3M™ Flexographic Plate Mounting Systems

Selection Guide

Balancing solids and dots for customer satisfaction
On easy with reduced air entrapment
Unlike flat or pebbled liners, E-Series liners are crosshatched. This imprints unique microchannels into the adhesive that allow air to flow throughout the adhesive. Air bubbles disappear from between the tape and plate, and between the tape and cylinder or sleeve for virtually bubble-free mounting. Setup is faster with smoother surfaces for cleaner print quality and higher productivity.

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

Peels off easily to reduce plate damage
Peels off so easily you can virtually eliminate plate back treatment. You’re less likely to damage plates, so you save time, labor, and money.

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

EH-Series Adhesive to hold the edge on small diameter cylinders
3M EH-Series Tapes combine the air-release of 3M E-Series Tapes with higher plate side adhesion to resist edge lifting on cylinder diameters as small as 2".
When plate contains slightly more solids in a combination of solid and halftone images.

E1715, E1715H
E1720, E1720H, E1720M

For high speed printing with fine type reverses and expanded color gamut.

E1515, E1515H
E1520, E1520H

When solid and halftone areas are equally important.

E1015, E1015H, 1015, 1015M
E1020, E1020H, 1020, 1020M, 1020R
E1040, E1040H, 1040
E1060, E1060H, 1060

For high speed printing of combination work when halftone areas exceed solid.

E1315, E1315H
E1320, E1320H

Improved tone reproduction at high speed when process and halftone images predominate.

E1915, E1915H, E1915S, E1915HS, 1915M

Low density maximizes dot reproduction for high speed process work and screen printing.

E1215, E1215H
E1220, E1220H

Low density maximizes dot reproduction for high quality process work and screen printing.

E1115, E1115H, 1115
E1120, E1120H, 1120, 1120K

M - Modified Plate Side Adhesion  R - For Rubber Plates  S - High Sleeve Side Adhesion for Urethane Sleeves  
Additional calipers available for specialized needs.
### 3M™ Flexographic Plate Mounting Systems Selection Guide

#### 3M™ Cushion-Mount™ Plus 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</th>
<th>Color</th>
<th>Features</th>
</tr>
</thead>
<tbody>
<tr>
<td>E1815H, E1815, 1815M</td>
<td>0.015 (0.38)</td>
<td>0.017 (0.43)</td>
<td>Differential acrylate adhesive system on each side of a foam carrier, protected by a release liner on one side.</td>
<td>P</td>
<td>SS/SL</td>
<td>Blue</td>
<td>Better solid ink density than the standard combination printing tapes.</td>
</tr>
<tr>
<td>E1820H, E1820, 1820M</td>
<td>0.020 (0.51)</td>
<td>0.022 (0.56)</td>
<td>Differential acrylate adhesive system on each side of a foam carrier, protected by a release liner on one side.</td>
<td>P</td>
<td>SS/SL</td>
<td>Blue</td>
<td>Clean removal from plate and print cylinder.</td>
</tr>
<tr>
<td>E1840, E1840H</td>
<td>0.040 (1.02)</td>
<td>0.042 (1.07)</td>
<td>Differential acrylate adhesive system on each side of a foam carrier, protected by a release liner on one side.</td>
<td>P</td>
<td>SS/SL</td>
<td>Blue</td>
<td></td>
</tr>
<tr>
<td>E1860, E1860H</td>
<td>0.060 (1.52)</td>
<td>0.062 (1.57)</td>
<td>Differential acrylate adhesive system on each side of a foam carrier, protected by a release liner on one side.</td>
<td>P</td>
<td>SS/SL</td>
<td>Blue</td>
<td></td>
</tr>
</tbody>
</table>

### 3M™ Flexomount™ 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</th>
<th>Color</th>
<th>Features</th>
</tr>
</thead>
<tbody>
<tr>
<td>10 Series 3M™ Cushion-Mount™ Plus Tapes</td>
<td>0.015 (0.38)</td>
<td>0.017 (0.43)</td>
<td>Differential acrylate adhesive system on each side of a foam carrier, protected by a release liner on one side.</td>
<td>P</td>
<td>SS/SL</td>
<td>Teal</td>
<td>Quality results when plate contains slightly more solids in a combination of solid and halftone images.</td>
</tr>
<tr>
<td>E1715H, E1715</td>
<td>0.015 (0.38)</td>
<td>0.017 (0.43)</td>
<td>Differential acrylate adhesive system on each side of a foam carrier, protected by a release liner on one side.</td>
<td>P</td>
<td>SS/SL</td>
<td>Teal</td>
<td></td>
</tr>
<tr>
<td>E1720H, E1720, 1720M</td>
<td>0.020 (0.51)</td>
<td>0.022 (0.56)</td>
<td>Differential acrylate adhesive system on each side of a foam carrier, protected by a release liner on one side.</td>
<td>P</td>
<td>SS/SL</td>
<td>Purple</td>
<td>High quality, medium combination print. Adhesive removes cleanly from the print plate and the print cylinder.</td>
</tr>
<tr>
<td>E1515H, E1515</td>
<td>0.015 (0.38)</td>
<td>0.017 (0.43)</td>
<td>Differential acrylate adhesive system on each side of a foam carrier, protected by a release liner on one side.</td>
<td>P</td>
<td>SS/SL</td>
<td>Purple</td>
<td></td>
</tr>
<tr>
<td>E1520, E1520H</td>
<td>0.020 (0.51)</td>
<td>0.022 (0.56)</td>
<td>Differential acrylate adhesive system on each side of a foam carrier, protected by a release liner on one side.</td>
<td>P</td>
<td>SS/SL</td>
<td>Purple</td>
<td></td>
</tr>
</tbody>
</table>

### 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</th>
<th>Color</th>
<th>Features</th>
</tr>
</thead>
<tbody>
<tr>
<td>13 Series 3M™ Cushion-Mount™ Plus Tapes</td>
<td>0.015 (0.38)</td>
<td>0.017 (0.43)</td>
<td>Differential acrylate adhesive system on each side of a foam carrier, protected by a release liner on one side.</td>
<td>P</td>
<td>SS/SL</td>
<td>Yellow</td>
<td>High quality, medium-soft combination print. Adhesive removes cleanly from the print plate and the print cylinder.</td>
</tr>
<tr>
<td>E1315H, E1315</td>
<td>0.015 (0.38)</td>
<td>0.017 (0.43)</td>
<td>Differential acrylate adhesive system on each side of a foam carrier, protected by a release liner on one side.</td>
<td>P</td>
<td>SS/SL</td>
<td>Yellow</td>
<td></td>
</tr>
<tr>
<td>E1320H, E1320</td>
<td>0.020 (0.51)</td>
<td>0.022 (0.56)</td>
<td>Differential acrylate adhesive system on each side of a foam carrier, protected by a release liner on one side.</td>
<td>P</td>
<td>SS/SL</td>
<td>Pink</td>
<td>Soft support improves tone reduction when process and halftone images predominate.</td>
</tr>
<tr>
<td>E1915, E1915H, 1915M</td>
<td>0.015 (0.38)</td>
<td>0.017 (0.43)</td>
<td>Differential acrylate adhesive system on each side of a foam carrier, protected by a release liner on one side.</td>
<td>P</td>
<td>SS/SL</td>
<td>Pink</td>
<td></td>
</tr>
<tr>
<td>E1915HS, E1915S</td>
<td>0.015 (0.38)</td>
<td>0.017 (0.43)</td>
<td>Differential acrylate adhesive system on each side of a foam carrier, protected by a release liner on one side.</td>
<td>P</td>
<td>SS/SL</td>
<td>Pink</td>
<td></td>
</tr>
<tr>
<td>E1920H, E1920, 1920M</td>
<td>0.020 (0.51)</td>
<td>0.022 (0.56)</td>
<td>Differential acrylate adhesive system on each side of a foam carrier, protected by a release liner on one side.</td>
<td>P</td>
<td>SS/SL</td>
<td>Pink</td>
<td></td>
</tr>
</tbody>
</table>

### Notes:
- This technical information and data should be considered representative or typical only and should not be used for specification purposes.
### 3M™ Flexographic Plate Mounting Systems Selection Guide (continued)

<table>
<thead>
<tr>
<th>Product Number</th>
<th>Application Thickness Inches (mm)</th>
<th>Manufactured Target Thickness Inches (mm)</th>
<th>Description</th>
<th>Plates</th>
<th>Cylinders</th>
<th>Color</th>
<th>Features</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>11 Series 3M™ Cushion-Mount™ Plus Process Printing Tapes</strong></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>E1115H, E1115, 1115</td>
<td>0.015 (0.38)</td>
<td>0.017 (0.43)</td>
<td>Differential acrylate adhesive system on each side of a foam carrier, protected by a release liner on one side.</td>
<td>P</td>
<td>SS/SL</td>
<td>Orange</td>
<td>Better tone reproduction than the standard combination printing tapes. Clean removal from plate and print cylinder.</td>
</tr>
<tr>
<td>E1120, E1120, 1120</td>
<td>0.020 (0.51)</td>
<td>0.022 (0.56)</td>
<td>Differential acrylate adhesive system on each side of a foam carrier, protected by a release liner on one side.</td>
<td>P</td>
<td>SS/SL</td>
<td>Tan</td>
<td></td>
</tr>
<tr>
<td>E1120-20H, E1120-20, 1120-20</td>
<td>0.020 (0.51)</td>
<td>0.020 (0.51)</td>
<td></td>
<td>P</td>
<td>SS/SL</td>
<td>Tan</td>
<td></td>
</tr>
<tr>
<td>1120K</td>
<td>0.020 (0.51)</td>
<td>0.022 (0.56)</td>
<td></td>
<td>P</td>
<td>SL</td>
<td>Tan</td>
<td></td>
</tr>
</tbody>
</table>

When cushioning 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 Corrugated</th>
<th>Rotary Letterpress</th>
<th>Make Ready</th>
<th>Features</th>
</tr>
</thead>
<tbody>
<tr>
<td>415</td>
<td>0.004 (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>Good adhesion to a wide range of surfaces; can be used for Cameron Press applications.</td>
<td></td>
</tr>
<tr>
<td>442KW</td>
<td>0.004 (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>Plate mounting applications requiring a thin tape to bond rubber or photopolymer plates to metal cylinders.</td>
<td></td>
</tr>
<tr>
<td>927</td>
<td>0.002 (0.05)</td>
<td>Acrylic adhesive transfer tape.</td>
<td>X</td>
<td>X</td>
<td>Corrugated plate mounting applications where repositionability and removability are not required.</td>
<td></td>
</tr>
<tr>
<td>950</td>
<td>0.005 (0.13)</td>
<td>Acrylic adhesive transfer tape.</td>
<td>X</td>
<td></td>
<td>Corrugated plate mounting applications where repositionability and removability are not required.</td>
<td></td>
</tr>
<tr>
<td>2205</td>
<td>0.005 (0.13)</td>
<td>Double coated film tape with differential acrylic adhesive on a polyester film carrier.</td>
<td>X</td>
<td></td>
<td>Adhesives designed specifically for corrugated flexo mounting. Removes cleanly and easy to reposition.</td>
<td></td>
</tr>
<tr>
<td>9500PC</td>
<td>0.005 (0.13)</td>
<td>High performance acrylic adhesive on each side of a polyester carrier.</td>
<td>X</td>
<td>X</td>
<td>Thin tape plate mounting applications requiring higher performance than 442KW Tape.</td>
<td></td>
</tr>
</tbody>
</table>

All tapes listed on this chart have been used successfully on non-compressible sleeves.  
**Note:** This technical information and data should be considered representative or typical only and should not be used for specification purposes.

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**3M™ Thin Tapes**

When cushioning is unnecessary, these tapes can mount both rubber and photopolymer plates. Some are also repositionable.

- **415**
  - **Tape Thickness:** 0.004 (0.10) Inch
  - **Description:** Double coated tape with a medium-firm acrylic adhesive on each side of a polyester carrier.
  - **Compressible Corrugated:** Yes
  - **Rotary Letterpress:** Yes
  - **Make Ready:** Yes
  - **Features:** Good adhesion to a wide range of surfaces; can be used for Cameron Press applications.

- **442KW**
  - **Tape Thickness:** 0.004 (0.10) Inch
  - **Description:** Double coated tape with a firm rubber adhesive on each side of a polyester carrier.
  - **Compressible Corrugated:** Yes
  - **Rotary Letterpress:** Yes
  - **Make Ready:** Yes
  - **Features:** Plate mounting applications requiring a thin tape to bond rubber or photopolymer plates to metal cylinders.

- **927**
  - **Tape Thickness:** 0.002 (0.05) Inch
  - **Description:** Acrylic adhesive transfer tape.
  - **Compressible Corrugated:** Yes
  - **Rotary Letterpress:** Yes
  - **Make Ready:** Yes
  - **Features:** Corrugated plate mounting applications where repositionability and removability are not required.

- **950**
  - **Tape Thickness:** 0.005 (0.13) Inch
  - **Description:** Acrylic adhesive transfer tape.
  - **Compressible Corrugated:** Yes
  - **Rotary Letterpress:** Yes
  - **Make Ready:** Yes
  - **Features:** Corrugated plate mounting applications where repositionability and removability are not required.

- **2205**
  - **Tape Thickness:** 0.005 (0.13) Inch
  - **Description:** Double coated film tape with differential acrylic adhesive on a polyester film carrier.
  - **Compressible Corrugated:** Yes
  - **Rotary Letterpress:** Yes
  - **Make Ready:** Yes
  - **Features:** Adhesives designed specifically for corrugated flexo mounting. Removes cleanly and easy to reposition.

- **9500PC**
  - **Tape Thickness:** 0.005 (0.13) Inch
  - **Description:** High performance acrylic adhesive on each side of a polyester carrier.
  - **Compressible Corrugated:** Yes
  - **Rotary Letterpress:** Yes
  - **Make Ready:** Yes
  - **Features:** Thin tape plate mounting applications requiring higher performance than 442KW Tape.

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Plate Edge Sealing

3M™ Scotch-Weld™ Hot Melt Bonding Systems

Easily apply 3M™ Scotch-Weld™ Hot Melt Adhesives 3762LM, 3776LM, 3792LM, or 3798LM with a 3M™ Scotch-Weld™ Hot Melt Applicator LT to seal plate edges against ink and solvent penetration that can cause edge lifting.

A general purpose tip (9921) is supplied with each 3M™ Scotch-Weld™ Applicator. Optional tips are available to increase productivity.

Increase capacity and ease of operation with Quadrack Converter and Palm Trigger.

Heavy-Duty Benchstand for added convenience.

<table>
<thead>
<tr>
<th>3M™ Scotch-Weld™ Hot Melt Applicator</th>
<th>Weight</th>
<th>Output lb/hr</th>
<th>Temperature</th>
<th>Adhesive Size (dia. x length)</th>
<th>Accessories (keyed below)</th>
</tr>
</thead>
<tbody>
<tr>
<td>LT</td>
<td>10.0 oz.</td>
<td>2.6</td>
<td>265°F (129°C)</td>
<td>5/8 x 2’</td>
<td>1 2 3 4</td>
</tr>
<tr>
<td>LT with Quadrack™ Converter</td>
<td>13.8 oz.</td>
<td>2.6</td>
<td>265°F (129°C)</td>
<td>5/8 x 8’</td>
<td>1 4</td>
</tr>
</tbody>
</table>

Tip No. | Description
--- | ---
9913 | 2 Hole Spreader (1/4” hole span)
9916 | 3 Hole Spreader
9921 | .090” Fluted Tip
9922 | .063” Fluted Tip
9940 | .125” Fluted Tip
9725 | Mini Extension Tip .072” Opening
9785 | .070” Tapered Aluminum Extension

A general purpose tip (9921) is supplied with each 3M™ Scotch-Weld™ Applicator. Optional tips are available to increase productivity.

Product Information

<table>
<thead>
<tr>
<th>3M™ Scotch-Weld™ Hot Melt Adhesives (Color)</th>
<th>Features</th>
<th>Application Ideas</th>
<th>Sizes</th>
<th>Delivery Time (sec) for 1” x 3” Cartridge</th>
<th>Heat Resistance (°F/C)</th>
<th>Peel Strength PIW” 72°F (22°C)</th>
<th>Shear Strength PSI” 72°F (22°C)</th>
<th>Open Time 1/8” Bead (sec)³</th>
</tr>
</thead>
<tbody>
<tr>
<td>3762LM* Lt. Amber</td>
<td>Economical, fast setting general purpose</td>
<td>5/8” x 8”, 5/8” x 2”</td>
<td>45</td>
<td>130/54</td>
<td>6</td>
<td>480</td>
<td>25</td>
<td>30</td>
</tr>
<tr>
<td>3776LM Tan</td>
<td>Bonds variety of materials</td>
<td>5/8” x 8”</td>
<td>47</td>
<td>140/60</td>
<td>9</td>
<td>600</td>
<td>40</td>
<td>40</td>
</tr>
<tr>
<td>3792LM* Clear</td>
<td>Clear, multi-purpose</td>
<td>5/8” x 8”, 5/8” x 2”</td>
<td>57</td>
<td>140/60</td>
<td>13</td>
<td>350</td>
<td>40</td>
<td>40</td>
</tr>
<tr>
<td>3798LM Clear</td>
<td>Gummy glue removable adhesive</td>
<td>5/8” x 2”</td>
<td>N/A</td>
<td>N/A</td>
<td>N/A</td>
<td>N/A</td>
<td>N/A</td>
<td>30</td>
</tr>
</tbody>
</table>

* Also available in bulk.  
(1) On canvas (2) On Douglas Fir (3) 1/8” semicircular bead, Douglas Fir to Douglas Fir.  
Note: This technical information and data should be considered representative or typical only and should not be used for specification purposes.
Plate Edge Sealing (continued)

**Multiple options with 3M™ Single Coated Tapes**

3M™ Aluminum Foil Tape 425, 3M™ Vinyl Tape 471, or 3M™ Polyester Film Tape 850 are pressure sensitive adhesive tapes that bond on contact to seal plate edges against ink and solvent penetration that can cause edge lifting.

To seal plate edges against ink and solvent penetration that can weaken mounting tape strength, 3M™ Aluminum Foil Tape 425 (left) and 3M™ Vinyl Tape 471 (right) apply easily, bonding on contact and conforming over the plate edge.

**Product Information**

<table>
<thead>
<tr>
<th>Product/Color</th>
<th>Tape Structure (Backing/Adhesive)</th>
<th>Backing Thickness mils (mm)</th>
<th>Total Thickness mils (mm)</th>
<th>Adhesion to Steel oz./in. (N/100 mm)</th>
<th>Tensile Strength lbs./in. (N/100 mm)</th>
<th>Elongation at Break %</th>
<th>Temperature Range °F (°C)</th>
<th>Comments</th>
</tr>
</thead>
</table>
| Premium Performance Aluminum Foil Tape 425 | Aluminum/Acrylic | 2.8 (0.07) | 4.6 (0.12) | 47 (51) | 30 (525) | 8 | -65 to 300°F (-54 to 149°C) | Most versatile aluminum tape.
| Premium Performance Vinyl Tape 471/Various Colors | Vinyl/Rubber | 4.1 (0.10) | 5.2 (0.13) | 23 (25) | 16 (280) | 130 | 40 to 170°F (4 to 77°C) | Conformable and clean removal. |
| General Industrial Tapes 850/Transparent | Polyester/Acrylic | 0.9 (0.02) | 1.9 (0.05) | 30 (33) | 28 (491) | 120 | -60 to 300°F (-50 to 150°C) | Splicing, holding, sealing, highly transparent. |
| 850/White/Red/Blk | Polyester/Acrylic | 0.9 (0.02) | 1.9 (0.05) | 30 (33) | 28 (491) | 120 | -60 to 300°F (-50 to 150°C) | Splicing, holding, decorating, color-coding, sealing. |
| 850/Silver/Gold | Metallic Polyester/Acrylic | 0.9 (0.02) | 1.9 (0.05) | 42 (46) | 28 (491) | 120 | -60 to 300°F (-50 to 150°C) | Splicing, holding, decorating, color-coding, sealing. |

1 Can be qualified to L-T-80B.MIL-T-23397B II 2 Meets U.L., Class L File R 7311 3 F.A.R.25.853 (a) 4 Meets U.L.746C File E12298

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**Other Mounting Essentials**

**3M™ Cylinder Mount Build-Up Tape 1640**

For use with any 3M flexographic tape to add 0.040" thickness. Facilitates use of thinner printing plates.

**Scotch® Magic Tape 810**

Secures proofing paper to a proofer/mounter with good adhesion but simple removal from the proofing cylinder.

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

**3M™ Hand Roller 903** – For virtually air-free mounting, helps air bleed through and out of the adhesive microchannels in 3M™ Flexographic Plate Mounting Tapes
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