



tesa® ACXplus 74712 Seal Line



Product Information

1.2 mm heat activatable acrylic foam tape for mounting of demanding seal applications such as door seals

Product Description

tesa® ACX^{plus} 74712 Seal Line is a deep black acrylic foam tape for permanent mounting of seals, mainly on automotive clearcoat. It has a heat-activatable adhesive on the non-liner side. The adhesive gets activated by hot air or near-infrared when applying it onto the PP/EPDM, PP, TPV, or TPE seal.

Compared to the conventional process with primer, tesa® ACX^{plus} 74712 Seal Line ensures a highly secure bond to the rubber profile, enables a higher application speed than using primer, and improves the operational safety during the production process.

By introducing a functional layer at the liner side, tesa® ACX^{plus} 74712 can be used on various automotive clearcoats even without the use of adhesion promoters. The acrylic foam core ensures outstanding dimensional stability even at high temperatures and loads. At the same time, by its viscoelastic properties, tesa® ACX^{plus} 74712 Seal Line absorbs and dissipates dynamic and static loads. This also allows compensation of extreme physical stress caused by the different thermal elongation of bonded parts in rapidly changing temperatures.

The deep black color provides an enhanced appearance and high design flexibility.

Product Features

- Efficient and secure bonding of the heat-activatable layer to seals
- Application on clearcoats without primer
- Final peel adhesion reached after 24 h
- Enhanced temperature resistance
- Robust shear performance even at high temperatures
- PFAS / PFOS free product
- Strong bonding of the heat-activatable layer to acrylic core that withstands even humidity and heat
- Closed cell acrylic foam core for reliable sealing to prevent water penetration
- High humidity and UV resistance
- Excellent cold shock performance

Application Fields

tesa® ACX^{plus} 74712 Seal Line can be widely used for all kinds of automotive seal applications within a temperature range of -40 °C to 90 °C.



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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	foamed acrylic	• Color	deep black
• Type of adhesive	acrylic	• Color of liner	blue
• Type of liner	PE/PP protection film	• Type of adhesive to seal	heat-activatable
• Total thickness	1200 µm		

Product Assortment

• Available colors	deep black
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Properties/Performance Values

• Elongation at break	500 %	• Ageing resistance (UV)	very good
• Tensile strength	19 N/cm	• Humidity resistance	very good

Adhesion to Values

• Clear coat (after 20 min)	18 N/cm	• Steel (after 3 days)	36 N/cm
• Clear coat (covered side, after 3 days)	36 N/cm	• TPE (T-Peel, after 3 days warm / humid)	16 N/cm
• Steel (initial)	36 N/cm	• TPE (T-Peel, after 3 days)	16 N/cm

Additional Information

- PV29 = filmic liner in royal blue, siliconized to adhesive side and silicone free to tabbing side, works with both heat and adhesive tabbing tapes. Liner removal force ≤ 100 cN/cm.
- Adhesion to steel and tesa standard clearcoat: measured at 90°, 300mm/min, tape reinforced with aluminium foil
- T-Peel test: heat-activatable adhesive to standard TPE seal, 300 mm/min
- Warm/humid storage: 72 h at 40°C and 100% r.h.



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