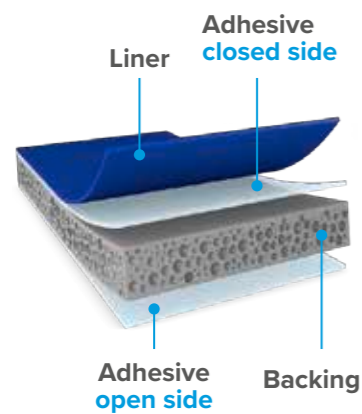


ACX^{plus} assortment for attachment part mounting



Part type	Small (e.g. emblems)		Mid to large (pre treatment LSE)		Mid to large		Large & more demanding	Plastic to plastic
Product	tesa® 772XX		tesa® 78XX	tesa® 776XX	tesa® 777XX	tesa® 778XX	tesa® 790XX <small>NEW</small>	tesa® 79XXX <small>NEW</small>
	Single layer		Two layers		Two layers		Three layers	
Construction								
Color	Gray	Black	Gray					
Backing	Soft acrylic foam	Foamed acrylic	Soft acrylic foam	Soft acrylic foam	Soft acrylic foam	Soft acrylic foam	Special acrylic foam	Special acrylic foam
Adhesive	Closed side	-	-	LSE A	-	LSE A	CC 2	LSE B
	Open side	-	-	-	LSE A	LSE A	LSE B	LSE B
Special features	High cohesion		•					
	High temperature resistance						•	•
	Demanding clear code bonding		•	•		•	•	•
	LSE bonding				•	•	•	•
Thickness	0.4	77204						
	0.5		7805			77805		
	0.6	77206						
	0.8	77208	7808	77608	77708	77808	79008 (Q1/2024) <small>NEW</small>	79X08 (Q4/2024) <small>NEW</small>
	1.0	77210						
	1.1		7811	77611	77711	77811	79011 (Q1/2024) <small>NEW</small>	79X11 (Q4/2024) <small>NEW</small>
	1.2	77212	7812					
	1.5		7815	77615	77715	77815	79015 (Q1/2024) <small>NEW</small>	79X15 (Q4/2024) <small>NEW</small>
	1.6	77216 <small>NEW</small>						
2.0	77220 <small>NEW</small>	7820						

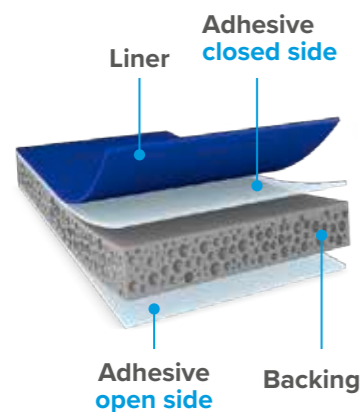


ACX^{plus} assortment for attachment part mounting



Part type	Small (e.g. emblems)		Mid to large (pre treatment LSE)		Mid to large		Large & more demanding	Plastic to plastic		
Product	tesa® 772XX		tesa® 78XX	tesa® 776XX	tesa® 777XX	tesa® 778XX	tesa® 790XX <small>NEW</small>	tesa® 79XXX <small>NEW</small>		
Construction	Single layer		Two layers		Two layers		Three layers			
Temperature	Long (3 months)	80°C / -40°C	80°C	80°C	80°C	80°C	90°C	90°C		
	Short (15 min)	120°C / -40°C	120°C	120°C	120°C	120°C	120°C	120°C		
Peel adhesion	Clear coat / paint (covered side (1.100 µm))	31 N/cm	28 N/cm	36 N/cm	32 N/cm	39 N/cm	40 N/cm	-		
	LSE (e.g. PP EPDM) w/o pre treatment (1.100µm)	-	-	-	40 N/cm	40 N/cm	40 N/cm	40 N/cm		
	MSE (e.g. ABS) w/o pre treatment (1.100µm)	-	35 N/cm	-	36 N/cm	31 N/cm	40 N/cm	40 N/cm		
Liner	Paper	PV04	PV25	-	-	-	-	-		
	PE	PV31/34 (white)	PV29 (blue)	PV15 (blue)	PV15 (blue)	PV15 (blue)	PV15/PV29 (blue)	PV15/PV29 (blue)		
	PET	PV36 (translucent)								
Approvals / references / spec passed (European OEMs)	VW Group ^{2,3} BMW Group ^{2,3} STELLANTIS ^{2,3} Mercedes ^{2,3} tesla ² Volvo ^{2,3}		VW Group ^{2,3} BMW Group ^{1,2,3} STELLANTIS ^{1,2,3} Mercedes ^{1,2,3} Volvo ³ JLR ^{1,2,3}		VW Group ^{2,3} BMW Group ^{2,3} STELLANTIS ^{1,2,3}		VW Group ^{2,3} BMW Group ³ STELLANTIS ^{1,2,3} Volvo ² JLR ^{1,2,3}		VW Group ³ BMW Group ³ Mercedes ³	

¹Material approval, ² Part reference, ³Internal spec test passed



tesa ACX^{plus} Seal Line assortment



tesa ACX^{plus}

tesa® 745xx Seal Line

tesa® 746xx Seal Line



tesa® 747xx Seal Line



Product design



Two layers



Two layers



Three layers

Backing		Foamed acrylic	Foamed special acrylic	Foamed special acrylic
Adhesive	Closed side	-	-	CC 3
	Open side	Heat activatable (HA1)	Heat activatable (HA2)	Heat activatable (HA2)
Color		Deep black	Deep black	Deep black
Main application		Waterbox seal, sunroof seal, anti-pinch, etc.	Sunroof seal, anti-pinch, applications with high demands for low deformation	Door seals
USP		High peel to various substrates High dynamic stability	Low deformation at static load and elevated temperatures Optimized foam split properties	Low deformation at static load and elevated temperatures No primer needed Optimized foam split properties
Temperature	Short (15 min)	-40°C – 120°C	-40°C – 120°C	-40°C – 120°C
	Long (3 months)	-40°C – 80°C	-40°C – 90°C	-40°C – 90°C
Liner		Blue filmic PE / PV29	Blue filmic PE / PV29	Blue filmic PE / PV29
Thickness Range [mm]	0.8	74508	74608	
	1.2	74512		74712
Approvals / references / spec passed (European OEMs)				VW Group ³

¹Material approval, ² Part reference, ³ Internal spec test passed

tesa ACX^{plus} liner assortment



Liner	Product version	Available on	Thickness [mm]	Material	Features			
					Color	Tensile strength	Elongation at break [%]	Available tabbing
PE film based	PV 29	78xx 745xx 746xx 747xx	130	PE film, one side siliconized	Royal blue	>30N/cm	>300%	Heat tabbing: 50999 Adhesive tabbing: 50099 / 50988
	PV 15	76xx 776xx 777xx 778xx	100	PE film, both sides siliconized	Royal blue	>17N/cm	>1.000%	Adhesive tabbing: 50099 / 50699
	PV 31	772xx (except for 77204)	110	PE film, both sides siliconized	White	>20N/cm	>800%	Adhesive tabbing: 50099
	PV 34	77204 77208	80	PE film, one side siliconized	White	>15N/cm	>800%	Adhesive tabbing: 50099 / 50699
Paper based	PV 25	78xx	122	PE coated paper	White	>73N/cm	>2,5%	NA
	PV 04	772xx	122	PE coated paper	White	>73N/cm	>2,5%	NA
PET film based	PV 36	77204		Siliconized PET film	Transparent blue	>75N/cm		Adhesive tabbing: 50699

tesa ACX^{plus} backing and adhesives



Backing	Features				
	Color	Self sticky	Inner strength	Temperature resistance	
				Short term	Long term
Soft acrylic foam	Gray	Yes	Good	120°C	80°C
Foamed acrylic	Black	Yes	Very high	120°C	80°C
Foamed special acrylic	Black	Yes	Highly balanced	120°C	90°C
Special acrylic foam	Gray	Yes	Highly balanced	120°C	90°C

Additional adhesives	USP	Temperature resistance	
		Short term	Long term
CC 2	Special Adhesive with excellent initial and long term adhesion on difficult to bond clear coat. Very robust processability.	120°C	90°C
CC 3	Special Adhesive with excellent initial and long term adhesion on difficult to bond clear coat. Very robust processability.	120°C	90°C
LSE B	Special Low Surface Energy (LSE) adhesive with excellent initial and long term adhesion on difficult to substrates like PP EPDM. Very robust processability.	120°C	90°C
LSE A	Special Low Surface Energy (LSE) adhesive with best initial tack on difficult to substrates like PP EPDM. Very good initial and long term adhesion on difficult to bond clear coats.	120°C	80°C
HA2	Heat activated layer for bonding of PP/EPDM, PP, TPV, and TPE materials for optimized anchorage	120°C	90°C
HA1	Heat activated layer for bonding of PP/EPDM, PP, TPV, and TPE materials	120°C	90°C