



# Flexographic Mounting Systems Selection Guide

*Balancing solids and dots  
for customer satisfaction*



## 3M™ Solid Printing Tapes

Product Number	Application Thickness		Manufactured Target Thickness		Description	Plates	Cylinders/Sleeves	Color	Features
	Inches	mm	Inches	mm					
<b>3M™ Flexomount™ Solid Printing Tapes</b>									
411DL	0.015	0.38	0.015	0.38	Gray double coated tape with a soft rubber adhesive on each side of a vinyl carrier. Available in single and double liner.	P/R	SS/S/K	Gray	Gray vinyl products with a high adhesion. Helps reduce edge lifting. Helps minimize pin holing on solid work.
412DL	0.020	0.51	0.020	0.51		P/R	SS/S/K	Gray	
447DL	0.010	0.25	0.010	0.25		P/R	SS/S/K	Gray	
413DL	0.015	0.38	0.015	0.38	Black double coated tape with a firm rubber adhesive on each side of a vinyl carrier. Available in double liner only.	P/R	SS/S/K	Black	Black vinyl - lower adhesion. Higher temperature and solvent resistance. Helps minimize pin holing on solids.
414DL	0.020	0.51	0.020	0.51		P/R	SS/S/K		
<b>3M™ Cushion-Mount™ Solid Printing Tapes</b>									
929	0.060	1.52	0.062	1.57	Rubber adhesive on each side of a high density elastomeric foam.	P	SS/S/K	Tan	Highest density 3M™ Cushion-Mount™ products. Use for solid and bold line work.
933	0.015	0.38	0.017	0.43		P	SS/S/K	Tan	
939	0.020	0.51	0.022	0.56		P	SS/S/K	Tan	
949	0.020	0.51	0.022	0.56	Differential adhesive with a high density elastomeric foam.	R	SS/S/K	Tan	Helps reduce cylinder bounce at higher speeds.
<b>3M™ Combination Printing Tapes</b>									
<b>3M™ Cushion-Mount™ Plus Firm Combination Printing Tapes</b>									
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.
E1820 & 1820M	0.020	0.51	0.022	0.56		P	SS/S/K	Blue	
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.
E1720 & 1720M	0.020	0.51	0.022	0.56		P	SS/S/K	Teal	
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.
E1015-15 & 1015-15	0.015	0.38	0.015	0.38		P	SS/S/K	White	
E1020, 1020 & 1020M	0.020	0.51	0.022	0.56		P	SS/S/K	White	
E1020-20 & 1020-20	0.020	0.51	0.020	0.51		P	SS/S/K	White	
1020R	0.020	0.51	0.022	0.56		P/R	SS/S/K	White	
E1040 & 1040	0.040	1.02	0.042	1.07		P	SS/S/K	White	
E1060, 1060 & 1060M	0.060	1.52	0.062	1.57	P	SS/S/K	White		
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.
E1920 & 1920M	0.020	0.51	0.022	0.56		P	SS/S	Pink Berry	
E1920S & 1920S	0.020	0.51	0.022	0.56		P	S/K	Pink Berry	
<b>3M™ Process Printing Tapes</b>									
E1115 & 1115	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.
E1115-15 & 1115-15	0.015	0.38	0.015	0.38		P	SS/S	Tan	
E1120 & 1120	0.020	0.51	0.022	0.56		P	SS/S	Tan	
E1120-20 & 1120-20	0.020	0.51	0.020	0.51		P	SS/S	Tan	
1120K	0.020	0.51	0.022	0.56		P	S/K	Tan	

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.**

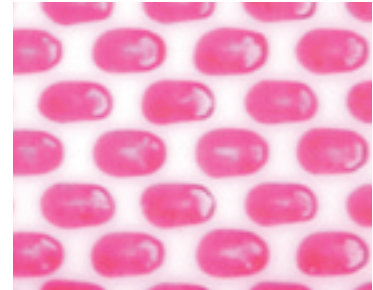
## 3M™ Solid Printing Tapes

When your customer wants solid ink coverage and crisp line work

### Solid Printing Tapes with Vinyl Carrier

### Solid Printing Tapes with Foam Carrier

10% HIGHLIGHT



40% MIDTONE



REVERSE



POSITIVE



- Maximum firmness and high density for uniform coverage of solids when halftone dot reproduction is not critical

- Minimum pin holing

**Tapes: 411DL, 412DL, 413DL, 414DL, 447DL**

- Compression and recovery helps reduce cylinder bounce and deliver more consistent solid print quality

- High density ink coverage

**Tapes: 929, 933, 939, 949**

# 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

## Medium Firm Combination Printing Tapes with Foam Carrier

## Standard Combination Printing Tapes with Foam Carrier

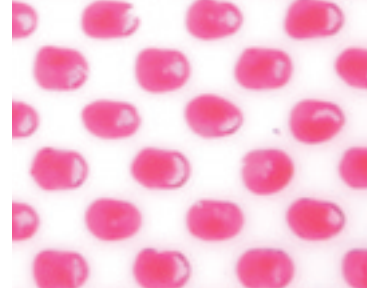
## Soft Combination Printing Tapes with Foam Carrier



9



10



11



16



17



18



23



24



25



30



31



32



- Quality results when plate contains mostly solids in a combination of solid and half-tone images
- “E” products with Easy Mount technology and “M” products for modified plate side adhesion

**Tapes: E1815/E1820,  
1815M/1820M**

- Quality results when plate contains slightly more solids in a combination of solid and half-tone images
- “E” products with Easy Mount technology and “M” products for modified plate side adhesion

**Tapes: E1715/E1720,  
1720M**

- Quality results when solid and half-tone areas are equally important
- “E” products with Easy Mount technology and “M” products for modified plate side adhesion

**Tapes: E1015/E1020, 1015/1020,  
1015M/1020M, 1020R,  
E1040, 1040, E1060, 1060**

- Soft support improves reproduction when half-tone images present
- “E” products with Easy Mount technology and “M” products for modified plate side adhesion

**Tapes: E1915/E1920,  
E1920S, 1920**

**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 bpi

DL - Double Liner

E - Air Release Liner

M - Modified Plate Side Adhesion

R - Rubber Plates

S - Urethane Sleeve

K - Composite Sleeve

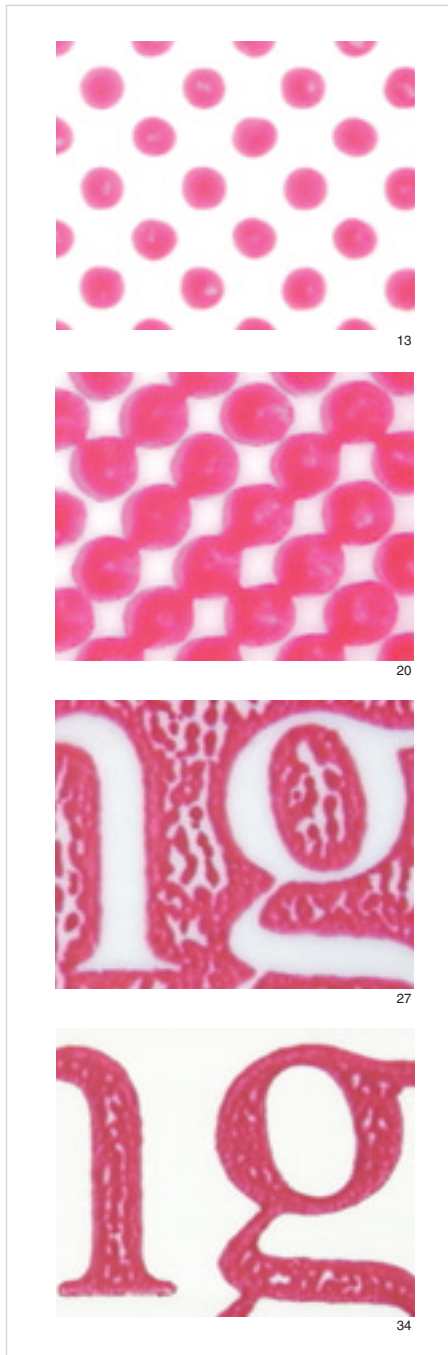
## 3M™ Process Printing Tapes

When customers want high quality process work and screen printing

### Foam Carrier



### Process Printing Tapes with Foam Carrier



- 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

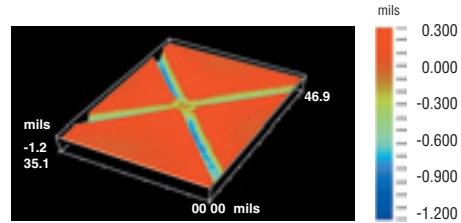
Tapes: E1115/E1120, 1115/1120, 1120K

## E-Series Tapes with Easy Mount Adhesive

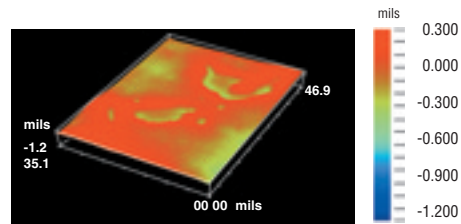
### On easy with reduced air entrapment

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.

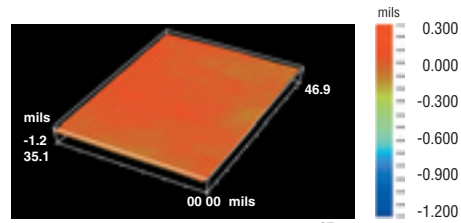
Microscopic view of adhesive surface measured with interferometer



Easy Mount Adhesive 35



Pebbled Liner 36



Flat Liner 37

### 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

oves tone  
process and  
redominate

Easy Mount  
T” products for  
e adhesion

0, 1915M/1920M,  
0S

cm.

## 3M™ Thin Tapes

When a thicker caliper or cushion is unnecessary, these tapes can mount both rubber and photopolymer plates. Some are also repositionable.

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

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™ Polygon™ 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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## Industrial Business Industrial Adhesives and Tapes Division

Customer Response Center  
900 Bush Avenue,  
Building 21-1W-10  
St. Paul, MN 55144-1000  
1-800-362-3550  
[www.3M.com/industrialtape](http://www.3M.com/industrialtape)