



# Cushion-Mount™ Plus Tapes with Easy Mount Adhesive

E1815, E1820

E1715, E1720

E1515, E1520

E1015, E1020, E1040, E1060

E1315, E1320

E1915, E1920, E1920S

E1215, E1220,

E1115, E1120

## Technical Data

June, 2008

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### Product Description

3M™ Cushion-Mount™ Plus Tapes with Easy Mount Adhesive 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.

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### 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 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 Tapes with Easy Mount Adhesive

E1815 • E1820 • E1715 • E1720 • E1515 • E1520 • E1015 • E1020 • E1040

E1060 • E1315 • E1320 • E1915 • E1920 • E1920S • E1215 • E1220 • E1115 • E1120

**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 Printing Tapes		3M™ Cushion-Mount™ Plus Medium Firm Combination Printing Tapes		3M™ Cushion-Mount™ Plus Medium Combination Printing Tapes	
		E1815	E1820	E1715	E1720	E1515	E1520
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)	25 (28)	25 (28)	25 (28)	25 (28)	25 (28)	25 (28)
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 Tapes with Easy Mount Adhesive

E1815 • E1820 • E1715 • E1720 • E1515 • E1520 • E1015 • E1020 • E1040  
E1060 • E1315 • E1320 • E1915 • E1920 • E1920S • E1215 • E1220 • E1115 • E1120

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

Product		3M™ Cushion-Mount™ Plus Standard Combination Printing Tapes		3M™ Cushion-Mount™ Plus Standard Combination Printing Tapes		3M™ Cushion-Mount™ Plus Medium Soft Process Printing Tapes	
		E1015	E1020	E1040	E1060	E1315	E1320
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)	25 (28)	25 (28)	18 (20)	12 (14)	25 (28)	25 (28)
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 Tapes with Easy Mount Adhesive

E1815 • E1820 • E1715 • E1720 • E1515 • E1520 • E1015 • E1020 • E1040

E1060 • E1315 • E1320 • E1915 • E1920 • E1920S • E1215 • E1220 • E1115 • E1120

**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 Printing Tapes		3M™ Cushion-Mount™ Plus Light Medium Combination Printing Tape	3M™ Cushion-Mount™ Plus Light Combination Printing Tapes	
		E1915	E1920	E1920S	E1215	E1220
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)	0.020 (0.508)	0.015 (0.381)	0.020 (0.508)
Thickness						
Tape	in (mm)	0.017 (0.432)	0.022 (0.559)	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)
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)
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)
Roll Length	yd (m)	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)
Minimum Width	in (mm)	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)
Density	lb/ft³ (kg/m³)	26 (416)	26 (416)	26 (416)	25 (400)	25 (400)
Compression Deflection						
10% Compression	lb/in² (kPa)	10 (70)	10 (70)	10 (70)	8 (56)	8 (56)
25% Compression	lb/in² (kPa)	20 (138)	20 (138)	20 (138)	17 (104)	17 (104)
Durometer ASTM-D2240 Shore A		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)	30 (33)	30 (33)
Non-linered side - Composite Sleeve	oz/in (N/100mm)	28 (31)	28 (31)	65 (71)	28 (31)	28 (31)
Non-linered side - Polyester	oz/in (N/100mm)	35 (39)	35 (39)	50 (55)	35 (39)	35 (39)
Non-linered side - Urethane - A	oz/in (N/100mm)	45 (50)	45 (50)	75 (82)	50 (55)	50 (55)
Non-linered side - Urethane - B	oz/in (N/100mm)	35 (39)	35 (39)	70 (77)	35 (39)	35 (39)
Peel Adhesion (Modified ASTM-D3330)						
Linered side - Photopolymer	oz/in (N/100mm)	25 (28)	25 (28)	25 (28)	25 (28)	25 (28)
Solvent Resistance						
Water		Excellent	Excellent	Excellent	Excellent	Excellent
Alkanes		Excellent	Excellent	Excellent	Excellent	Excellent
Alcohols		Good	Good	Good	Good	Good
Acetates		Fair	Fair	Fair	Fair	Fair
Heat Resistance	°F (°C)	120 (49)	120 (49)	120 (49)	120 (49)	120 (49)

# 3M™ Cushion-Mount™ Plus Tapes with Easy Mount Adhesive

E1815 • E1820 • E1715 • E1720 • E1515 • E1520 • E1015 • E1020 • E1040  
E1060 • E1315 • E1320 • E1915 • E1920 • E1920S • E1215 • E1220 • E1115 • E1120

**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 Process Printing Tapes	
		E1115	E1120
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)	25 (28)	25 (28)
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 Tapes with Easy Mount Adhesive

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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 this product within one year from date of manufacture.
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<b>Product Use</b>	All statements, technical information and recommendations contained in this document are based upon tests or experience that 3M believes are reliable. However, many factors beyond 3M's control can affect the use and performance of a 3M product in a particular application, including the conditions under which the product is used and the time and environmental conditions in which the product is expected to perform. Since these factors are uniquely within the user's knowledge and control, it is essential that the user evaluate the 3M product to determine whether it is fit for a particular purpose and suitable for the user's method of application.
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<b>Warranty and Limited Remedy</b>	Unless stated otherwise in 3M's product literature, packaging inserts or product packaging for individual products, 3M warrants that each 3M product meets the applicable specifications at the time 3M ships the product. Individual products may have additional or different warranties as stated on product literature, package inserts or product packages. 3M MAKES NO OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE OR ANY IMPLIED WARRANTY ARISING OUT OF A COURSE OF DEALING, CUSTOM OR USAGE OF TRADE. User is responsible for determining whether the 3M product is fit for a particular purpose and suitable for user's application. If the 3M product is defective within the warranty period, your exclusive remedy and 3M's and seller's sole obligation will be, at 3M's option, to replace the product or refund the purchase price.
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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.



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