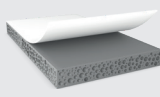

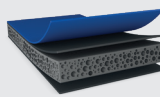
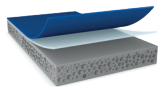
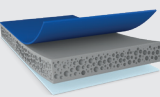
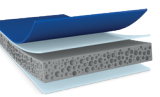





Acrylic Foam Tape Assortment (July 2021)

| Product family | tesa® ACX ^{plus} 772XX Base Line | tesa® ACX ^{plus} 78XX Black Line | tesa® ACX ^{plus} 771XX | tesa® ACX ^{plus} 776XX | tesa® ACX ^{plus} 777XX Primerless Line | tesa® ACX ^{plus} 778XX Primerless Line ¹⁾ | |
|---------------------------------|---|--|---|---|---|--|-------------|
| Product design |  Single layer |  Single layer |  Three layers |  Two layers |  Two layers |  Three layers | |
| Construction | Pure acrylic foam | Modified acrylic foam | Pure acrylic foam core with tackified acrylic adhesive | Pure acrylic foam core with covered side LSE adhesive | Pure acrylic foam core with open side LSE adhesive | Pure acrylic foam core with both sides LSE adhesive | |
| Color | Gray | Deep black | Black | Gray | Gray | Gray | |
| Thickness [mm] | 0.4 | tesa® 77204 | | | | | |
| | 0.5 | | tesa® 7805 | | | tesa® 77805 | |
| | 0.6 | tesa® 77206 | | | | | |
| | 0.8 | tesa® 77208 | tesa® 7808 | tesa® 77108 | tesa® 77608 | tesa® 77708 | tesa® 77808 |
| | 1.1 | | tesa® 7811 | | tesa® 77611 | tesa® 77711 | tesa® 77811 |
| | 1.2 | tesa® 77212 | tesa® 7812 | tesa® 77112 | | | |
| | 1.5 | | tesa® 7815 | tesa® 77115 | tesa® 77615 | tesa® 77715 | tesa® 77815 |
| Liner and tabbing | PV31 – white film liner • Thickness: 110 µm • Both sides siliconized • Tabbing solution: 54999 (50099 for log roll) and 54699 (50699 for log roll) adhesive tabbing PV04 – white PE coated paper liner • Thickness: 140 µm • Both sides siliconized • Available for 77204 only | PV29 – blue film liner • Thickness: 130 µm • Siliconized only on tape side Tabbing solution: 50999 heat tabbing film, 54999 (50099 for log roll) and 54699 (50699 for log roll) adhesive tabbing PV25 – white paper liner • Thickness: 122 µm • Both sides siliconized | PV28 – blue film liner • Thickness: 160 µm • Silicone free film Tabbing solution: 50999 heat tabbing film, 54988 (50988 for log roll) adhesive tabbing PV26 – white paper liner • Thickness: 160 µm Both sides siliconized | PV15 – blue film liner • Thickness: 100 µm • Both sides siliconized • 54699 (50699 for log roll) adhesive tabbing  | PV15 – blue film liner • Thickness: 100 µm • Both sides siliconized • 54699 (50699 for log roll) adhesive tabbing  | PV15 – blue film liner • Thickness: 100 µm • Both sides siliconized Tabbing solution: 54999 (50099 for log roll) and 54699 (50699 for log roll) adhesive tabbing  | |
| Special features | <ul style="list-style-type: none"> • Good initial adhesion on MSE²⁾ substrates • Good shear resistance at elevated temperatures | <ul style="list-style-type: none"> • High bonding power on MSE²⁾ substrates, outstanding on PC and PMMA • Excellent with primer on LSE³⁾ plastics especially on ribbed surfaces • Deep black color for invisible bond lines | <ul style="list-style-type: none"> • Excellent wet-out for high initial bonding power on MSE²⁾ substrates • Strong with primer on LSE³⁾ plastics especially on ribbed surfaces • Excellent shear resistance at elevated temperatures | <ul style="list-style-type: none"> • Excellent performance within the first minute of application on clear coats • Outstanding performance at an application temperature as low as 5 °C | <ul style="list-style-type: none"> • High initial adhesion to LSE³⁾ plastics • Full performance at an application temperature as low as 5 °C | <ul style="list-style-type: none"> • High initial adhesion to LSE³⁾ plastics and clear coats • Full performance at an application temperature as low as 5 °C | |
| Adhesion after 72 h | tesa® 77212 | tesa® 7812 | tesa® 77112 | tesa® 77611 | tesa® 77711 | tesa® 77811 | |
| | Steel | 27 N/cm | 32 N/cm | 28 N/cm | Open side: 26 N/cm Liner side: 31 N/cm | Open side: 31 N/cm Liner side: 26 N/cm | 35 N/cm |
| | ABS | 12 N/cm | 24 N/cm | 26 N/cm | Open side: 12 N/cm Liner side: 28 N/cm | Open side: 28 N/cm Liner side: 12 N/cm | 31 N/cm |
| | PP | 37 N/cm ⁴⁾ | 90 N/cm ⁴⁾ | 73 N/cm ⁴⁾ | 37 N/cm ⁴⁾ | Open side: 36 N/cm | 38 N/cm |
| Temperature range | -40 to +80 °C | -40 to +80 °C | -40 to +90 °C | -40 to +80 °C | -40 to +80 °C | -40 to +80 °C | |
| Static shear resistance at heat | 90 °C > 10.000 min | 90 °C > 10.000 min | 100 °C > 10.000 min | 90 °C > 10.000 min | 90 °C > 10.000 min | 90 °C > 10.000 min | |

Test methods:



Adhesion after 72 h:
Peel test in 90° angle
test speed: 300 mm/min



Static shear resistance
area: 25 mm x 25 mm
on steel, load: 200 g

1) 778XX roll with blue core, the rest products with white core
2) MSE: medium surface energy (38 - 50 mN/m)
3) LSE: low surface energy (29 - 37 mN/m)
4) Using tesa® 60153 primer

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.