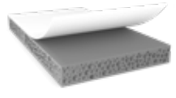
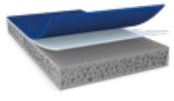
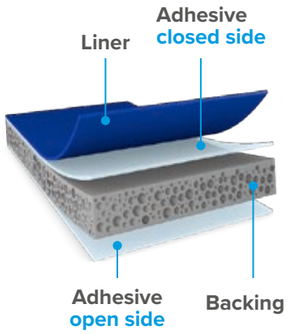
ACX^{plus} assortment for attachment part mounting

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



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ACX^{plus} assortment for attachment part mounting

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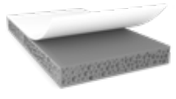
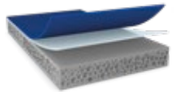
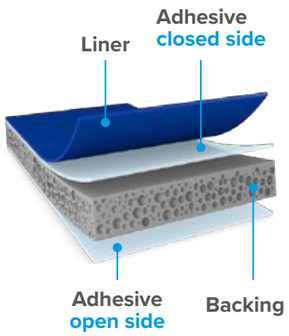
	Product	**tesa® 772XX**	**tesa® 78XX**	**tesa® 776XX**	**tesa® 777XX** Primerless	**tesa® 778XX** Primerless	**tesa® 790XX** NEW Primerless
Construction							
		Single layer		Two layers	Two layers	Three layers	
Temperature	**Long (3 months)**	80°C / -40°C	80°C	80°C	80°C	80°C	95°C
	Short (15 min)	120°C / -40°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
	MSE (e.g. ABS) w/o pre treatment (1.100µm)	-	35 N/cm	-	36 N/cm	31 N/cm	40 N/cm
Liner	**Paper**	PV04	PV25	-	-	-	-
	PE	PV31/34 (white)	PV29 (blue)	PV15 (blue)	PV15 (blue)	PV15 (blue)	PV15 / PV19 (coming soon)
	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] Volvo [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 [1; 3] Mercedes [1;3]

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



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tesa ACX^{plus} Seal Line assortment

PFAS FREE

tesa ACX^{plus}		tesa® 745xx Seal Line	tesa® 746xx Seal Line NEW	tesa® 747xx Seal Line NEW
Product design		 Two layers	 Two layers	 Three layers
Backing		Tackified acrylic foam	Soft acrylic foam	Soft acrylic foam
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]

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

tesa ACX^{plus} liner assortment

PFAS FREE

Liner	Product version	Available on	Features					Available tabbing
			Thickness [mm]	Material	Color	Tensile strength	Elongation at break [%]	
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

PFAS FREE

Backing	Features				
	Color	Self sticky	Inner strength	Temperature resistance	
				Short term	Long term
Acrylic foam	Gray	Yes	Good	120°C	80°C
Tackified acrylic foam	Black	Yes	Very high	120°C	80°C
Soft acrylic foam	Black	Yes	Highly balanced	120°C	90°C
Tackified acrylic foam	Gray	Yes	Highly balanced	120°C	95°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, MSE plastics and other MSE materials. Very robust processability.	120°C	95°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 **L**ow **S**urface **E**nergy (LSE) adhesive with excellent initial and long term adhesion on PP EPDM substrates. Very robust processability	120°C	95°C
LSE A	Special **L**ow **S**urface **E**nergy (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 activatedlayer 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