



08/2021



Our management system is certified according to the standards ISO 9001, ISO/TS 16949, ISO 14001, and ISO 50001.



Tape solutions for custom applications

Assortment for Converter Partners

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tesa.com/company/locations

tesa.com



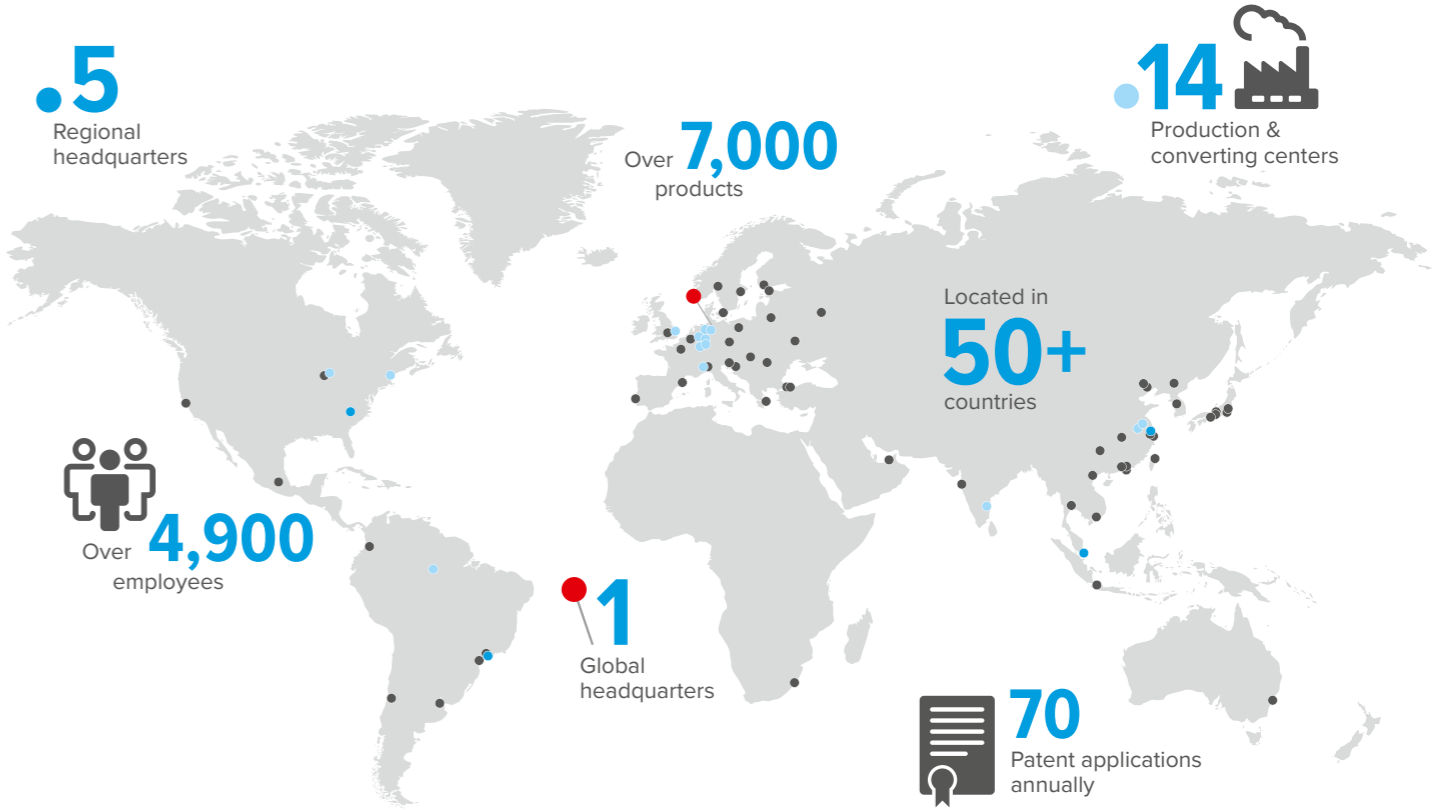
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By your side

About us



Your adhesive solutions partner

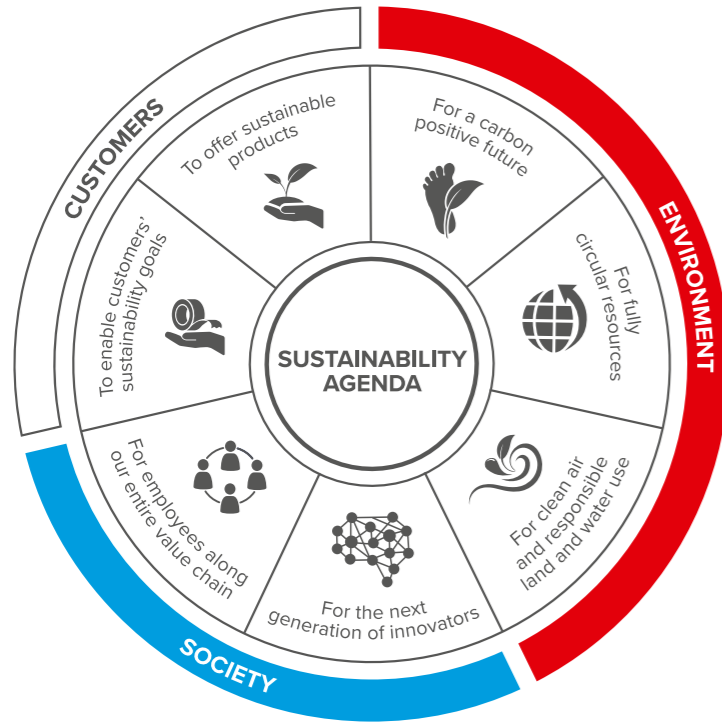
tesa's story begun in 1890 and today is that of one of the world's leading manufacturers of technical adhesive tapes and self-adhesive system solutions, with an assortment of more than 7,000 products. Our solutions prove their performance in countless sectors around the globe, also thanks to a capillary network composed of thousands of distribution and converting partners.

Industrial applications - in sectors such as the automotive and transportation industries, electronics, printing and paper, building supply, healthcare and renewable energy - account for about 75% of the tesa group's sales. This allowed us to build a solid expertise and market intimacy that we channel in our continuous product developments.

Sustainability agenda

A compass for a positive change

As one of the world's leading adhesive technology companies, at tesa we make an important contribution by firmly anchoring sustainability in our core business processes and decisions and driving equitable growth for the benefit of all stakeholders.



Environment

Contributing to climate protection and circular economy by reducing our environmental footprint along the product life cycle.

Customers

Expanding the range of sustainable products and enabling customers to meet their sustainability goals.

Society

Ensuring good working conditions for employees along our entire value chain and empowering the next generation of innovators.

Goals and pillars

To meet our commitments, we have defined a set of goals and indicators aligned with our Sustainability Agenda:

Environment

- Reduce energy-related CO2 emissions absolute by 30% versus 2018
- Purchase solely renewable electricity and switch to clean energy sources for electricity production
- Strive for smarter chemicals
- Achieve zero waste to landfill

Customers

- Increase sales with sustainable products
- Strive for sustainable packaging
- Increase share of recycled and renewable materials

Society

- Source 80% of direct spend from responsible suppliers
- Strive for zero accidents
- Empower young people through education in STEM

Did you know?



Sustainable products

We promote the transition to recycled and/or renewable material in our products.

Increased share of sustainable products



Carbon neutrality

We are accelerating our work to reach a zero-carbon footprint by 2050 – focusing on efficiency, green energy and low-carbon products & solutions.

Significant reduction of absolute carbon emissions



Responsible supply chains

We monitor key suppliers' sustainability practices by using EcoVadis.

Ensure we work only with suppliers that adhere to social and environmental standards

A strong track record in 2020



tesa awarded CDP "B"-rating for climate engagement



100% green electricity purchased for all sites and investment decision for solar panels at plant in China



23% absolute CO2 reduction compared to 2018



Headquarters and tesa Converting Center awarded „Sicher mit System“ quality seal for occupational safety



EcoVadis: tesa belongs to top 15% in the industry



31% of direct spend from responsible suppliers

You want to learn more?

To know more about our Sustainability agenda visit our website: www.tesa.com/en/about-tesa/sustainability





Converting
expertise

Product excellence and market intimacy across industries

By partnering with tesa as a Converter Partner, you have decided to join our network of strategic business allies. Your company is recognized as a strong and proficient resource and working together we believe we can mutually grow our businesses.

As a Converter Partner, your company has access to the consistent high quality of the extended tesa assortment as well as to the expertise and support of our sales, supply chain, marketing, customer support and Customer Solution Center teams.



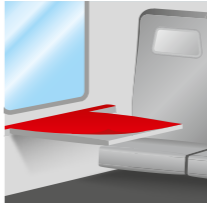
Customized solutions across industries



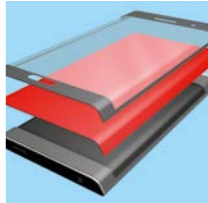
Automotive



Appliance



Transportation



Electronics



Health & medical



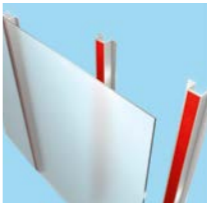
Leather & textile



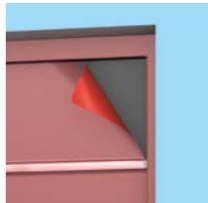
Signage



Furniture



Construction



Doors & windows



Renewable



Retail

From sketch to reality

Even with the most demanding requirements, we support you in finding the best possible solution. We know converting involves a variety of processes, such as:

- Die cutting
- Punching
- Lasering
- Slitting
- Rewinding
- Laminating
- Printing
- Spooling

By combining your converting expertise with our high-quality products and expert adhesive consultancy, you can create customized products for all market needs.



Partners beyond tape



Product excellence

Access to the broadest tesa product portfolio, including a selection of 60+ products handpicked for our Converter Partners, on which we guarantee quick sampling in different formats (mini-log, A4 sheets) and minimum order quantity of one log roll on most standard orders.



Expert support

Our Sales personnel and Converter Experts are there to assist you with any customer request. Technical experts at tesa Customer Solution Center also offer on-site and remote support and evaluation of your individual application under laboratory conditions.



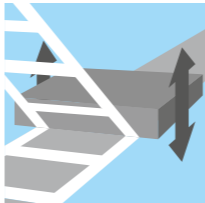
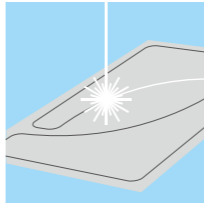
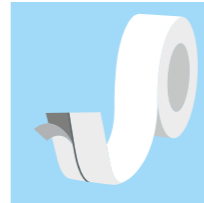
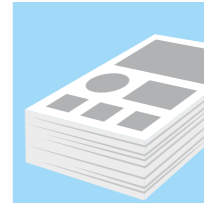
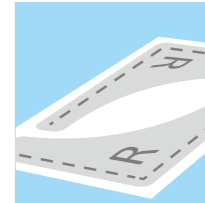
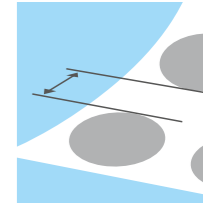
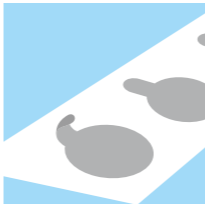
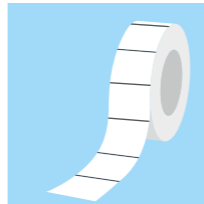
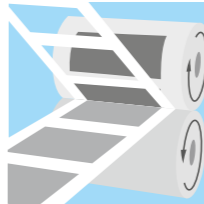

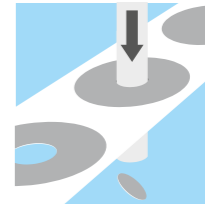
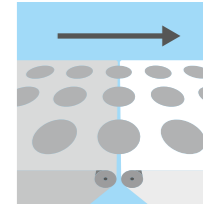
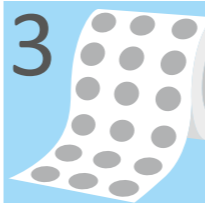
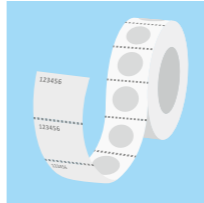

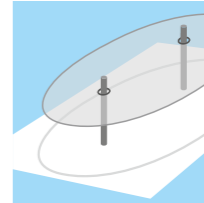
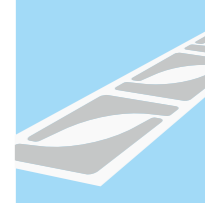
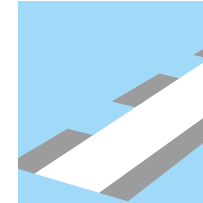
Testing & benchmarking

Technical consultants will support you on-site and remotely from our labs, resorting to state-of-the-art equipment to perform:

- Comparative tests with competitor products
- Customized tests with customer substrates
- Simulations under a wide range of environmental conditions

Sample converting applications

The world of converting is one of endless opportunities, powered by technical expertise as well as the right amount of creativity. These are just some examples of die-cutting designs you can create with our broad tape assortment:

					
Flatbed die and kiss cutting	Die cuts lasered onto rolls or sheets	Seperable paper layer with possible divisions	Family sheets (different shapes on the same sheet)	Die cuts with print or tape as application aid	Individually desinable gaps between die cuts
					
Finger lift with grabbing tab	Butt cutting, with or without space between objects	Rotary die cutting with hole punching	Die cuts and rolls with positioning tabs	Hole punching with automatic waste removal	Die cut can be easily transferred to another backing
					
Die cuts placed in multiple rows along the same sheet	Sections of roll can be perforated for easy separation	Butt cutting, with or without space between objects	Positioning features to aid marking	Die cuts interlaced to save material	Intermittent adhesive zones can be produced

Pressure-sensitive adhesive basics

An interplay between adhesion and cohesion



■ Substrate ■ Pressure-sensitive adhesive

Adhesion

Adhesion refers to the sum of all forces which occur at the interfaces between two substrates, e.g. a surface to be bonded and a pressure-sensitive adhesive. The measurable bond strength of adhesion results from the combination of these physical interactions and the energy dissipation from the pressure-sensitive adhesive's viscoelastic properties.

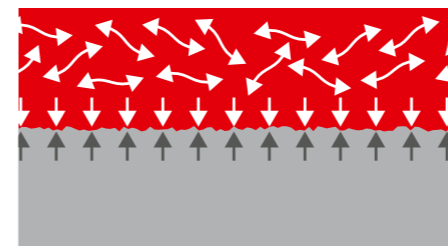
A particular form of adhesion is the tack, which determines whether an adhesive mass can quickly wet a surface with which it comes into contact with virtually no pressure. But the tack does not ultimately correlate with the actual bond strength of a pressure-sensitive adhesive. Pressure-sensitive adhesives with a low tack are capable of withstanding high stresses when high final adhesive strength and/or high shear strength are formed.



■ Substrate ■ Pressure-sensitive adhesive

Cohesion

For the adhesive bond to stay intact, sufficient cohesion (internal strength) of the pressure-sensitive adhesive is required. The cohesion of a pressure-sensitive adhesive describes the elastic behaviour of the adhesive, which in turn has an impact on the shear strength or restoring forces of a bond.



■ Substrate ■ Pressure-sensitive adhesive

Adhesive strength

Adhesive strength is described by the interplay of adhesion and cohesion, i.e. only through a certain combination of adhesion and internal strength is an adhesive bond able to withstand the stresses that act on it.

The role of polarity

Surface tension

In order to achieve sufficient contact points for the formation of high adhesion forces, the pressure-sensitive adhesive must be able to sufficiently wet the substrate to be bonded. Wetting largely depends on the surface tension or energy of the substrate and the pressure-sensitive adhesive.

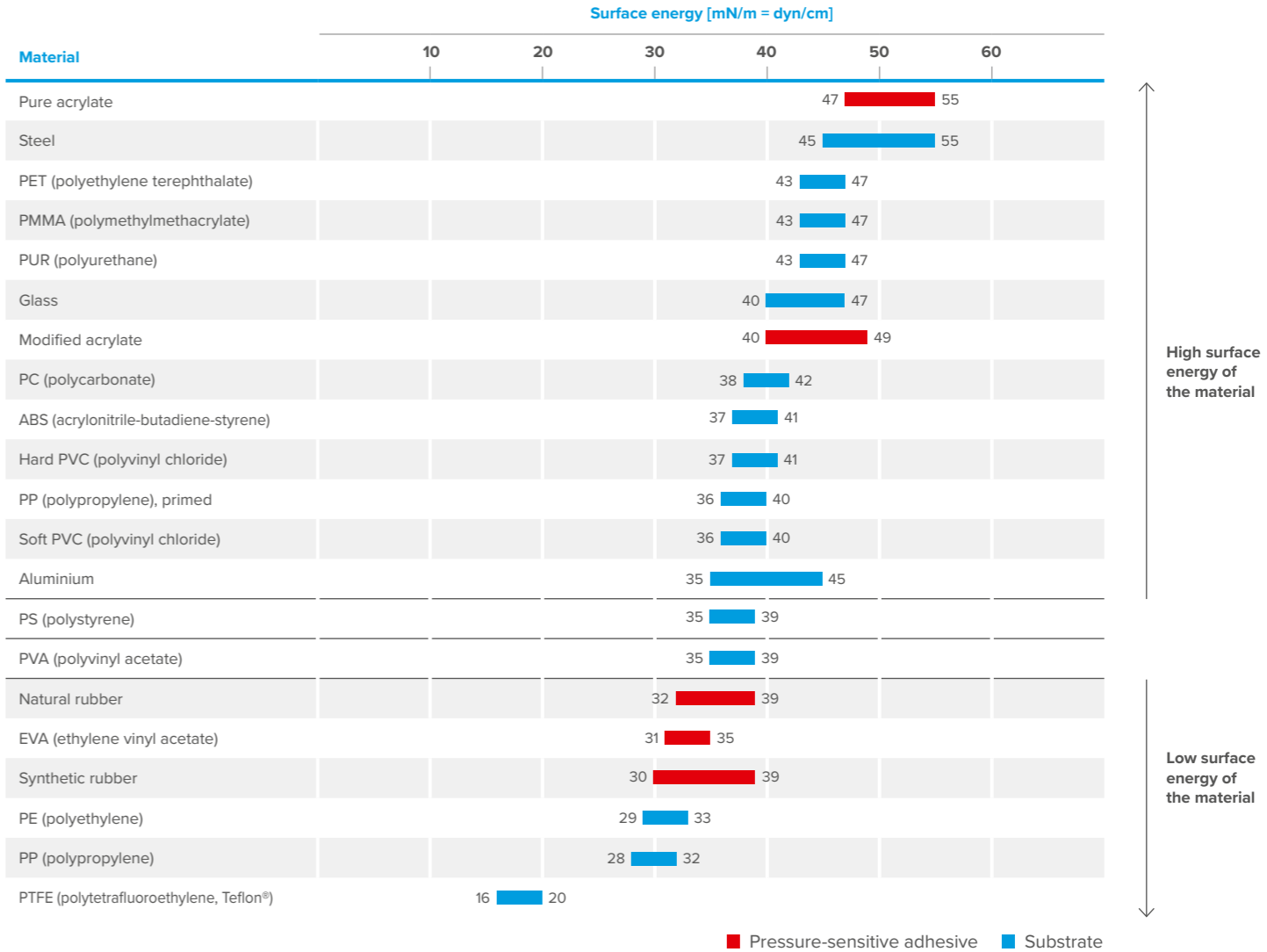
A pressure-sensitive adhesive is generally able to wet-out a substrate if the substrate's surface energy is greater than or equal to that of the adhesive. The higher the wet-out, the more contact points are available to form a bond between two surfaces. As a first indication one can use a water droplet to differentiate between high and low surface energy

Wettability	Poor	Good	Very good
Surface energy	Pressure-sensitive adhesive > substrate	Pressure-sensitive adhesive = substrate	Pressure-sensitive adhesive < substrate

substrates. If the droplet forms a film, this points to a high surface energy. On the other hand, if it stays a droplet or drips off, it points to a lower surface energy than water. In this case, bonding to the substrate may be difficult.

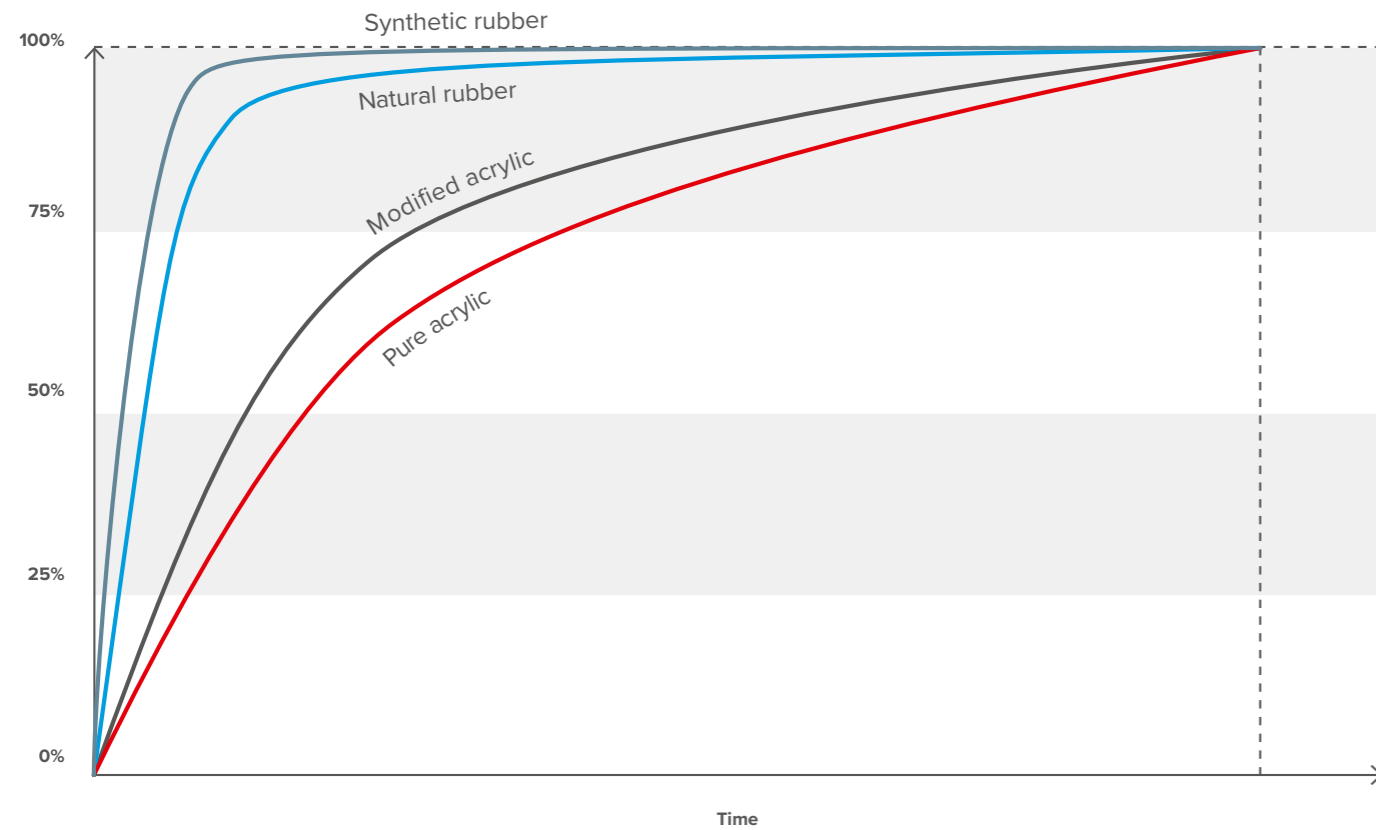
More accurate results are achieved with so-called test inks, which are also available in pen form. The surface energy is given in mN/m, dyn/cm or sometimes also in mJ/m², whereby: 1 mN/m = 1 dyn/cm.

The boundary between low-energy and high-energy surfaces is usually drawn in the range of a surface energy of 36 – 38 mN/m. Therefore, the bondability for surface tensions above this range is usually problem-free, whereas at values below this range a pretreatment of the surface to be bonded should be considered.



Peel adhesion and tape structure

Initial and ultimate peel adhesion



Due to the viscoelastic character of an adhesive tape the peel adhesion increases over time. The time needed to achieve the ultimate peel adhesion strongly depends on factors such as the type of adhesive mass, temperature, contact pressure and substrate. This behavior is described as the initial and ultimate peel adhesion.

As the chart shows, both synthetic and natural rubber pressure-sensitive adhesives require less time to reach the ultimate peel adhesion than acrylic-based pressure-sensitive

adhesives. As a rule of thumb, it takes 72 hours to achieve the ultimate peel adhesion of acrylic adhesives. With the use of a bonding agent (adhesion promoter) the time needed to achieve the ultimate peel adhesion is typically reduced.

Higher temperatures also significantly reduce the time needed to achieve the ultimate peel adhesion. At lower processing temperatures, a much longer time is once again required to achieve the ultimate peel adhesion.

Adhesive tape structure

All adhesive tapes consist essentially of a backing material and at least one self-adhesive layer of adhesive. The product structures shown on the right are typical for single-sided and double-sided adhesive tapes.

The adhesive and backing materials are adapted to the specific application requirements of each tesa® adhesive tape solution. Examples of adhesive masses are acrylics, natural rubber and synthetic rubber.

Examples of backings are film, paper, tissue and foam. In order to help you choose the appropriate adhesive tape, we offer product ranges for the various fields of application. These include, for example, adhesive tapes for surface protection, masking, bundling and permanent bonding in the automotive, electronics, construction or furniture industries.



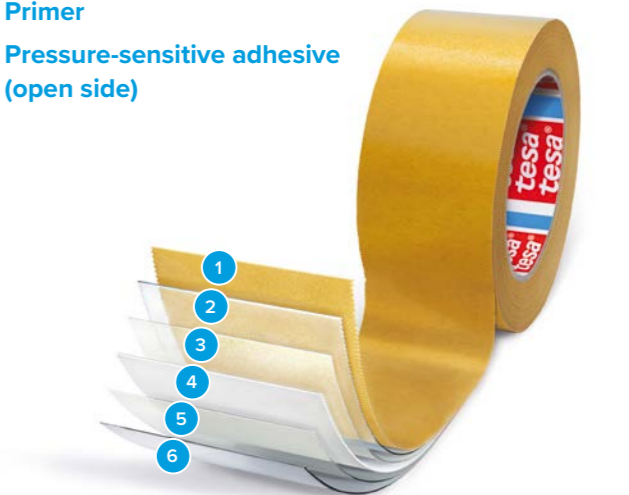
Product structure single-sided adhesive tape:

- 1 Rear surface release coating
- 2 Backing
- 3 Primer
- 4 Pressure-sensitive adhesive



Product structure double-sided adhesive tape:

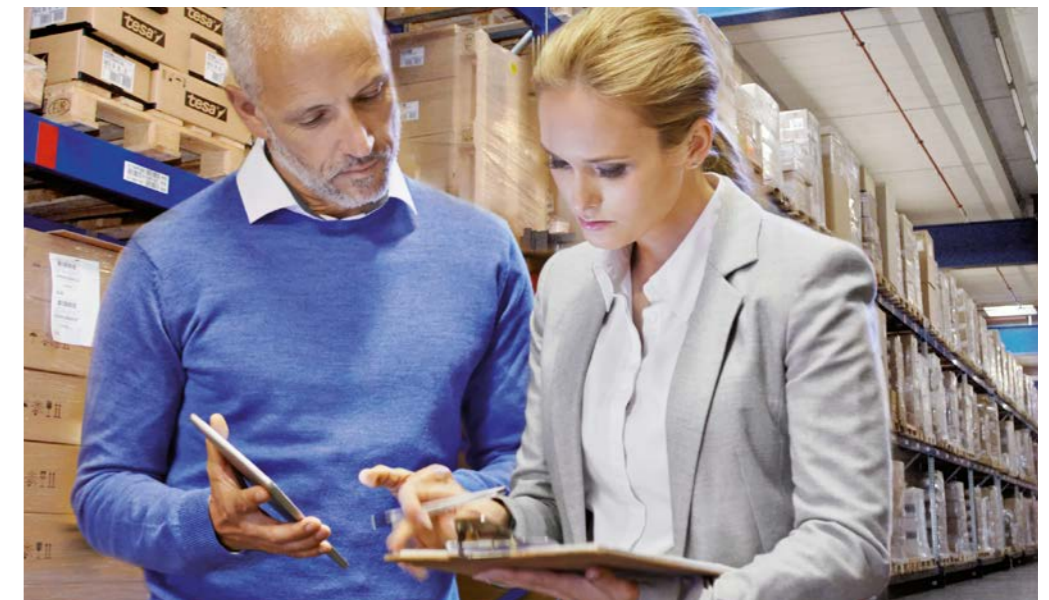
- 1 Separation cover (siliconized)
- 2 Pressure-sensitive adhesive (covered side)
- 3 Primer
- 4 Backing
- 5 Primer
- 6 Pressure-sensitive adhesive (open side)



Core assortment for Converters

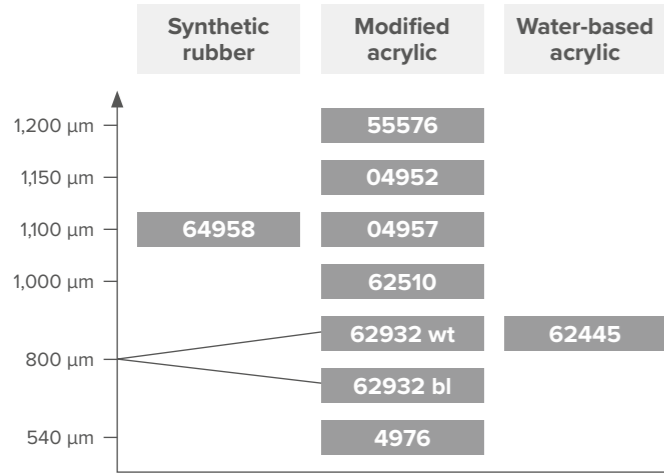
Product overview

Application	Category	Tapes	Page
Bonding & lamination	tesa® ACX ^{plus} acrylic core tapes	7254, 7255, 7272, 7273, 7274, 7282, 7283, 7284, 7074, 7805, 7808, 7811, 7812	29
	Double-sided foam tapes	4952, 4957, 4976, 55576, 62455, 62510, 62932, 64958, 45001	31
	Double-sided filmic tapes	4965, 4965 (59650), 4965 (59651), 4965 (59652), 4968, 4970, 4972, 4982, 51966, 51970	33
	Double-sided tissue tapes	4934, 4943, 4959, 4962, 4964, 51570, 51571	35
	Transfer & scrim tapes	52105, 52110, 4985, 4965, 88125, 88150, 88225, 88250, 66013, 66022, 75007,	37
Repairing & general applications	Premium cloth tapes	4651, 4657	41
	Mid-grade cloth tape	4688	41
	Sandplasting tapes	4432	45
Masking & surface protection	Powder coating tapes	50600, 50650	45
	Surface protection tapes	4414, 51136	45
	Masking specialties	51407	45
Ancillary	Roller wrapping	4863	49
	Adhesion promoters, removers & cleaners	60040, 60150, 60151, 6012, 60153, 60042	50

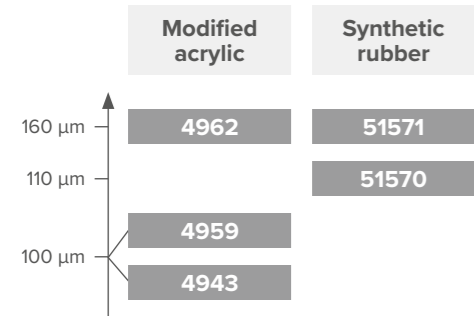


Product overview

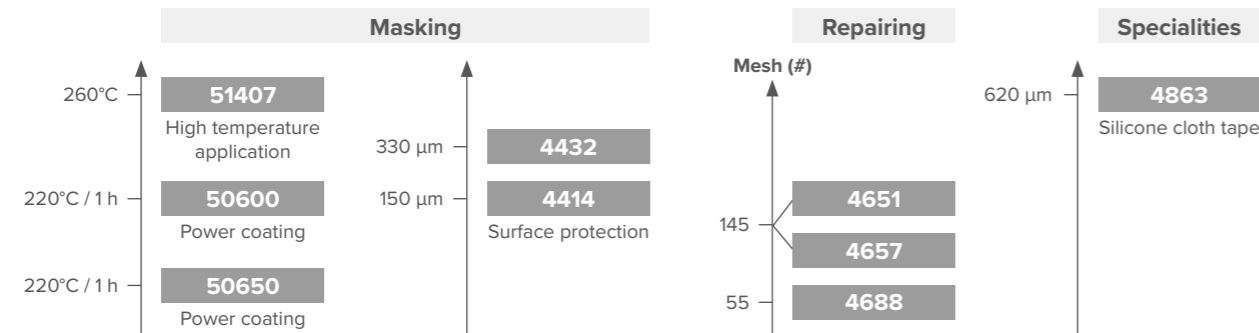
PE Foam Tapes



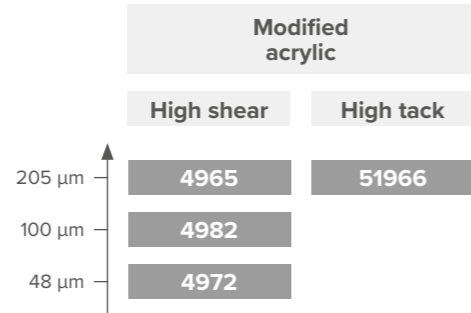
Non-woven Tapes



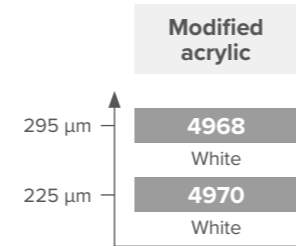
Single Sided Tapes



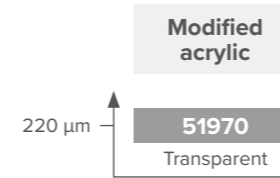
Filmic PET Tapes



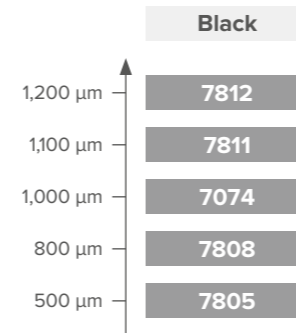
Filmic PVC Tapes



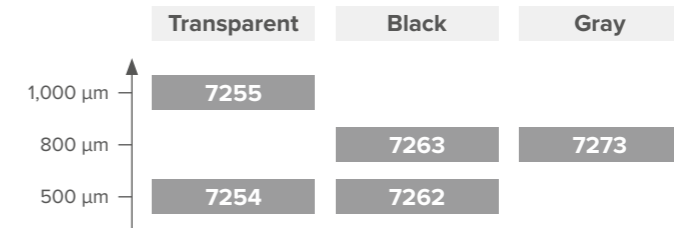
Filmic PP Tapes



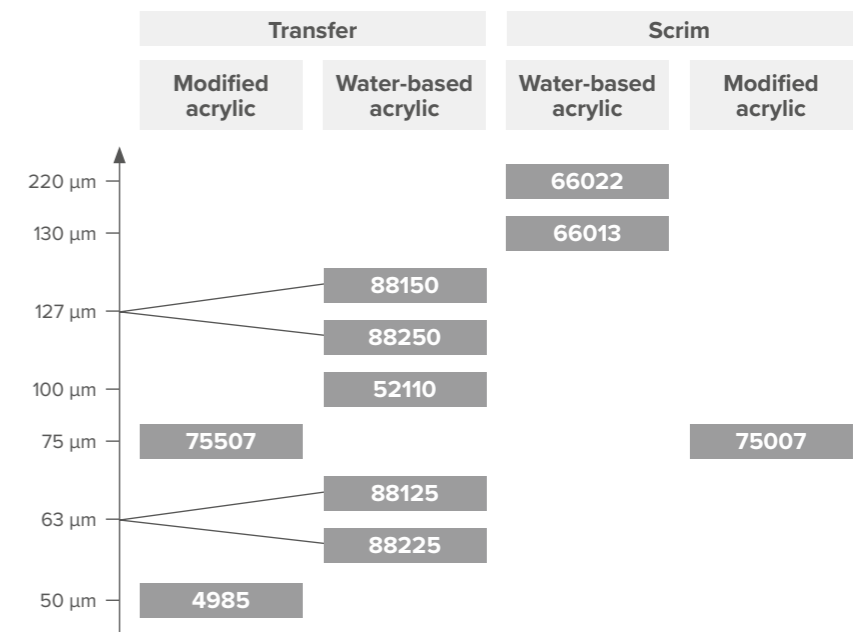
tesa® ACX^{plus} Specialities



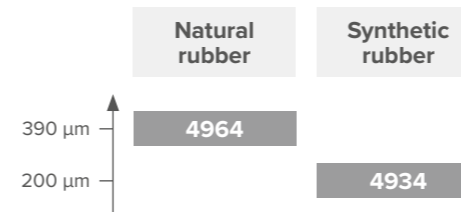
tesa® ACX^{plus} MP



Transfer & Scrim Tapes



Cloth Tapes



Endless possibilities

The products showcased in this brochure are just a small portion of our complete tape assortment, counting more than 7,000 references.

Get in touch with us if you are looking for a solution that you cannot find in this document, as most likely we already have something available for you.

If that is not the case, in some circumstances we may even evaluate starting a new product development that meets your specific needs.





Bonding & lamination











The world of double-sided tapes

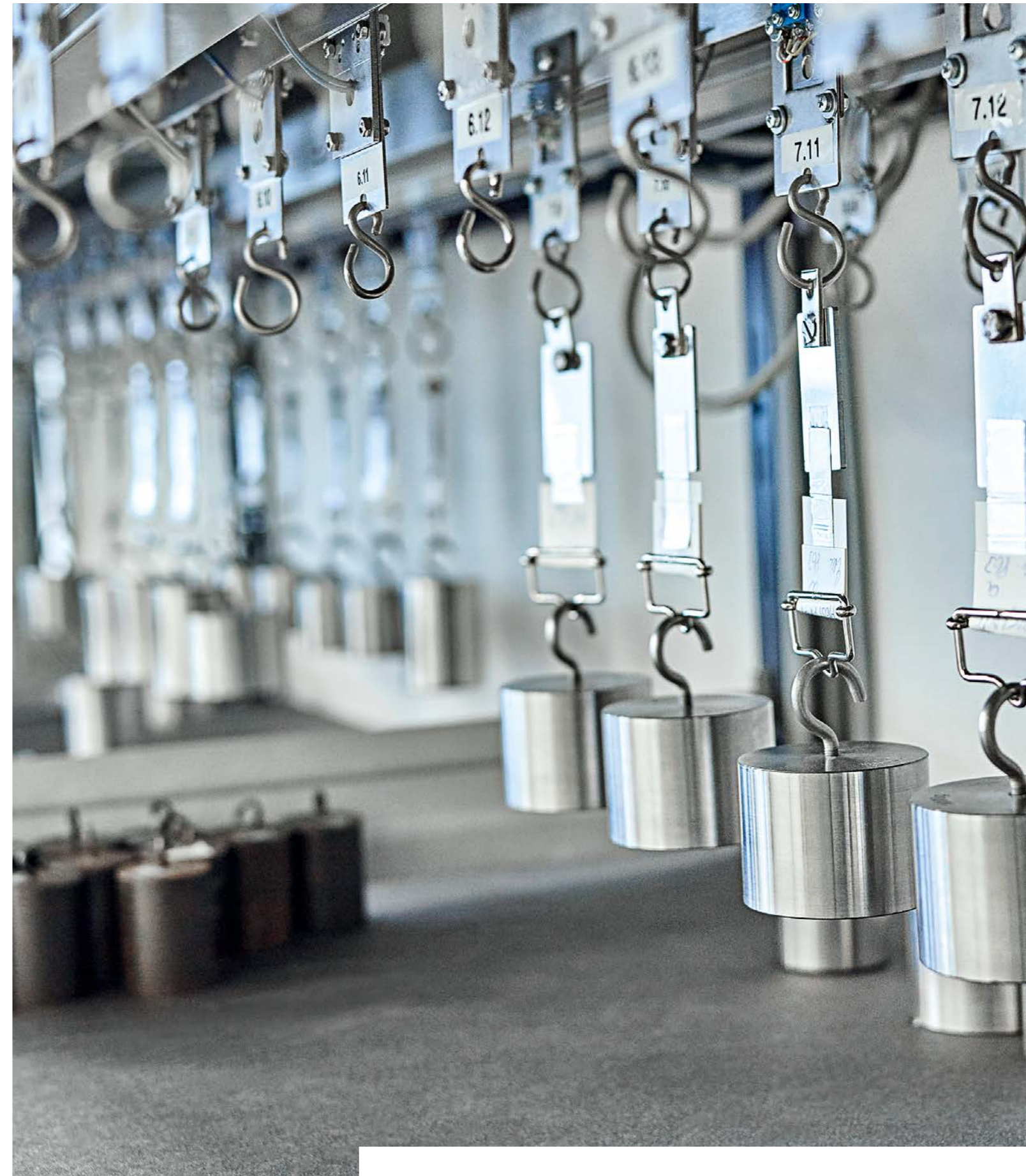
In many industries double-sided tapes are an important bonding solution. They are used in cars, electronic devices, household appliances, facade elements, windows and doors, glass partition walls, elevators, furniture, etc.

Depending on the tape's specific characteristics, they also dissipate stress due to their viscoelastic behavior, prevent oxidation, and are resistant to UV radiation, extreme temperatures, humidity, aging, and chemicals.

Compared to other bonding technologies like welding, screws, nails, and liquid glue, double-sided adhesive tape provides many advantages.

Advantages of double-sided tape vs. liquid glue and mechanical fastening

		Double-sided tape	Liquid glue	Mechanical fastening (e.g., rivets, screws, nails)	
Design		Improved visual appearance – no damage to the material	••••	•••	•
		Invisible fastening – mounting of transparent materials	••••	•••	•
Assembly		Fast application process – elimination of curing time and reduction of complexity	••••	•	••
		Healthy working environment and clean production sites	••••	••	••
Quality		Compensation of irregular or uneven surfaces – gaps between bonded surfaces are eliminated	•••	••••	•
		Compensation of tension and stress dissipation – single bonding point with mechanical fasteners can lead to material breakage	••••	••	•
		Noise-dampening properties – sounds caused by vibration are eliminated	••••	•••	•
		Shock absorption	••••	••	•
		Sealing function – tape seals and protects against dust and moisture	••••	••••	••
		Reduced risk of corrosion	••••	••••	•

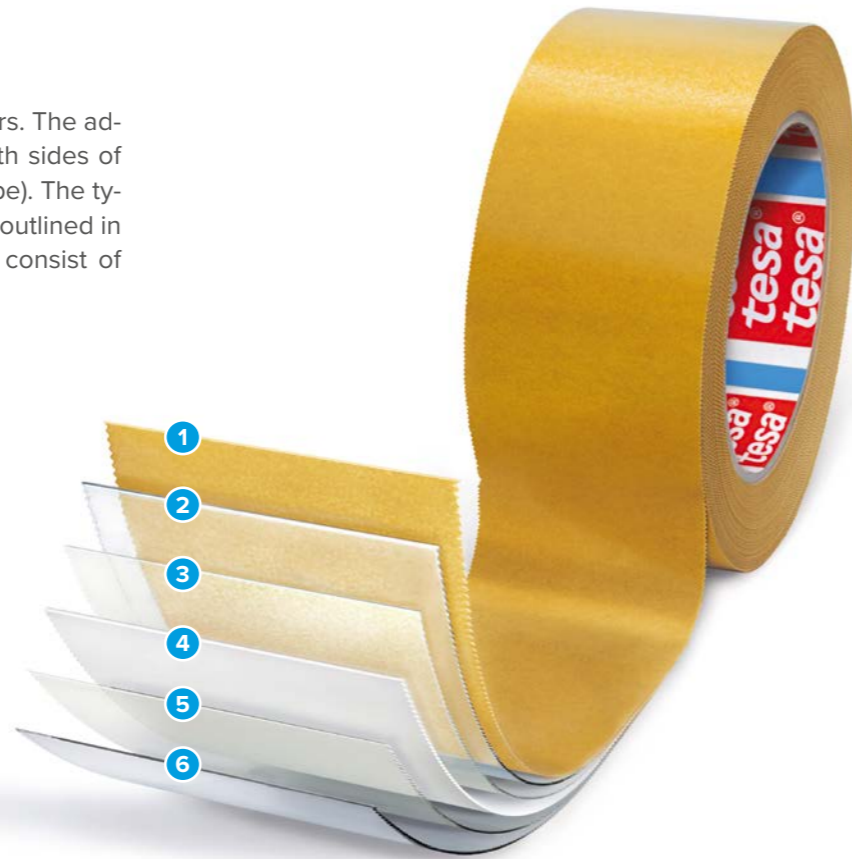


The structure of double-sided tapes

Adhesive tapes consist of various functional layers. The adhesive layer can be applied to either one or both sides of the backing (to create single- or double-sided tape). The typical structure of double-sided adhesive tapes is outlined in the following diagram. Our double-sided tapes consist of five main components:

Structure of double-sided adhesive tape:

- 1 Release liner (silicon coated)
- 2 Adhesive (closed side)
- 3 Primer
- 4 Backing
- 5 Primer
- 6 Adhesive (open side)



Backing

The backing is relevant for some of the main features of a double-sided tape. For rough surfaces, thicker foam tapes come into play. Thinner filmic tapes can be used for transparent bonding requirements and high-performance tapes are able to dissipate stress thanks to their viscoelastic behavior.

Liner

Some adhesive tapes have special separating layers, the so-called release coating and the release liner, on the top side, so that the adhesive tape on the roll does not stick to the layer above it. Siliconized papers or films are the main types of release liners. The optimal liner choice depends on the application. If die-cut ability is required, polyester liners are preferable. If the tape is exposed to humidity, poly-coated papers are mainly used due to their dimensional stability. For most applications, paper liners are the liners of choice.

Adhesive System

The proper choice of the adhesive depends on how the double-sided tape is to be used: the kind of surfaces and materials which are to be bonded, how long the bond is supposed to last, and whether it is an indoor or an outdoor application.

Primer

Often, the backing consists of plastic, for example, because that is the most sensible solution for this area of use. However, there are plastics and other materials which adhesive does not stick well to. Polyethylene (PE), polypropylene (PP), Teflon, rubber and silicone are some of these. Experts speak of “very low surface energy.” The actually “exciting” thing about a primer is: it increases this surface tension, which lets the backing and the adhesive stick to each other more strongly.

Backings

Backing	Description
tesa® ACX ^{plus}	<ul style="list-style-type: none"> • Viscoelasticity • Bonding power • Stress dissipation • Temperature and weather resistance
Foam tapes	<ul style="list-style-type: none"> • Compensation of tension, gaps and irregular surfaces • High bonding power even on rough surfaces • Excellent shock absorption • Sealing function against dust and moisture
Film tapes	<ul style="list-style-type: none"> • High tensile strength • Well suited for die-cut production • For high-speed manufacturing processes
Cloth tapes	<ul style="list-style-type: none"> • Flexible • High temperature resistance • Thick backings are abrasion resistant
Non-woven tapes	<ul style="list-style-type: none"> • Flexible and extremely conformable • Hand tearable, but nick resistance • Cushioning features

Liners

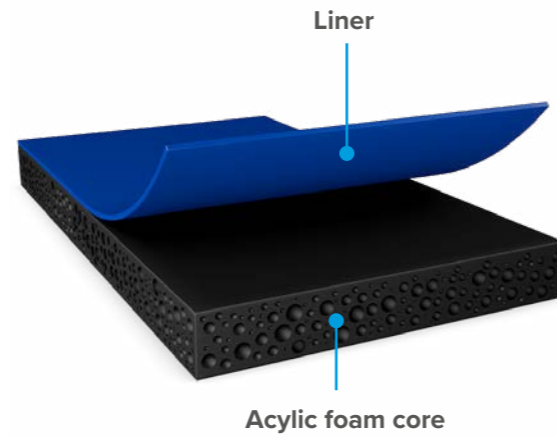
Product features/advantages	Color	Thickness	Weight [g/m ²]	Breaking force [N/cm]
Siliconized paper <ul style="list-style-type: none"> • Low electric discharge • Stable under pressure due to hard paper core 	Brown	70	82	> 63
PE (polyethylene) coated paper <ul style="list-style-type: none"> • Good tensile strength • Excellent die-cutting properties • Excellent humidity resistance 	White	122	120	> 73
PP (polypropylene) release film <ul style="list-style-type: none"> • Dust-free convertibility • High tear resistance • Safe use in automated processes 	Red	80	72	> 180
		120	108	> 180
PET (polyethylene terephthalate) release film <ul style="list-style-type: none"> • Excellent tear strength • Good thickness tolerance • Dust-free processing 	Transparent	50	72	> 70
		75	109	> 100
PE (polyethylene) release film <ul style="list-style-type: none"> • Flexible and soft for easy application on curved surfaces • No fraying during the sawing process 	Dark blue	100	94	> 16

Adhesive systems

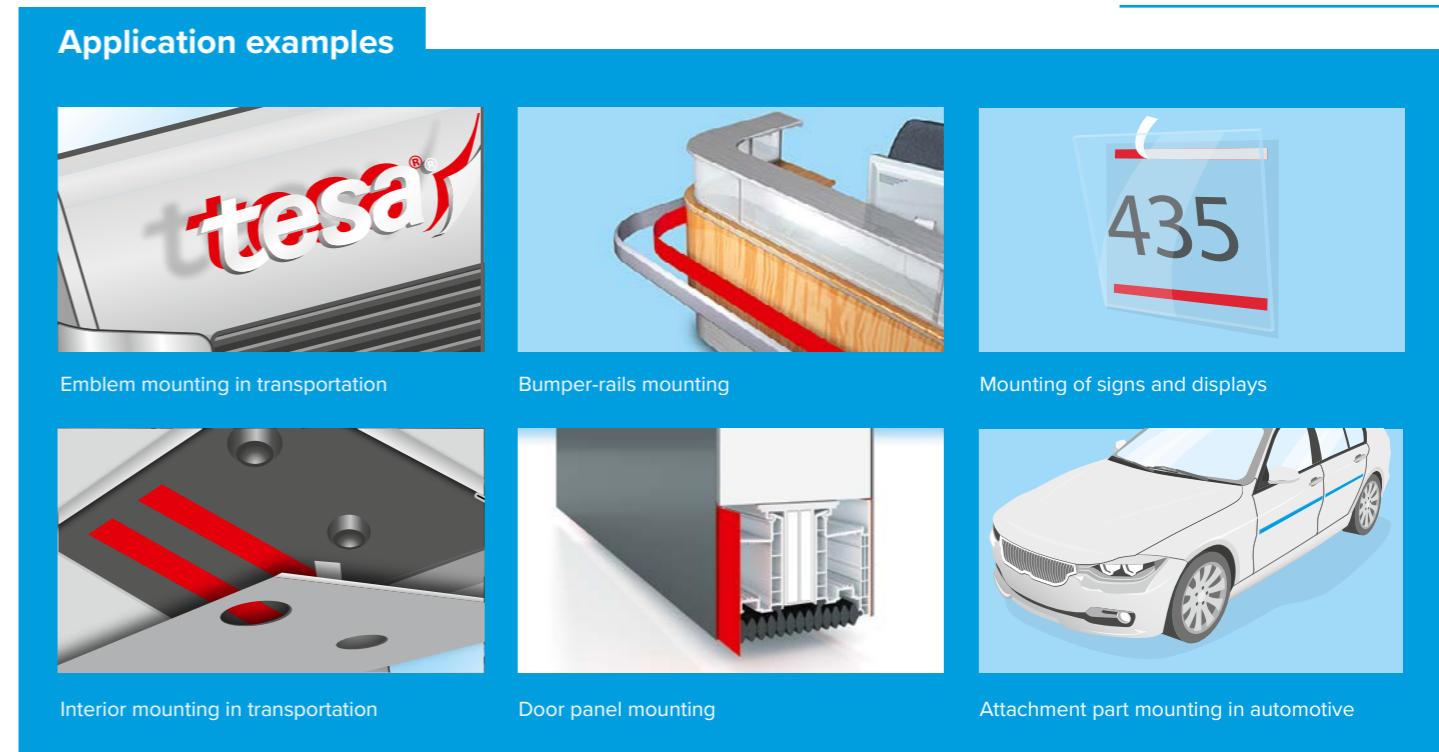
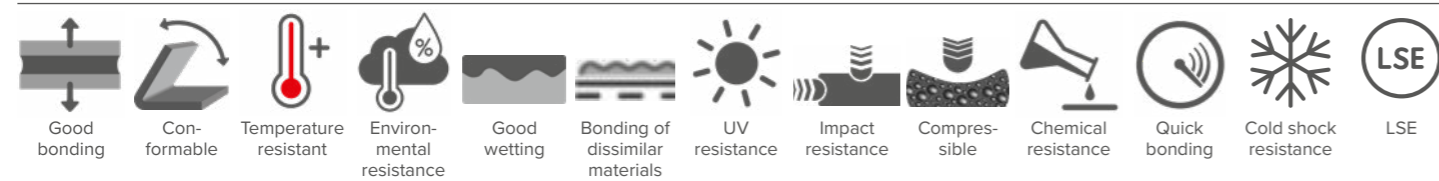
	Description	Attributes
Pure acrylic	Pure acrylic adhesive is especially suitable for outdoor applications and applications at elevated temperatures	<ul style="list-style-type: none"> • Good adhesive strength on polar and pretreated non-polar surfaces • Very good performance -at elevated temperatures • Resistance against environmental conditions (e.g. UV, humidity) and aging
Tackified acrylic	Tackified acrylic is a versatile adhesive with a well-balanced performance on a wide variety of surfaces for permanent applications	<ul style="list-style-type: none"> • Very good adhesive strength on polar surfaces, good on non-polar surfaces • High initial adhesion power • Resistance against environmental conditions (e.g. UV, humidity) and aging
Water-based acrylic	Water-based acrylic adhesives are solvent-free and thus feature low VOC emissions. They are quite versatile and perform well in lamination and lightweight mounting applications.	<ul style="list-style-type: none"> • Low VOC • High tack • Good adhesion to polar substrates • Good heat and aging resistance • Poor adhesion to non-polar substrates • Preferred for indoor use or temporary outdoors applications
Synthetic rubber (SiS)	SiS adhesive is suitable for a variety of surfaces but offers limited aging and temperature resistance	<ul style="list-style-type: none"> • High immediate adhesive bonding strength • Good shear resistance • Very good bonding on polar and non-polar surfaces
Natural rubber	Natural rubber adhesive is extremely sticky for use on rough surfaces	<ul style="list-style-type: none"> • High immediate adhesive bonding strength • Very good bonding on polar and non-polar surfaces • Preferred for use in indoor applications


tesa® ACX^{plus} acrylic core tapes

Constructive bonding is a key element in every industry and can be very challenging. Traditional mechanical fasteners like rivets, welds, screws, or liquid glue may not be suitable or can even damage the substrates. That is where our high-performance bonding tapes come into play. tesa® ACX^{plus} is an acrylic foam tape with very special bonding capabilities based on its viscoelasticity: this leads to elastic and viscous characteristics, providing inner strength as well as relaxation of mechanical stresses. tesa® ACX^{plus} bonding solutions can outperform conventional fastening methods by optimizing our customers' production processes and the quality and aesthetics of their products.



Main features



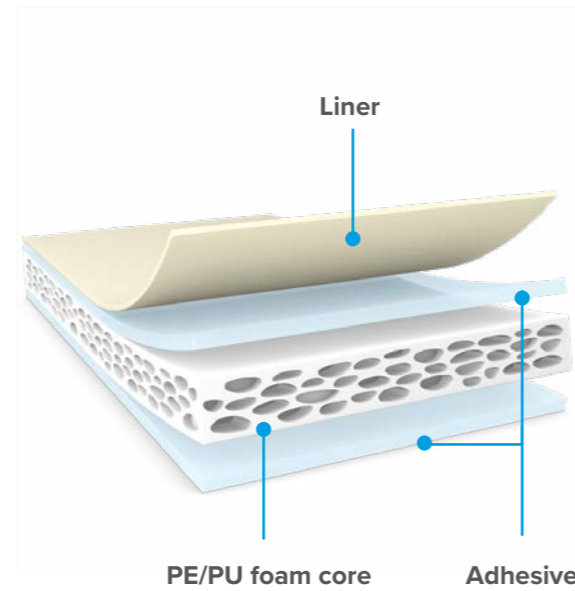
Product	Description	Backing	Adhesive	Liner	Thickness [µm]	Color	Standard log roll width [mm]	Core material / diameter	Adhesion to steel - Ultimate [N/cm]	Temperature resistance short / long term [°C]	Adhesion to ABS - Ultimate [N/cm]	Adhesion to PVC - Ultimate [N/cm]	Ageing resistance	Humidity resistance
tesa® ACX^{plus} Multi Purpose														
 tesa® ACX^{plus} 7254 Multi Purpose	Transparent acrylic foam tape suitable for a wide range of general bonding applications between transparent or translucent surfaces.	Solid acrylic	Pure acrylic	PE-coated paper white w/logo	500	⊗	900	PE / 3"	19	200 / 100	Values measured only for tesa® ACX ^{plus} Specialties		o	••
tesa® ACX^{plus} 7255 Multi Purpose		Solid acrylic	Pure acrylic	PE-coated paper white w/logo	1000	⊗	900	PE / 3"	24	200 / 100				
tesa® ACX^{plus} 7272 Multi Purpose	Acrylic foam tape suitable for a wide range of general bonding applications, such as mounting of emblems, decorative parts and signs.	Foamed acrylic	Pure acrylic	Filmic white w/logo	600	●	900	PE / 3"	28	200 / 100				
tesa® ACX^{plus} 7273 Multi Purpose		Foamed acrylic	Pure acrylic	Filmic white w/logo	800	●	900	PE / 3"	28	200 / 100				
tesa® ACX^{plus} 7274 Multi Purpose		Foamed acrylic	Pure acrylic	Filmic white w/logo	1000	●	900	PE / 3"	28	200 / 100				
tesa® ACX^{plus} 7282 Multi Purpose	Acrylic foam tape suitable for a wide range of general bonding applications, such as mounting of emblems, decorative parts and signs. Shows good adhesion on surfaces with low surface energy, e.g. plastics/PE.	Foamed acrylic	Modified acrylic	Filmic white w/logo	640	●	630	PE / 3"	26	200 (short)				
tesa® ACX^{plus} 7283 Multi Purpose		Foamed acrylic	Modified acrylic	Filmic white w/logo	800	●	630	PE / 3"	27	200 (short)				
tesa® ACX^{plus} 7284 Multi Purpose		Foamed acrylic	Modified acrylic	Filmic white w/logo	1100	●	630	PE / 3"	29	200 (short)				
tesa® ACX^{plus} Specialties														
tesa® ACX^{plus} 7074 High Resistance	Acrylic foam tape for permanent demanding outdoor bonding applications, showing outstanding cold shock, UV, chemicals, salt water and cleaning agent resistance.	Foamed acrylic	Pure acrylic	HDPE blue	1000	●	1240	PE / 3"	30	200 / 100	-	30	o	••
tesa® ACX^{plus} 7805 Black Line	Closed cell acrylic foam tape showing high bonding power on MSE clear coats and plastics, as well as impressive cold shock, humidity and UV resistance.	Foamed acrylic	Tackified acrylic	HDPE blue	500	●	1260	PE / 3"	21	80	18	21	••	••
tesa® ACX^{plus} 7808 Black Line		Foamed acrylic	Tackified acrylic	HDPE blue	800	●	1260	PE / 3"	26	80	22	26	••	••
tesa® ACX^{plus} 7811 Black Line		Foamed acrylic	Tackified acrylic	HDPE blue	1100	●	1260	PE / 3"	32	70	24	32	••	••
tesa® ACX^{plus} 7812 Black Line		Foamed acrylic	Tackified acrylic	HDPE blue	1200	●	1260	PE / 3"	32	80	24	32	••	••

•• very good • good o discrete - poor

Double-sided foam tapes

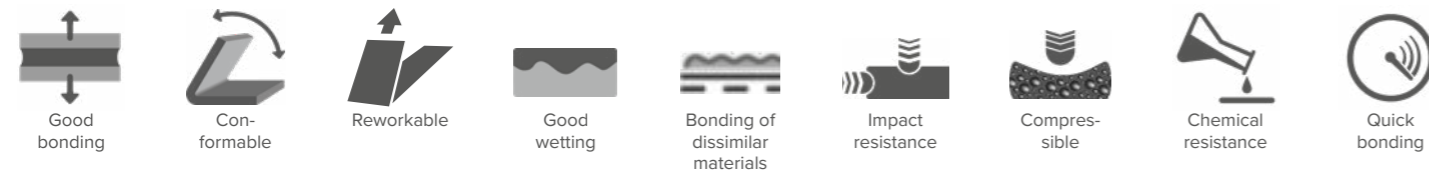
Double-sided foam tapes are a broad category which includes products that, thanks to the characteristics of their backing, can be used to compensate for gaps, bond different substrates, and dampen unwanted noises or vibrations.

Depending on the foam and adhesive composition, they can be suitable for lightweight or more demanding mounting applications, permanent or temporary, even on LSE surfaces. Some may also be used for outdoors applications, thanks to their resistance against UV, humidity and ageing.



Check out more details by clicking on the product name.

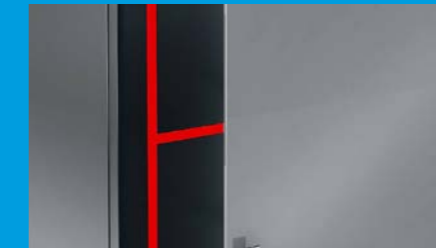
Main features



Application examples



Mounting of signs and displays



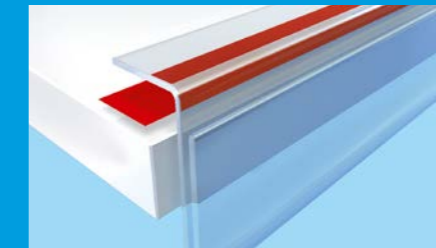
Deco glass mounting in appliances



Mirror mounting



Deco panel mounting in furniture



Store shelf edge mounting



Interior wall cladding

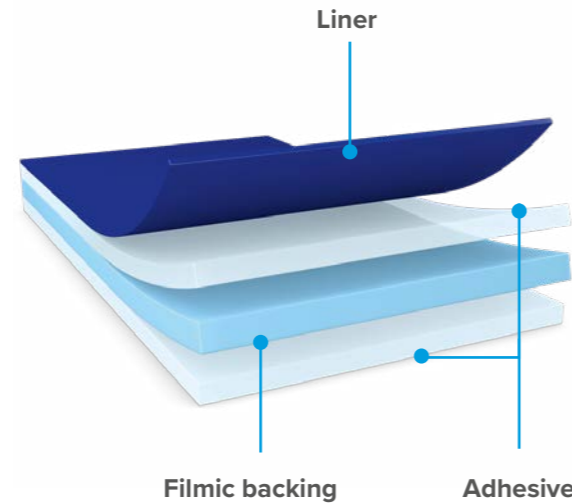
Product	Description	Backing	Adhesive	Liner	Thickness [µm]	Color	Standard log roll width [mm]	Core material / diameter	Adhesion to steel - Ultimate [N/cm]	Adhesion to PE - Ultimate [N/cm]	Adhesion to PVC - Ultimate [N/cm]	Temperature resistance short / long term [°C]	Static shear resistance at 23 °C	Tack	Ageing resistance	Humidity resistance
tesa® 4952	Double-sided PE foam tape for mounting applications, resistant against UV, humidity, water, chemicals, and aging. Suitable for fixing flat objects such as mirrors, signs, and decorative materials	PE foam	Tackified acrylic	Glassine brown	1150	○	1360	cardboard / 3"	8	2.8	8	80 / 80	●	●	●	●●
tesa® 4957	Double sided PE foam tape for general mounting applications indoors and outdoors: resistant against UV, water, chemicals, and aging. Certified for furniture mirror mounting and window bar mounting.	PE foam	Tackified acrylic	Glassine brown	1100	●	1360	cardboard / 3"	4	2.2	4	80 / 80	●	●	●	●●
tesa® 4976	Conformable double sided open-cell PU foam tape for general mounting applications. Shows high short term temperature resistance and good sealing functions.	PE foam	Tackified acrylic	Glassine brown	540	●	1360	cardboard / 3"	12	4.3	12	200 / 80	●	●	●	●●
tesa® 55576	Double sided PE foam tape for light duty mounting of trims & profiles, POS signs, advertising material and mirror pre-mounting.	PE foam	Tackified acrylic	PE red	1200	○	1060	cardboard / 3"	5.5**	1.4**	3**	80 / 60				
tesa® 62455	Double-sided PE foam tape with good peel adhesion even on critical surfaces, suitable for basic indoor and outdoor applications. Designed mainly for trims & profiles mounting.	PE foam	Water-based acrylic	Glassine white	1000	○	9, 12, 19	cardboard / 3"	6*		6	80 / 80				
tesa® 62510	Conformable double sided highly-compressed PE foam tape for general mounting applications. Fully outdoor suitable: resistant against UV, water and aging.	PE foam	Tackified acrylic	Glassine brown	1000	●	1360	cardboard / 3"	13.5	0.9	13.5	80 / 80	●	●	●	●●
tesa® 62932	Thin double sided PE foam tape for a variety of constructive mounting applications. Fully outdoor suitable: resistant against UV, water, ageing and cold shocks.	PE foam	Tackified acrylic	Glassine brown	500	●○	1360	cardboard / 3"	17	3	17	80 / 80	●	●	●	●●
tesa® 64958	Conformable double sided PE foam tape for general mounting applications, showing immediate bonding strength even on rough, uneven surfaces and LSE surfaces.	PE foam	Synthetic rubber	Glassine paper	1050	○	1400	cardboard / 3"	4	4	4	60 / 40	●●	●	●	●
tesa® 45001	PE-foam tape for permanent mounting in demanding applications, flame-retardant according to FAR 25.853(a) and UL 94 HBF-HF1. Highly conformable and lightweight.	PE foam	Pure acrylic	MOPP red	1000	○	1360	cardboard / 3"	22			100 / 80	●●		●●	●●

●● very good ● good ○ discrete - poor ** Initial peel adhesion * to Aluminum

Double-sided filmic tapes

Double-sided filmic tapes are relatively thin, dimensionally stable, and are ideal for bonding to flat, smooth surfaces such as glass, metal, and non-embossed plastics. Nevertheless, thicker tapes offer good performance also on rough, hard to stick surfaces and generally offer a good temperature resistance.

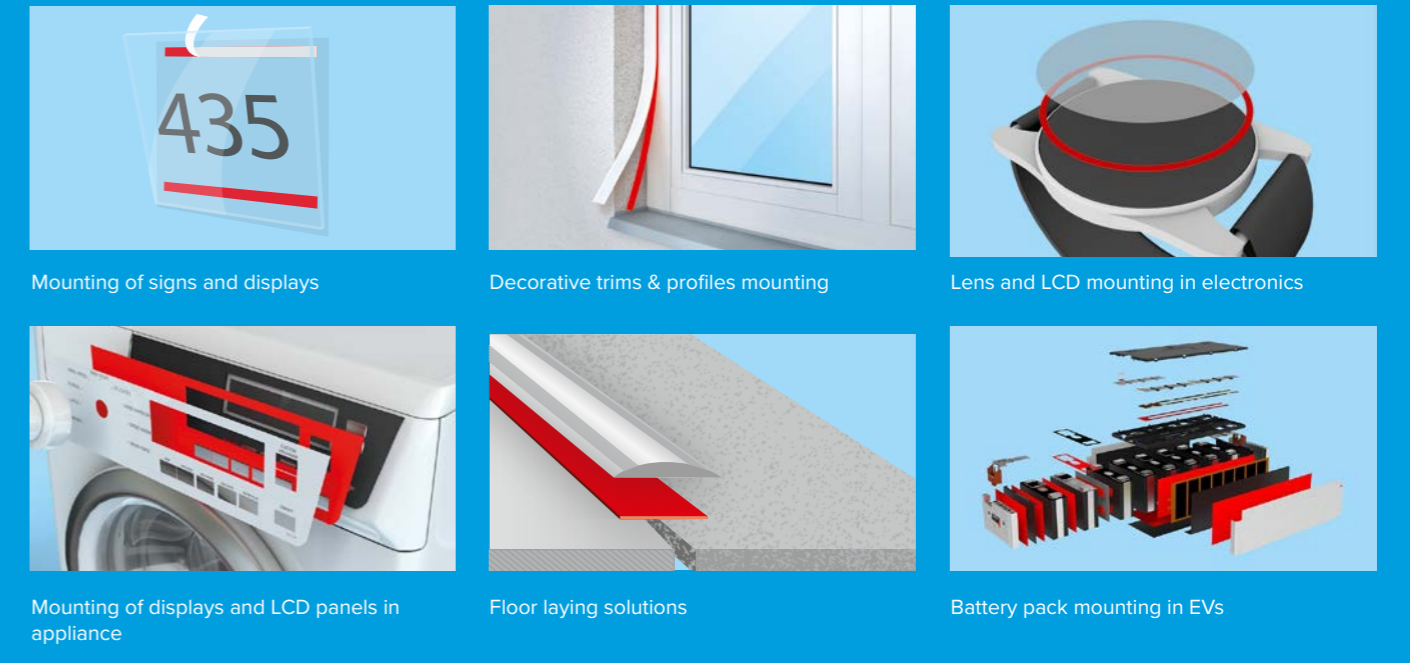
The wide range of thicknesses from 48 µm to 300 µm offer multiple performance and design to cost options. Selected tapes for lamination and converting applications also offer very low VOC emissions.













Main features



Application examples



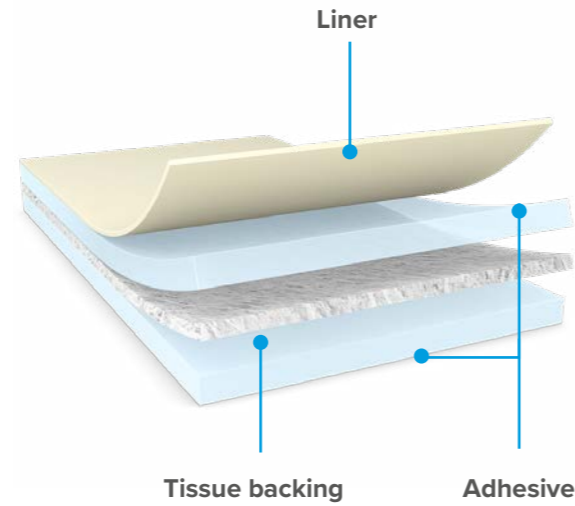
Product	Description	Backing	Adhesive	Liner	Thickness [µm]	Color	Standard log roll width [mm]	Core material / diameter	Adhesion to steel - Ultimate [N/cm]	Adhesion to PE - Ultimate [N/cm]	Adhesion to PVC - Ultimate [N/cm]	Temperature resistance short / long term [°C]	Static shear resistance at 23 °C	Tack	Ageing resistance	Humidity resistance
 tesa® 4965 Original	High performance transparent PET double-sided tape based on a patented product formulation, showing reliable bond even on hard to stick surfaces and under critical conditions.	PET film	Tackified acrylic	MOPP red	205	⊗	1372	Cardboard / 3"	11.8	6.9	13	200 / 100	•	•	•	••
 tesa® 4965 Thin (59650)	Thin transparent double-sided PET tape equipped with our proven tesa® 4965 adhesive. Shows high holding power even at high temperatures and on LSE surfaces, superior converting performance and reduced adhesive mass flow.	PET film	Tackified acrylic	Glassine brown	160	⊗	1372	PE / 3"	13.4	5.7	11.9	200 / 100	•	•	••	••
 tesa® 4965 Thick (59651)	Thick transparent double-sided PET tape equipped with our proven tesa® 4965 adhesive. Shows high holding power even under demanding environmental conditions and good converting performance.	PET film	Tackified acrylic	Glassine brown w/logo	300	⊗	1372	PE / 3"	12.9	6.4	14.3*	200 / 100	•	•	••	••
 tesa® 4965 Black (59652)	Black double-sided PET tape equipped with our proven tesa® 4965 adhesive. Shows outstanding holding power even to LSE surfaces and powder painted substrates. The black color optimizes automatic pick and place processes.	PET film	Tackified acrylic	Glassine brown w/logo	205	●	1372	Cardboard / 3"	14	6.6	12.8	200 / 100	•	•	••	••
 tesa® 4968	PVC double-sided tape showing high UV-stability, chemical resistance and flame retardancy. Proves exceptional bonding to low energy or rough substrates, for general mounting applications.	PVC film	Tackified acrylic	Glassine brown	295	○	1372	Cardboard / 3"	21.2	14.1**	24.6*	70 (short)	•	•	•	••
 tesa® 4970	Thick PVC double-sided tape showing high tack, immediate adhesion and good performance on rough or dusty surfaces. Suitable for long term mounting of signage, POS materials and trims.	PVC film	Tackified acrylic	Glassine brown	225	○	1372	Cardboard / 3"	13.6	9.1	16.6	70 / 60	•	•	•	••
 tesa® 4972	Transparent PET double-sided tape with high initial tack and adhesion. Suitable for long term mounting applications and designed for converter and tape specialist business.	PET film	Tackified acrylic	Glassine brown w/logo	48	⊗	1240	Cardboard / 3"	9.6	3.5	9.4	200 / 100	•	○	○	••
 tesa® 4982	Transparent PET double-sided tape with excellent bonding strength/thickness ratio and temperature resistance. Good for mounting of LCD panels and battery packs.	PET film	Tackified acrylic	Glassine brown w/logo	100	⊗	1372	PE / 3"	11.7	5.1	10	200 / 100	•	○	○	••
 tesa® 51966	Transparent PET double-sided tape with high initial tack and adhesion. Suitable for long term mounting applications and designed for converter and tape specialist business.	PET film	Tackified acrylic	Glassine brown w/logo	200	⊗	1372	Cardboard / 3"	11	7.5	13	130 / 80	•	••	••	•
 tesa® 51970	Transparent PP double-sided tape showing high tack and adhesion, secure bond even on critical materials such as PP, PE and rough surfaces, good temperature resistance and outdoor suitability.	PE film	Tackified acrylic	Glassine brown	220	⊗	1372	Cardboard / 3"	13.5	6.8	17	130 / 80	•	•	•	••

•• very good • good ○ discrete - poor * to PC ** to PP

Double-sided tissue tapes

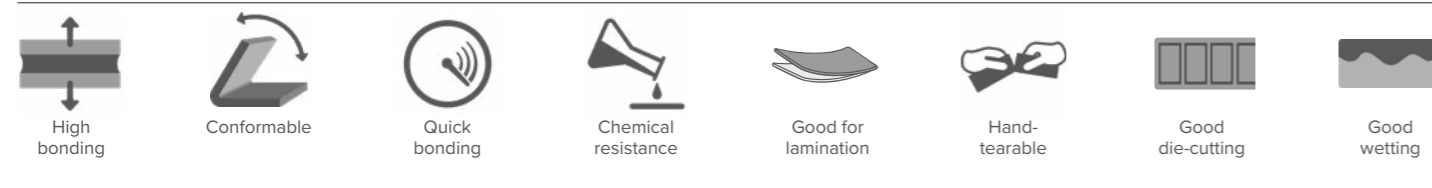
Tissue double-sided tapes, thanks to their non-woven or cloth backings, are conformable and flexible, allowing them to stick to irregular surfaces as needed. They are made to be easily die-cut and to be tearable by hand whilst being tear resistant.

They are in many cases suitable to quite demanding and permanent mounting applications in a variety of industries and offer a very good initial tack on most surfaces. Thanks to their flexibility, they can also be used for lamination and splicing of foams, textiles, leather and heavy papers, as well as floor laying applications.



Check out more details by clicking on the product name.

Main features



Application examples

Floor laying
Foam lamination
Leather mounting
Membrane switch mounting in appliances
Mounting of evaporators in appliance
General lightweight mounting

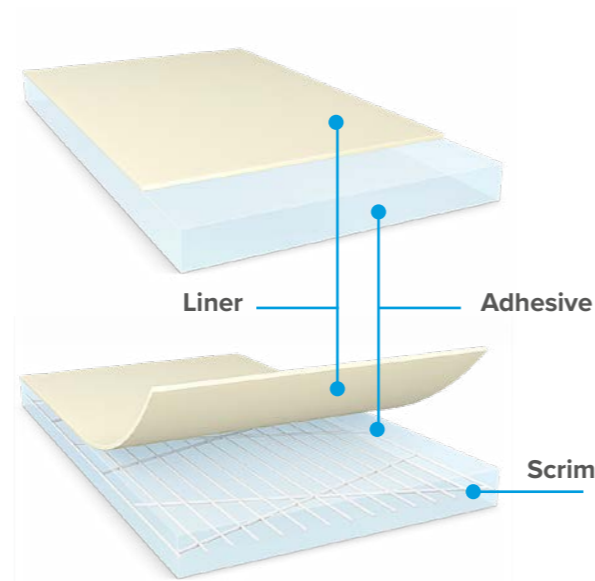
Product	Description	Backing	Adhesive	Liner	Thickness [µm]	Color	Standard log roll width [mm]	Core material / diameter	Adhesion to steel - Ultimate [N/cm]	Adhesion to PE - Ultimate [N/cm]	Adhesion to PVC - Ultimate [N/cm]	Temperature resistance short / long term [°C]	Static shear resistance at 23 °C	Tack	Ageing resistance	Humidity resistance
tesa® 4934	Solvent-free double-sided cloth tape with high tack, humidity resistance and suitable for rough surfaces. Performs best in indoor applications such as carpet laying and can be torn by hand.	cloth	Synthetic rubber	Glassine white	200	○	1400	Cardboard / 3"	24	8.5	22.5	60 / 40	●●	●●	●●	●
tesa® 4943	Double-sided non-woven tape providing high initial tack and good shear resistance. Optimal for lamination, lightweight mounting, splicing and bag sealing.	non-woven	Tackified acrylic	Glassine white w/logo	100	○	1220	Cardboard / 3"	8.1	0	10.8	100 / 70	●●	●	●	●
tesa® 4959	Double-sided non-woven tape providing high initial tack and good shear, UV and plasticizer resistance. Optimal for lamination, lightweight mounting, splicing and bag sealing.	non-woven	Tackified acrylic	Glassine brown	100	○	1372	Cardboard / 3"	8.5	4.5	14	200 / 80	●	●●	●●	●
tesa® 4962	High-adhesion double-sided non-woven tape proving excellent wetting power on rough surfaces and temperature resistance. Optimal for mounting of plastic and foam parts, heavy papers, textiles and leather	non-woven	Tackified acrylic	Glassine brown	160	○	1372	Cardboard / 3"	12	7	15	200 / 80	●	●●	●●	●●
tesa® 4964	Strong and flexible double-sided cloth tape created to adhere to rough and non-polar surfaces with residue-free removability. Suitable for laminations, splicing and applications in the carpentry and leather industry.	cloth	Natural rubber	Glassine brown	390	○	1550	Cardboard / 3"	7.6	5.4	7	110 / 30	○	●●	●●	○
tesa® 51570	Double-sided non-woven tape for permanent mounting of metal and plastic materials. The thick adhesive bonds well on uneven surfaces and shows a very high initial tack.	non-woven	Tackified acrylic	Glassine brown	110	○	1400	Cardboard / 3"	13	7	12.5	80 / 40	●	●●	●●	●
tesa® 51571	Double-sided non-woven tape for permanent mounting of metal and plastic materials. The thick adhesive bonds well on uneven surfaces and shows a very high initial tack.	non-woven	Tackified acrylic	Glassine brown	160	○	1400	Cardboard / 3"	13	8.5	13	80 / 40	●●	●	●	●


●● very good ● good ○ discrete - poor * to PC * to PP

Transfer & scrim tapes

Double-sided transfer tapes differ from other double-sided tapes in that they have no backing. Scrim tapes are similar in structure, with the only difference that the adhesive mass is reinforced by a scrim.

They are transparent and extremely conformable, but do not allow re-positioning. Being thin but strong products, they also ensure an efficient converting and laminating process. They can be used in a variety of lamination, splicing and lightweight mounting, especially when extreme thinness and/or adhesion to flexible substrates is requested. Solvent-free production results in an environmentally friendly application process, with Low VOC features.



Check out more details  by clicking on the product name.

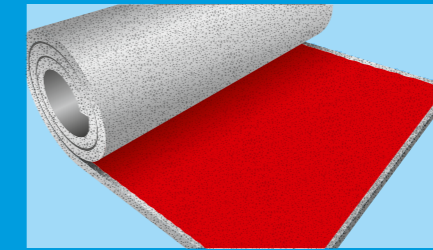
Main features



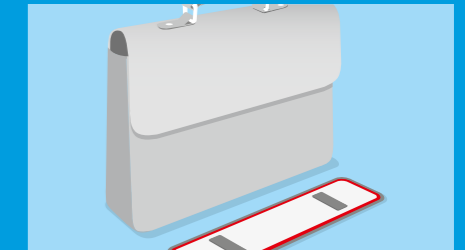
Application examples



Signage mounting



Foam lamination



Leather mounting










Splicing of heavy papers



Mounting of POS displays



Membrane switch mounting in appliances

Product	Description	Backing	Adhesive	Liner	Thickness [µm]	Color	Standard log roll width [mm]	Core material / diameter	Adhesion to steel - Ultimate [N/cm]	Adhesion to PE - Ultimate [N/cm]	Adhesion to PVC - Ultimate [N/cm]	Temperature resistance short / long term [°C]	Tack	Ageing resistance
Transfer tapes														
 tesa® 52105 Ultra Low VOC	Conformable, water-based acrylic adhesive transfer tape with low VOC properties, suitable for laminating flexible substrates and lightweight mounting. Good die cutting properties and LSE performance.	None	Water-based acrylic	Glassine yellow	50	⊗	1500	Cardboard / 3"	9.5	1,5*	8,5**	170	••	••
 tesa® 52110 Ultra Low VOC	Conformable, water-based acrylic adhesive transfer tape with low VOC properties, suitable for laminating flexible substrates and lightweight mounting. Good die cutting properties and LSE performance.	None	Water-based acrylic	Glassine yellow	100	⊗	1500	Cardboard / 3"	13	9,5*	11**	180	••	••
 tesa® 4985	Transparent transfer tape with a modified acrylic adhesive. It offers good immediate grab to uneven surfaces. Used for mounting of posters, photos, fabrics and paper splicing.	None	Tackified acrylic	Glassine brown	50	⊗	1270	Cardboard / 3"	11.1	4.9	9.4	200	••	••
 tesa® 4965 Transfer (75507)	Conformable, tackified acrylic transfer tape equipped with our proven tesa® 4965 adhesive. Shows excellent die-cutting properties. Suitable for a variety of lamination, splicing and lightweight mounting applications.	None	Tackified acrylic	Glassine brown	75	⊗	1372	PE / 3"	11			100	•	••
 tesa® 88125	Conformable, transparent water-based acrylic transfer tape developed for lamination of flexible substrates (NVH, BSR, rubber, fabrics). Good die cutting properties.	None	Water-based acrylic	PE-coated paper white w/logo	63	⊗	1524	Cardboard / 3"	6	1	13.4***	200	•	•
 tesa® 88150	Conformable, transparent water-based acrylic transfer tape developed for lamination of flexible substrates (NVH, BSR, rubber, fabrics). Good die cutting properties.	None	Water-based acrylic	PE-coated paper white w/logo	127	⊗	1524	Cardboard / 3"	8	1.5	14***	200	•	•
 tesa® 88225	Conformable, transparent water-based acrylic transfer tape developed for lamination of flexible substrates (NVH, BSR, rubber, fabrics). Good die cutting properties and LSE performance.	None	Water-based acrylic	PE-coated paper white w/logo	63	⊗	1524	Cardboard / 3"	10	3	9***	180	••	••
 tesa® 88250	Conformable, transparent water-based acrylic transfer tape developed for lamination of flexible substrates (NVH, BSR, rubber, fabrics). Good die cutting properties and LSE performance.	None	Water-based acrylic	PE-coated paper white w/logo	127	⊗	1524	Cardboard / 3"	10	5	12***	180	••	••
Scrim tapes														
 tesa® 66013 Ultra Low VOC	Conformable, water-based acrylic adhesive tape reinforced by a PET scrim and low VOC properties, suitable for laminating all kinds of flexible substrates and lightweight mounting. Good die cutting properties and LSE performance.	None	Water-based acrylic w/ PET scrim	Glassine brown w/ logo	130	⊗	1150	Cardboard / 3"	16.5	7.2	14.3	180	••	••
 tesa® 66022 Ultra Low VOC	Conformable water-based acrylic adhesive tape reinforced by a PET scrim, with low VOC properties. Suitable for laminating all kinds of flexible substrates and lightweight mounting. Good die cutting properties.	None	Water-based acrylic w/ PET scrim	Glassine brown w/ logo	220	⊗	1150	Cardboard / 3"	17.3	9	19.3	200	••	••
 tesa® 75007 Low VOC	Conformable, tackified acrylic adhesive tape reinforced by a PET scrim, with low VOC properties. Suitable for demanding lamination and mounting applications, even on low surface energy substrates.	None	Tackified acrylic w/ PET scrim	Glassine brown w/ logo	75	⊗	1372	Cardboard / 3"	8.6	4.9	8.8	170	••	••

•• very good • good ○ discrete - poor * to PP, initial ** to PC, initial * to PC



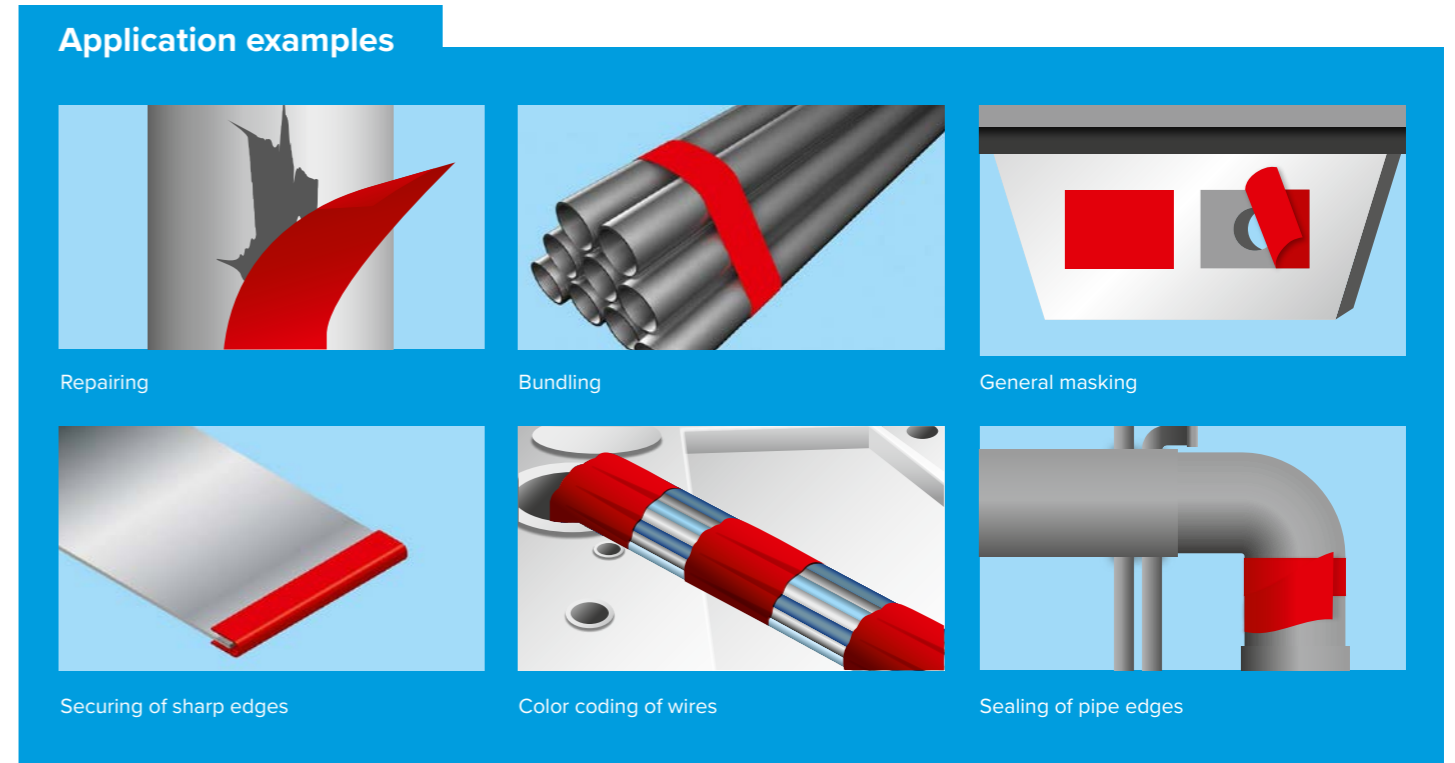
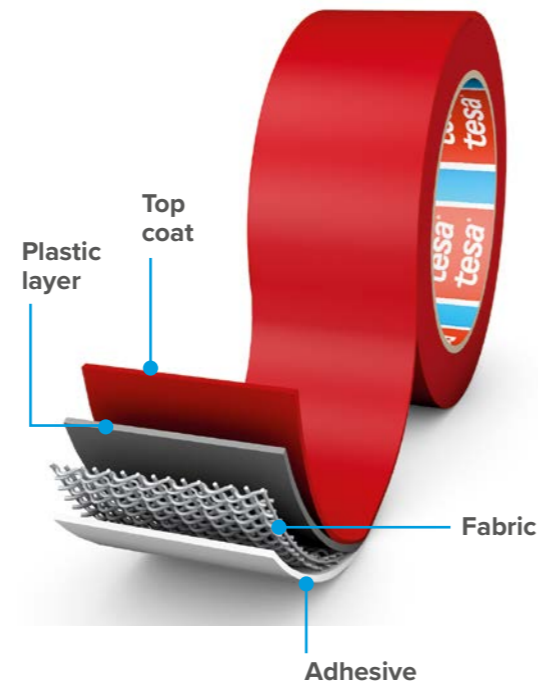
Repairing &
general applications

Cloth tapes

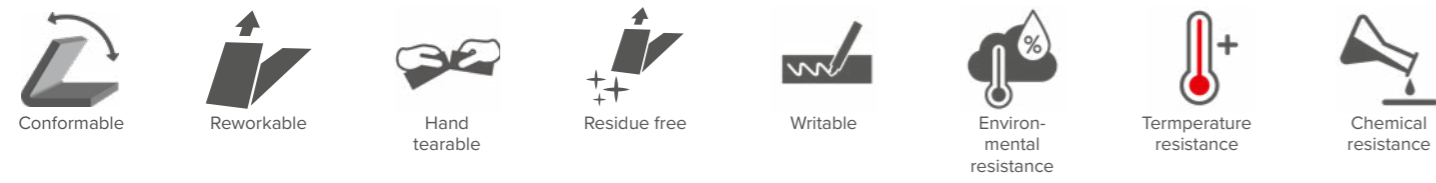
[Check out more details](#) by clicking on the product name.



Cloth tapes are ideal products for temporary applications, such as repairing, sealing, bundling, masking. They can bond to rough surfaces, are hand tearable and can be removed quickly and cleanly after use. The higher the mesh count of the backing, the tougher the tape is and the higher its tensile strength and abrasion resistance. Mesh count is a measure of how many threads cross each other per square inch of tape.

Cloth tapes are very versatile and may be used not only for repairing applications, but also for masking while sandblasting or spray painting, bundling and reinforcing, color coding of wires, permanent sealing of pipe joints, securing of sharp edges, fixing and insulating wires.



Main features



Product	Description	Level	Backing	Adhesive	Thickness [μm]	Color	Standard log roll width [mm]	Core material / diameter	Adhesion to steel - Ultimate [N/cm]	Temperature resistance short / long term [°C]	Mesh count	Tensile strength
 tesa® 4651	Very strong cloth tape for almost every application, including masking, sealing, bundling, or repairing. Due to its resistance to water, UV and humidity, it is ideal for long term outdoor applications	Premium	Acrylic-coated cloth	Natural rubber	310		970	Cardboard / 3"	3.3	130	145	100
 tesa® 4657 PV1	High-quality cloth tape showing good tensile strength, hand-tearability and resistance to high temperatures, water, abrasion and solvents. Used for a wide range of fastening, covering, and masking applications indoors and outdoors.	Premium	Thermosetting natural rubber	Tackified acrylic	290		965	Cardboard / 3"	4.6	180	145	100
 tesa® 4688	Mid-grade cloth tape used for various masking, marking, packaging, protecting and repairing applications. It is water repellant, hand-tearable and temperature and abrasion resistant.	Mid-grade	PE extruded cloth	Natural rubber	260		1300	Cardboard / 3"	4.5	110	110	52

•• very good • good ○ discrete - poor



Masking &
surface protection

Industrial paint jobs & surface protection tapes

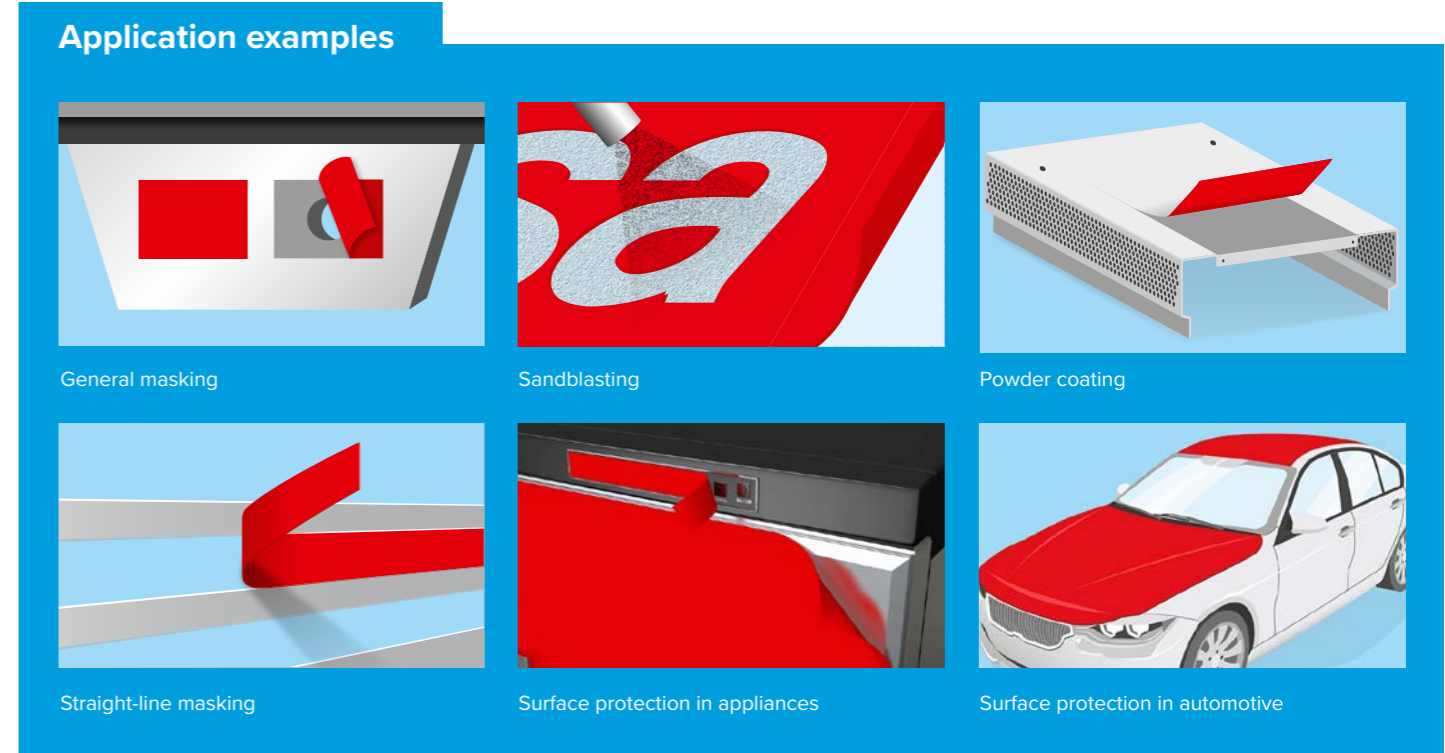
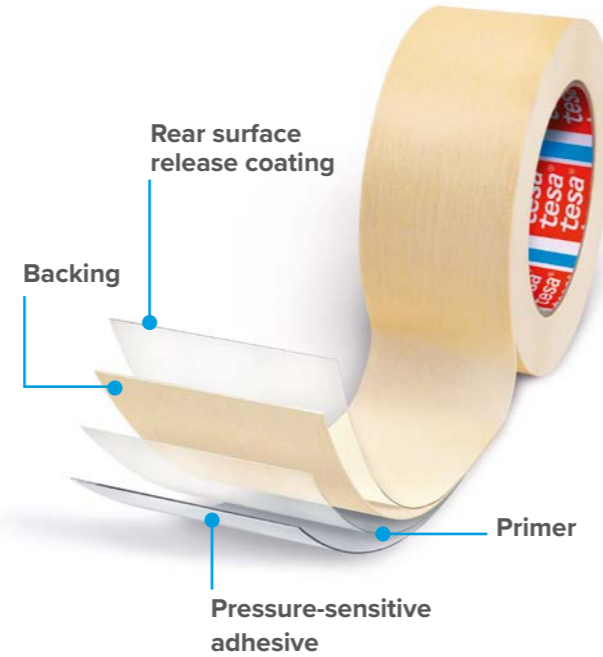
Check out more details [by clicking on the product name.](#)

Masking tapes are essential for a variety of industrial painting applications, even at very high temperatures, while surface protection tapes protect sensitive surfaces from scratches. They must be easy to use and removable without residue, both indoors and outdoors.

The most common industrial application fields for masking tapes are the following:

- Wet coating/spray painting
- Powder coating
- Sandblasting
- Galvanizing
- Surface protection

Our tapes with a paper or film backing have a low elongation and are therefore perfect when straight paint edges are required, for example for two-tone applications. Due to their good quick-stick properties, the paper masking tapes can also be used to securely fix masks that protect surrounding areas against overspray.



Main features



Product	Description	Main application	Backing	Adhesive	Thickness [µm]	Color	Standard log roll width [mm]	Core material / diameter	Adhesion to steel - Ultimate [N/cm]	Temperature resistance short / long term [°C]	Tensile strength
tesa® 4432	Strong flat paper masking tape mainly used for stenciling during sandblasting applications. Features strong hold on multiple surfaces, high tack, great paint anchorage and plottability.	Sandblasting	Fiat paper	Natural rubber	330	Yellow	1020	Cardboard / 3"	8	100	93
tesa® 50600 Standard	High-temperature PET masking tape used for masking during powder-coating processes or bonding and splicing applications of non-polar materials. Features: easy to apply, residue-free removability. tesa® 50600 is also available on a special PET liner	Powder coating	PETP	Silicone	80	Green	1280	PE / 3"	4	220	75
tesa® 50650 Conformable	Conformable high-temperature PET masking tape used for masking during powder-coating processes, surface protection applications and bonding of non-polar materials. Features: easy to apply, residue-free removability.	Powder coating	PETP	Silicone	55	Blue	1280	PE / 3"	3.3	220	50
tesa® 4414	UV-stabilized strong PE tape with high tack and clean removability up to 6 months, even in outdoors conditions. Used for temporary protection of surfaces during assembly, storage and transportation.	Surface protection	PE film	Acrylic	150	Blue	1450	Cardboard / 3"	2.2	70	23
tesa® 51136 PV2	PE tape featuring good adhesion and traceless removal, used for masking large areas of interior plastic parts and textiles, mainly in transportation industries.	Surface protection	PE film	Acrylic	110	Green	1450	Cardboard / 3"	2.6	100	19
tesa® 51407	Polyimide tape with silicone adhesive developed to provide extremely high temperature and chemical resistance. Used for wave soldering, thermal insulation, cable wrapping and powder-coating masking.	Speciality	Polyimide	Silicone	62	Yellow	1000	PE / 3"	2.5	260	40

● very good ● good ○ discrete - poor



Ancillary products

Roller wrapping

Our decades of experience as the pioneering manufacturer of roller wrapping tapes have made our Printer's Friend® tapes a benchmark. They support a variety of manufacturing and printing processes that utilize roller systems and process materials such as films, textiles, paper, and more.

Ever striving for highest quality and optimal solutions, the well-proven tape design has been improved even further over the years, ensuring maximum process reliability and efficiency. The tape design allows for clean and accurate application, while at the same time ensuring easy removal. Applied on the roller, the tape will securely keep its position, even at elevated temperatures.

Our Printer's Friend® roller wrapping tapes:

- Offer outstanding grip and traction to provide tension in the web being processed
- Repel a variety of substances involved in the process (e.g. adhesives or inks)
- Are highly resistant to wear
- Are easily removable, even after a prolonged period of time
- Are exceptionally temperature resistant



Wrap the tape once around the roller at the desired angle and mark the point where the end of the roll meets the second turn of the tape.



Put the tape on a flat surface and cut it diagonally from the end of the roll to the marked point of the tape.



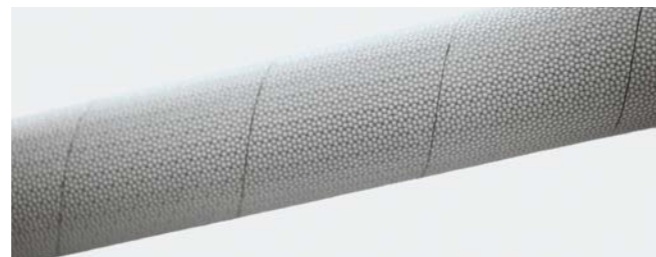
Remove the liner and start applying the tape, starting from the edge of the roller.



Keep on wrapping the roller with the tape at even angles, leaving no gaps in between the layers.



Complete roller spiral wrapped, providing grip and a nonstick surface.



Alternative design, starting from the middle and wrapping to the ends aids in pulling the material evenly across the roller to eliminate creases.

Product	Description	Backing	Adhesive	Liner	Thickness [%]	Color	Standard log roll width	Core material / diameter	Adhesion to steel ultimate
tesa Printer's Friend® 4863	Cloth tape with embossed silicone coated surface, which offers reliable "grip". Designed for roller wrapping in a variety of manufacturing, converting and printing processes.	Silicone-coated cloth	Natural rubber	PP red	620	●	100	cardboard / 3"	3

Surface cleaning

The surfaces to be bonded must be clean, dry and free of dust, grease, oil and release agents. For cleaning, only use clean cloths and material-compatible cleaning agents. The components must be adapted to the ambient climate for a sufficient period to prevent the formation of condensation on the surfaces.

Prior to bonding, the surfaces are cleaned and thus all impurities removed. These include:

- Dust
- Release agents
- Greases
- Waxes
- Plasticisers
- Oxidation layers, e.g. rust

Coarse, dusty or grainy impurities can best be removed with a brush or a white lint-free cloth.

Cleaning with water and solvent



Water-soluble impurities can be removed with water and detergents. Other impurities, e.g. oil traces, grease, wax, and release agents, can strongly reduce the bonding capacity of the surface. Special care must be taken to remove such impurities. Suitable solvents for this are:

- tesa® 60040 Industry Cleaner
- Isopropanol
- Isopropanol + water (1:1)
- Acetone or methyl ethyl ketone (butanone)

Determining which solvent is required is ultimately dependent on the surface to be cleaned. It is recommended to follow the manufacturer's cleaning recommendations. During cleaning, please make sure to work with lint-free and always wipe in one direction. The rags should be changed several times until complete removal of all impurities. Thereafter, the solvent must evaporate completely.

Mechanical cleaning



If the above cleaning agents are not sufficient, the surface can be prepared for bonding by means of mechanical treatment. Loose oxides (such as rust) and poorly adhering coatings are removed with a suitable abrasive, e.g. Mirlon Sanding Fleece VF 360.

The surface should only be roughened slightly and remain flat. Corrosion protection coatings must not be damaged. Thereafter, the surface must be cleaned again to remove the grinding dust with a brush or a white lint-free cloth.

tesa® 60040 Industry Cleaner

Cleaning of surfaces for optimum bonding results with adhesive tapes and spray glues.

- Evaporates without leaving residues
- Excellent cleaning results on machinery and many different surfaces like plastic and metal
- Color: Transparent



Adhesion promoters

For bonding – especially outdoors and on challenging surfaces – we recommend the use of a bonding agent (adhesion promoter). Bonding agents form a layer on the surface to which the pressure-sensitive adhesive adheres particularly well. This layer also prevents water from entering the adhesive joint and thus enables consistent outdoor bonding.



tesa® Adhesion Promoter 60150 – Universal

Our universal adhesion promoter is recommended for a broad variety of substrates including zinc, steel, and PP/EPDM. Its UV-traceability allows easy quality control during the application process.



tesa® Adhesion Promoter 60151 – Glass

This highly transparent adhesion promoter was specifically developed to ensure permanent bonding and moisture resistance on glass substrates.



tesa® Adhesion Promoter 60152 – PU/HPVC

This adhesion promoter can be used to improve the adhesion on specific substrates such as PU* and HPVC**. Its UV-traceability allows easy quality control during the application process.



tesa® Adhesion Promoter 60153 – Fast Cure

Our fast-curing adhesion promoter can be used on various surfaces, including PP/EPDM***. Its UV-traceability allows easy quality control during the application process.

* PU = Polyurethane ** HPVC = Hard Polyvinyl chloride *** PP/EPDM = Polypropylene diene monomer

When using our adhesion promoters, the following instructions should be observed:

Surface	tesa® Adhesion promoter	Repositionability	Application	Tools	Evaporation time	Time window for subsequent bonding
Plastic and metal surfaces (PP, EPDM, zinc, paints)	tesa® 60150, tesa® 60153	tesa® 60150: Yes tesa® 60153: No (high initial bond strength)	Apply thinly	Line-free cloth, brush, application pen	30 sec to 5 min	Several hours/days
Glass	tesa® 60151	No	Apply thinly and wipe with a clean cloth	Line-free cloth, brush, application pen	30 sec to 5 min	5 min
PUR/hard PVC/PVC-U	tesa® 60152	Yes	Apply thinly	Line-free cloth or brush	2 to 5 min	Several hours/days

Physical pretreatment

The surfaces of the material to be bonded and the pressure-sensitive adhesive ideally have a similar surface energy. By means of physical methods such as flame treatment, corona discharge or plasma treatment, the surface energy of an object is increased short-term by the attachment of polar and reactive molecular groups.

However, such activated surfaces can easily and quickly become deactivated by contact with gases and dust of the

ambient climate. The application of physical methods to increase the surface energy should therefore take place immediately before the bonding. It is especially suitable for continuous processing operations.

Ask your application consultant for our technical customer service, who will gladly assist you in implementing physical pretreatment methods.



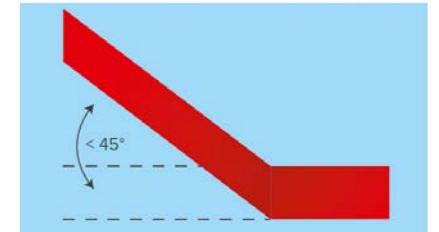


Adhesive Remover

Detaching a single-sided adhesive tape

When removing single-sided adhesive tapes, you should proceed as follows:

- Peel off adhesive tape at an acute angle to the substrate. Ideal: 45° angle. Then the risk that residues will be left behind is at its lowest.
- Always pull slowly and evenly. Thus, residue and tearing of the adhesive tape can be avoided.
- When peeling off, the substrate temperature should be > 10 °C. The carrier material and the adhesive mass will otherwise become brittle and the tendency of the adhesive tape to tear increases.
- If an adhesive tape is difficult to remove, it may help to heat the tape briefly with a hair dryer.



Detaching a double-sided adhesive tape

When peeling off, the substrate temperature should be > 10 °C. The carrier material and the adhesive mass will otherwise become brittle and the tendency of the adhesive tape to tear increases. If an adhesive tape is difficult to remove, it may help to heat the tape briefly with a hair dryer.

If the adhesive joint is sufficiently accessible, then interconnected surfaces can be separated again by cutting the ad-

hesive tape. This is especially possible with thick products such as foam adhesive tapes or tesa® ACX^{plus}.

For this we recommend, for example, the use of an automatic sealing compound cutter or a knife with a sharp and stable blade in combination with a lever tool. Carefully cut through the adhesive tape with these tools.

Removing pressure-sensitive adhesive residues

In practice, adhesive mass residues may remain if it occurs that an unsuitable adhesive tape is used or one has waited too long to remove the tape. In this case, proceed as follows:

- Dab residues with the adhesive side of a more adhesive product, such as tesa® 4651.
- Use tesa® 60042 Adhesive Remover. Removes most adhesive residues on glass, metal and plastic surfaces reliably.
- Alternatively use mineral spirits, isopropanol or similar: Thoroughly soak and expel the adhesive mass with a plastic spatula to avoid damage. Please test solvent on concealed area first.

tesa® 60042 adhesive remover
 Reliable removal of glue residues from plastic parts and glass and metal surfaces.

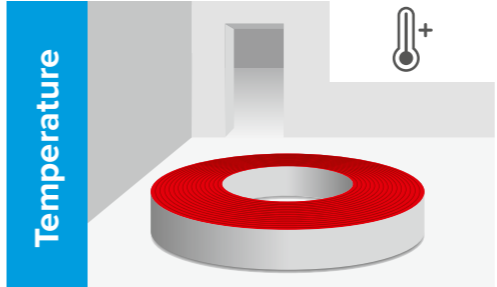
- Evaporates without leaving residues
- Easy removal of labels
- Color: Transparent



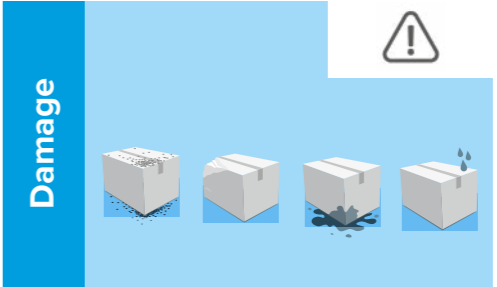
Storage & transportation

Tips before and after converting

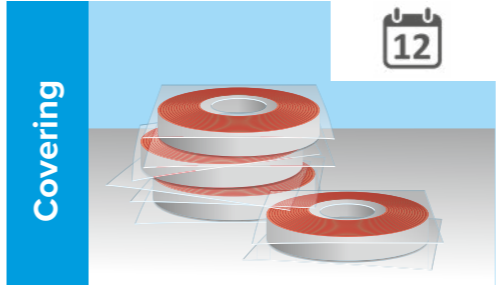
The storage or transport of adhesive tapes is best done at normal room temperature and low air humidity. The rolls are to be covered individually with release film.



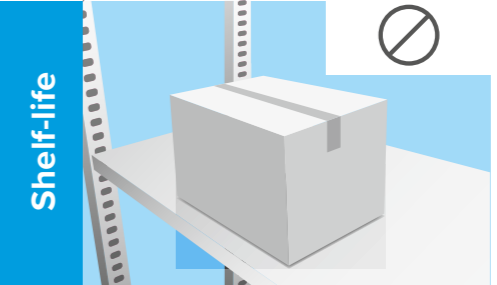
tesa® adhesive tapes are best stored at temperatures between 15–35 °C and at normal relative humidity between 50–70 %.



Ensure during transport and storage that the packaging is not damaged or deformed. The packaging should be resealed after parts removal so that the adhesive tapes are protected against dust, moisture and dirt.



In the case of side-tacky products, the side surfaces of the rolls must be covered with appropriate silicone-coated release sheets. When stacking several rolls on top of each other, a double layer of release sheets is recommended.



If all transport and storage recommendations are adhered to, the minimum shelf-life of tesa® products is usually twelve months from the date of delivery.



Customer
Solution Center

Technical customer service is our top priority

We offer you a wide range of products supporting you in all of your business fields. Many options often require a closer look into the specific application. At the Customer Solution Center we can support you by taking into account your specific materials, their application process, and the operating conditions for the product in use.

From a range of several hundred adhesive tape solutions, we select the right product for your customers' application while considering their specific requirements.

In our Customer Solution Centers we analyze customers' materials, in combination with our adhesive tape products, depending on the application-specific demands, such as bonding power, shock absorption, resistance to environmental impacts, removability, and much more.

During on-site visits, we assist you in detecting such requirements and translate those into appropriate test programs.

Not only do we recommend the suitable products, we also support the implementation stage of our solutions into your customers' process with application tools and equipment.

Based on our modular training program, we individually teach you and your customers about the adhesive tape technology, along with our products, their applications, and corresponding tools. This can either be done at our technical training facilities or even as on-site training on your premises.

Our global network of application engineers collaborate closely to provide short response times and close customer contact, offering you many years of experience and expertise in adhesive tape products and applications.

Our Sales team will assist you in directing your inquiries to our Customer Solution Centers.

Learn more
Scan the QR code to learn more about the Customer Solution Center



