



# tesa® 77815 Primerless Line



## Product Information

1.5 mm double-sided acrylic foam tape for mounting of automotive exterior attachment part

## Product Description

tesa® ACX<sup>plus</sup> 77815 can help you eliminate the primer in your process!

Its high-performance LSE adhesive creates an efficient and secure bond to typical automotive attachment parts made of LSE (like PP and PP/EPDM) and MSE (like ABS) plastics without primer. In addition, our product also has excellent adhesive properties when it comes to different types of OEM clear coats. (LSE: low surface energy; MSE: medium surface energy). Thanks to its viscoelastic acrylic foam core, tesa® ACX<sup>plus</sup> 77815 Primerless Line has the ability to absorb and dissipate dynamic and static loads.

0.5, 0.8 mm and 1.1 mm thicknesses are available

## Product Features

Features:

- # High initial performance on LSE plastics and difficult-to-bond OEM clear coats
- # Excellent bonding stability at wider range of temperatures
- # Reaches high peel-adhesion level right after application
- # Superior peel adhesion on PP substrates, even at an application temperature as low as 5°C
- # Viscoelastic acrylic foam core to compensate for different thermal elongation of bonded parts
- # Outstanding wet-out property
- # High humidity and UV resistance

Benefits:

- # Eliminates the primer in the production process
- # Enables a much more efficient and robust application
- # Reduces the total process cost
- # Realizes healthier working conditions

For latest information on this product please visit <http://l.tesa.com/?ip=77815>



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#### Product Features

# Achieves a more environmentally friendly production

#### Application Fields

tesa® ACX<sup>plus</sup> 77811 Primerless Line is suitable for a wide range of permanent exterior mounting applications. To ensure the highest performance possible, our aim is to fully understand your application (including the substrates involved) in order to provide the right product recommendation.

# Body side moldings and decorative trims

# Emblems

# Spoilers

# Antennas

# Pillar appliqués

# PDC mounting

#### Technical Information (average values)

The values in this section should be considered representative or typical only and should not be used for specification purposes.

#### Product Construction

• Backing material	Acrylic foam	• Total thickness	1500 µm
• Type of adhesive	LSE	• Colour	grey
• Type of liner	PE	• Colour of liner	blue

#### Properties/Performance Values

• Ageing resistance (UV)	good	• Static shear resistance at 90°C	very good
• Humidity resistance	very good	• T-block	very good
• L-jig	good	• Temperature range	-40 to +80 °C

#### Adhesion to Values

• ABS (after 3 days)	34 N/cm	• Steel (after 14 days)	39 N/cm
• ABS (initial, 1 min)	32 N/cm	• Steel (after 3 days)	39 N/cm
• PP (after 3 days)	44 N/cm	• Steel (initial, 1 min)	36 N/cm
• PP (initial, 1 min)	34 N/cm		

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### Disclaimer

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