



Adhesive Tape Systems

Flexographic Mounting Tapes - Bringing life to your prints

ORAFLEX® Cushion
Cushion Mounting Tapes

for Flexible Packaging



Engineered to Perform Better™



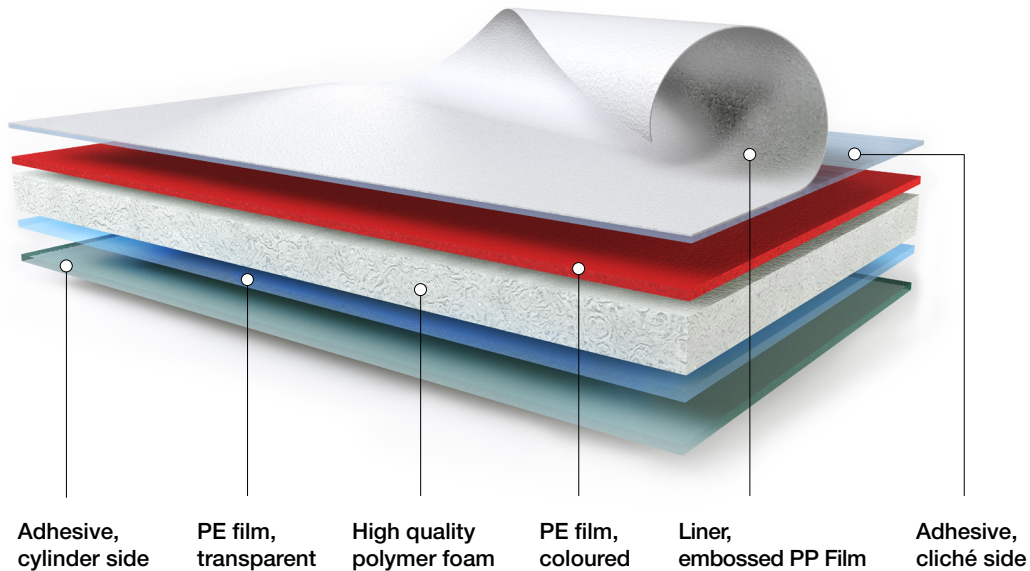
ORAFOL Europe GmbH

ORAFOL's Worldwide Locations



The **ORAFLEX®** Cushion Tapes are produced using odour-free pure solvent acrylate adhesives featuring the latest **ORAFLEX®** product designs with several adhesive types offering different levels of bonding and repositionability. These adhesives are also designed to be resistant to the typical solvents contained in inks used in flexographic printing.

ORAFLEX® Cushion Tapes' Compressible Foam and Film Reinforcement Construction



The **ORAFLEX®** Cushion Tapes' compressible foam and film reinforcement construction technology guarantees an optimized thickness accuracy, with minimal thickness tolerances (+/- 0.02 mm).

The flexible PE-film reinforcement reduces dot gain by perfect cushioning the applied impression.

The flexible product design also fully compensates expansion of thin-walled sleeves and ensures best bonding also on scratched sleeves.

It is interesting to note that the medium **ORAFLEX®** Cushion Tapes (1165X) offer a very wide range of linear dot gain making the hardness choice very easy – one medium tape can be used for most combinations and printing requirements.

ORAFLEX® Cushion product code identification

ORAFLEX®
product range




ORAFLEX® 11 6 2 4

Application thickness
„500 micron / 20 mil“

Adhesion level
„4-series“

Foam hardness
„Soft“

Product overview








	ORAFLEX® 1162X	ORAFLEX® 1165X	ORAFLEX® 1168X
Thickness category	0.5 mm 20 mil	0.5 mm 20 mil	0.5 mm 20 mil
Hardness, colour	Soft	Medium	Firm
Typical relationship between screen and solids			
Desired print image	Screen, half tones and minimum dot gain	Combination of solids and screens	Solid (no pinholing) optimal ink transfer
2-series Balanced adhesion	11622	11652	11682
4-series Enhanced plate side adhesion	11624	11654	11684
6-series Higher plate and sleeve side adhesion	11626	11656	11686
3-series Enhanced cylinder side adhesion for thin plates	11623	11653	11683
5-series Enhanced cylinder side adhesion for thick or stiff plates	11625	11655	11685

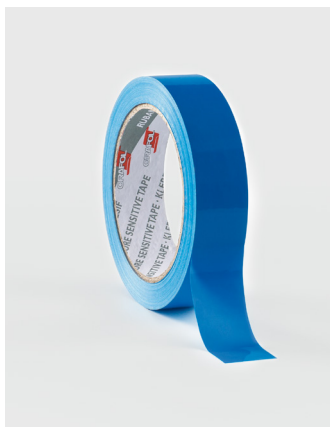
Tested by **DATA** TECHNOLOGIEZENTRUM
Die FlexoKompetenz.

ORAFLEX® Cushion

With the **ORAFLEX®** Cushion Tapes, consistent superb quality is ensured for your entire print run. The 0.5 mm tapes are available in three hardnesses, and designed to give good tolerance on pressure settings so that the optimal impression can be set very quickly. Now also available with five different adhesion levels. With the **ORAFLEX®** Cushion tapes, the plate is effectively protected from distortion factors, providing a great print result. Also issues such as bouncing stripes caused by press vibration at high speeds are avoided.



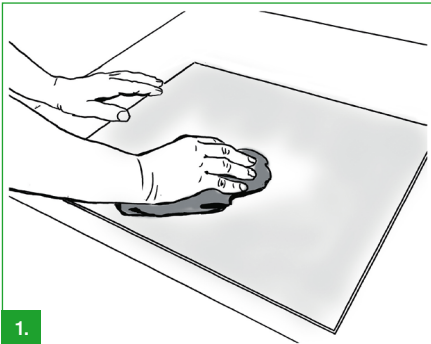
	Product	Colour	Thickness (µm)	Application
SPLICING 	ORABOND® 1301 	Red	90	Especially suitable in processes when visual splice is crucial. FDA certificate.
	ORABOND® 1346	Translucent	110	Splicing of paper, cardboard and film.
	ORABOND® 1459 	Translucent	140	Splicing of PE coated paper. FDA certificate.
	ORAFIX® 1490 QS Quick Splice 	Red	120	For flying splice applications in film and paper processing, e.g. printing processes. ORAFIX® 1490QS offers "Quick Splice" preparation combined with secure roll closure during flying splices.
EDGE SEALING 	ORAFLEX® 11405	Blue	60	Edge sealing tape can additionally be used to seal the plate edges on printing cylinders/ sleeves with small diameter.
CORE STARTING 	ORABOND® 1396TM 	Translucent	130	Core starting and splicing at high temperatures. FDA certificate.



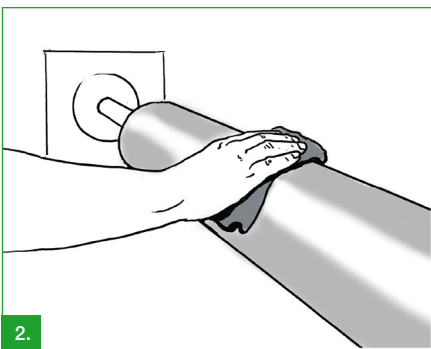
Application instructions

The self-adhesive ORAFLEX® tapes from ORAFOL are supplied in rolls. Always store them either suspended (with end caps) or standing on end on the roll blocks. Never store them lying down (without end caps). Store and process the materials in cool, dry environments. Specifically, a relative air humidity between 40% and 50% and a temperature between +18° to +22° C (64° to 72° F) should be ensured. Direct sunlight, storage beside radiators etc. should be avoided at all times. Please refer to the individual storage instructions listed in the technical data sheet for each type of material. 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).

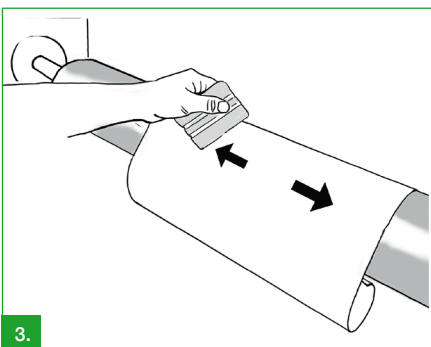
Clean and dry surfaces of cylinder and plates are very important for a proper tape performance during print (eg. plate lifting) and demounting (e.g. adhesive residues).



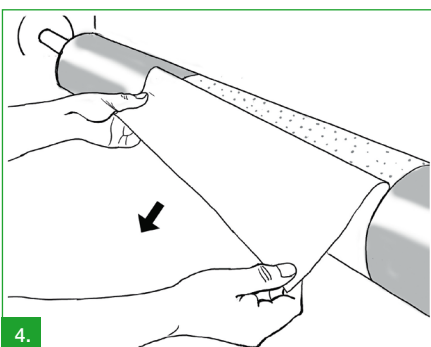
Clean the print plate. Make sure it is completely free from dust and other contaminations (e.g. ink or adhesive residues). Cleaning can happen with a suitable solvent and a lint-free cloth. Recommended solvent to use is isopropyl alcohol. Solvents like ethyl acetate should be avoided and can strongly affect adhesive performance. Ensure the surface is totally dried before mounting.



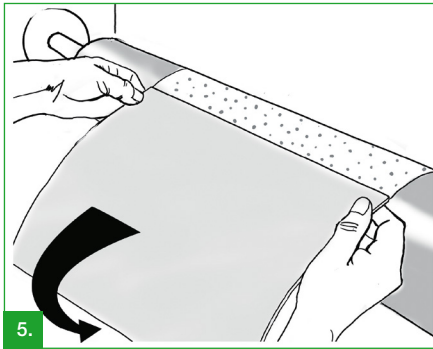
Clean the print cylinder per manufacturer recommendations and wipe dry with clean lint-free cloth. Make sure it is completely free from dust and other contaminations (e.g. ink or adhesive residues). Recommended solvent to use is isopropyl alcohol. Solvents like ethyl acetate should be avoided and can strongly affect adhesive performance. Ensure the surface is totally dried before mounting.



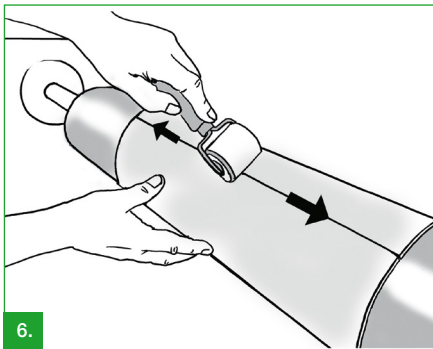
To avoid tensions in the adhesive bond the ORAFLEX® tape should be applied onto the printing cylinder / sleeve first. To avoid air entrapments apply the ORAFLEX® tape in a sweeping motion line by line on the printing cylinder. For best results use a squeegee or rubber roller.



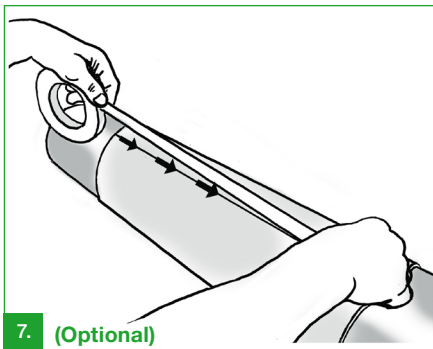
Pull down the liner and remove it from the ORAFLEX® tape without touching the adhesive.



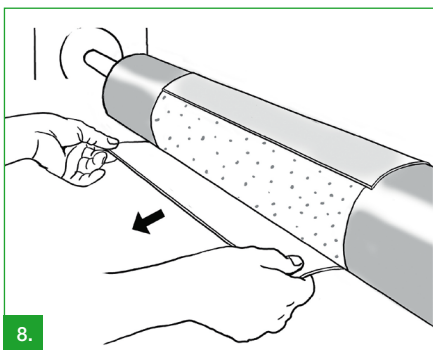
The print plate should be applied immediately after liner removal as dust might deactivate the open adhesive layer. Only fix the plate without pressure on a narrow area of the ORAFLEX® tape. Once the correct plate orientation is justified begin to apply the plate on the ORAFLEX® tape by using a rubber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



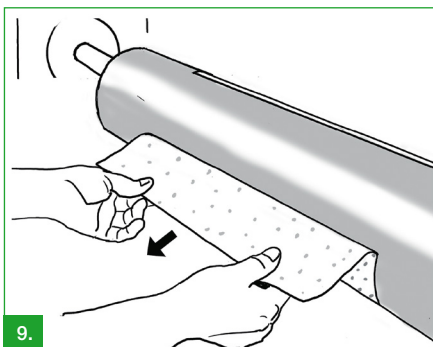
Particular care is required when pushing the ORAFLEX® tape into contact with the plate edges to avoid edge lifting especially on the leading and trailing edge.



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 contact of tape and print substrate.



For demounting: remove plate first. To avoid stretching of the plate 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® tape.



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.

Flexographic Mounting Tapes
Engineered to Perform Better™



ORAFOL Europe GmbH

Orafolstraße 1, D-16515 Oranienburg, Germany
Tel: +49 (0)3301 864-0 · Fax: +49 (0)3301 864-100
adhesive.tapes@orafol.de · www.orafol.com

