and positioning accuracy
- Clean removal from plate and cylinder
- Adhesive type and strength

For example, tapes designated with an “E” are Easy Mount products that virtually eliminate air bubbles and edge lifting, yet remove easily without plate damage.

**Carrier density...**

To meet reproduction requirements, the foam carrier gets progressively softer from series 18, 17, 10, 19, and 11.

**Beyond technology and product...**

3M flexographic sales specialists and technical service engineers can help you select the optimum tape and use it with maximum effectiveness.

**Manufactured under a 3M quality system registered to ISO 9002 standards.**
3M™ Combination Printing Tapes
When you need to consistently balance solid and dot reproduction on the same job

Firm Combination Printing Tapes with Foam Carrier
- Quality results when plate contains mostly solids in a combination of solid and halftone images
- “E” products with Easy Mount technology and “M” products for modified plate side adhesion
Tapes: E1815/E1820, 1815M/1820M

Medium Firm Combination Printing Tapes with Foam Carrier
- Quality results when plate contains slightly more solids in a combination of solid and halftone images
- “E” products with Easy Mount technology and “M” products for modified plate side adhesion
Tapes: E1715/E1720, 1720M

Standard Combination Printing Tapes with Foam Carrier
- Quality results when solid and halftone areas are equally important
- “E” products with Easy Mount technology and “M” products for modified plate side adhesion
Tapes: E1015/E1020, 1015M/1020M, 1020R, E1040, 1040, E1060, 1060

Soft Combination Printing Tapes with Foam Carrier
- Soft support improvement when halftone images print
- “E” products with Easy Mount technology and “M” products for modified plate side adhesion

NOTE ON SOLID AND DOTS REPRODUCTION: 40x magnification on dots; 20x on positive and reverse type; process magenta ink on 2 mil polyethylene film; 1 mil impression at 88 fpm, 800 line, 2.4 bc

DL - Double Liner  E - Air Release Liner  M - Modified Plate Side Adhesion  R - Rubber Plates  S - Urethane Sleeve  K - Composite Sleeve
3M™ Process Printing Tapes
When customers want high quality process work and screen printing

Process Printing Tapes with Foam Carrier

E-Series Tapes with Easy Mount Adhesive

On easy with reduced air entrapment
Unlike flat or pebbled liners, E-Series liners are crosshatched on both sides with unique microchannels that allow air to flow throughout the adhesive. Improved airflow virtually eliminates air bubble problems for easier application. Air bleeds from between the tape and plate, and between the tape and cylinder or sleeve for virtually error-free mounting. Setup is shorter with smoother surfaces for cleaner print quality and higher productivity.

Microscopic view of adhesive surface measured with interferometer

Stays on with reduced edge-lifting
Exclusive 3M plate-side adhesive maintains tight contact between tape and plate to dramatically reduce edge lifting. Saves the prep time, downtime, and labor of sealing plate edges.

Peels off easily to reduce plate damage
E-series tapes grip tightly but peel off so easily you can virtually eliminate plate back treatment. You’re less likely to damage plates, so save time, labor, and money.

Air-free print quality
- Prevent blemishes in screen and process printing
- Help assure proper registration

- Low density maximizes dot reproduction for high quality process work and screen printing
- “E” products with Easy Mount technology and “K” product for mounting plates to fiberglass or composite sleeves

Tapes: E1115/E1120, 1115/1120, 1120K
When a thicker caliper or cushion is unnecessary, these tapes can mount both rubber and photopolymer plates. Some are also repositionable.

<table>
<thead>
<tr>
<th>Product Number</th>
<th>Tape Thickness Inch (mm)</th>
<th>Description</th>
<th>Compressible Sleeves</th>
<th>Corrugated</th>
<th>Rotary Letterpress</th>
<th>Make Ready</th>
<th>Features</th>
</tr>
</thead>
<tbody>
<tr>
<td>415</td>
<td>0.004&quot; (0.10)</td>
<td>Double coated tape with a medium-firm acrylic adhesive on each side of a polyester carrier.</td>
<td>X</td>
<td>X</td>
<td></td>
<td></td>
<td>Good adhesion to a wide range of surfaces; can be used for Cameron Press applications.</td>
</tr>
<tr>
<td>442KW</td>
<td>0.004&quot; (0.10)</td>
<td>Double coated tape with a firm rubber adhesive on each side of a polyester carrier.</td>
<td>X</td>
<td>X</td>
<td></td>
<td></td>
<td>Plate mounting applications requiring a thin tape to bond rubber or photopolymer plates to metal cylinders.</td>
</tr>
<tr>
<td>443</td>
<td>0.005&quot; (0.13)</td>
<td>Double coated tape with a soft rubber adhesive on each side of a polyester carrier.</td>
<td>X</td>
<td>X</td>
<td></td>
<td></td>
<td>Mounting applications requiring a thin tape to bond polyester, fiberglass, and other surfaces.</td>
</tr>
<tr>
<td>465</td>
<td>0.002&quot; (0.05)</td>
<td>Acrylic adhesive transfer tape.</td>
<td>X</td>
<td>X</td>
<td></td>
<td></td>
<td>Small area plate build-up or make-ready. Also used to mount primed rubber plates.</td>
</tr>
<tr>
<td>927</td>
<td>0.002&quot; (0.05)</td>
<td>Acrylic adhesive transfer tape.</td>
<td>X</td>
<td>X</td>
<td></td>
<td></td>
<td>Corrugated plate mounting applications where repositionability and removability are not required.</td>
</tr>
<tr>
<td>950</td>
<td>0.005&quot; (0.13)</td>
<td>Acrylic adhesive transfer tape.</td>
<td>X</td>
<td></td>
<td></td>
<td></td>
<td>Corrugated plate mounting applications where repositionability and removability are not required.</td>
</tr>
<tr>
<td>2205</td>
<td>0.005&quot; (0.13)</td>
<td>Double coated film tape with differential acrylic adhesive on a polyester film carrier.</td>
<td>X</td>
<td></td>
<td></td>
<td></td>
<td>Adhesives designed specifically for corrugated flexo mounting. Removes cleanly and easy to reposition.</td>
</tr>
<tr>
<td>9500</td>
<td>0.005&quot; (0.13)</td>
<td>High performance acrylic adhesive on each side of a polyester carrier.</td>
<td>X</td>
<td></td>
<td></td>
<td></td>
<td>Thin tape plate mounting applications requiring higher performance than 443 Tape.</td>
</tr>
</tbody>
</table>

All tapes listed on this chart have been used successfully on non-compressible sleeves.

### 3M™ Flexographic Mounting Aids

**3M™ Cylinder Mount Build-Up Tape 1640**
For use with any 3M flexographic tape to add 0.040" thickness.

**3M™ Primer 94**
Helps hold the leading and trailing edges of the plate to prevent edge lifting.

**3M™ Jet-melt™ Adhesives 3762LM, 3776LM, or 3792LM**
Used with 3M™ Polygun™ LT Applicator to seal plate edges against ink and solvent penetration that causes edge lifting.

**3M™ Aluminum Foil Tape 425, 3M™ Vinyl Tape 471, or 3M™ Polyester Film Tape 850**
Seals plate edges against ink and solvent penetration that causes edge lifting.

**Scotch® Magic Tape 810**
Secures proofing paper to a proofer/mounter with good adhesion but simple removal from the proofing cylinder.

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