



STANDARD OPERATING PROCEDURE

Preparing Plates and Activating, Mounting,
De-Mounting tesa Twinlock® Sleeves



ACTIVATING THE SELF-ADHESIVE SLEEVES



1a. Start by wrapping the cleaning cloths around the supportive block multiple times with the rough side on the outside.

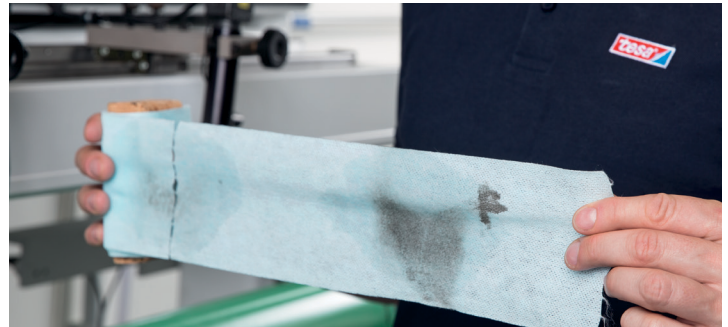


1b. We recommend wrapping the cleaning cloths around the supportive block at least 6 times.



2a. Wet the cleaning cloths with the tesa Twinlock® Activator (with the rough surface of the cloth being on the outside). Place the supportive block with the cleaning cloths on top of the sleeve. Use the register slot (notch) as a reference for knowing when you have cleaned.

2b. Use the rough side of the wet cloth to effectively clean the sleeve. This will remove all dust and dirt from the tesa Twinlock® sleeve surface.



2c. Remove the dirty cleaning cloths by tearing if from the rest of the roll.

3. Let the tesa Twinlock® sleeve dry for 1 - 2 minutes before mounting the printing plates.



Make sure that all residual marks left by the adhesion promoter are removed.

Apply pressure with the cloth when cleaning the sleeve. Inspect the sleeve from an angle.

PREPARING THE PLATES BEFORE MOUNTING



Burr under
the plate



ROUGH CUTS / BURR

NO BURR



1. Check your plates for rough cuts or burrs.

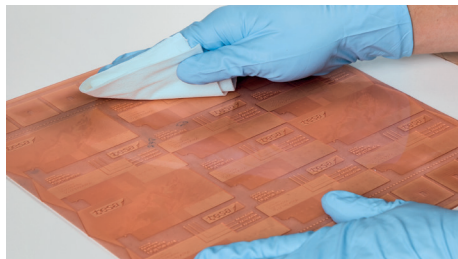
Trim the edges using the burr trimmer (ceramic / martor).

Do not apply pressure and hold the burr trimmer at a 45 degree angle.



2. Clean the back of the printing plate with tesa Twinlock® Activator before mounting. Solvents used in printing plate processors can be very greasy and will leave some residue on the back of the plate.

Residues decrease the adhesion between the printing plate and the tesa Twinlock® sleeve.



It is important to clean the back of the printing plate with tesa Twinlock® activator before mounting.

PRIMING THE PLATES WITH ADHESION PROMOTER



1. Place your printing plates upside down on a table.
(Printing surface facing down)
- 2a. Hold the primer pen upside down and press until the felt is wet (be careful not to press too much!)
- 2b. Apply a thin layer of adhesion promoter by moving the pen along the leading edges of the plate.

Make sure that you apply the adhesion promoter across the whole width of the plate.

The adhesion promoter is transparent, look at it from an angle to ensure you have applied it evenly across the plate.

- Allow the primer to dry for 1 - 2 minutes.

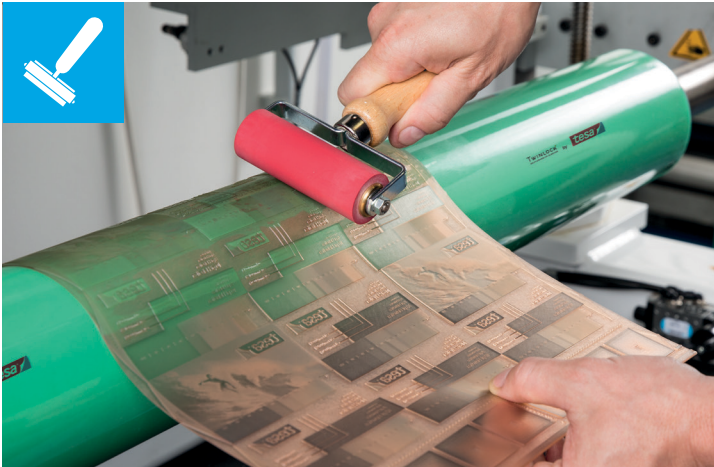


- 2c. You can also place the plates on top of each other (staggered) and apply the primer on each edge, as shown in the picture.
- Make sure the primer is dry before doing the same on the other edge.
 - Allow the primer to dry for 1 - 2 min on each edge.
 - Avoid touching the primed surface before mounting!

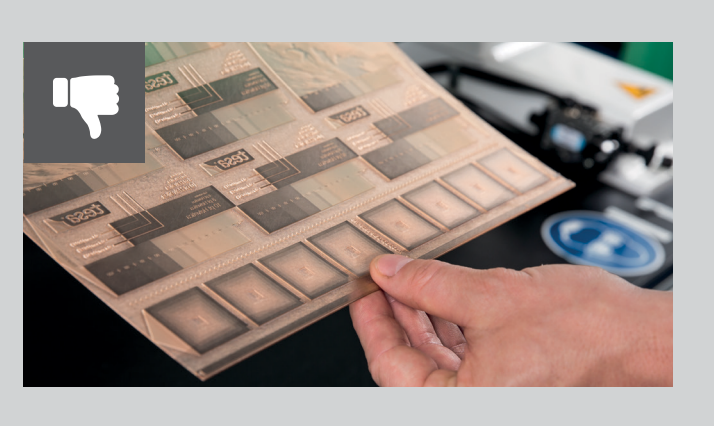
MOUNTING ON SELF-ADHESIVE SLEEVES



1. Avoid touching the primed surface when supporting the plate.



2. Always use a roller when applying the plate manually. Slowly apply pressure from side to side over the plate.



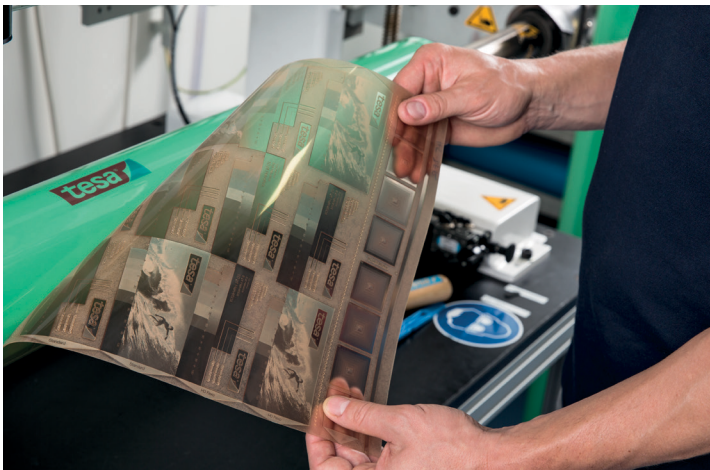
DE-MOUNTING FROM SELF-ADHESIVE SLEEVES



1. After printing remove the plate as normal.

We recommend to use your fingernails to lift the edge.

- Never use any sharp tools.

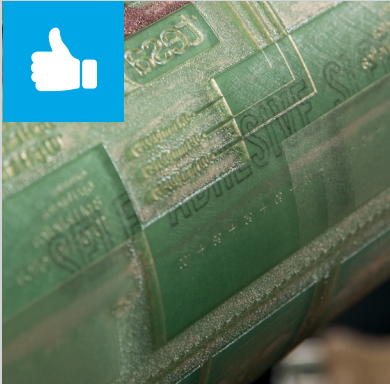


2. Remove the plate at an angle without using any force.

Especially when using Adhesion Promoter, because this makes the plate edge stick firmly.

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IMPORTANT ASPECTS WHEN USING SELF-ADHESIVE SLEEVES



Air bubbles should always be avoided when mounting on tesa Twinlock®.

Please see page 5 points 1 and 2 on how to avoid this.



tesa Twinlock® Sleeve accidentally stuck together?

Never use force to separate tesa® Twinlock sleeves that are stuck together.

Place a cloth on the floor to prevent spillage.

Pour a small amount (10 ml or 1/3 oz) of tesa® Twinlock Activator between the sleeves. Alternatively, water can also be used.

Now carefully separate the sleeves. Inspect the sleeves for any possible damage that may have occurred.

No Knives!
No Cutting
on tesa
Twinlock® Sleeves.





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Our management system is certified according to the standards ISO 9001, ISO 14001, and ISO/TS 16949.

Creating the bonds that drive people and the world forward

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