

## Description

This document describes the application and removal procedures for ORAFLEX® Flexographic Mounting Tapes to print plates and printing cylinders.

## Storage and Processing Conditions

The self-adhesive ORAFLEX® cushion tapes are supplied in rolls, with end caps. Always store them either suspended (with end caps) or standing on end on roll blocks. Never store them lying down, without end caps. Store and process the materials in a cool, dry environment. Specifically, the relative air humidity should be between 40 % and 50 % and a temperature of between +18° to +22° C (64° to 72° F) should be maintained. Direct sunlight and storage beside radiators etc. should be avoided at all times.

## Application Temperatures

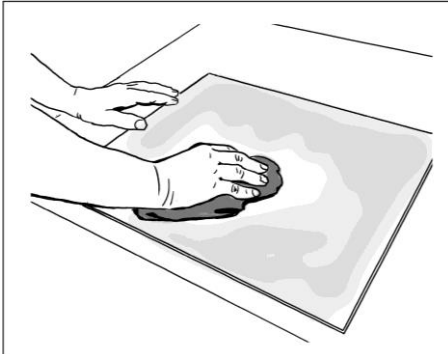
For specific application temperatures for the materials, please refer to the data sheet for your specific product. The optimum surface temperature ranges between +15° to 25° C (59° to 77° F).

## Application – General Information

It is vital that the print cylinder and plate surfaces are properly cleaned and dried for a proper tape performance during printing (e.g. plate lifting) and demounting (e.g. adhesive residues).

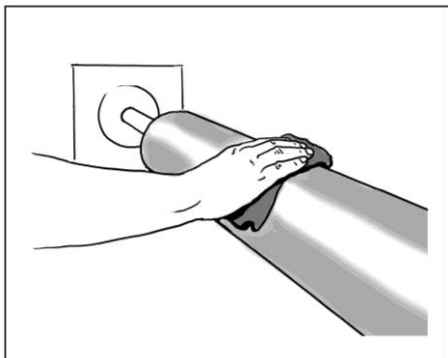
### Mounting of Print Plate

Below is a brief overview of how to use ORAFLEX® cushion tapes for optimal mounting to a print plate.



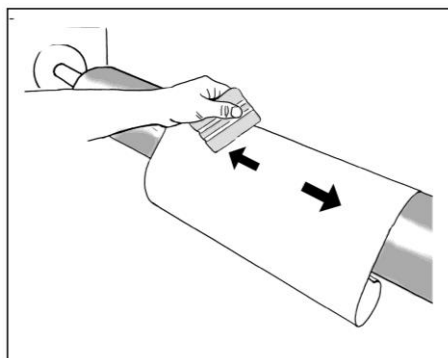
#### Step 1

Clean the print plate. Make sure it is completely free from dust and other contaminants (e.g. ink or adhesive residues). Clean with a suitable solvent and lint-free cloth. The recommended solvent to use is isopropyl alcohol or 1:1 mixture by volume of isopropyl alcohol and water. Solvents like ethyl acetate, ketones or ester ("thinner") should be avoided and can strongly affect adhesive performance. Ensure the surface is totally dried before mounting.



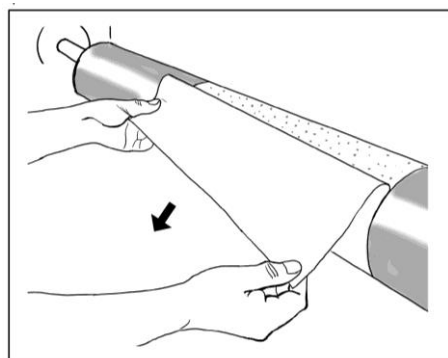
#### Step 2

Clean the print cylinder per manufacturer recommendations and wipe dry with clean lint-free cloth. Make sure it is completely free from dust and other contaminants (e.g. ink or adhesive residues). The recommended solvent to use is isopropyl alcohol or 1:1 mixture by volume of isopropyl alcohol and water. Solvents like ethyl acetate, ketones or ester ("thinner") should be avoided and can strongly affect adhesive performance. Ensure the surface is totally dried before mounting.



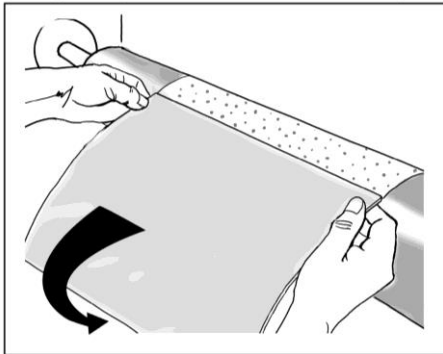
#### Step 3

To avoid tension in the adhesive bond the ORAFLEX® tape should first be applied to the printing cylinder / sleeve. To avoid air entrapments, apply the ORAFLEX® cushion tape in a sweeping motion line by line onto the printing cylinder. For best results use a squeegee or rubber roller.



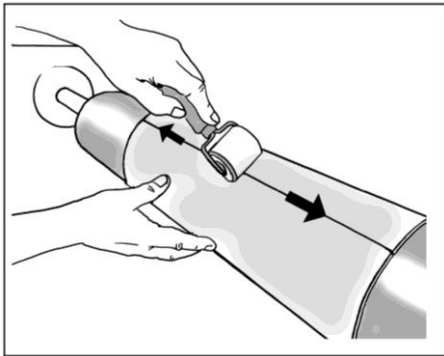
#### Step 4

Pull down the liner and remove it from the ORAFLEX® cushion tape without touching the adhesive.



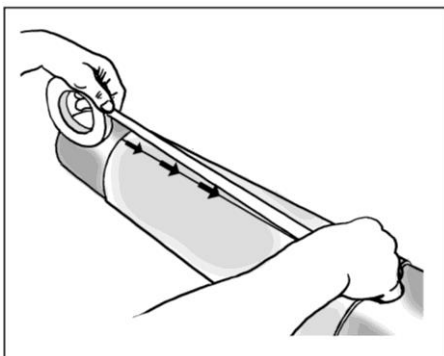
### Step 5

The print plate should be applied immediately after liner removal, as dust might deactivate the open adhesive layer. To begin with, fix the plate without pressure on a narrow area of the ORAFLEX® cushion tape. Once the correct plate orientation is justified, begin to apply the plate onto the ORAFLEX® cushion tape by using a rubber roller in a sweeping motion line by line.



### Step 6

Particular care is required when pushing the plate edges into contact with the ORAFLEX® cushion tape to avoid edge lifting, especially on the leading and trailing edge.

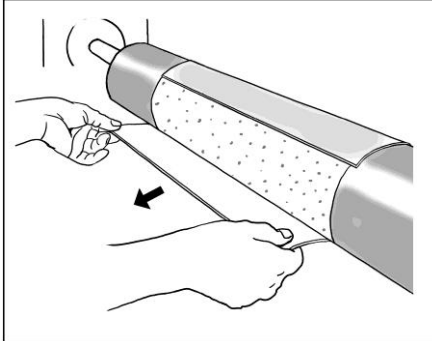


### Step 7 (Optional)

ORAFLEX® 11405 Edge Sealing tape can additionally be used to seal the plate edges on printing cylinders / sleeves with small diameter. Overlapping tape should be removed to avoid web breaks caused by the contact of tape and print substrate.

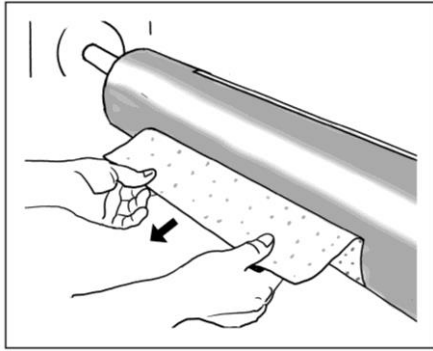
### Demounting of Print Plate

Below is a brief overview of easy demounting of print plates.



#### Step 1

Remove the plate first. To avoid plate stretching the peel angle should be flat. Loosen the edges of the print plate and pull it downwards, detaching it from the adhesive side of the ORAFLEX® cushion tape.



#### Step 2

Pull back the ORAFLEX® cushion tape from the cylinder and remove it. The printing cylinder / sleeve and plate should be cleaned before the next use.

For further help regarding the application and removal of ORAFLEX® cushion tapes, please contact ORAFOL's Customer Support (contact details below).

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