

A woman with long brown hair in a ponytail, wearing a teal sweater and blue jeans, is standing in a supermarket aisle. She is holding a red and white box of food in her right hand and looking at it. A shopping cart is visible in the foreground, and shelves stocked with various food items are in the background.

# Reliability & efficiency in food packaging

Adhesive tape solutions for food packaging producers



# Your partner for all adhesive needs in food packaging

## A complete package for your packaging requirements

Choosing the right food packaging is essential for protecting and maintaining food. It is the most reliable way to control and protect food against biological and physical factors. From solutions for single- and double-sided bag reclosure, to bag and candy cup sealing, innovative carton box closures, and palletizing, we provide a full assortment for the global packaged consumer goods industry.



## Solutions without a compromise

As a global partner to various food industry enterprises, we offer a wide range of food packaging assortments to match the needs of individual customers for both inner and outer packaging. Our decades of experience as one of the world's leading manufacturers of self-adhesive tape have not only resulted in a comprehensive product assortment; we at tesa also focus very much on our customers' processes, their value chains, and we constantly strive to understand and solve process needs.

## Main products benefits at a glance



### Sustainability targets

Strong focus on more sustainable solutions in final packaging, constantly adapting to market needs



### Proven processability

Smooth unwinding and proven processability on market-standard applicators



### Reliable performance

Strong backing and high adhesion on relevant substrates ensures high performance



### Aesthetic appeal

A pleasing visual appearance for your final packaging, approved by leading design centers



# Our adhesive solutions for inner packaging

## Secure packaging solutions for enhanced customer experience

Inner packaging applications require the most attention, as your end customers are in direct contact with them. Therefore, they need products that provide secure packaging, while offering attractive and convenient handling or resealing of your product's packaging. Whether they require a food safe approval for indirect food contact or other special requirements, we are looking forward to providing you with distinguishable inner packaging solutions. For example, with our single- and double-sided bag reclosure solutions, your product packaging will be safe and convenient for end customers.

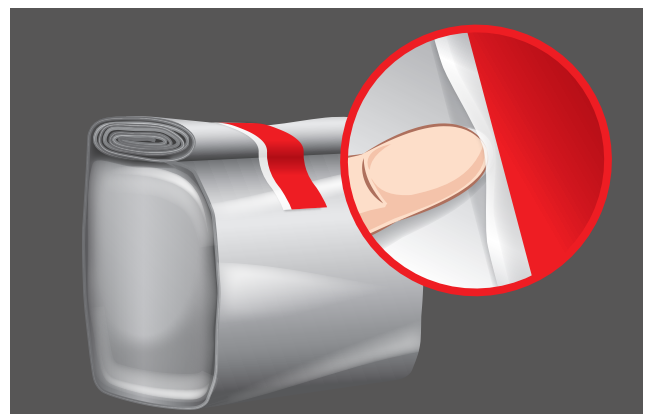
## Resealable bag closure – single-sided solutions for convenient reclosure

### tesa® Lift & Reseal

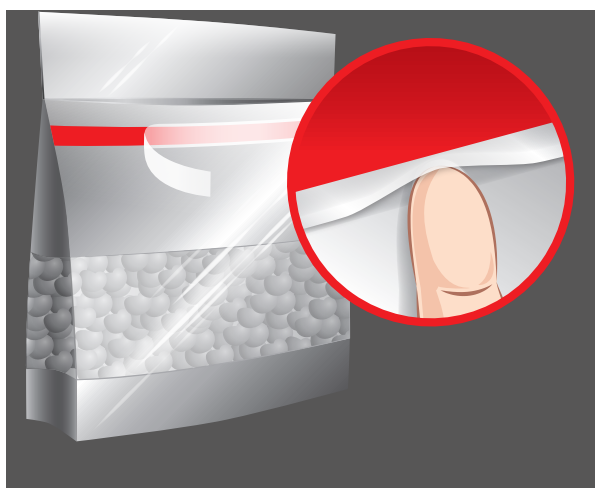
Our tesa® Lift & Reseal single-sided resealable bag closure system offers approximately 20 effective reclosure actions, giving consumers the ability to reseal the pack for the lifetime of its contents. Alongside the possibility of adding value to your end product, tesa® Lift & Reseal is developed to be easily integrated into the packaging process. Whether you are packing nuts, snacks, fruits, or vegetables, tesa® Lift & Reseal is a convenient reclosure solution to keep them fresh.

#### Features of tesa® Lift & Reseal

- High-tack tape with good shear strength, enabling effective reclosure that will not pop open
- Robust and stable adhesive – no residues, good aging resistance
- Custom printed fingerlift strip for easy peel back
- Supplied spool wound, for rapid integration on the production line
- A full and complete solution including the tape and a tesa® 6081 dispenser, with no impact on your running speed



# Resealable bag closure – double-sided solutions for convenient reclosure



Depending on your production requirements, we offer you a full assortment of different double-sided resealable bag closure solutions. The main advantage of our reclosure tapes is the long-lasting freshness achieved by its tight closure. All products are available with and without a liner with overhanging fingerlift, which offers convenient liner removal. Our product alternatives enable that we can offer a suitable solution for all kinds of bags.

## Features of our double-sided resealable bag closures

- Strong and stable acrylic or synthetic rubber adhesive
- No residues, excellent aging resistance
- Extended fingerlift liner available for easy liner removal
- Supplied spool wound, for rapid integration on the production line

### tesa® 4917

#### Double-sided filmic tape with differential adhesive system, without fingerlift

tesa® 4917 consists of a transparent double-sided PP film with a differential adhesive system. The product can easily be cut with the hot wire systems of common bag machine producers.

### tesa® 6917

#### Double-sided filmic tape with differential adhesive system and fingerlift

tesa® 6917 is a transparent double-sided PP film with a differential adhesive system that can easily be cut with the hot wire systems of common bag machine producers. tesa® 6917 comes with fingerlift (extended liner) for convenient liner removal.

### tesa® 64621 PV0

#### Double-sided filmic tape with and without fingerlift

tesa® 64621 PV0 is a transparent double-sided self-adhesive tape consisting of a PP backing and a synthetic rubber adhesive. tesa® 64621 PV0 is solvent-free and offers a very high tack.

### tesa® 64621 PV6

#### Double-sided filmic tape with fingerlift

Stable red filmic liner of tesa® 64621 PV6 leads to an easy automatic application process, with a spool length of 8000 m leads to fewer machine stops and contributes to an efficient production process.

#### Main applications

- Reopenable closure system for filmic bags
- Removable emblems or profi

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- General purpose fixing
- Self-adhesive mounting of decorative and packaging materials
- Bonding of foils, fabrics, paper, and plastic materials

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- Bonding of foils, fabrics, paper, and plastic material



## Find the right resealable double-sided bag closure option

tesa® 4917



tesa® 6917



tesa® 64621 PV0



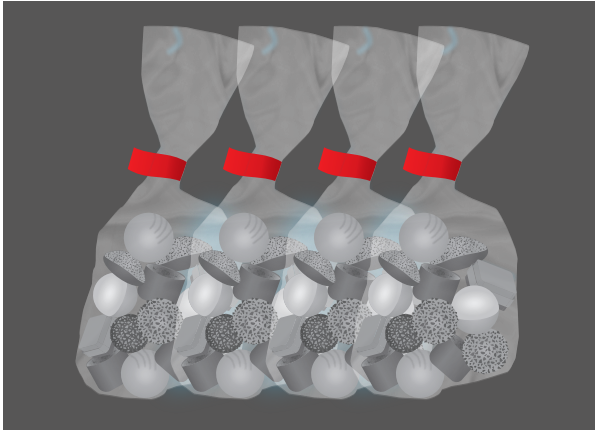
tesa® 64621 PV6



Backing material	PP film	PP film	PP film	PP film
Total thickness [µm]	90	90	90	90
Type of adhesive	Tackified acrylic	Tackified acrylic	Synthetic rubber	Synthetic rubber
Adhesion to steel (after 14 days)	11.4 N/cm	11.4 N/cm	15.0 N/cm	15.0 N/cm
Adhesion to PE (after 14 days)	4.1 N/cm	4.1 N/cm	6.5 N/cm	6.5 N/cm
Temperature resistance (short term)	120°C	120°C	80°C	80°C
Temperature resistance (long term)	80°C	80°C	40°C	40°C
Differential adhesive	Yes	Yes	No	No
Tack	● ● ●	● ● ●	● ● ● ●	● ● ●
Aging resistance (UV)	● ● ● ●	● ● ● ●	● ●	● ●
Humidity resistance	● ● ● ●	● ● ● ●	● ● ●	● ● ●
Static shear resistance at 23°C	● ● ●	● ● ●	● ●	● ●
Static shear resistance at 40°C	● ● ●	● ● ●	●	●
Color	Transparent	Transparent	Transparent	Transparent
Type of liner	PP	PP	Glassine paper	PP
Color of liner	Red	Red	Yellow	Red
Fingerlift	No	Yes	Yes/No	Yes
Thickness of liner [µm]	80	80	70	80

Evaluation across relevant tesa® assortment: ● ● ● ● Very good ● ● ● Good ● ● Medium ● Low



# Bag sealer – Secure closure with bag sealing tapes



Bakery products, candies, and other consumables that are packed in bags require a reliable closure. With our bag sealing tapes we offer suitable solutions here. Furthermore, we provide supplementary dispensers for efficient operations.

### Features of our bag sealer

- For sealing small boxes and cans
- Use at bakery and flower shop counters
- Available in transparent and different colors
- A full and complete solution including the tape and a tesa® 6094 dispenser

Product description and application	Main application	Backing	Adhesion to steel	Total thickness	Tensile strength	Elongation at break	Color
		Adhesive		Backing thickness			
 <p><b>tesa® 4204 PVO</b> <b>Colored filmic packaging tape</b> tesa® 4204 PVO is based on a stable PVC backing coated with a natural rubber adhesive. This product can generally be used on all common desk dispensers.</p>	<ul style="list-style-type: none"> <li>• Sealing small boxes and cans</li> <li>• Use at bakery and flower shop counters</li> <li>• Suitable for marking based on the variety of colors</li> </ul>	PVC film	2.0 N/cm	59 µm	50 N/cm	75%	<div> <div>○</div> White*           <div>●</div> Red           <div>●</div> Yellow           <div>●</div> Blue           <div>●</div> Green           <div>●</div> Havana*           <div>○</div> Trans-parent*         </div>
		Natural rubber		32 µm			
 <p><b>tesa® 4205</b> <b>Transparent small item packaging tape</b> tesa® 4205 is based on a 28 µm PP backing coated with a natural rubber adhesive. This product design provides good properties for sealing applications of small items. tesa® 4205 can be used on all common desk dispensers.</p>	<ul style="list-style-type: none"> <li>• Sealing of small boxes or cans</li> <li>• Bundling of small items</li> </ul>	PP film	2.5 N/cm	45 µm	43 N/cm	145%	○ Trans-parent
		Natural rubber		28 µm			

\* tesa® 4204 white, havana, and transparent have other technical data.






# Sealing of candy cups – Colorful solutions for sealing candy cups



Classic candy tins must be sealed with a layer of adhesive tape. We offer reliable solutions for their closure during transportation until they reach the end customer. Our transparent versions are most commonly used in this application, but we also offer a wide range of colors.

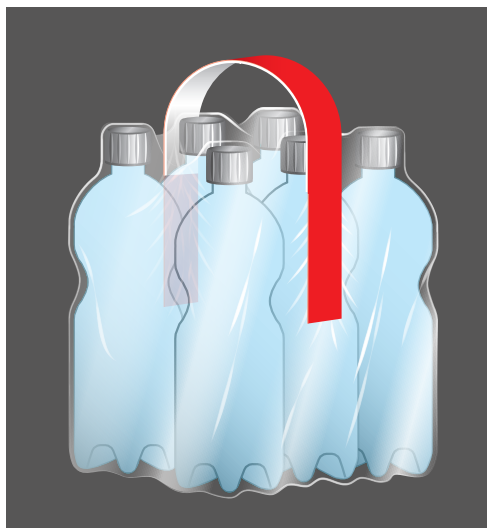
## Features of candy cup sealing

- Sealing small boxes (cardboard or plastic)
- Sealing tins and bags
- Available in transparent and different colors
- tesa® 60404 red enables sharp-edge masking for multicolor painting

Product description and application	Main application	Backing	Adhesion to steel	Total thickness	Tensile strength	Elongation at break	Color
		Adhesive		Backing thickness			
 <b>tesa® 4204 PV0</b> <b>Colored filmic packaging tape</b> tesa® 4204 PV0 is based on a stable PVC backing coated with a natural rubber adhesive. This product can generally be used on all common desk dispensers.	<ul style="list-style-type: none"> <li>• Sealing small boxes and cans</li> <li>• Use at bakery and flower shop counters</li> <li>• Suitable for marking based on the variety of colors</li> </ul>	PVC film	2.0 N/cm	59 µm	50 N/cm	75%	○ White* ● Red ● Yellow ● Blue ● Green ● Havana* ○ Trans-parent*
		Natural rubber		32 µm			
 <b>tesa® 60404 colored</b> <b>Brilliant colored filmic packaging tape</b> tesa® 60404 is a premium packaging tape based on a PVC-film backing and a natural rubber adhesive. It shows excellent performance on all kinds of cardboards and secures a safe closure.	<ul style="list-style-type: none"> <li>• Sealing small boxes (card-board or plastic)</li> <li>• Sealing tins and bags</li> <li>• Variety of colors available make tesa® 4104 ideal for marking</li> </ul>	PVC film	3.6 N/cm	67 µm	60 N/cm	60%	● Black ○ White ● Red ● Orange ● Yellow ● Blue ● Green
		Natural rubber		40 µm			
 <b>tesa® 4205</b> <b>Transparent small item packaging tape</b> tesa® 4205 is based on a 28 µm PP backing coated with a natural rubber adhesive. This product design provides good properties for sealing applications of small items. tesa® 4205 can be used on all common desk dispensers.	<ul style="list-style-type: none"> <li>• Sealing small boxes and cans</li> <li>• Bundling of small items</li> </ul>	PP film	2.5 N/cm	45 µm	43 N/cm	145%	○ Trans-parent
		Natural rubber		28 µm			

\* tesa® 4204 white, havana, and transparent have other technical data.

# Handylift – Carrying handle for convenience





While carrying water bottles or other products with a high weight, a strong and comfortable handle tape is required. Our tesa® handylift offers you an efficient solution that allows you to run a fast production process while reducing downtime. This high-quality product is suitable on almost all kinds of wrapping material, ensuring a reliable bond.

Our tesa® handylift product consists of a strong MOPP tape (Mono-axially Oriented Polypropylene) with an laminated, non-sticky, and printable foam, foil, or paper.

## Features of handylift

- Pre-material for carry handles
- Applicable for weights up to 18 kg
- High-quality natural rubber adhesive
- Handle can be custom printed

Product description and application	Main application	Backing	Adhesion to steel	Total thickness	Tensile strength	Elongation at break
		Adhesive				
 <b>tesa® 64285</b> <b>Tensilized polypropylene tape</b> tesa® 64285 is a tensilized polypropylene tape with a natural rubber adhesive. It exhibits good tensile strength with low elongation at the same time. The product is especially recommended for handylift applications. It provides residue-free removal and no discoloration.	<ul style="list-style-type: none"> <li>• Pre-material for handylift</li> <li>• Palletizing, adhering, or bundling are also possible</li> </ul>	MOPP	6.0 N/cm	72 µm	180 N/cm	35%
		Synthetic rubber				
 <b>tesa® 64286</b> <b>Strapping tape for basic applications</b> tesa® 64286 is a tensilized polypropylene strapping tape with a hot melt adhesive system. It has good tensile strength with low elongation at the same time. The product shows a high peel adhesion.	<ul style="list-style-type: none"> <li>• Pre-material for handylift</li> <li>• Palletizing</li> <li>• Reinforcing</li> <li>• Closing of shipping cartons is also possible</li> </ul>	MOPP	7.5 N/cm	73 µm	175 N/cm	35%
		Synthetic rubber				



# Our adhesive solutions for carton packaging



## Outstanding quality for crucial applications

Secure packaging is the primary requirement to ensure a product reaches its destination intact. It provides protection from a variety of factors en route to the recipient. However, it is not only the cardboard box that is of significance – a huge range of other requirements are also placed on the adhesive tapes holding the box together. tesa® packaging tapes are the result of decades of experience in the secure sealing of cartons. They have proven their worth millions of times over as a safe solution, under a huge range of different conditions, for the transportation of goods.





Overview  
Core Assortment  
Packaging



- Questions to ask:
- How heavy is the carton to be closed?
  - How important is a sustainable product solution?
  - Is the tape meant for manual or automatic application?

Color Coding  
& Positioning Logic:



**Specialty**  
Products offering unique features  
and advanced functionalities to cover  
special technical requirements



**Performance**  
Market proven flagship products across  
multiple industries that are suitable for a  
wide range of applications

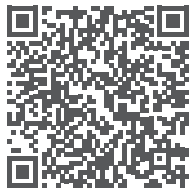


**Commercial**  
Quality products that cover all basic  
technical requirements and are available in  
all standard dimensions



Industry Sustainability marker - high-  
lighting our sustainable products for  
industrial customers and markets.

Learn more:



		Paper					Filmic							
Weight category	Heavy >30kg					60013 🌱							4122	64044
	Medium <30kg								60418 🌱	4100	4120	4124	60412 🌱	
	Medium <20kg		4513 🌱	60408 🌱	4313 🌱									
	Light <15kg						4024	64014						
	Light <10kg	4713 🌱												
Colors		○●	●	●	○●	●	●○●	●○●	●○●	●○●	●○●	●○●	●○●	●○●
Printable		yes	yes	yes	yes	no	yes	yes	no	yes	yes	yes	yes	yes
Machine rolls (automatic application)		yes	yes	yes	yes	yes	yes	no	yes	yes	yes	yes	no	yes
Initial adhesion		★★★★☆	★★★★☆	★★★★☆	★★★★☆	★★★★★	★★★★☆	★★★★☆	★★★★☆	★★★★☆	★★★★☆	★★★★★	★★★★☆	★★★★★
Tear resistance		★★★☆☆	★★★★☆	★★★★☆	★★★★★	★★★★★	★★★★☆	★★★★☆	★★★★☆	★★★★☆	★★★★☆	★★★★★	★★★★★	★★★★★
Paper from well-managed sources		yes	yes	yes	yes	yes	no	no	no	no	no	no	no	no
Solvent free production		yes	yes	yes	yes	yes	yes	yes	yes	no	no	no	yes	yes
Bio-based content (DIN)		no	no	yes	no	no	no	no	no	no	no	no	no	no
INDEGE Method 12		yes	yes	yes	yes	yes	no	no	yes	no	no	no	yes	no





## Certifications

Our company is focused on international quality, environmental, and occupational safety standards.

Please find more information regarding our certifications at:  
[www.tesa.com/certifications](http://www.tesa.com/certifications)

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