



FORUM 2023
TRADITION REIMAGINED

Sunday, April 16, 2023

Session Three Proceedings

The Great Tape Debate

Session Chairs



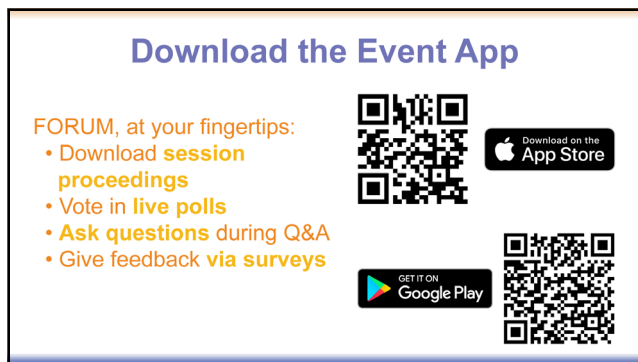
Catherine Haynes
All Printing Resources



Scott Rickard
DuPont



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Please Silence Your Devices

As a courtesy to our presenters and your fellow attendees, **please set your phone, laptop and other devices to silent.**



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Session Proceedings

Follow along with this session's presenters using the proceedings, **found in the Event App.**



5



Relaxed Commercialism

Some sessions follow FTA's **relaxed commercialism policy.**



You will see **company, brand and product names.**

6

Got Questions?

Three Ways to Submit

Via the Web

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Via the App



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The Great Tape Debate

Session Chairs:

Catherine Haynes, APR
&
Scott Rickard, DuPont

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Panel Hosts



Catherine Haynes
VP of Growth & Development
All Printing Resources
Over 26 years in Flexo. Involved with technical support, training, and product development.



Scott Rickard
Staff Associate Investigator
DuPont™ Cyrel® Solutions
Involved with new product development for flexo plate materials and technologies.





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Alix Guyot



- Application Solution Engineer for Flexo, Print & Paper at tesa tape
- Over 12 years in the flexo industry working on: Product Testing, Training, fingerprinting, RIP and color management software
- Current Chair of the FTA Excellence in Flexography committee
- *FIRST* Certified and a Graduate of Cal Poly's Graphic Communication program

Wanna hear a joke about paper?
...Nevermind, it's tearable



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VP of Sales-Polymount US
Graduated from Georgia Tech
MS Industrial Management

Alan Rogers



POLYMOUNT

29+ years experience in flexo industry

- Polymount US-2 Years
 - Self Adhesive Sleeves
 - Film Cleaners
 - Automated Plate Cleaners
- Harper Corporation of America-17 Years
 - Anilox Rolls
- Arcar Graphics/Flint Ink-10 Years
 - Water-base/UV Inks

If The Village People sang at FTA, what song would they sing? It's fun to print CMYK!



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Mat Waddell



- Application Engineering Specialist, 3M
- Five years in flexographic printing and industrial adhesives and tape
- Over 15 years of human factors and product development experience
- *FIRST* Certified Implementation Specialist

What is stronger than tape?
...More Tape



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- Applications Engineer Manager Graphics
 - Responsibilities include product testing, application troubleshooting, customer training, new product validation, and other related activities
 - 29 years with Lohmann: sales management, sales support, technical support
- Over 36 years in Flexographic Printing Industry
 - 8 years in Corrugated Preprint as a press helper and a plate mounter
- 10 years offset press operator

Stan Riches



Why do our noses run but our feet smell?...



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PHOTOGRAPHY BY JEFF RANDAZZO

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Jeff Randazzo



Controlled Displacement Technologies LLC



President CDT

- 50+ years in the printing industry
- The first to successfully produce color separations that match prepress proofs using photopolymer plate technology
- Founding father of *first* specifications
- Co-inventor of Displacement Cushioning
- 4 patents have been granted with additional patents pending

How do you make an "eggroll"? ...Push it



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PHOTOGRAPHY BY JEFF RANDAZZO

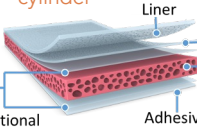
14



Mounting Tape 101

Foam Tape

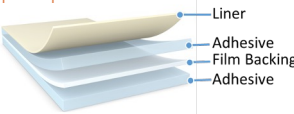
Used on a hard sleeve or cylinder



Thin Tape

Used on a compressible or cushion sleeve

Used for corrugated post print plates





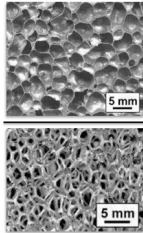
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Self-Adhesive Sleeves 101

Tape utilizes **closed cell foam** which is only temporarily compressible

Self-adhesive sleeves utilize **open cell foam** that does not collapse under print pressure and can absorb bounce more effectively



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Self-Adhesive Sleeves 101

Does not require plate mounting tape

Sleeve is constructed by applying a polyurethane foam over the sleeve topped with a permanent adhesive polymer

Plates stick directly to the polymer



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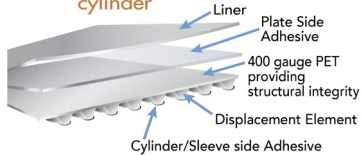
17



Displacement Cushioning Tape 101

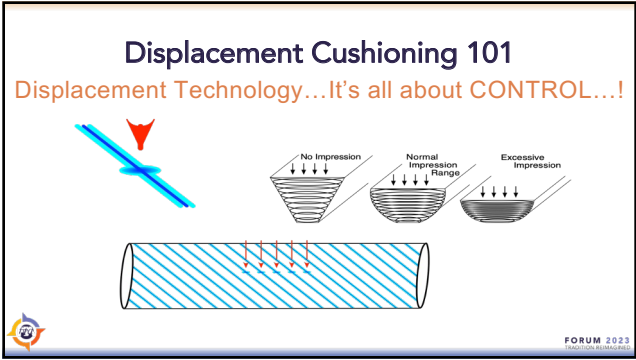
Displacement Cushion

- Used on a hard sleeve or cylinder

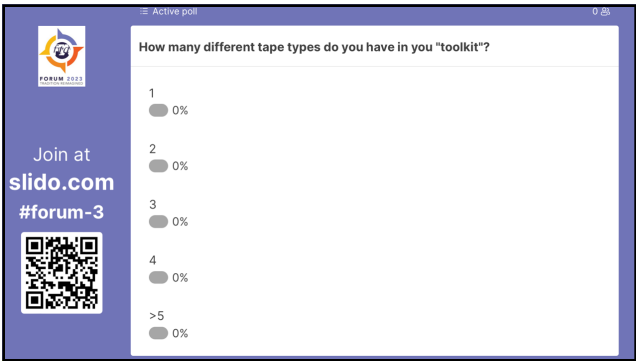


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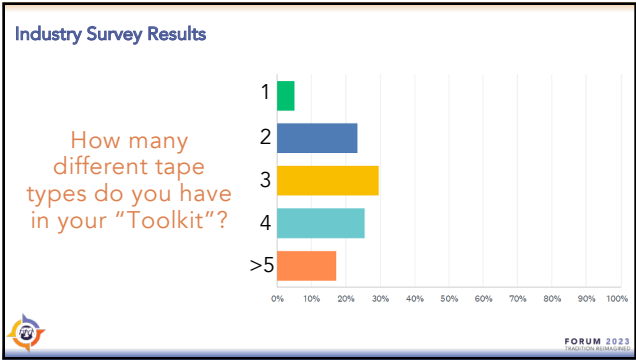
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How Many Different Tape Options Should a Print Shop Have Available?

Does this answer change based on market segment?

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Differences in Foam Tape Durometers

X-Soft		Soft		Medium		Medium-Hard		Hard		X-Hard	
Screen 40%	Screen 10%	Screen 40%	Screen 10%	Screen 40%	Screen 10%	Screen 40%	Screen 10%	Screen 40%	Screen 10%	Screen 40%	Screen 10%
Quality	Quality	Quality	Quality	Quality	Quality	Quality	Quality	Quality	Quality	Quality	Quality
Screen	Screen	Screen	Screen	Solid	Knock Out	Solid	Knock Out	Solid	Knock Out	Solid	Knock Out

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What Characteristics Differentiate Mounting Tapes & Self-Adhesive Sleeves?

Tape offers up to 6+ different densities which creates more inventory

Self-Adhesive Sleeves come in 3 different densities:
Soft, Medium and Hard



SOFT MEDIUM HARD
CUSHION AVAILABILITY

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One Durometer for All



Line Screen	152 LPI
Plate	Flat top with surface screening
Tape	Medium
Substrate	OPP

Anilox Specifications

Ink	Volume	Linescreen
C, M, Y, K	2.25 BCM	1168 LPI
Red	4.83 BCM	711 LPI

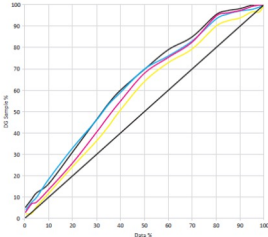
Values from tesa Softprint™ Print Study

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One Durometer for All

Tonal Value Increase



Solid Ink Density

Cyan	Magenta	Yellow	Black
1.30	1.30	1.10	1.35

Values from tesa Softprint™ drupa Print Study

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How Many Different Tape Types Do You NEED in Your "Toolkit"?

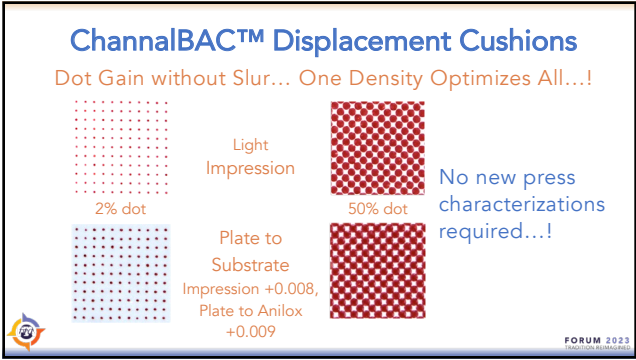
The Graphic elements below were produced, using a medium density foam

			
2% dot	30% dot	Solid	Line Copy

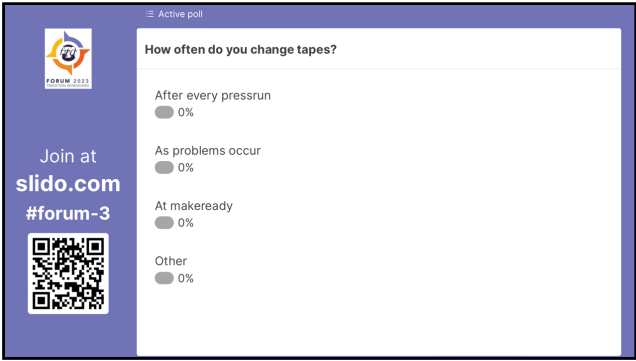
The Graphic elements above were produced, using a displacement cushion

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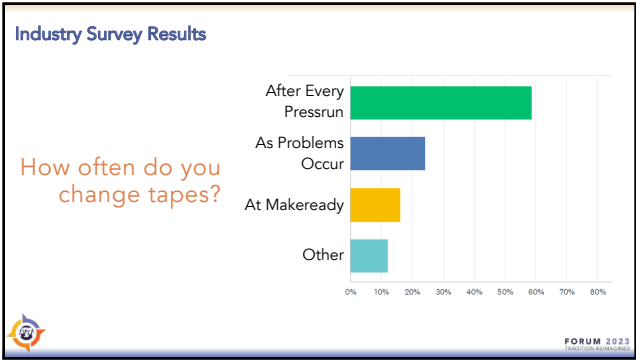


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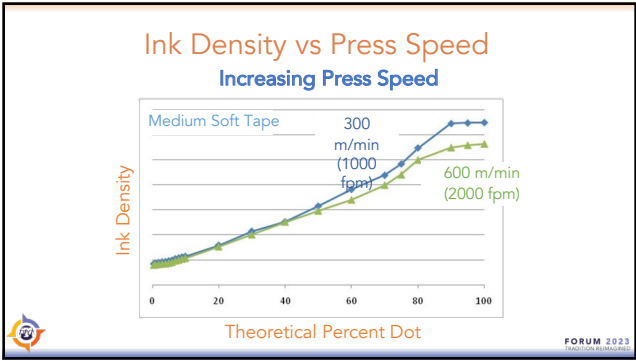


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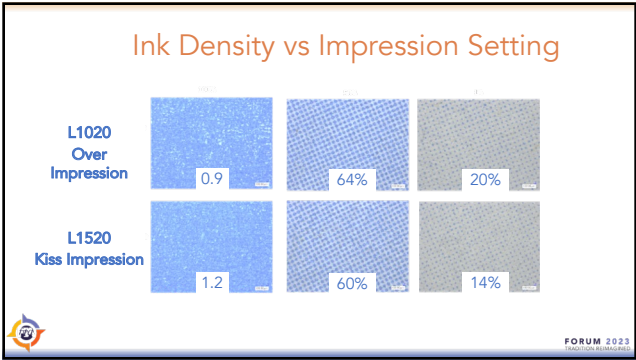
When Should Tapes or Self-Adhesive Sleeves Be Changed?

Are there any physical indicators to monitor?

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Ink Density vs Plate Technology

L1020
Smooth
Plate

L1320
Textured Plate

L1020
Textured Plate

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Self-Adhesive Sleeves

- The polyurethane foam underneath the sticky layer is manufactured using Open Cell Technology, which will not wear out!
- The sticky layer is made of an extremely stable polymer that simply does not change its structure
- This polymer layer is a permanent adhesive layer and therefore, does not require changing
- As long as SOPs are followed and the adhesive layer has not been damaged, it will outlive the life of the sleeve!

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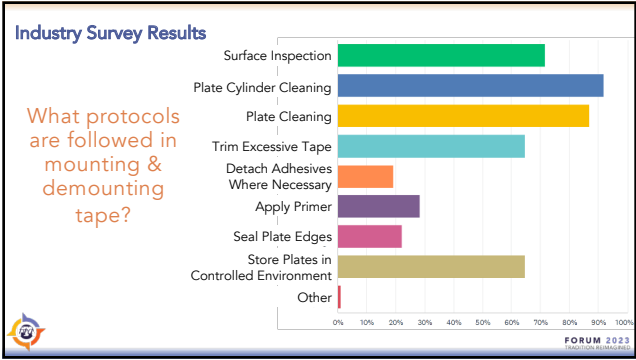
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Active poll

What protocols are followed in mounting and demounting tape?

- Surface inspection
☐ 0%
- Plate cylinder cleaning
☐ 0%
- Plate cleaning
☐ 0%
- Trim excessive tape
☐ 0%
- Detach adhesives where necessary
☐ 0%
- Apply primer
☐ 0%
- Seal plate edges
☐ 0%

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TRADITION REMAINS

What Are Best Practices for Mounting & Demounting Plates from Tape or Sleeves?

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Best Practices



Step 1



Step 2



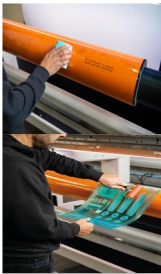
Step 3

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Best Practices - Self-Adhesive Sleeves

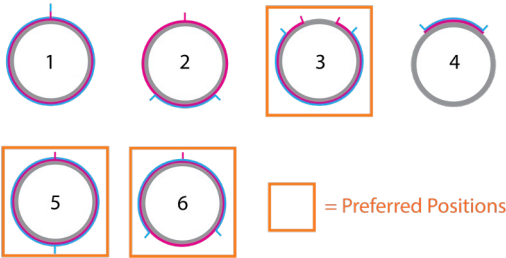
- Plate Mounting
 - Clean the sleeve with the **sleeve activator** by wiping side to side for 60 seconds
 - Make sure any **adhesion promoter** is removed
 - Let sleeve dry for 2 minutes
 - Clean the back of the plate
 - Start mounting the plate





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Best Practices



 = Preferred Positions



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Best Practices



Step 4 **Step 5** **Step 6**



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Best Practices



Step 4

Step 5

Step 6



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FLEXIBLE TECHNOLOGIES

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Best Practices



Step 4

Step 5

Step 6



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FLEXIBLE TECHNOLOGIES

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Active poll

What variables in the print environment lead to the tape becoming problematic on press?

Increased press speed

0%

New/unfamiliar substrate

0%

Increase in plate durometer

0%

New variety of plate

0%

Over-aggressive solvent

0%

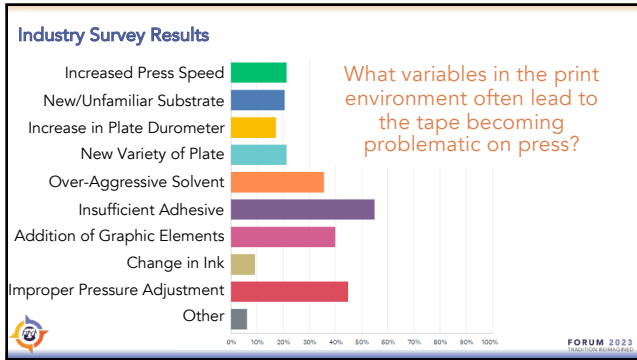
Insufficient Adhesive

0%

Addition of graphic elements

0%

45



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What Variables Have the Biggest Impact When Trying to Standardize Tapes & Adhesive Sleeves Across Sites

What are some strategies to mitigate or compensate for the inherent differences?

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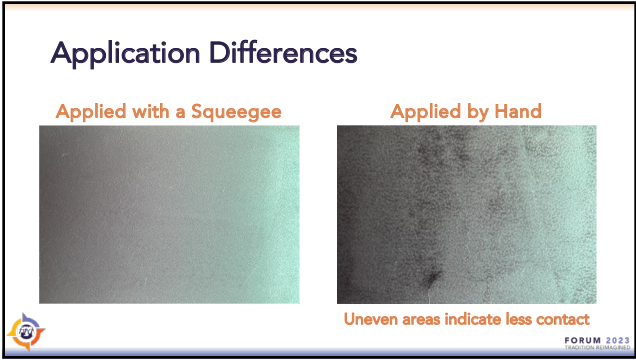
Surface Condition of Plate or Sleeve

Smooth Surface vs Rough Surface Clean Surface vs Dirty Surface

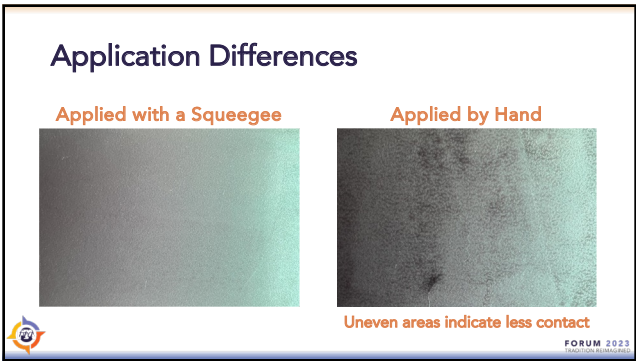
Adhesive	Adhesive	Adhesive	Adhesive
Sleeve/Cylinder Or Plate	Sleeve/Cylinder Or Plate	Sleeve/Cylinder Or Plate	Sleeve/Cylinder Or Plate

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Active poll

What are the advantages of mounting tape vs self-adhesive sleeves?

- Tighter registration
☐ 0%
- Faster press speeds
☐ 0%
- Minimize photopolymer plate wear
☐ 0%
- Relieve pressure
☐ 0%
- Control vibration
☐ 0%
- Mitigate bounce
☐ 0%
- Ensure consistent print result
☐ 0%

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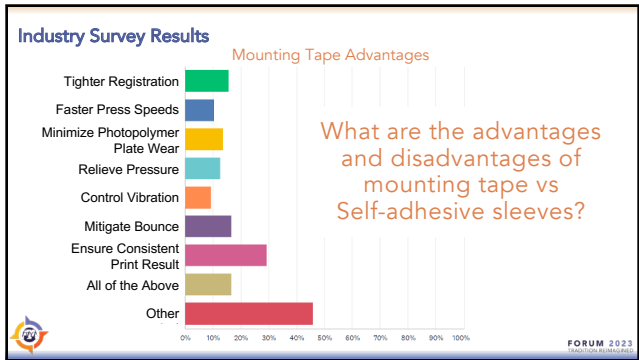
Active poll

What are the disadvantages of mounting tape vs self-adhesive sleeves?

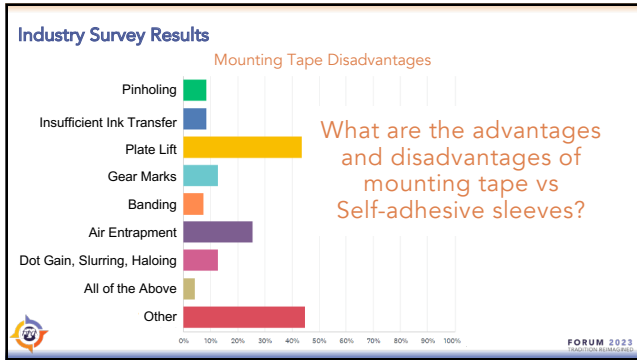
- Pinholing
☐ 0%
- Insufficient ink transfer
☐ 0%
- Plate lift
☐ 0%
- Gear marks
☐ 0%
- Banding
☐ 0%
- Air entrapment
☐ 0%
- Dot gain, slurring, haloing
☐ 0%

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What Characteristics Differentiate Mounting Tapes & Self-Adhesive Sleeves?

Is there room for having both at a print facility?

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What Characteristics Differentiate Mounting Tapes & Self-Adhesive Sleeves?

Tape is disposable and creates waste

Self-Adhesive Sleeves create less waste, and are more sustainable

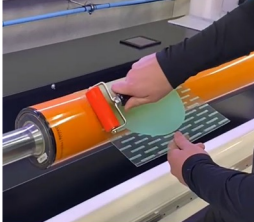


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What Characteristics Differentiate Mounting Tapes & Self-Adhesive Sleeves?

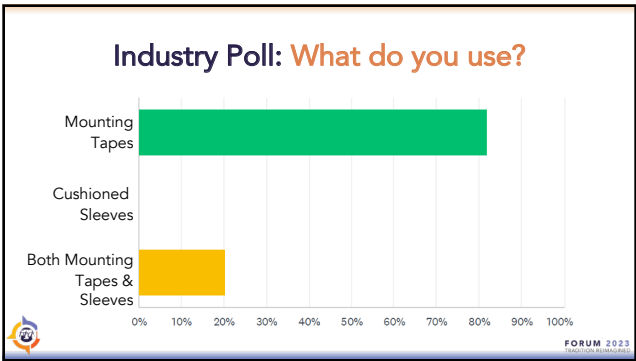
You are not double mounting, i.e., mounting tape prior to the plate, so your plate mounting department becomes more efficient, with time savings up to 40%





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PHOTOGRAPHY & VIDEO

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Active poll

What are the biggest challenges for mounting tapes and self-adhesives sleeves?

Plate lift

0%

Print quality

0%

Inventory

0%

Over aggressive adhesives

0%

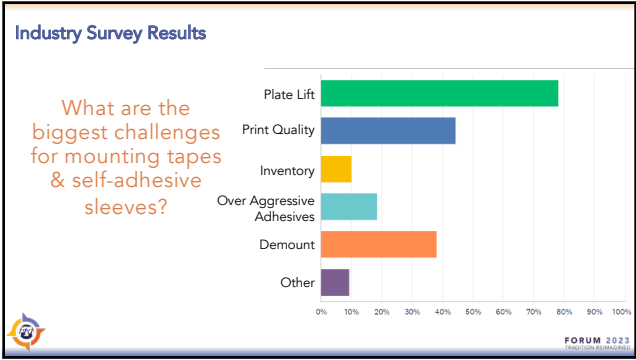
Demount

0%

Other

0%

60



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What Are the Biggest Future Challenges for Tapes, Displacement Cushioning & Self-Adhesive Sleeves?

What needs to be addressed to drive innovation?

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Staying Ahead of Global Trends



Automation
Sustainability
High Worker Turnover Rates

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tesa

Alix Guyot
Booth 629

Panelists

Lohmann

The Bonding Engineers

Stan Riches
Booth 529

POLYMOUNT

Alan Rogers
Booth 429

Controlled Displacement Technologies LLC

Jeff Randazzo
Booth 701

3M

Mat Waddell
Booth 513

Panel Co-Chairs

apr

Catherine Haynes
Booth 701

DUPONT

Scott Rickard
Booth 617

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HOUSTON, TEXAS

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See You This Evening

6:30 p.m. – 7:30 p.m. — President’s Reception

7:30 p.m. – 9:30 p.m. — Awards Banquet



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