



# tesa® ACX<sup>plus</sup> SEAL LINE

## Our Solutions for Mounting of Window and Water Box Seals

### tesa® ACX<sup>plus</sup> 74508 Seal Line 0.8 mm heat-activatable acrylic foam tape

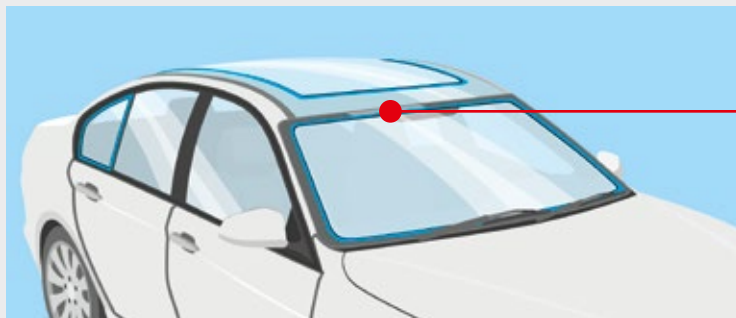
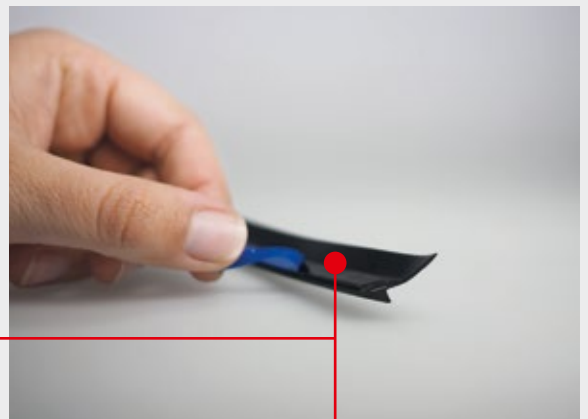
tesa® ACX<sup>plus</sup> 74508 Seal Line is a deep black acrylic foam tape for permanent mounting of weather strips and water box seals, mainly on automotive glass. It has a heat-activatable adhesive on the non-liner side. The adhesive gets activated by hot air or near-infrared when applying it onto the PP/EPDM, PP, TPV, and TPE seal.

Compared to the conventional process with primer, tesa® ACX<sup>plus</sup> Seal Line ensures a highly secure bond to the rubber profile, enables higher application speed than using primer, and realizes a more environmental-friendly production process.

Its outstanding cold-shock resistance is based on a modified acrylic foam core, which assures a reliable bond even at extreme low temperatures. Being viscoelastic, tesa® ACX<sup>plus</sup> 74508 Seal Line absorbs and dissipates dynamic and static loads optimally. This exceptional capability enables tesa® ACX<sup>plus</sup> 74508 Seal Line to compensate for extreme physical stress caused by the different thermal elongation of bonded parts in rapidly changing temperatures.

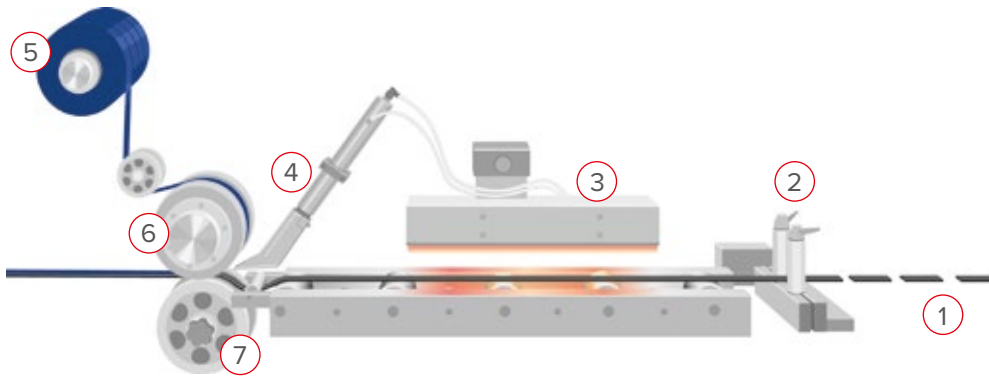
#### Features:

- Efficient and secure bonding of the heat-activatable layer to seals
- Strong bonding of the heat-activatable layer to backing which withstands humidity and heat
- High stiffness of tesa® ACX<sup>plus</sup> 74508 Seal Line is especially suitable for mounting of water box profiles
- Extremely high shear resistance
- Closed cell acrylic foam core for reliable sealing to prevent water penetration
- High humidity and UV resistance
- Excellent cold-shock performance



tesa® ACX<sup>plus</sup> 74508 Seal Line can be widely used for mounting window seals, water box seals, sunroof seals, and obstacle detection systems (ODS). The deep black color provides an enhanced appearance and high design flexibility.

## Process diagram for heat-activatable tesa® ACX<sup>plus</sup> 74508 Seal line



1. Continuously or discontinuously feeding the profile
2. Positioning of the profile
3. Infrared lamp to preheat the profile (optional)
4. Hot air/blowtorch\*
5. Unwinding station ACX<sup>plus</sup> Seal Line
6. Water-cooled lamination unit
7. Lamination unit (unchilled)

\* Blowtorch is displaceable, so the hot air does not heat the machine and tape whilst machine is not running

## Product finder

Step 1: Material for seal		PP/EPDM/TPV		PVC
Step 2: Process options for applying tape to seal		Hot air or infrared	Adhesion promoter	Adhesion promoter
Step 3: Choice of tape		74508	7808	7808
Step 4: Choice of tabbing solution	Adhesive tabbing	PV29	PV29	PV29
	Heat-sealable tabbing	PV28/PV29	PV29	PV29

Remark:

- PV28 = filmic liner in royal blue, heat sealable, silicone free
- PV29 = filmic liner in royal blue, siliconized to adhesive side and silicon free to tabbing side

## Product range

	Thickness of tape [µm]	Adhesive	Color	Backing	Liner	90° peel adhesion		Dynamic shear resistance			
						PP/EPDM	Glass	PP/EPDM		Glass	
						RT 3 days [N/cm]	RT 3 days [N/cm]	after warm humid ageing (240h 40°C/100 - 6% r.h + 8h 70°C) [N/cm <sup>2</sup> ]	after 90°C ageing 240 h [N/cm <sup>2</sup> ]	after warm humid ageing (240h 40°C/100 - 6% r.h + 8h 70°C) [N/cm <sup>2</sup> ]	after 90°C ageing 240 h [N/cm <sup>2</sup> ]
tesa® 74508	840	Modified acrylic	Deep black	Foamed acrylic	PV28/PV29	56	30*	120	190	120*	190*
tesa® 7808	800	Modified acrylic	Deep black	Foamed acrylic	PV29	60*	30*	120*	150*	120*	150*

\* With adhesion promoter

Remark: all values are preliminary

## Tabbing tapes

	Liner type	Thickness [µm]	Adhesive	Backing	Tensile strength [N/cm]	Elongation at break [%]
<b>Adhesive tabbing tapes</b>						
tesa® 54999	PV29	150	Silicone	PET	>100	>75
<b>Heat tabbing film</b>						
tesa® 50999	PV28 PV29	150	LDPE	PET	40	>75

## Adhesion promoters

	Surface	Drying	UV traceability	Application time	Toluene content
tesa® 60151	Glass	Min. 30 sec. **	No	5 min.	None
tesa® 60153	PP/EPDM Glass	Min. 30 sec. **	Yes	Several days ***	None

\*\* Solvent has to be flashed off

\*\*\* Surface has to stay free of dust

tesa® products prove their impressive quality day in, day out in demanding conditions and are regularly subjected to strict controls. All technical information and data above mentioned are provided to the best of our knowledge on the basis of our practical experience. They shall be considered as average values and are not appropriate for a specification. Therefore tesa SE can make no warranties, express or implied, including, but not limited to any implied warranty of merchantability or fitness for a particular purpose. The user is responsible for determining whether the tesa® product is fit for a particular purpose and suitable for the user's method of application. If you are in any doubt, our technical support staff will be glad to support you.