



# Cushion-Mount™ Plus Plate Mounting Tapes with Easy Mount Adhesive High Plateside Adhesion

E1815H, E1820H

E1715H, E1720H

E1515H, E1520H

E1015H, E1020H, E1040H, E1060H

E1315H, E1320H

E1915H, E1915HS, E1920H, E1920HS

E1215H, E1220H,

E1115H, E1120H

## Technical Data

July, 2010

### Product Description

3M™ Cushion-Mount™ Plus Plate Mounting Tapes with Easy Mount Adhesive High Plateside Adhesion are designed for mounting flexographic print plates to cylinders or sleeves. This family of foam mounting tapes provides excellent print quality for process, combination, and solid printing.

### Features

- Offers a complete range of foam densities providing excellent print quality from process to combination to solid printing.
- Consistent caliper control allows the printer to use multiple foam densities on a print job to optimize print quality.
- Use the 3M proprietary Easy Mount liner, creating micro-channels in both adhesive surfaces. The crosshatched pattern creates a continuous and permanent network of micro-channels in the adhesive, allowing air to escape from between the tape and cylinder/sleeve and between the tape and plate.
- The adhesive on the lined side (plate side) of the tape is designed for mounting of photopolymer plates, excellent holding power on-press with high plateside adhesion and clean plate removal when demounting.
- The adhesive on the non-lined side (cylinder side) of the tape is designed for mounting to flexographic printing cylinders or sleeves, providing easy application at mounting and clean removability when demounting.

# 3M™ Cushion-Mount™ Plus Plate Mounting Tapes with Easy Mount Adhesive High Plateside Adhesion

E1815H • E1820H • E1715H • E1720H • E1515H • E1520H • E1015H • E1020H • E1040H • E1060H

E1315H • E1320H • E1915H • E1920H • E1920HS • E1215H • E1220H • E1115H • E1120H

**Typical Physical Properties and Performance Characteristics** **Note:** The following technical information and data should be considered representative or typical only and should not be used for specification purposes.

Product		3M™ Cushion-Mount™ Plus Firm Combination Plate Mounting Tapes		3M™ Cushion-Mount™ Plus Medium Firm Combination Plate Mounting Tapes		3M™ Cushion-Mount™ Plus Medium Combination Plate Mounting Tapes	
		E1815H	E1820H	E1715H	E1720H	E1515H	E1520H
Adhesive		Differential Acrylate		Differential Acrylate		Differential Acrylate	
Polyethylene Carrier		Firm Blue Foam		Medium Firm Teal Foam		Medium Purple Foam	
Type of Printing		Combination of solid and line with minimal tone reproduction		Combination of solid and line with tone reproduction and fine reverses		Combination of solid and line with tone reproduction and fine reverses	
Application Thickness	in (mm)	0.015 (0.381)	0.020 (0.508)	0.015 (0.381)	0.020 (0.508)	0.015 (0.381)	0.020 (0.508)
Thickness							
Tape	in (mm)	0.017 (0.432)	0.022 (0.559)	0.017 (0.432)	0.022 (0.559)	0.017 (0.432)	0.022 (0.559)
Film Liner	in (mm)	0.0045 (0.114)	0.0045 (0.114)	0.0045 (0.114)	0.0045 (0.114)	0.0045 (0.114)	0.0045 (0.114)
Lot to Lot Tolerance	in (mm)	±0.0015 (±0.038)	±0.0015 (±0.038)	±0.0015 (±0.038)	±0.0015 (±0.038)	±0.0015 (±0.038)	±0.0015 (±0.038)
Typical Application Area Caliper Variation	in (mm)	±0.0004 (±0.010)	±0.0004 (±0.010)	±0.0004 (±0.010)	±0.0004 (±0.010)	±0.0004 (±0.010)	±0.0004 (±0.010)
Roll Length	yd (m)	25 (22.9)	25 (22.9)	25 (22.9)	25 (22.9)	25 (22.9)	25 (22.9)
Maximum Width	in (mm)	54 (1371.6)	54 (1371.6)	54 (1371.6)	54 (1371.6)	54 (1371.6)	54 (1371.6)
Minimum Width	in (mm)	2 (50.8)	2 (50.8)	2 (50.8)	2 (50.8)	2 (50.8)	2 (50.8)
Slitting Tolerance	in (mm)	±1/32 (±0.794)	±1/32 (±0.794)	±1/32 (±0.794)	±1/32 (±0.794)	±1/32 (±0.794)	±1/32 (±0.794)
Density	lb/ft³ (kg/m³)	32 (512)	32 (512)	30 (480)	30 (480)	29 (465)	29 (465)
Compression Deflection							
10% Compression	lb/in² (kPa)	35 (241)	35 (241)	30 (207)	30 (207)	26 (180)	26 (180)
25% Compression	lb/in² (kPa)	60 (414)	60 (414)	50 (345)	50 (345)	40 (276)	40 (276)
Durometer ASTM-D2240 Shore A		72	72	68	68	67	67
Peel Adhesion (Modified ASTM-D3330)							
Non-linered side - Stainless Steel	oz/in (N/100mm)	55 (60)	55 (60)	55 (60)	55 (60)	55 (60)	55 (60)
Non-linered side - Composite Sleeve	oz/in (N/100mm)	65 (71)	65 (71)	65 (71)	65 (71)	65 (71)	65 (71)
Non-linered side - Polyester	oz/in (N/100mm)	68 (75)	68 (75)	68 (75)	68 (75)	68 (75)	68 (75)
Non-linered side - Urethane - A	oz/in (N/100mm)	70 (77)	70 (77)	70 (77)	70 (77)	70 (77)	70 (77)
Non-linered side - Urethane - B	oz/in (N/100mm)	60 (66)	60 (66)	55 (60)	55 (60)	55 (60)	55 (60)
Peel Adhesion (Modified ASTM-D3330)							
Linered side - Photopolymer	oz/in (N/100mm)	70 (77)	70 (77)	70 (77)	70 (77)	70 (77)	70 (77)
Solvent Resistance							
Water		Excellent	Excellent	Excellent	Excellent	Excellent	Excellent
Alkanes		Excellent	Excellent	Excellent	Excellent	Excellent	Excellent
Alcohols		Good	Good	Good	Good	Good	Good
Acetates		Fair	Fair	Fair	Fair	Fair	Fair
Heat Resistance	°F (°C)	120 (49)	120 (49)	120 (49)	120 (49)	120 (49)	120 (49)

# 3M™ Cushion-Mount™ Plus Plate Mounting Tapes with Easy Mount Adhesive High Plateside Adhesion

E1815H • E1820H • E1715H • E1720H • E1515H • E1520H • E1015H • E1020H • E1040H • E1060H

E1315H • E1320H • E1915H • E1920H • E1920HS • E1215H • E1220H • E1115H • E1120H

**Typical Physical Properties and Performance Characteristics** **Note:** The following technical information and data should be considered representative or typical only and should not be used for specification purposes.

Product		3M™ Cushion-Mount™ Plus Standard Combination Plate Mounting Tapes		3M™ Cushion-Mount™ Plus Standard Combination Plate Mounting Tapes		3M™ Cushion-Mount™ Plus Medium Soft Process Plate Mounting Tapes	
		E1015H	E1020H	E1040H	E1060H	E1315H	E1320H
Adhesive		Differential Acrylate		Differential Acrylate		Differential Acrylate	
Polyethylene Carrier		Standard White Foam		Standard White Foam		Medium Soft Yellow Foam	
Type of Printing		Combination of solids and tone reproduction where solids and process are equally important		Combination of solids and tone reproduction where solids and process are equally important		Combination of solids and tone reproduction where process printing is important	
Application Thickness	in (mm)	0.015 (0.381)	0.020 (0.508)	0.040 (1.016)	0.060 (1.524)	0.015 (0.381)	0.020 (0.508)
Thickness							
Tape	in (mm)	0.017 (0.432)	0.022 (0.559)	0.042 (1.017)	0.062 (1.525)	0.017 (0.432)	0.022 (0.559)
Film Liner	in (mm)	0.0045 (0.114)	0.0045 (0.114)	0.0045 (0.114)	0.0045 (0.114)	0.0045 (0.114)	0.0045 (0.114)
Lot to Lot Tolerance	in (mm)	±0.0015 (±0.038)	±0.0015 (±0.038)	±0.0015 (±0.038)	±0.0015 (±0.038)	±0.0015 (±0.038)	±0.0015 (±0.038)
Typical Application Area Caliper Variation	in (mm)	±0.0004 (±0.010)	±0.0004 (±0.010)	±0.0004 (±0.010)	±0.0004 (±0.010)	±0.0004 (±0.010)	±0.0004 (±0.010)
Roll Length	yd (m)	25 (22.9)	25 (22.9)	50 ft. (15.4)	50 ft. (15.4)	25 (22.9)	25 (22.9)
Maximum Width	in (mm)	54 (1371.6)	54 (1371.6)	54 (1371.6)	54 (1371.6)	54 (1371.6)	54 (1371.6)
Minimum Width	in (mm)	2 (50.8)	2 (50.8)	2 (50.8)	2 (50.8)	2 (50.8)	2 (50.8)
Slitting Tolerance	in (mm)	±1/32 (±0.794)	±1/32 (±0.794)	±1/32 (±0.794)	±1/32 (±0.794)	±1/32 (±0.794)	±1/32 (±0.794)
Density	lb/ft³ (kg/m³)	28 (450)	28 (450)	28 (450)	28 (450)	27 (433)	27 (433)
Compression Deflection							
10% Compression	lb/in² (kPa)	15 (104)	15 (104)	15 (104)	15 (104)	12 (49)	12 (49)
25% Compression	lb/in² (kPa)	30 (207)	30 (207)	25 (172)	25 (172)	25 (172)	25 (172)
Durometer ASTM-D2240 Shore A		65	65	40	38	63	63
Peel Adhesion (Modified ASTM-D3330)							
Non-linered side - Stainless Steel	oz/in (N/100mm)	55 (60)	55 (60)	55 (60)	65 (71)	55 (60)	55 (60)
Non-linered side - Composite Sleeve	oz/in (N/100mm)	65 (71)	65 (71)	58 (63)	65 (71)	65 (71)	65 (71)
Non-linered side - Polyester	oz/in (N/100mm)	60 (66)	60 (66)	55 (60)	65 (71)	60 (66)	60 (66)
Non-linered side - Urethane - A	oz/in (N/100mm)	80 (88)	80 (88)	70 (77)	80 (88)	80 (88)	80 (88)
Non-linered side - Urethane - B	oz/in (N/100mm)	65 (71)	65 (71)	50 (55)	55 (60)	65 (71)	65 (71)
Peel Adhesion (Modified ASTM-D3330)							
Linered side - Photopolymer	oz/in (N/100mm)	70 (77)	70 (77)	45 (50)	35 (38)	70 (77)	70 (77)
Solvent Resistance							
Water		Excellent	Excellent	Excellent	Excellent	Excellent	Excellent
Alkanes		Excellent	Excellent	Excellent	Excellent	Excellent	Excellent
Alcohols		Good	Good	Good	Good	Good	Good
Acetates		Fair	Fair	Fair	Fair	Fair	Fair
Heat Resistance	°F (°C)	120 (49)	120 (49)	120 (49)	120 (49)	120 (49)	120 (49)

**3M™ Cushion-Mount™ Plus Plate Mounting Tapes with Easy Mount Adhesive High Plateside Adhesion**  
E1815H • E1820H • E1715H • E1720H • E1515H • E1520H • E1015H • E1020H • E1040H • E1060H  
E1315H • E1320H • E1915H • E1920H • E1920HS • E1215H • E1220H • E1115H • E1120H

**Typical Physical Properties and Performance Characteristics** **Note:** The following technical information and data should be considered representative or typical only and should not be used for specification purposes.

Product		3M™ Cushion-Mount™ Plus Light Medium Combination Plate Mounting Tapes		3M™ Cushion-Mount™ Plus Light Medium Combination Plate Mounting Tape		3M™ Cushion-Mount™ Plus Light Combination Plate Mounting Tapes	
		E1915H	E1920H	E1915HS	E1920HS	E1215H	E1220H
Adhesive		Differential Acrylate		Differential Acrylate		Differential Acrylate	
Polyethylene Carrier		Light Medium Pink Foam		Light Medium Pink Foam		Light Orange	
Type of Printing		Combination of solids and tone reproduction where process printing is important		Combination of solids and tone reproduction where process printing is important		Combination of solids and tone reproduction where process printing is important	
Application Thickness	in (mm)	0.015 (0.381)	0.020 (0.508)	0.015 (0.381)	0.020 (0.508)	0.015 (0.381)	0.020 (0.508)
Thickness							
Tape	in (mm)	0.017 (0.432)	0.022 (0.559)	0.017 (0.432)	0.022 (0.559)	0.017 (0.432)	0.022 (0.559)
Film Liner	in (mm)	0.0045 (0.114)	0.0045 (0.114)	0.0045 (0.114)	0.0045 (0.114)	0.0045 (0.114)	0.0045 (0.114)
Lot to Lot Tolerance	in (mm)	±0.0015 (±0.038)	±0.0015 (±0.038)	±0.0015 (±0.038)	±0.0015 (±0.038)	±0.0015 (±0.038)	±0.0015 (±0.038)
Typical Application Area Caliper Variation	in (mm)	±0.0004 (±0.010)	±0.0004 (±0.010)	±0.0004 (±0.010)	±0.0004 (±0.010)	±0.0004 (±0.010)	±0.0004 (±0.010)
Roll Length	yd (m)	25 (22.9)	25 (22.9)	25 (22.9)	25 (22.9)	25 (22.9)	25 (22.9)
Maximum Width	in (mm)	54 (1371.6)	54 (1371.6)	54 (1371.6)	54 (1371.6)	54 (1371.6)	54 (1371.6)
Minimum Width	in (mm)	2 (50.8)	2 (50.8)	2 (50.8)	2 (50.8)	2 (50.8)	2 (50.8)
Slitting Tolerance	in (mm)	±1/32 (±0.794)	±1/32 (±0.794)	±1/32 (±0.794)	±1/32 (±0.794)	±1/32 (±0.794)	±1/32 (±0.794)
Density	lb/ft³ (kg/m³)	26 (416)	26 (416)	26 (416)	26 (416)	25 (400)	25 (400)
Compression Deflection							
10% Compression	lb/in² (kPa)	10 (70)	10 (70)	10 (70)	10 (70)	8 (56)	8 (56)
25% Compression	lb/in² (kPa)	20 (138)	20 (138)	20 (138)	20 (138)	17 (104)	17 (104)
Durometer ASTM-D2240 Shore A		60	60	60	60	58	58
Peel Adhesion (Modified ASTM-D3330)							
Non-linered side - Stainless Steel	oz/in (N/100mm)	30 (33)	30 (33)	55 (60)	55 (60)	35 (38)	35 (38)
Non-linered side - Composite Sleeve	oz/in (N/100mm)	28 (31)	28 (31)	65 (71)	65 (71)	34 (38)	34 (38)
Non-linered side - Polyester	oz/in (N/100mm)	35 (39)	35 (39)	50 (55)	50 (55)	44 (49)	44 (49)
Non-linered side - Urethane - A	oz/in (N/100mm)	45 (50)	45 (50)	75 (82)	75 (82)	65 (71)	65 (71)
Non-linered side - Urethane - B	oz/in (N/100mm)	35 (39)	35 (39)	70 (77)	70 (77)	44 (49)	44 (49)
Peel Adhesion (Modified ASTM-D3330)							
Linered side - Photopolymer	oz/in (N/100mm)	70 (77)	70 (77)	70 (77)	70 (77)	70 (77)	70 (77)
Solvent Resistance							
Water		Excellent	Excellent	Excellent	Excellent	Excellent	Excellent
Alkanes		Excellent	Excellent	Excellent	Excellent	Excellent	Excellent
Alcohols		Good	Good	Good	Good	Good	Good
Acetates		Fair	Fair	Fair	Fair	Fair	Fair
Heat Resistance	°F (°C)	120 (49)	120 (49)	120 (49)	120 (49)	120 (49)	120 (49)

# 3M™ Cushion-Mount™ Plus Plate Mounting Tapes with Easy Mount Adhesive High Plateside Adhesion

E1815H • E1820H • E1715H • E1720H • E1515H • E1520H • E1015H • E1020H • E1040H • E1060H

E1315H • E1320H • E1915H • E1920H • E1920HS • E1215H • E1220H • E1115H • E1120H

**Typical Physical Properties** Note: The following technical information and data should be considered representative and Performance or typical only and should not be used for specification purposes.

## Characteristics

Product		3M™ Cushion-Mount™ Plus Process Plate Mounting Tapes	
		E1115H	E1120H
Adhesive		Differential Acrylate	
Polyethylene Carrier		Soft Tan Foam	
Type of Printing		Tone reproduction where where process printing is important	
Application Thickness	in (mm)	0.015 (0.381)	0.020 (0.508)
Thickness			
Tape	in (mm)	0.017 (0.432)	0.022 (0.559)
Film Liner	in (mm)	0.0045 (0.114)	0.0045 (0.114)
Lot to Lot Tolerance	in (mm)	±0.0015 (±0.038)	±0.0015 (±0.038)
Typical Application Area Caliper Variation	in (mm)	±0.0004 (±0.010)	±0.0004 (±0.010)
Roll Length	yd (m)	25 (22.9)	25 (22.9)
Maximum Width	in (mm)	54 (1371.6)	54 (1371.6)
Minimum Width	in (mm)	2 (50.8)	2 (50.8)
Slitting Tolerance	in (mm)	±1/32 (±0.794)	±1/32 (±0.794)
Density	lb/ft³ (kg/m³)	24 (384)	24 (384)
Compression Deflection			
10% Compression	lb/in² (kPa)	5 (35)	5 (35)
25% Compression	lb/in² (kPa)	10 (70)	10 (70)
Durometer ASTM-D2240 Shore A		55	55
Peel Adhesion (Modified ASTM-D3330)			
Non-linered side - Stainless Steel	oz/in (N/100mm)	30 (33)	30 (33)
Non-linered side - Composite Sleeve	oz/in (N/100mm)	28 (31)	28 (31)
Non-linered side - Polyester	oz/in (N/100mm)	35 (39)	35 (39)
Non-linered side - Urethane - A	oz/in (N/100mm)	50 (55)	50 (55)
Non-linered side - Urethane - B	oz/in (N/100mm)	35 (39)	35 (39)
Peel Adhesion (Modified ASTM-D3330)			
Linered side - Photopolymer	oz/in (N/100mm)	70 (77)	70 (77)
Solvent Resistance			
Water		Excellent	Excellent
Alkanes		Excellent	Excellent
Alcohols		Good	Good
Acetates		Fair	Fair
Heat Resistance	°F (°C)	120 (49)	120 (49)

## 3M™ Cushion-Mount™ Plus Plate Mounting Tapes with Easy Mount Adhesive High Plateside Adhesion

E1815H • E1820H • E1715H • E1720H • E1515H • E1520H • E1015H • E1020H • E1040H • E1060H

E1315H • E1320H • E1915H • E1920H • E1920HS • E1215H • E1220H • E1115H • E1120H

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<b>Storage</b>	Store under normal conditions of 60° to 80°F (16° to 27°C) and 40 to 60% relative humidity in the original carton.
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<b>Shelf Life</b>	To obtain best performance, use all products, except 3M™ Cushion-Mount™ Plus Plate Mounting Tapes with Easy Mount Adhesive High Plateside Adhesion E1040H and E1060H, within two years from date of manufacture. For Cushion-Mount Tapes E1040H and E1060H use within one year from date of manufacture.
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<b>Technical Information</b>	The technical information, recommendations and other statements contained in this document are based upon tests or experience that 3M believes are reliable, but the accuracy or completeness of such information is not guaranteed.
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<b>Product Use</b>	Many factors beyond 3M's control and uniquely within user's knowledge and control can affect the use and performance of a 3M product in a particular application. Given the variety of factors that can affect the use and performance of a 3M product, user is solely responsible for evaluating the 3M product and determining whether it is fit for a particular purpose and suitable for user's method of application.
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<b>Warranty, Limited Remedy, and Disclaimer</b>	Unless an additional warranty is specifically stated on the applicable 3M product packaging or product literature, 3M warrants that each 3M product meets the applicable 3M product specification at the time 3M ships the product. 3M MAKES NO OTHER WARRANTIES OR CONDITIONS, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OR CONDITION OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE OR ANY IMPLIED WARRANTY OR CONDITION ARISING OUT OF A COURSE OF DEALING, CUSTOM OR USAGE OF TRADE. If the 3M product does not conform to this warranty, then the sole and exclusive remedy is, at 3M's option, replacement of the 3M product or refund of the purchase price.
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<b>Limitation of Liability</b>	Except where prohibited by law, 3M will not be liable for any loss or damage arising from the 3M product, whether direct, indirect, special, incidental or consequential, regardless of the legal theory asserted, including warranty, contract, negligence or strict liability.
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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.



### Industrial Adhesives and Tapes Division

3M Center, Building 225-3S-06  
St. Paul, MN 55144-1000  
800-362-3550 • 877-369-2923 (Fax)  
www.3M.com/flexo



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