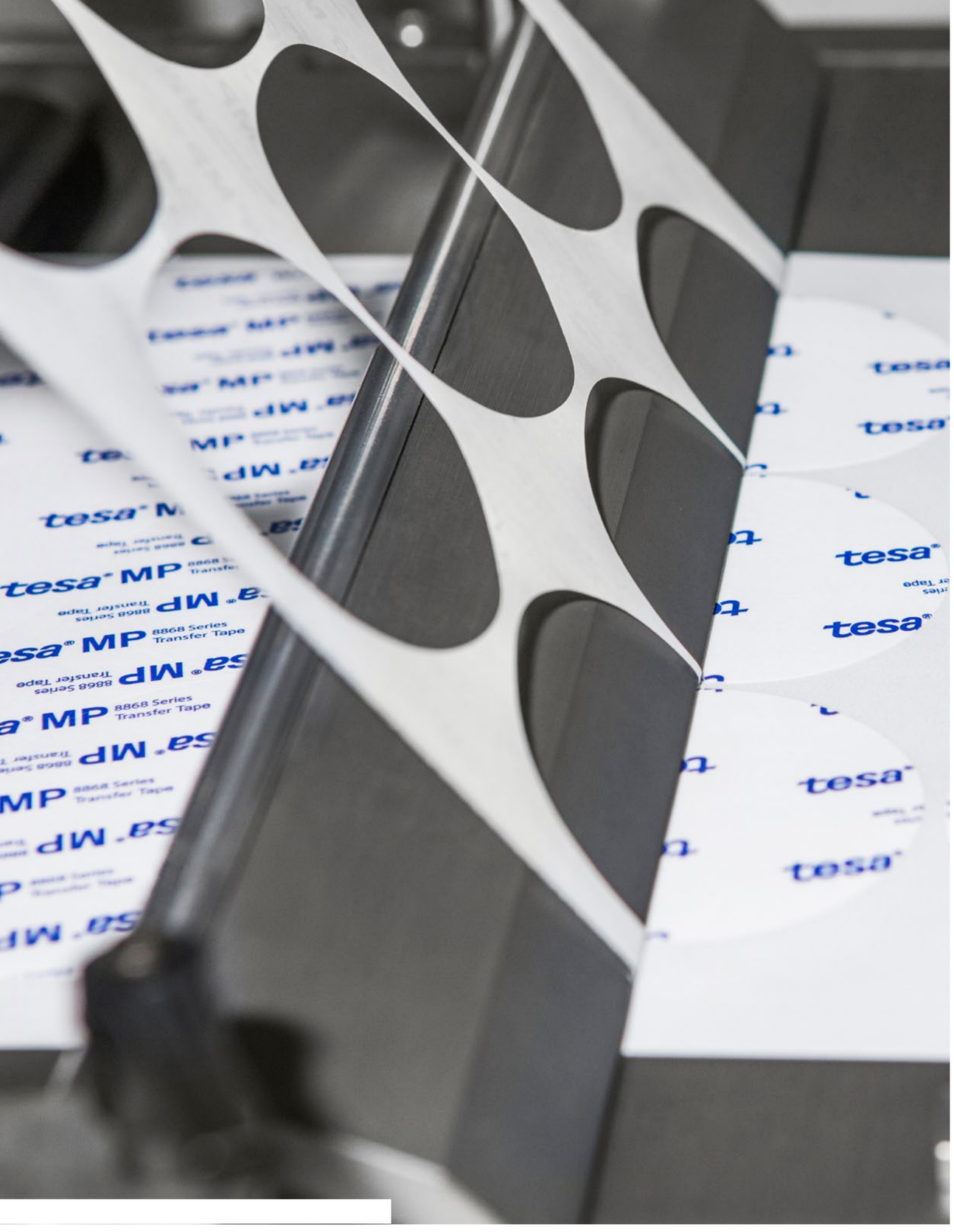
Converter core assortment

Core assortment for Converter Partners



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By your side

About us

- regional headquarters
- production centers
- plants
- Customer Solution Centers
- offices

Your adhesive solutions partner

As a multinational company, tesa develops innovative adhesive tapes and self-adhesive system solutions for various industries, commercial customers, and end consumers. The age of technical adhesive tapes began 125 years ago, and there are already more than 7,000 tesa adhesive solutions that help improve the work, products, and lives of our customers.

Today, the focus is on sustainability and energy-saving processes. tesa invests in the development of environmentally friendly products and solvent-free manufacturing processes, as well as in the use of renewable energy sources at its locations.

We are firmly committed to sustainability – it shapes our strategy and goals

Taking on more responsibility for the world around us is becoming increasingly important – for us as a company, for our employees, and for our business partners and customers. That is why we aim to make sustainability a priority at tesa and get to work with this crucial transformation of our business significantly faster and more urgently than previously envisaged.

Want to know more about sustainability at tesa? Scan or click here!

Reduction of emissions

Tackling the global climate crisis and accelerating positive change are central elements of our committment. Our mission to reduce global emissions includes upstream and downstream processes as well as our own production. Green energy is a key pillar of our commitment. Since 2020, we have sourced 100 percent of our purchased electricity from renewable energy sources. In addition to reducing fossil-based energy consumption, increasing energy efficiency also plays an important role. To achieve this goal, we are implementing technologies that are particularly efficient in conserving resources and energy.

Responsible sourcing

We want to ensure that fair working conditions, human rights, and environmental protection are upheld along the supply chain. To this end, we plan to use certifications, get involved in associations, and assess suppliers. In the long term, we aim to achieve 100 percent responsible and sustainable sourcing for all of our raw materials.

Use of recycled and bio-based materials

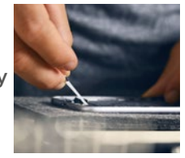
tesa has set itself the goal of significantly increasing product sustainability and is working on this every day. Over the next few years, for example, we will be developing many new products that make a sustainable contribution to our top product ranges in the automotive, electrical, and construction industries, as well as for our consumers in the office and home. In doing so, we are focusing on reducing non-recycled fossil plastics and will increasingly use recycled and bio-based materials.

Circularity and reduction of waste

tesa will contribute to the circular economy and use resources as carefully as possible. First and foremost, this involves avoiding waste. Where that is not possible, we reduce it. Where waste is unavoidable, we seek to reuse or recycle it by various means. By 2025, we want to eliminate all landfill disposal of production-related waste.

tesa will further invest significantly in the further development of solvent-free and energy-efficient production technology and capacity. The facilities on which we currently coat with solvents are to be technically upgraded so that the solvents are fully recovered at the end of the process and thus remain in the cycle.

Enable sustainability at customer



Achieving a higher level of sustainability is an important goal for many of our customers - just as it is for us. We are taking this path together with them and supporting them with innovative adhesive solutions. In addition to our own product sustainability, we are working to ensure that our customers enjoy ecological benefits through the use of our products; for example, tesa® Bond & Detach makes smartphone components recyclable and can be removed easily without leaving any residue. The aim is to make these contributions more visible in the future.

Converting expertise

Product excellence and market intimacy across industries

By partnering with tesa as a Converter Partner, you have decided to join our network of strategic business allies. Your company is recognized as a strong and proficient resource and working together we believe we can mutually grow our businesses.

As a Converter Partner, your company has access to the consistent high quality of the extended tesa assortment as well as to the expertise and support of our sales, supply chain, marketing, customer support, and Customer Solution Center teams.

Customized solutions across industries

Automotive

Appliance

Transportation

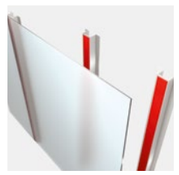
Electronics

Health & medical

Leather & textile

Signage

Furniture



Construction

Doors & windows

Renewable

Retail

Even with the most demanding requirements, we support you in finding the best possible solution. We know converting involves a variety of processes, such as:

- **Die-cutting**
- **Punching**
- **Lasering**
- **Slitting**
- **Rewinding**
- **Laminating**
- **Printing**
- **Spooling**

By combining your converting expertise with our high-quality products and expert adhesive consultancy, you can create customized products for all market needs.

Partners beyond tape

Product excellence
Access to the broadest tesa product portfolio, including a selection of 60+ products handpicked for our Converter Partners, for which we guarantee quick sampling in differ-ent formats (mini-log, A4 sheets) and minimum order quantity of one log roll on most standard orders.

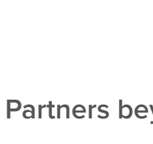
Expert support
Our Sales personnel and Converter Experts are there to assist you with any customer request. Technical experts at tesa Customer Solution Center also offer on-site and remote support and evaluation of your individual application under laboratory conditions.

Testing & benchmarking
Technical consultants will support you on-site and remotely from our labs, resorting to state-of-the-art equipment to perform:

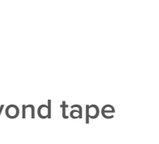
- Comparative tests with competitor products
- Customized tests with customer substrates
- Simulations under a wide range of environmental conditions

Converting processes and part designs

The world of converting is one of endless opportunities, powered by technical expertise as well as the right amount of creativity. These are just some examples of die-cutting designs you can create with our broad tape assortment:



Flatbed die- and kiss cutting



Die-cuts lasered onto rolls or sheets

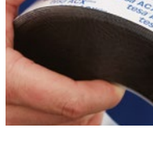
Separable paper layer with possible divisions

Family sheets (different shapes on the same sheet)

Die cuts with print or tape as application aid

Individually designed gaps between die cuts

Temporary fixing aid, which keeps the cut out in place

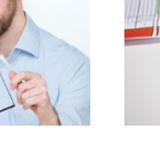


Finger lift with grabbing tab

Butt cutting, with or without space between objects

Rotary die cutting with hole punching

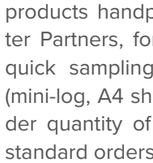
Die cuts and rolls with positioning tabs



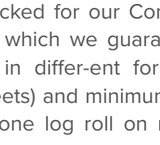
Hole punching with automatic waste removal

Die cut can be easily transferred to another liner

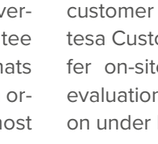
Multi-level rotational cutting



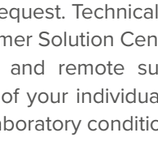
Die cuts placed in multiple rows along the same sheet



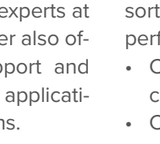
Sections of roll can be perforated for easy separation



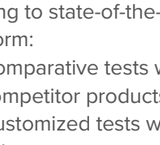
Butt cutting, with or without space between objects



Positioning features to aid marking



Die cuts interlaced to save material



Intermittent adhesive zones can be produced

Core assortment

tesa® adhesive solutions play an indispensable role in many industrial processes. In our core assortment, we bring together products for the most important needs in manufacturing.

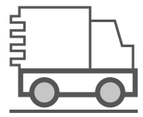
Specialty offer
- Product meeting special technical requirements
- Contains a special feature that sets it apart e.g. electrical or thermal conductivity, flame retardancy, LSE

Performance offer
- Market proven flagship products
- Performance profile covering many applications (Independent Certifications and Indsutry Approvals)
- High variations of log roll sizes, liner versions
- Short lead time, stock items, MOQ1

Commercial offer
- Product for lower technical requirements
- Commercially attractive and high-volume products
- Standardized product offering (few dimensions, certificates, liner variations)

Consistent

Consistent market approach
- Focused and available communication materials for online and offline channels
- Regular and focused promotions
- Easy marketing of core assortment towards end-users
- All core packages available in all countries/languages



Optimized

Optimized availability
- Quick product availability and sampling
- Speedy service availability of technical and commercial support

Refined

Refined product selection
- One assortment covering majority of applications
- Simple to understand
- Easier training and quicker onboarding of new sales from partners
- Fast product selection

Efficiency

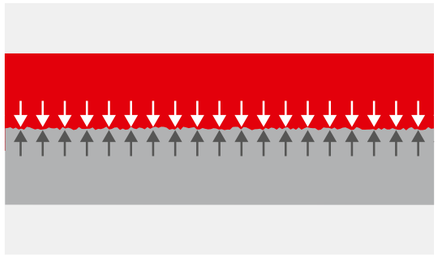
Efficiency gains
- Faster product selection and sampling
- Quicker time to market

Empowering your future with mounting solutions – Technical basics

Mounting tapes

Pressure sensitive adhesive basic

Adhesion



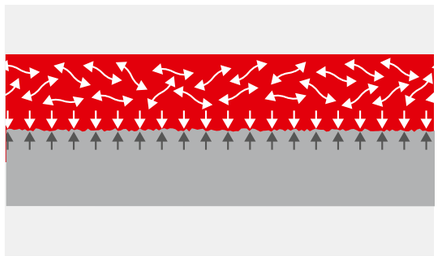
Adhesion is the total force at the interface between substrates, such as a surface and adhesive, resulting from physical interactions and the adhesive's viscoelastic energy dissipation.

Tack refers to an adhesive's ability to wet a surface quickly without pressure, but it doesn't indicate bond strength. Adhesives with low tack can endure high stresses due to strong final adhesion and shear strength.

Cohesion

For the adhesive bond to stay intact, sufficient cohesion (internal strength) of the pressure-sensitive adhesive is required. The **cohesion** of a pressure-sensitive adhesive describes the elastic behavior of the adhesive, which in turn has an impact on the shear strength or restoring forces of a bond.

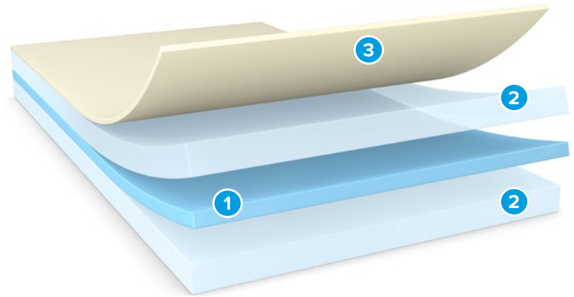
Adhesive strength



Adhesive strengt his described by the interplay of adhesion and cohesion, i.e. only through a certain combination of adhesion and internal strength is an adhesive bond able to withstand the stresses that act on it.

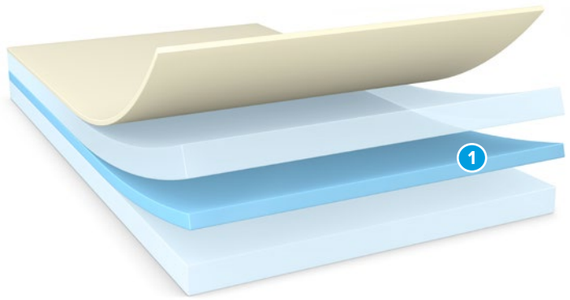
Substrate Pressure-sensitive adhesive

Double-sided tape main components



1 Backing	2 Adhesive	3 Liner
• The backing provides structural support for the adhesive. • Backing properties can vary and have an impact on the tape's strength, durability, flexibility, and ability to fill gaps. • The thickness and strength can vary based on application requirements.	• It allows the bonding of two surfaces together. • The type of surface, tem perature, humidity, and presence of chemicals can have an impact on the type of adhesive. • There are different types of adhesives to suit various applications depending on the surfaces being bonded.	• Protective layer that covers one side of the tape. • It prevents the adhesive from sticking to unwanted surfaces or debris before the tape is applied to the intended surface. • Release liners are easy to remove from the tape.
Types		
• Film (PET, PP, PVC) • Non-woven • Cloth • PE foam • Acrylic core / foam	• Tackified acrylic • Pure acrylic • Natural rubber • Synthetic rubber	• Glassine paper • PE coated paper • PE, PP, PET

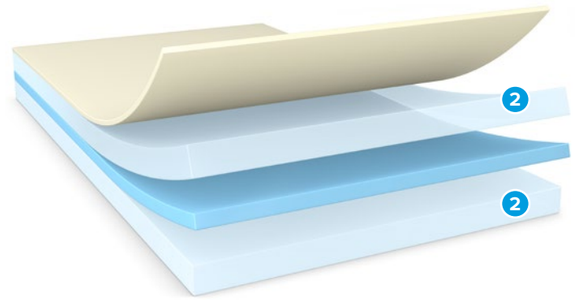
Backing – Choosing the right double-sided tape



1 Backing

Non-woven	• Better processability features than transfer • High flexibility and conformability is needed • Clean and translucent bond is required • Proper for manual processes
Cloth	• High tear resistance and high conformability is required • It can be torn by hand • Higher inner strength compared to transfer and non-woven is needed • Perfect material when clean, residue-free removal is required
Film	• Ideal for applications where a dimensionally stable product is needed • Suitable for converting and automatic • High temperature resistance depending on the type of film • Available either in a transparent or a colored version
PE foam	• Best for bonding of materials with uneven or irregular surfaces • Cushioning and shock absorption is required • Gap, joint, and seams sealing is needed • High elasticity and, consequently, high stress dissipation properties
Acrylic foam	• Better stress dissipation than PE foam due to their viscoelastic adhesive • Can withstand higher loads than PE foam due to their higher density • Weatherproofing and insulation properties are needed • Higher UV / temperature resistance than PE foam is required
Transfer (no backing)	• Ideal for flexible materials such as textiles, fabrics or flexible plastics • High flexibility and conformability is needed • Transparent bonding is required • Optimal solution for automated processes

Adhesive – Choosing the right double-sided tape



2 Adhesive

Acrylic	• Good bonding on valid for pure acrylic, tackified acrylic can also bond to MSE and LSE • High temperature resistance • High aging resistance • High shear resistance (at room and high temperatures) • Limited removability
Natural rubber	• Good bonding on polar substrates • Moderate bonding on non-polar substrates • High shear resistance at room temperature • Ideal solution if removability is required • Limited aging, UV, temperature and chemical resistance
Synthetic rubber	• Good bonding on polar and non-polar substrates • High shear resistance at room temperature • Removability possible • Limited aging, UV and chemical resistance • Very limited temperature resistance (e.g. outdoor applications)

The role of polarity

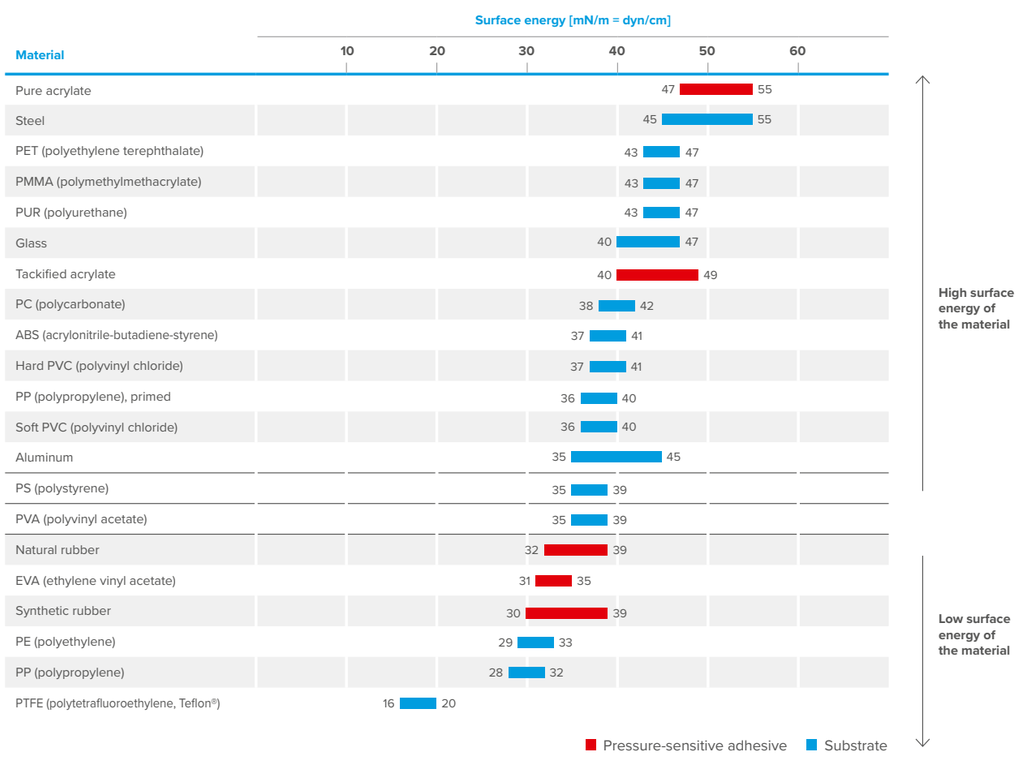
Surface tension

In order to achieve sufficient contact points for the formation of high adhesion forces, the pressure-sensitive adhesive must be able to sufficiently wet the substrate to be bonded. Wetting largely depends on the surface tension or energy of the substrate and the pressure-sensitive adhesive.

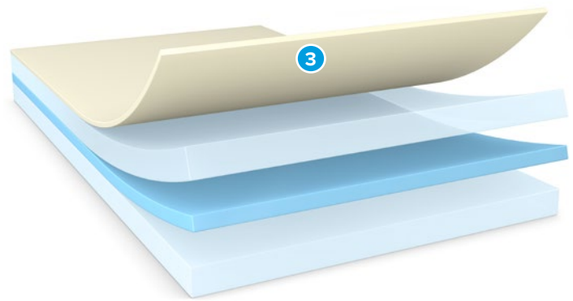
A pressure-sensitive adhesive is generally able to wet-out a substrate if the substrate's surface energy is greater than or equal to that of the adhesive. The higher the wet-out, the more contact points are available to form a bond between two surfaces. As a first indication one can use a water droplet to differentiate between high and low surface energy substrates. If the droplet forms a film, this points to a high surface energy. On the other hand, if it stays a droplet or drips off, it points to a lower surface energy than water. In this case, bonding to the substrate may be difficult. More accurate results are achieved with so-called test inks, which are also available in pen form. The surface energy is given in mN/m, dyn/cm or sometimes also in mJ/m^2, whereby: 1 mN/m = 1 dyn/cm.

The boundary between low-energy and high-energy surfaces is usually drawn in the range of a surface energy of 36 – 38 mN/m. Therefore, the bondability for surface tensions above this range is usually problem-free, whereas at values below this range a pretreatment of the surface to be bonded should be considered.

Wettability	Poor	Good	Very good
Surface energy	Pressure-sensitive adhesive > Substrate	Pressure-sensitive adhesive = Substrate	Pressure-sensitive adhesive < Substrate



Liner – Choosing the right double-sided tape



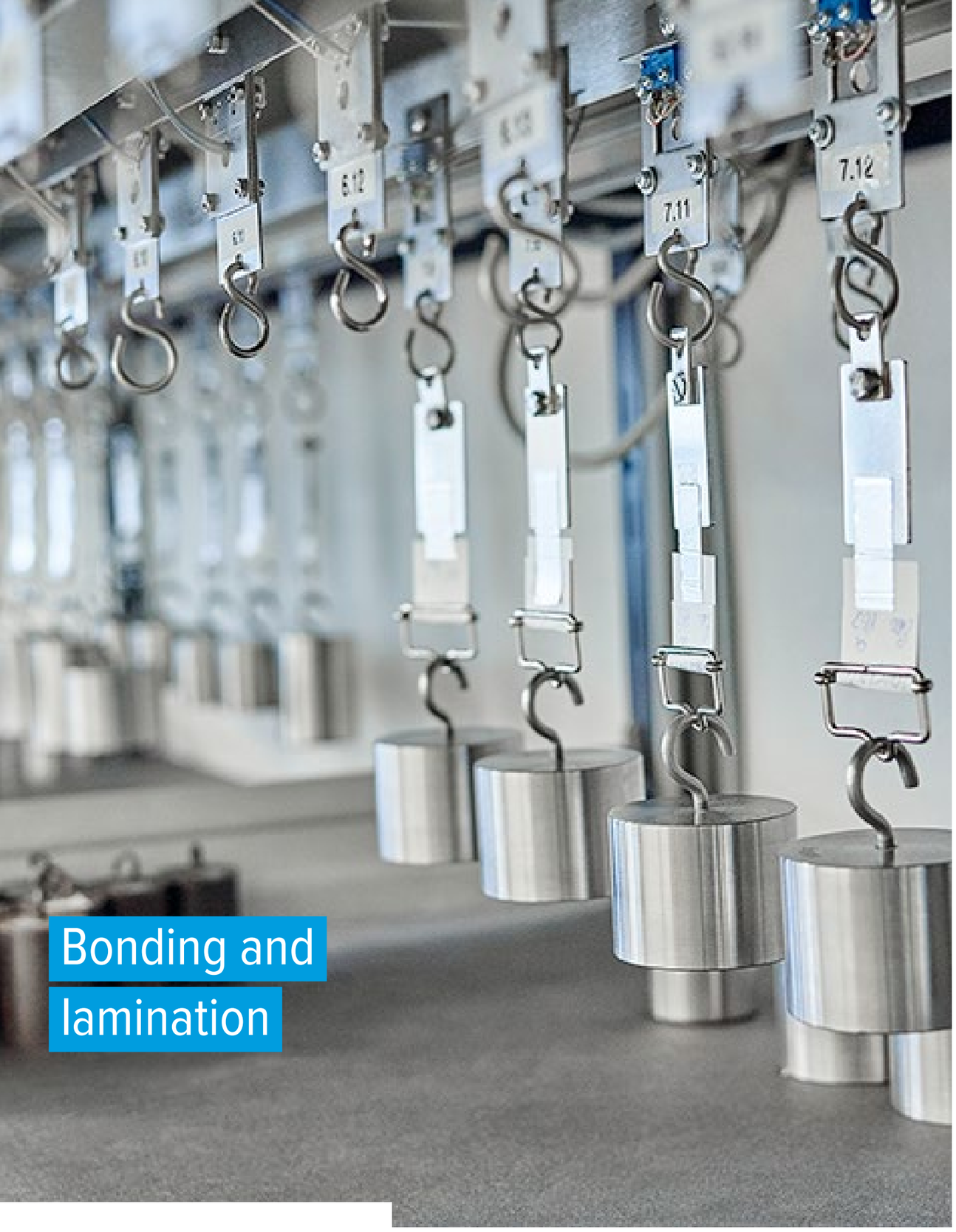
3 Liner

Paper	Glassine	• Easy to handle during application process (e.g. hand-tearable) • Good solution for die-cutting and other converting processes • Cost-effective solution • Branding possible
	PE coated	• Suitable for applications where exposure to humidity is a concern • Good solution for die-cutting and other converting processes • Branding possible
Filmic	PE	• Better tear resistance compared to paper liners • Flexible and soft for an easy application on curved surfaces • Suitable for applications where exposure to humidity is a concern
	MOPP	• Good dimensional stability for handling and automation • High tear resistance in machine direction • Limited cross-direction tear resistance (unsuitable for converters) • Suitable for applications where exposure to humidity is a concern
	PET	• Excellent dimensional stability (low thickness tolerances) • Preferred liner for converting • Ideal for applications where a transparent liner is needed • Suitable for applications where exposure to humidity is a concern

Core assortment for converters

Product overview

Application	Category	Tapes	Page
Bonding and lamination	Double-sided filmic tapes PET	88665, 61528, 61532, 61526, 49652, 5833x, 45051, 5837x, 4965, 59652, 4953, 4945, 51966, 51964, 51962	26
	Double-sided filmic tapes others	4968, 4970, 51970	28
	Double-sided transfer tapes	8401 HAF, 8410 HAF, 6074x series, 6073x series, 5839x series, 5832x series, 755xx series, 52110, 52105	32
	Double sided foam tapes	4952, 6293x series, 6262x series, 45001, 649xx series, 625xx series, 629xx series, 64958, 55576, 62455	36
	Double sided non-woven tapes	4914, 58375, 6037x series, 6025x series, 4962,4959, 58323, 8853, 52215, 52210, 4943	40
	tesa® ACX^{plus} acrylic core tapes	4506x series, 707x series, 921xx series, 6105x series, 704x series, 706x series, 78xx, 778xx series, 776xx series, 790xx series, 725x series, 727x series	44
Specialities double-sided tapes	Flame retardant tapes	flameXtinct 4051, flameXtinct 45063/45065/45020, FR 58375, FR 8372/58373	48
	Thermal management tapes	6073x, 6074x, 5839x, 5832x	52
	Electrically conductive tapes	60371, 60372, 60374, 60252, 60253, 60254, 60255, 60537, 60538, 04386, 60246, 60248, 60217, 60218	56
	High-performance low surface energy adhesive tapes	6022, 4965, 51970, 51570, 755xx, 92105, 92108, 92111, 77805, 77808, 77811, 77815, 64912, 8865	60
Masking and surface protection	Cloth tapes	4541, 4651, 4667, 4660, 4671, 4688, 4615	64
	Aluminum tapes	60632, 60652, 60672, 60677	66
Masking and surface protection	Masking tapes	4319, 4331, 4434, 4174, 4185, 51407, 4316, 4432, 4334, 4341, 4342, 50600, 50620, 50650	70
	Surface protection tapes	5053x series, 7133, 51136, 51134, 51132, 4848, 52995, 52994, 51206,51217,	72
Printing and ancillary	Printing solutions	51904, 64620, 60404, 4122, 4137, Printer's Friend 4863, Printer's Friend 4563, 4174, 51194, 52307, 52064, 52065	76
	Roller wrapping	Printer's Friend 4863, Printer's Friend 4563	77
	Adhesion promoters, removers, and cleaners	60040, 60150, 60151, 60153, 60042	79–81



Bonding and lamination

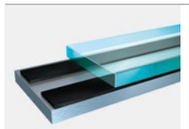
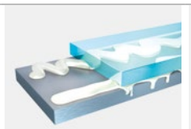
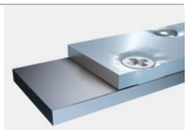
The world of double-sided tapes

In many industries double-sided tapes are an important bonding solution. They are used in cars, electronic devices, household appliances, facade elements, windows and doors, glass partition walls, elevators, furniture, etc.

Depending on the tapes' specific characteristics, they also dissipate stress due to their viscoelastic behavior, prevent oxidation, and are resistant to UV radiation, extreme temperatures, humidity, aging, and chemicals.

Compared to other bonding technologies like welding, screws, nails, and liquid glue, double-sided adhesive tape provides many advantages.

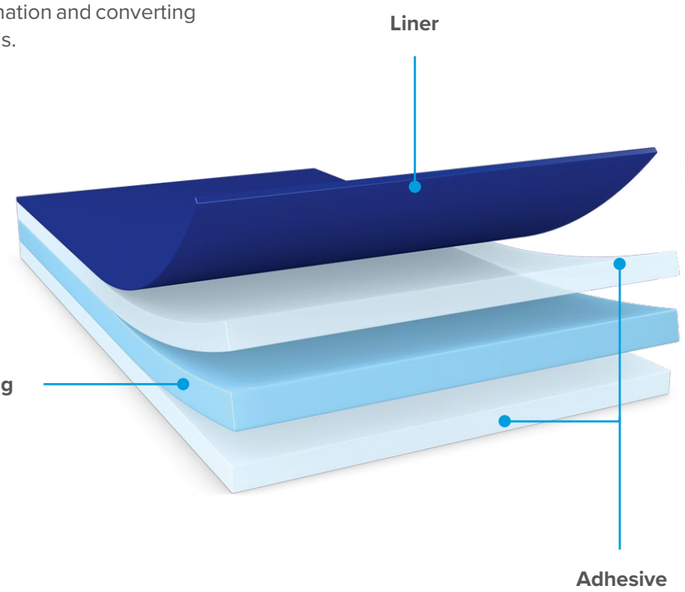
Advantages of double-sided tape vs. liquid glue and mechanical fastening

			Double-sided tape	Liquid glue	Mechanical fastening (e.g. rivets, screws, nails)
					
Design		Improved visual appearance – no damage to the material	••••	•••	•
		Invisible fastening – mounting of transparent materials	••••	•••	•
Assembly		Fast application process – elimination of curing time and reduction of complexity	••••	•	••
		Healthy working environment and clean production sites	••••	••	••
Quality		Compensation of irregular or uneven surfaces – gaps between bonded surfaces are eliminated	•••	••••	•
		Compensation of tension and stress dissipation – single bonding point with mechanical fasteners can lead to material breakage	••••	••	•
		Noise-dampening properties – sounds caused by vibration are eliminated	••••	•••	•
		Shock absorption	••••	••	•
		Sealing function – tape seals and protects against dust and moisture	••••	••••	••
		Reduced risk of corrosion	••••	••••	•

Evaluation across relevant tesa® assortment: •••• very good ••• good •• medium • low

Double-sided filmic tapes

Double-sided filmic tapes are relatively thin, dimensionally stable, and are ideal for bonding to flat, smooth surfaces such as glass, metal, and non-embossed plastics. Nevertheless, thicker tapes also offer good performance on rough, hard to stick surfaces and generally offer a good temperature resistance. The wide range of thicknesses from 50 µm to 300 µm offer multiple performance and design to cost options. Selected tapes for lamination and converting applications also offer very low VOC emissions.



Main features

- High bonding
- Excellent on smooth surfaces
- Quick bonding
- Chemical resistance
- Excellent die-cutting
- Temperature resistannce
- Environ-mental resistance
- LSE
- Low and Ultralow VOC
- Transparent bonding

Double-sided filmic tapes PET

tesa Sustainability Marker Industry

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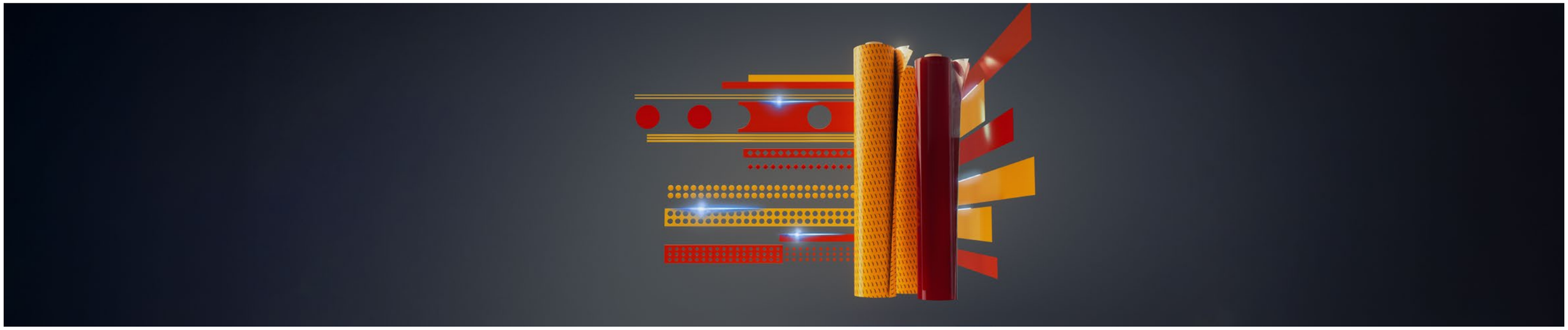
Product	Description	Backing	Adhesive	Thickness [µm]	Color	Liner	Adhesion to steel – Ultimate [N/cm]	Adhesion to PE – Ultimate [N/cm]	Adhesion to PVC – Ultimate [N/cm]	Temperature resistance short / long term [°C]	Features/ applications
tesa® 88665	Double sided differential tape (silicone/acrylic)	PET	Silicone (easy release) tackified acrylic (tight release)	115	⊗	PET / PCK	Silicone 7,6 Acrylic 9,3	Upon request	Upon request	150 / 150	Excellent bonding properties of the silicone adhesive especially to silicone or silicone containing substrates
tesa® 61528	Double sided differential tape (silicone/acrylic)	PET	Silicone (easy release) tackified acrylic (tight release)	100	⊗	PET / PET	Silicone 4,5 Acrylic 9,9"	Upon request	Upon request	Upon request	
tesa® 61532	Double sided differential tape (silicone/acrylic)	PET	Silicone (easy release) tackified acrylic (tight release)	50	⊗	PET / PET	Silicone 7,6 Acrylic 9,3"	Upon request	Upon request	Upon request	
tesa® 61526	Double sided differential tape (silicone/acrylic)	PET	Silicone (easy release) tackified acrylic (tight release)	30	⊗	PET / PET	Silicone 7,6 Acrylic 9,3"	Upon request	Upon request	Upon request	
tesa® 49652	Double sided transparent film tape with double liner	PET	Tackified acrylic	205	⊗	PET / glassine	11,8	6,9	13,0	200 / 100	4965 Original Next Gen with double liner for improved transparency
tesa® 5833x	Differentiated double-sided transparent tape	PET	Tackified acrylic	50 / 100 / 150	⊗	Glassine	>8,0	Upon request	Upon request	– / 150	Very fast wetting performance on rough surface, such as mica plate (> 2N/cm)
tesa® 45051	Double-sided flame retardant tape	PET	FR tackidied acrylic	200	⊗	MOPP	12,0	Upon request	Upon request	UL 94 V-0	Due to its non-flammable property it is particularly designed to meet power battery automobile and bulding requirements, halogene free! Certificate: UL94 VTM-0
tesa® 5837x	Double-sided flame retardant tape	PET	FR tackidied acrylic	50 / 80 / 100	⊗	Glassine	9,5	Upon request	Upon request	200 / 125 UL94 VTM-0	



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Double-sided filmic tapes PET

	Product	Description	Backing	Adhesive	Thickness [µm]	Color	Liner	Adhesion to steel – Ultimate [N/cm]	Adhesion to PE – Ultimate [N/cm]	Adhesion to PVC – Ultimate [N/cm]	Temperature resistance short / long term [°C]	Features / applications	Certificates / test reports / comments
Performance	tesa® 4965	High shear double sided transparent film tape	PET	Tackified acrylic	205	⊗	Glassine PE-Coated Paper	11,8	6,9	13,0	200 / 100	Suitability for critical demands such as heavy stress and high temperatures	- Skin contact certification according to ISO 10993-5 / 10 - In accordance with UL standard 969. UL file: MH 18055 - Tested according to DIN EN 45545-2 fulfilling 2R1+HL3 - Low VOC – measured according to VDA 278 analysis
	tesa® 59652	High shear double sided transparent film tape	PET	Tackified acrylic	205	●	Glassine	14,0	6,6	12,8	200 / 100	Contributes to light management in interior designs	- Skin contact certification according to ISO 10993-5 / 10 - In accordance with UL standard 969. UL file: MH 18055 - Low VOC – measured according to VDA 278 analysis
	tesa® 4953	High shear double sided transparent film tape	PET	Tackified acrylic	100	⊗	Glassine	11,7	5,1	10,0	200 / 100	Bonding components within electronic devices	- Team 4965 adhesive - Skin contact certification according to ISO 10993-5 / 10 - In accordance with UL standard 969. UL file: MH 18055 - Low VOC – measured according to VDA 278 analysis
	tesa® 4945	High shear double sided transparent film tape	PET	Tackified acrylic	50	⊗	Glassine	9,6	3,5	9,4	200 / 100	Bonding of metal or plastic badges and signs or lamination of foams	- Skin contact certification according to ISO 10993-5 /10 - In accordance with UL standard 969. UL file: MH 18055 - Low VOC – measured according to VDA 278 analysis
Commercial	tesa® 51966	High tack double sided transparent film tape	PET	Tackifed acrylic	200	⊗	Glassine	11,0	7,5	13,0	130 / 80	Various industrial long-term mounting applications	- 90% post-consumer recycled (PCR) PET backing
	tesa® 51964	High tack double sided transparent film tape	PET	Tackifed acrylic	125	⊗	Glassine	12,8	5,4	10,1	200 / 80	Various industrial long-term mounting applications	
	tesa® 51962	Double sided transparent film tape	PET	Tackifed acrylic	50	⊗	Glassine	7,2	2,8	7,9	200 / 100	General mounting and laminating applications	

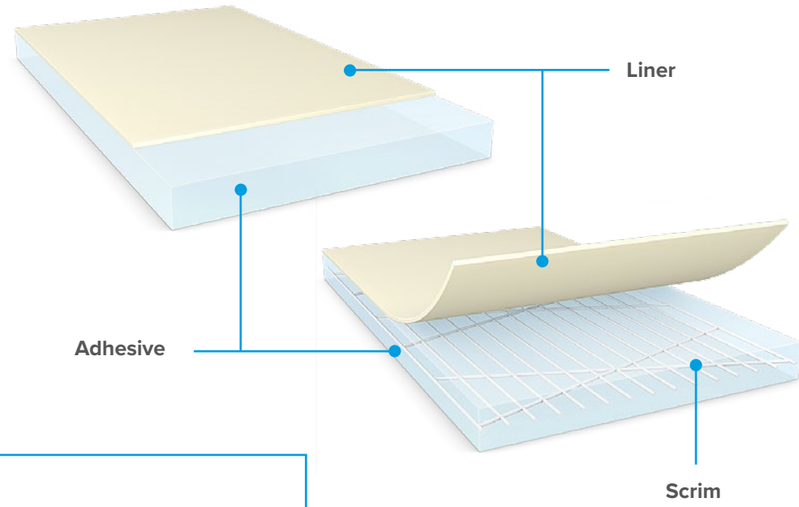
Double-sided filmic tapes others

	Product	Description	Backing	Adhesive	Thickness [µm]	Color	Liner	Adhesion to steel – Ultimate [N/cm]	Adhesion to PE – Ultimate [N/cm]	Adhesion to PVC – Ultimate [N/cm]	Temperature resistance short / long term [°C]	Features/ applications	Certificates / test reports / comments
Specialty	tesa® 4968	Double sided transparent film tape	PVC	Tackifed acrylic	295	○	Glassine	21,2	Upon request	25,3	70 / 60	Fastening heavy signs and point-of-sale displays	
	tesa® 4970	Double sided transparent film tape	PVC	Tackifed acrylic	225	○	Glassine	13,6	9,1	16,6	70 / 60	Fastening heavy signs and point-of-sale displays	
	tesa® 51970	Double sided transparent film tape	PP	Tackifed acrylic	220	⊗	Glassine	13,5	8,0	17,5	130 / 80	Mounting plastic or wooden trims	- Low VOC – measured according to VDA 278 analysis

Double-sided transfer tapes

Double-sided transfer tapes differ from other double-sided tapes in that they have no backing. Scrim tapes are similar in structure with the only difference that the adhesive mass is reinforced by a scrim.

They are transparent and extremely conformable, but do not allow repositioning. Being thin but strong products, they also ensure an efficient converting and laminating process. They can be used in a variety of lamination, splicing, and lightweight mounting applications, especially when extreme thinness and/or adhesion to flexible substrates is requested.



Main features

- High bonding
- Excellent on smooth surfaces
- Quick bonding
- Chemical resistance
- Conformable
- Good for lamination
- Low and Ultralow VOC
- Transparent bonding

Double-sided transfer tapes

	Product	Description	Backing	Adhesive	Thickness [µm]	Color	Liner	Adhesion to steel – Ultimate [N/cm]	Adhesion to PE – Ultimate [N/cm]	Adhesion to PVC – Ultimate [N/cm]	Temperature resistance short / long term [°C]	Features/ applications	Certificates / test reports / comments
Specialty	tesa® 8401 HAF	Heat reactive structural bonding film	None	Nitrile rubber / phenolic resin	200	●	Glassine	12 N/mm²	Upon request	Upon request	Upon request	It is suitable for structural bonding of all thermal resistant materials such as metal, glass, plastic, wood and textiles.	
	tesa® 8410 HAF	Heat reactive structural bonding film	None	Nitrile rubber / phenolic rsin	60	●	Glassine	12 N/mm²	Upon request	Upon request	Upon request		
	tesa® 6074x series	Thermal Management	None	Ceramic filled acrylic	10 - 100	○	PE-coated paper						
	tesa® 6073x series	Thermal Management	None	Ceramic filled acrylic	50 - 100	○	PE-coated paper					Dissipates heat when placed between heat source and heat sink.	
	tesa® 5839x series	Thermal Management	None	Ceramic filled acrylic	125 - 800	○	PE-coated paper						
	tesa® 5832x series	Thermal Management	None	Ceramic filled acrylic	1.200 - 2.000	○	PE-coated paper						
Performance	tesa® 75515	High shear double-si-ded transfer tape	None	Tackified acrylic	125	⊗	Glassine PET PE-Coated Paper*	12,0	6,0	15,0	200 / 100	Very good immediate grab to uneven surfaces and is suitable for a wide range of applications, such as lamination of lightweight, thin materials.	- Team 4965 adhesive - Skin contact certification according to ISO 10993-5 / 10 - In accordance with UL standard 969. UL file: MH 18055 - Low VOC – measured according to VDA 278 analysis
	tesa® 75507	High shear double-si-ded transfer tape	None	Tackified acrylic	75	⊗	Glassine PET PE-Coated Paper*	11,0	4,5	13,0	200 / 100		
	tesa® 75505	High shear double-si-ded transfer tape	None	Tackified acrylic	50	⊗	Glassine PET PE-Coated Paper*	8,5	3,5	11,0	200 / 100		
Commercial	tesa® 52110	Double sided transfer tape	None	Water based acrylic	100	⊗	Glassine	11,6	Upon request	Upon request	180 / 100	Suitable for lightweight mounting and lamiantions	According to VDA278 analysis tesa® 521xx does not contain any single substances restricted by the drafted GB regulations (China) as well as the indoor concentration guideline by Health, Labour and Welfare Ministry (Japan).
	tesa® 52105	Double sided transfer tape	None	Water based acrylic	50	⊗	Glassine	9,2	Upon request	Upon request	181 / 100		

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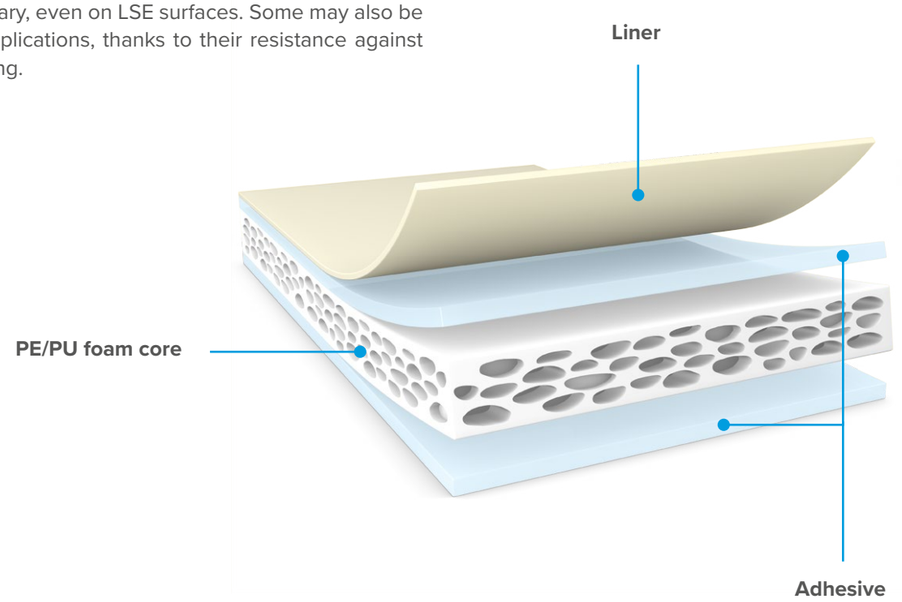
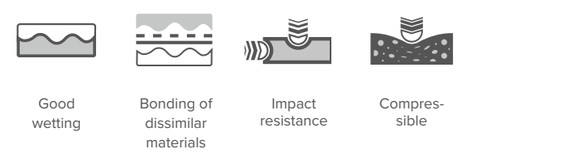
Double-sided foam tapes

Double-sided foam tapes are a broad category which includes products that, thanks to the characteristics of their backing, can be used to compensate for gaps, bond different substrates, and dampen unwanted noises or vibrations.

Depending on the foam and adhesive composition, they can be suitable for lightweight or more demanding mounting applications, permanent or temporary, even on LSE surfaces. Some may also be used for outdoors applications, thanks to their resistance against UV, humidity, and aging.

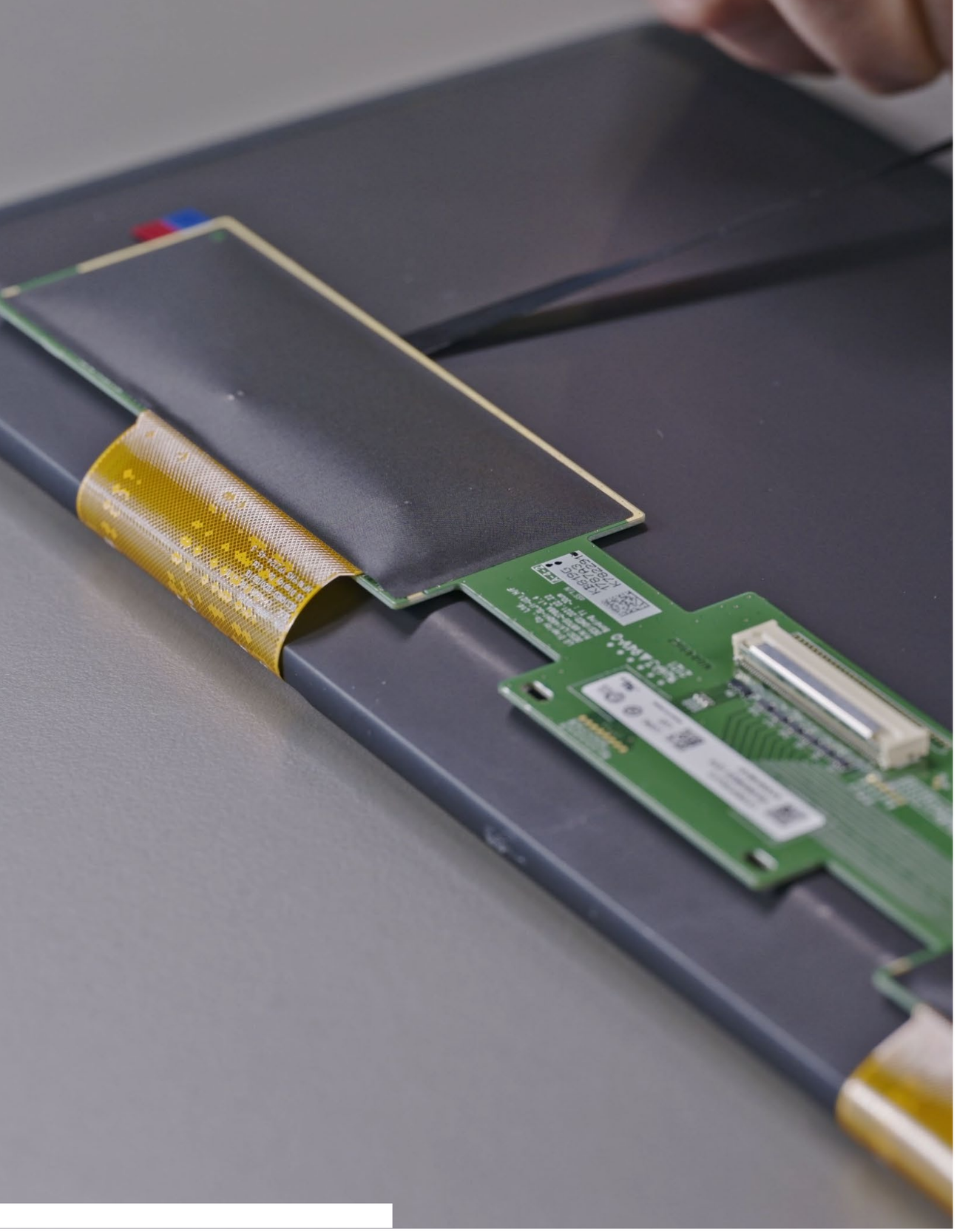


Main features



Double-sided foam tapes

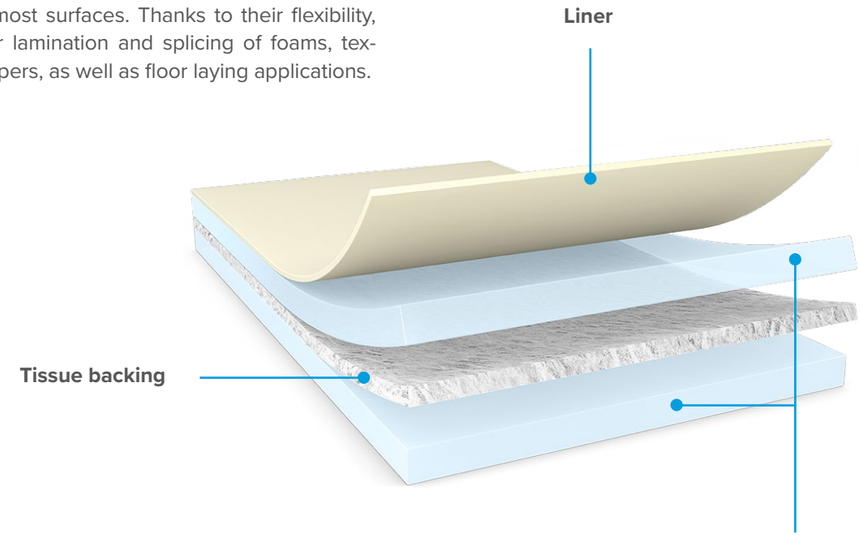
	Product	Description	Backing	Adhesive	Thickness [µm]	Color	Liner	Adhesion to steel – Ultimate [N/cm]	Adhesion to PE – Ultimate [N/cm]	Adhesion to PVC – Ultimate [N/cm]	Temperature resistance short / long term [°C]	Features/ applications	Certificates / test reports / comments
Specialty	tesa® 4952	Double sided Foam tape	PE	Tackified acrylic	1150	○	Glassine	8,0	2,8	8,0	80 / 80	PE foam tape for constructive mounting applications.	Approved by LGA institute for mirror mounting. Report number IWQ FSG 329 1189
	tesa® 6293x series	Double sided Foam tape	PE	Tackified acrylic	500 - 1600	●○	Glassine PP PE-coated paper PE"	17,0	3,0	17,0	80 / 80	PE foam tape for constructive mounting applications (indoor and exterior)	
	tesa® 6262x series	Double sided Foam tape	PE	Tackified acrylic	200 - 300	●○	PET	13,0	Upon request	Upon request	90 / 80	Highly conformable foam backing provides excellent shock resistance	
	tesa® 45001	double-sided flame retardant foam tape	PE	Tackified acrylic	1000	○	MOPP	22,0	Upon request	Upon request	80 / 80	Tape comprises of a flame retardant acrylic adhesive and flame retardant PE-foam with excellent bonding strength.	Proven flame retardant characteristics according to FAR 25.853(a) app. F part1 and UL 94 HBF - HF1
Performance	tesa® 649xx series	Double sided Foam tape	PE	Tackified acrylic	500 - 1200	●	Glassine	22,0	Upon request	Upon request	80 / 80	Mounting a wide range of automotive and applaince trims and parts (indoor and exterior)	
	tesa® 625xx series	Double sided Foam tape	PE	Tackified acrylic	500 - 3000	●	Glassine	9,5	1,2	9,5	80 / 80	Soft PE foam tape for lightweight mounting applications. It consists of a highly conformable PE foam backing (indoor and exterior)	
	tesa® 629xx series	Double sided Foam tape	PE	Tackified acrylic	400 - 600	●	Glassine	21,0	Upon request	Upon request	100 / 90	Mounting a wide range of small exterior trims and parts. (indoor and exterior)	
Commercial	tesa® 64958	Indoor double sided foam tape	PE	Synthetic rubber	1050	○	Glassine	4,0	4,0	4,0	60 / 40	General mounting	
	tesa® 55576	Indoor double sided foam tape	PE	Tackified acrylic	1200	○	PE-coated paper	Upon request	Upon request	Upon request	80 / 60	Lightweight PE-Foam core	
	tesa® 62455	Indoor double sided foam tape	PE	Water based acrylic	1000	○	Glassine	Upon request	Upon request	6,0	80 / 80	Medium-density, conformable PE foam and is equipped with an acrylic adhesive.	



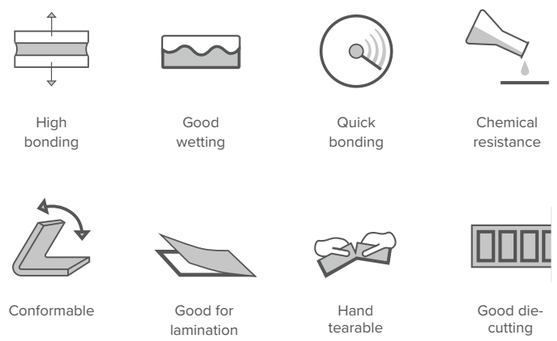
Double-sided non-woven tapes

Double-sided tissue tapes, thanks to their non-woven or cloth backings, are conformable and flexible, allowing them to stick to irregular surfaces as needed. They are made to be easily die-cut and to be tearable by hand while being tear resistant.

They are in many cases suitable to quite demanding and permanent mounting applications in a variety of industries and offer a very good initial tack on most surfaces. Thanks to their flexibility, they can also be used for lamination and splicing of foams, textiles, leather, and heavy papers, as well as floor laying applications.



Main features



Double-sided non-woven tapes

	Product	Description	Backing	Adhesive	Thickness [µm]	Color	Liner	Adhesion to steel – Ultimate [N/cm]	Adhesion to PE – Ultimate [N/cm]	Adhesion to PVC – Ultimate [N/cm]	Temperature resistance short / long term [°C]	Features/ applications	Certificates / test reports / comments
Specialty	tesa® 4914	Double sided asymmetrical tape	Non-woven	Tackified acrylic	250	red	PE	9,3 covered side	5,3 covered side	7,8 covered side	140 / 80	Excellent performance on rough surfaces like leather and textiles	- Low VOC according to VDA278 analysis - Flame retardant according to FAR/JAR/CS 25.853(a) Appendix F part I (a)(1)(ii)
	tesa® 58375	Double sided flame tape retardant	Non-woven	FR tackidied acrylic	130	⊗	Glassine	Upon request	Upon request	Upon request	UL 94 VTM-0	Halogene-fee mounting or lamination-requiring additional flame retardant property.	Flame retardant per UL 94 VTM-0 level
	tesa® 6037x series	Double sided Electrically conductive tape	Non-woven	Conductive acrylic	30 - 100	black	PET	5,6	Technical data and features in chapter XX			Electrical conductivity in XYZ-direction	
	tesa® 6025x sereis	Double sided Electrically conductive tape	Non-woven	Conductive acrylic	55 - 250	grey	PET	8,5				Excellent electrical conductivity in XYZ-direction even at high temperatures and humidity.	
Performance	tesa® 4962	Double sided	Non-woven	Tackified acrylic	160	⊗	Glassine	12,0	7,0	15,0	200 / 80	Industrial mounting, high-performance lamination, and splicing applications	Skin contact certification according to ISO 10993-5 / 10 According to VDA278 analysis, tesa® 4962 does not contain any single substances restricted by the drafted GB regulations (China) as well as the indoor concentration guideline by Health, Labour and Welfare Ministry (Japan)."
	tesa® 4959	Double sided	Non-woven	Tackified acrylic	100	⊗	Glassine	8,5	4,5	14,0	200 / 80	Industrial mounting, high-performance lamination, and splicing applications	Skin contact certification according to ISO 10993-5 / 10 According to VDA278 analysis, tesa® 4962 does not contain any single substances restricted by the drafted GB regulations (China) as well as the indoor concentration guideline by Health, Labour and Welfare Ministry (Japan).
	tesa® 58323	Double sided	Non-woven	Tackified acrylic	75	⊗	Glassine	7,7	Upon request	Upon request	/ 125	Ideal for FPC mounting applications. The acrylic adhesive gives this product a high bonding power and peel strength.	
Commercial	tesa® 8853	Double sided	Non-woven	Tackified acrylic	50	⊗	Glassine	6,5	Upon request	Upon request	260 /	FPC mounting application of electronic components, subjected to high temperature processing and operating environments	
	tesa® 52215	Double sided	Non-woven	Water based acyrlic	150	⊗	Glassine	12,0	5,0	8,6	190 / 80	The conformable non-woven tape is especially designed for general purpose lamination applications.	Ultra low total VOC concentration according to VDA 278 analysis
	tesa® 52210	Double sided	Non-woven	Water based acyrlic	100	⊗	Glassine	11,2	3,0	8,5	200 / 80	The conformable non-woven tape is especially designed for general purpose lamination applications.	Ultra low total VOC concentration according to VDA 278 analysis
	tesa® 4943	Double sided	Non-woven	Tackified acrylic	100	⊗	PE-coated paper	8,1	Upon request	10,8	100 / 70	General purpose, provides a high initial tack and a good shear resistance.	

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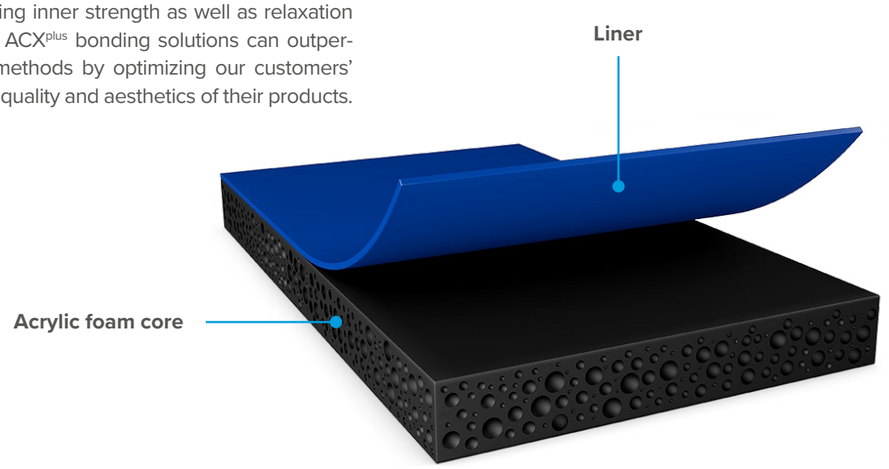
ACX acrylic core tapes

Constructive bonding is a key element in every industry and can be very challenging. Traditional mechanical fasteners like rivets, welds, screws, or liquid glue may not be suitable or can even damage the substrates. That is where our high-performance bonding tapes come into play. tesa® ACX^{plus} is an acrylic foam tape with very special bonding capabilities based on its viscoelasticity: this leads to elastic and viscous characteristics, providing inner strength as well as relaxation of mechanical stresses. tesa® ACX^{plus} bonding solutions can outperform conventional fastening methods by optimizing our customers' production processes and the quality and aesthetics of their products.



Main features


Good bonding


Good wetting


Quick bonding


Chemical resistance


Conformable


Environ-mental resistance


Cold shock resistance


Compres-sible


Impact resistance


UV resistance


Bonding of dissimilar materials


Temperature resistance

Acrylic core tapes ACX^{plus}

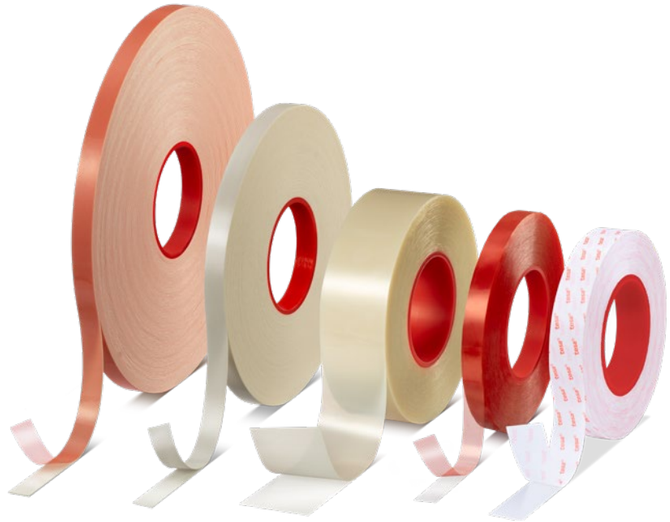
	Product	Description	Backing	Adhesive	Thickness [µm]	Color	Liner	Adhesion to steel – Ultimate [N/cm]	Adhesion to PE – Ultimate [N/cm]	Adhesion to PVC – Ultimate [N/cm]	Temperature resistance short / long term [°C]	Features/ applications	Certificates / test reports / comments
Specialty	**tesa® 4506x series**	Acrylic Foam flame retardant	Acrylic Core	pure acrylic	800 / 1200	○	PE-coated paper	32,0	Upon request	Upon request	200 / 100	Designed for applications where a flame retardant requirement of the tape or the building component is required	flame retardant according to FAR 25.853(a) app. F part 1 and UL 94 V-2
	tesa® 707x series	Acrylic Foam	Acrylic Core	pure acrylic	500 - 4000	●	Glassine PE-blue	32,0	Upon request	Upon request	Upon request	For powerful long-lasting bonds, even on material with different surface characteristics. The viscoelastic core compensates thermal elongations of bonded components	recognized according to UL Standard 746C. UL File QOQW2.E309290
	tesa® 921xx series	Double-sided foamed tape	none	polymer foam	500 - 1100	●	Glassine	29,0	30 (PP)	Upon request	100 / 80	for LSE surfaces: plastic to plastic application, not only in automotive interior	Low VOC (acc. GB 27630) – no critical substances detectable
	tesa® 6105x series	Acrylic Foam	Acrylic Core	modified acrylic	200 - 500	●	PET	19,0	Upon request	Upon request	180 / 90	Display or touch panel mounting for electronic devices and infotainment systems	
	tesa® 704x series	Acrylic Foam	Acrylic Core	pure acrylic	500 -2000	◐ ○	Glassine Filmic-blue Filmic-white	36,0	Upon request	Upon request	Upon request	Mounting applications in different industries (e.g. extruder, appliances, interior fit-out, signage	
	tesa® 706x series	Acrylic Foam	Acrylic Core	tackified acrylic	500 - 1500	●	Glassine Filmic-blue	48,0	Upon request	Upon request	Upon request	Designed for indoor bonding of “hard-to-bond-materials” such as powder coatings or plastic material	Recognized according to UL Standard 746C. UL File QOQW2.E309290 Recognized according to UL Standard 879. UL File UYMR2.E479260
Performance	**tesa® 78xx series**	Acrylic Foam	Acrylic Core	modified acrylic	500 - 2000	●	PE-coated paper Filmic-blue	21,0	Upon request	Upon request	Upon request	Exterior attachment part as well as interior display mounting applications automotive	Automotive OEM approval overview upon request
	tesa® 778xx series	Acrylic Foam	Acrylic Core	LSE	500 - 1500	◐	HDPE filmic	31,0	30 (PP)	Upon request	-40 to 80	Triple-layer symmetrically designed product, coated on both sides with LSE adhesive	Automotive OEM approval overview upon request
	tesa® 776xx series	primerless	Acrylic Core	LSE	1100 - 1500	◐	HDPE filmic	25,0	Upon request	Upon request	-40 to 80	Like tesa 778xx series but coated with low surface energy (LSE) adhesive on the covered side only	Automotive OEM approval overview upon request
	tesa® 790xx series	Acrylic Foam	Acrylic Core	LSE	800 - 1500	◐	Filmic-blue	40,0	40 (PP)	Upon request	120 / 95	New Primerless Line is suitable for a wide range of permanent exterior mounting applications	Automotive OEM approval overview upon request
	tesa® 725x series	Acrylic Foam	Acrylic Core	pure acrylic	500 - 1000	⊗	Glassine	19,0	Upon request	Upon request	200 / 100	Multi purpose transparent double-sided acrylic core tape	
Commercial	**tesa® 727x series**	Acrylic Foam	Acrylic Core	pure acrylic	640 - 1100	◐	Filmic-white	32,0	Upon request	Upon request	200 / 100	Multi-purpose bonding applications.	

Specialities double-sided tapes

Flame retardant tapes

Our flame retardant and halogen-free tape solutions
To ensure health and asset protection, fire safety regulations are of special importance in a variety of industries, such as aviation, trains, marine, building and construction, elevators, automotive and e-mobility.Our tesa® flame retardant assortment complies with fire regulation standards and all tapes are halogen-free, which supports smoke reduction and less gas toxicity. The wide variety of the assortment extends from thin double-sided tapes for lamination demands to the PE- and acrylic foam products for the constructive solutions.

Advantages of our flame retardant tapes:
- Compliance and fulfillment acc. to industry standards UL94 and FMVSS 302- All products are halogen-free- High performance on a variety of surfaces- Reliable long-term bonding- Large assortment for a wide range of applications.



tesa® flameXtinct tapes

Main features

Flame retardant

Halogen-free

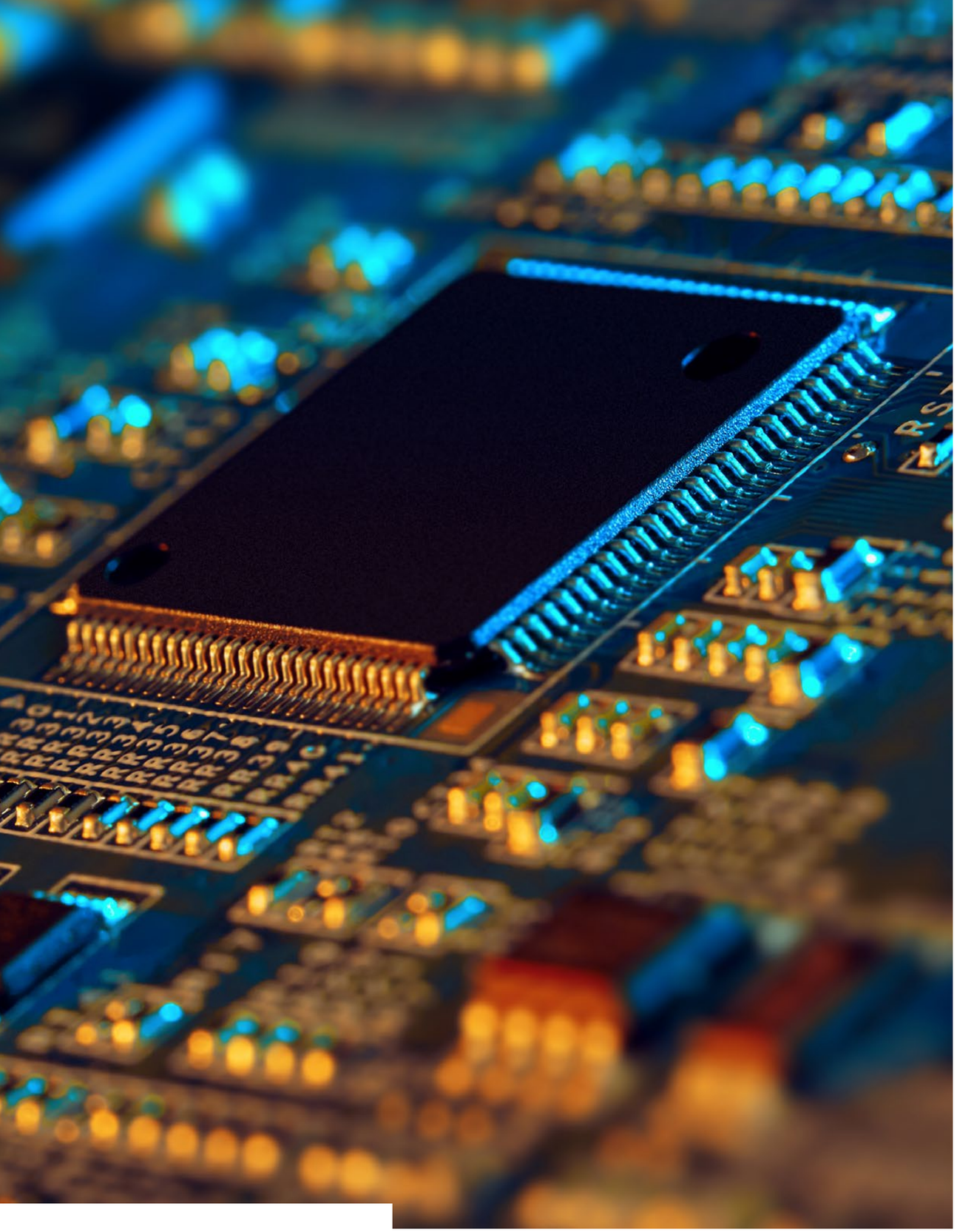
High performance adhesive

Wide product portfolio

Flame retardant tapes

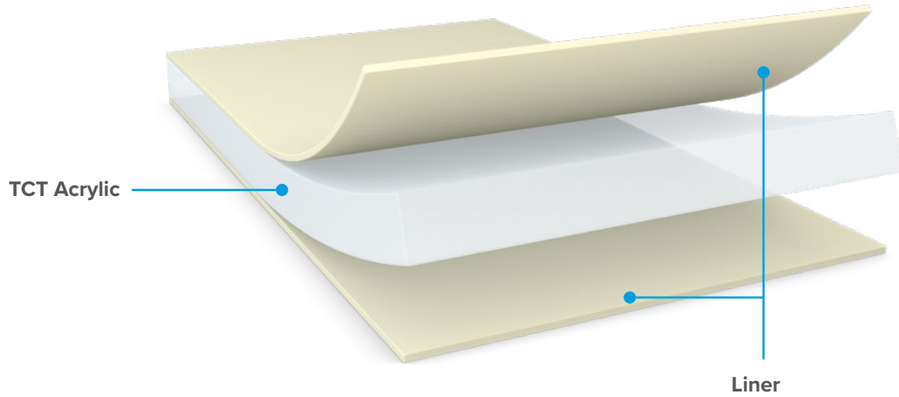
Product	Thickness [µm]	Product design	Color	UL 94	FAR 25.853	Gap filling	Shock absorbation	Light-weight	Viscoelasticity	Conformability	Standard bonding	Demanding bonding	Temperature resistance
tesa® flameXtinct 45051	200	Acrylic adhesive PET backing	Transparent tape Red liner	VTM-0	Yes	No	No	Yes	No	•	•••	•	•••
tesa® flameXtinct 45001	1000	Acrylic adhesive PE-foam backing	White tape Red liner	HBF HF-1	Yes	Yes	Yes	Yes	No	•••	•••	••	••
tesa® flameXtinct 45063/45065/ 45020	800/1200	Acrylic adhesive Acrylic core	White tape White liner	V-2	Yes	Yes	Yes	No	Yes	••	•••	•••	•••
tesa® FR 58375	130	Acrylic adhesive Non-woven	White tape White liner	VTM-0	Not tested	No	No	Yes	No	••	•••	•	•••
tesa® FR 8372/58373	50/80	Acrylic adhesive PET backing	Transparent tape White liner	VTM-0	Not tested	No	No	Yes	No	•	•••	•	•••

Evaluation across relevant tesa® assortment: •••• very good ••• good •• medium • low



Thermal management tapes

tesa® Thermal Management Tapes provides superior thermal transfer performance with excellent bonding properties. It delivers very good surface wet-out on substrates due to the transfer tape design which helps to maximize the thermal transfer efficiency in automotive and electronic devices. The available thickness range, which starts from ultrathin 10 µm and ends at 2000 µm, offers more flexibility in the device design.No oozing due to silicone-free technology. Tacky for reliable & automated processing. Excellent dielectric breakdown resistance. Flame retardant acc. to UL 94 VTM-0, Clean of fibers acc. to VDA19.



Main features

Excellent thermal conductivity

Strong bonding strength

Excellent surface wet-out

High breakdown voltage

Ultrathin design

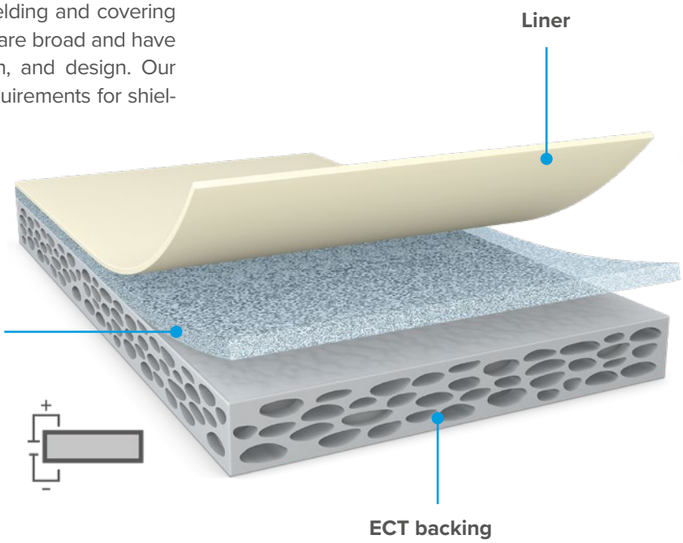
Thermal management tapes

	Product	Thickness [µm]	Thermal conductivity [Kcm²/W]	Thermal impedance [Kcm²/W]	Peel adhesion	Wetting	Breakdown voltage	Flame retardancy	Compression	Comment
Speciality	tesa® 6073x	50–100	0.7	1.6–1.8	+++	+++	++	+	+	Lamination/ mounting, great bonding/ wetting, good conductivity
	tesa® 6074x	10–100	1.0	0.6–1.1	++	++	++	+	+	Lamination/ mounting, good bonding/ wetting, great conductivity
	tesa® 5839x	125–800	0.8	2.4–11.7	+++	+++	+++	++	++	Mounting, great el. insulation, good conductivity
	tesa® 5832x	1,200–2,000	> 2.0	5.6–9.6	+	+++	+++	+++	+	Gap filling, great el. insulation, great conductivity

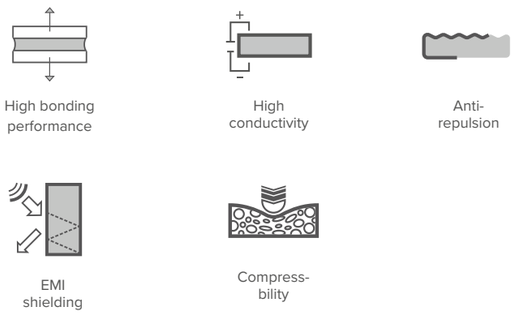
Electrically conductive tapes

With tesa® Electrically Conductive Double-sided and single sieded electrically conductive tapes we offer a broad assortment of filled acrylic adhesive systems, with a balance between electrical conductivity and adhesive properties. Simply decide what is the most important for your application: bonding performance, conductivity, or a balance of both. Our double-sided tapes are available with two different backings. The woven backing offers a higher tear resistance, very good dimensional stability, and better reworkability, while the nonwoven backing provides faster wetting, excellent conformability, and very good die cuttability.

Single-sided electrically conductive tapes for shielding and covering applications. Covering and shielding applications are broad and have different requirements for conductivity, adhesion, and design. Our single-sided ECT assortment meets the latest requirements for shielding and appearance.



Main features



Electrically conductive double-sided and single-sided electrically conductive tapes

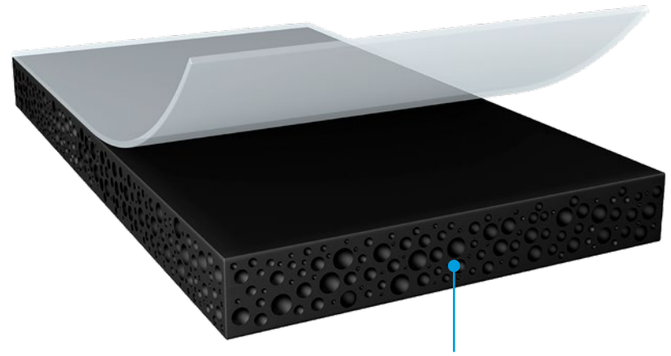
	Product	Backing	Type of adhesive	Thickness [µm]	Color	Liner & thickness [µm]	Log [m/mm]	Stock item MOQ1	Peel adhesion to SUS (ultimate) [N/cm]	Contact resistance [Ω]	Surface resistance [Ω/sq]	Shielding effectiveness [dB]	Features/ applications
Double-sided													
	tesa® 60371	Non-woven	Conductive acrylic	30	●	PET 50	100 x 1.040	1	5.1	0.01	0.1	>60	Best conductivity
	tesa® 60372	Non-woven	Conductive acrylic	50	●	PET 50	100 x 1.040	1	5.6	0.01	0.1	>60	Best conductivity
	tesa® 60374	Woven	Conductive acrylic	100	●	PET 50	50 x 1.040	1	8.5	0.01	0.1	>60	Best conductivity
Specialty	**tesa® 60252**	Woven	Conductive acrylic	55	●	PE paper 120	50 x 1.040	1	8.5	0.05	0.2	>50	Balanced conductivity and bonding
	tesa® 60253	Woven	Conductive acrylic	70	●	PCK 120	50 x 1.040	1	9.7	0.05	0.2	>50	Balanced conductivity and bonding
	tesa® 60254	Woven	Conductive acrylic	100	●	PCK 120	50 x 1.040	1	10.4	0.05	0.2	>50	Balanced conductivity and bonding
	tesa® 60255	Woven	Conductive acrylic	150	●	PCK 120	50 x 1.040	1	10.5	0.05	0.2	>50	Balanced conductivity and bonding
Single-sided													
Specialty	**tesa® 60537**	Copper	Conductive acrylic	30	●	PET 50	50 x 1.020	1	7.5	0.05	0.2	>70	Excellent bonding
	tesa® 60538	Copper	Conductive acrylic	50	●	PET 50	50 x 1.020	1	7.7	0.05	0.2	>70	Excellent bonding
	tesa® 04386	Aluminum	Conductive acrylic	85	◑	Paper 65	50 x 1.020	4	3.0		0.2		
Single-sided foam													
Specialty	**tesa® 60246**	Foam-gasket	Conductive acrylic	300	●	PCK 120	40 x 1.030	1	6.3	0.03	0.2	>70	Compression rate at 50%: <55 N/cm Recovery rate after 24h: 96%
	tesa® 60248	Foam-gasket	Conductive acrylic	500	●	PCK 120	30 x 1.030	1	6.3	0.03	0.2	>70	
	tesa® 60217	Foam-soft	Conductive acrylic	1.500	●	PCK 120	30 x 1.000	1	8.5	0.03	0.2	>70	Highly compressible and high adhesion levels
	tesa® 60218	Foam-soft	Conductive acrylic	2.000	●	PCK 120	20 x 1.000	1	8.5	0.03	0.2	>70	

Double-sided LSE tape solutions

tesa High-performance low surface energy (LSE) adhesive tapes create an outstanding and secure bond to typical LSE substrates in many industries including Automotive, Electronics Railways, Appliances, Aerospace - without pre-treatment processes!.

In the past, LSE plastics like Silicone, Thermoplastic Polyolefin (TPO), Polypropylene (PP), and certain types of Polyethylene (e.g., HDPE) posed challenges for adhesive bonding.

Recent Innovations: In the past decade, new adhesives and bonding tapes have been formulated to allow robust bonding of LSE plastics. These innovations enable manufacturers to benefit from adhesive bonding.



Main features


Anti-repulsion

Differential designs

LSE performance


LSE performance


Environ-mental resistance


Impact resistance

High-performance low surface energy adhesive tapes

Product	Backing	Adhesive	Thickness µm]	Color	Liner	Standard log roll width [mm]	Peel adhesion to PP [N/cm] (initial/3 days)	Temperature resistance [°C]	Features/ applications
tesa® 66022	None	Acrylic	220	⊗	Brown/ blue logo	1.150	14.0/16.0	200/-	Low VOC and high conformable to follow 3D shapes.
tesa® 4965	PET	Acrylic	205	⊗	Multiple	1,372	6.8/7.9 (14 days)	200/100	Immediate usability right after assembly, suitable for critical demands such as heavy stress and temperatures.
tesa® 51970	PP	Acrylic	220	⊗	Brown	1,372	6.8/8.8 (14 days)	130/80	Good static shear resistance at 23°C and 40°C.
tesa® 51570	Non-woven	Rubber	110	⊗	Brown	1,400	7.0/12.0 (14 days)	40/80	Good shear resistance at 23°C, low permanent temperature requirements.
tesa® 755xx	None	Acrylic	50, 70, 125	⊗	Brown	1,372	11.0 (initial on steel)	100/200	Excellent static shear resistance at 70°C
tesa® 92105	None	Performance polymeer foam	500	●	Transparent	610	25/30	-30 to 100	Low VOC, excellent static shear resistance, focusing plastic to plastic applications.
tesa® 92108	None	Performance polymeer foam	800	●	Transparent	610	28/36	-30 to 100	Low VOC, excellent static shear resistance, focusing plastic to plastic applications.
tesa® 92111	None	Performance polymeer foam	1100	●	Transparent	610	29/40	-30 to 100	Low VOC, excellent static shear resistance, focusing plastic to plastic applications.
tesa® 77805	Acrylic foam	Acrylic foam	500	●	Royal blue	900	26/28	-40 to +80	High initial adhesion to LSE and MSE surfaces without primer.
tesa® 77808	Acrylic foam	Acrylic foam	800	●	Royal blue	900	28/31	-40 to +80	High initial adhesion to LSE and MSE surfaces without primer. Auto attachment part mounting.
tesa® 77811	Acrylic foam	Acrylic foam	1100	●	Royal blue	900	33/38	-40 to +80	High initial adhesion to LSE and MSE surfaces without primer. Auto attachment part mounting.
tesa® 77815	Acrylic foam	Acrylic foam	1500	●	Royal blue	900	34/44	-40 to +80	High initial adhesion to LSE and MSE surfaces without primer. Auto attachment part mounting.
tesa® 64912	PE foam	Rubber	1200	●	Brown	1,240	20/20 (14 days)	-40 to reliable performance to higher temperatures	High initial adhesion to LSE and MSE surfaces without primer. Auto attachment part mounting.
tesa® 88665	PET	Acrylic/ silicone	115	⊗	Filmic-white	980	6.3/9.5 (silicone [N/cm])	150	Excellent bonding properties of the silicone adhesive especially to silicone or silicone containing substrates.

Single-sided tapes

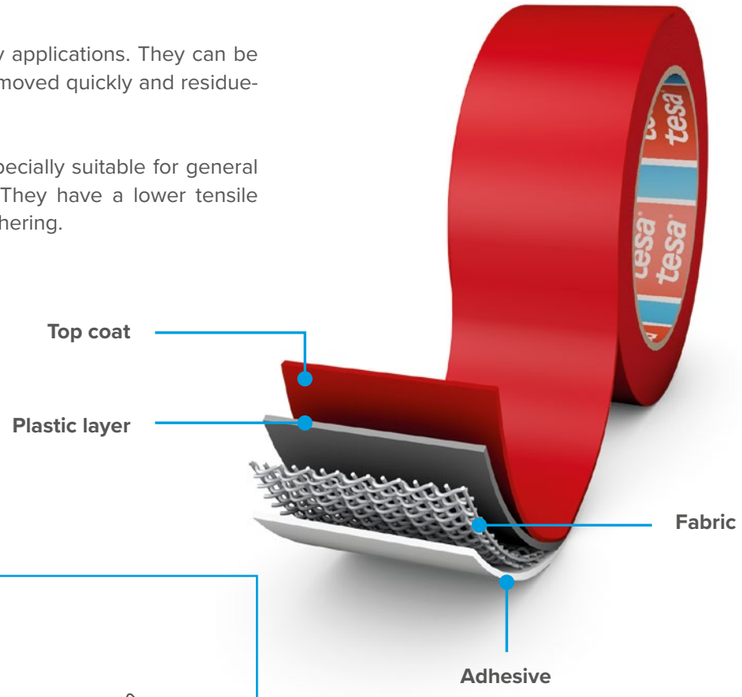
Cloth tapes

Our cloth tapes are ideal products for the daily demands encountered in industry and by craftsmen – the applications are endless, including usage in extreme temperature and climatic conditions.

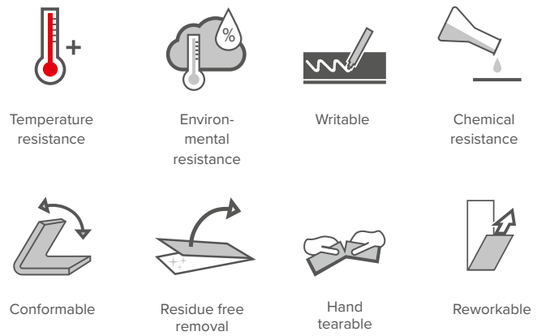
Specialties and Premium tapes: For sophisticated applications with a high level of properties: highly temperature- resistant, excellent abrasion resistance, and straight longitudinal and horizontal tear edges.

Gaffer tapes: Ideal tapes for temporary applications. They can be used on rough surfaces and can be removed quickly and residue-free after usage.

Duct tapes: The universal helper – especially suitable for general purpose and temporary applications. They have a lower tensile strength and limited resistance to weathering.



Main features



Cloth tapes

	Product	Description	Backing type	Adhesive	Thickness [µm]	Color	Mesh [#/inch²]	Liner available	Temperature resistance [°C]	Clean removable	Abrasion resistance	For rough surface	Sustainable product aspect
Specialty	tesa® 4541	Uncoated cloth	Uncoated cloth	Natural rubber	270	●○	145	No	130	Yes	●●●	●●●●	• 86% bio-based carbon content, tested acc. to DIN EN 16640
	tesa® 4651	Alrounder	Acrylic coated cloth	Natural rubber	310	●○●●●●●●	145	Glassine 76µm	130	Yes	●●●●	●●●●	• 72% bio-based carbon content, tested acc. to DIN EN 16640
	tesa® 4657	High temperature	Acrylic coated cloth	Natural rubber	290	●●	145	Glassine 76µm	180	Yes	●●●●	●●●●	• 77% bio-based carbon content, tested acc. to DIN EN 16640
	tesa® 4660	Printable	Acrylic coated cloth	Natural rubber	260	○●	145	Glassine 76µm	180	Yes	●●●●	●●●	• 74% bio-based carbon content, tested acc. to DIN EN 16640
	tesa® 4671	Neon gaffer	Acrylic coated cloth	Natural rubber	280	●○●●●●●	120	No	140	Yes	●●●	●●●	• 51% bio-based carbon content, tested acc. to DIN EN 16640
Performance	tesa® 4688	Robust starter	PE-extruded cloth	Natural rubber	260	●○●●●●●●	55	No	110	Yes	●●●	●●●	• None
Commercial	tesa® 4615	PCR duct tape	PE-laminated cloth	Hotmelt SR	175	◑●	27	No	60	No	●●	●●	• 63% of the backing is made from post-consumer recycled plastics, which accounts for 31 % of the total product

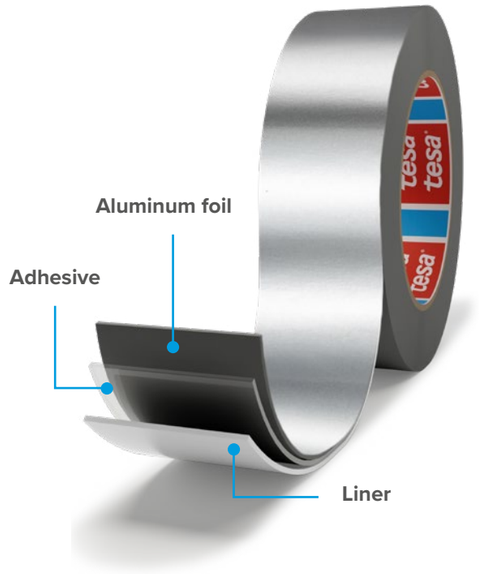
Evaluation across relevant tesa® assortment: ●●●● very good ●●● good ●● medium ● low

Aluminum tapes

tesa® offers a complete line of aluminum foil tapes, specifically engineered to meet the toughest requirements of the HVAC, metal construction, electrical, and household appliance industries.

Our range is characterized by high thermal resistance, durability, and conductivity, and can help increase efficiency and meet sustainability goals by minimizing air distribution loss.

Even for chemical masking, we offer you a solution resistant to chemicals to protect surfaces during the de-paint process and other chemical masking operations.



Main features

	Product	Description	Backing	Adhesive	Thickness [µm]	Color	Standard log roll width [mm]	Core material / diameter	Adhesion to steel – Ultimate [N/cm]	Adhesion to PE – Ultimate [N/cm]	Adhesion to PVC – Ultimate [N/cm]	Tensile strength [N/cm]	Features/ applications
Commercial	tesa® 60632	tesa® 60632 is a conformable aluminum tape based on a 30 µm (1.2 mil) aluminum foil, a transparent acrylic adhesive, and a white, single-sided siliconized, 85 µm thick paper liner.	Aluminum foil	Acrylic	65		1,200	Paper / 3“	8	4	6	25	• Flame retardant according to DIN 4102, class B1 and to the requirements in UL 510A • Service temperature from –20°C up to 160°C • Aluminum alloy 8011 • White paper liner with 85 µm thick
Performance	tesa® 60652	tesa® 60652 is an aluminum tape based on a 50 µm (2 mil) aluminum foil, a transparent acrylic adhesive, and a white, single-sided siliconized, 85 µm thick paper liner.	Aluminum foil	Acrylic	90		1,200	Paper / 3“	9	5	6	40	
Specialty	tesa® 60672	tesa® 60672 is a robust aluminum tape based on a 75 µm (3 mil) aluminum foil, a transparent acrylic adhesive, and a white, single-sided siliconized, 85 µm thick paper liner	Aluminum foil	Acrylic	125		1,200	Paper / 3“	10	6	4	60	
	tesa® 60677*	tesa® 60677 is a 75 µm removable aluminum tape for high temperature masking applications.	Aluminum foil	Acrylic	75		1,200	Paper / 3“	3.4	-	-	60	

Masking and surface protection solutions

Masking tapes are essential for a variety of industrial painting applications, even at very high temperatures, while surface protection tapes protect sensitive surfaces from scratches. They must be easy to use and removable without residue, both indoors and outdoors.

The most common industrial application for masking tapes are the following:
- Wet coating/spray painting
- Powder coating
- Sandblasting
- Galvanizing
- Surface protection

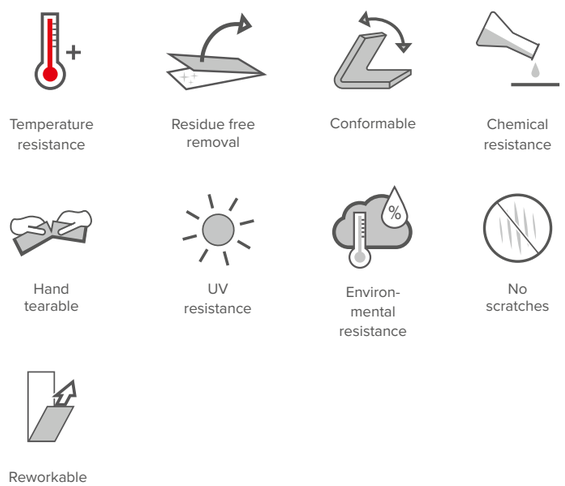
Our tapes with a paper or film backing have a low elongation and are therefore perfect when straight paint edges are required, for example, for two-tone applications. Due to their good quick-stick properties, the paper masking tapes can also be used to securely fix masks that protect surrounding areas against overspray.

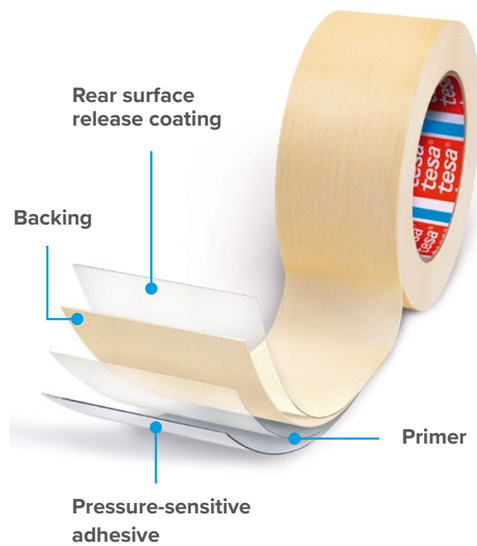
Surface protection tapes are essential tools in various industries, designed to shield surfaces from potential damage during manufacturing, transportation, or storage. Temporary adhesive surface protection tapes are ideal for short-term applications, providing a barrier against abrasions, debris, and environmental elements. They are often used during processes like painting or spraying, where easy removal after the job is crucial.

On the other hand, permanent adhesive surface protection tapes are used for long-term protection. These tapes are engineered to withstand more severe conditions, including exposure to UV, high temperatures, water, and other challenging environments. They are typically employed in situations where sensitive surfaces require durable and lasting protection against wear and tear.

Both types of tapes are tailored to meet the specific needs of the application, ensuring that surfaces remain pristine and unblemished throughout their use.

Main features





Masking

tesa Sustainability Marker Industry

This icon identifies our more sustainable products. We continually strive to make our products and assortment more sustainable. To demonstrate our initiatives and efforts in the industrial segment, this marker highlights our more sustainable products.

Scan here for more infos!

	Product	Description	Backing	Adhesive	Thickness [µm]	Temperature resistance [°C/30 min.]	Temperature resistance [°C/60 min.]	Adhesion to steel [N/cm]	Tensile Strength [N/cm]	Elongation at break [%]	Features/ applications
Specialty	tesa® 4319	Paper masking	Highly-creped paper	Natural rubber	375	-	60	4,5	24	58	High creped backing for taping curves & 3D objects
	tesa® 4331	Filmic masking	PET / non-woven	Silicone	110	200	-	4,0	53	100	Special laminate for high tear resistance & no curling
	tesa® 4434	Paper masking	Flat paper	Natural rubber	670	-	100	3,5	180	6	High Grade Paper Stencil Masking Tape for Sandblasting, Protection and Reinforcement
	tesa® 4174	Fineline	PVC	Natural rubber	110	-	150	3,7	25	200	Fineline tape for design painting in the automotive industry, most suitable for curved designs
	tesa® 4185	Fineline	PVC	Natural rubber	100	-	160	3,1	25	200	Flexible fineline tape for curves and 3D-shapes
	tesa® 51407	Filmic masking	Polyimide	Silicone	62	260		2,5	40	35	Masking during powder-coating processes where the tape enables sharp color edges and offers excellent paint anchorage. These have high chemical resistance and dielectric strength. Flame retardant according to UL510 and DIN EN 60454-2 (VDE 0340-2):2008-05, clause 20
Performance	tesa® 4316	Paper masking	Slightly-creped paper	Natural rubber	140	-	100	3,4	38	10	Slightly creped paper baking with excellent adhesion of filler or paints preventing any kind of paint flaking. Natural rubber adhesive for easy removal after oven drying process without tearing and leaving any residues.
	tesa® 4432	Paper masking	Flat paper	Natural rubber	330	-	100	8	93	6	tesa® 4432 can be used as shatterproof safety tape, meeting the requirement according to DIN EN 12600 with the durability of 6 sec./4 bar
	tesa® 4334	Paper masking	Washi paper	Acrylic	90	-	150	1,8	30	5	Vivid yellow colored washi paper backing for razor sharp paint lines and no tearing upon removal. Temperature, UV and aging resistant acrylic adhesive for resiue free removal after up to 8 weeks outdoor.
Commercial	tesa® 4341	Paper masking	Slightly-creped paper	Natural rubber	190	-	140	4,7	53	13	Robust, brown colored and slightly creped paper backing - can withstand wet sand-blasting and is suitable for protecting sensitive surfaces. No paint leakage. Thermo-setting natural rubber adhesive with high adhesion even on rough surfaces.
	tesa® 4342	Paper masking	Washi paper	Acrylic	85	-	150	1,5	32	10	Vivid orange colored washi paper backing for very sharp paint lines and no tearing upon removal. Temperature, UV and aging resistant acrylic adhesive for resiue free removal after up to 3 weeks outdoor
	tesa® 50600	Filmic masking	PET green	Silicone	80	220	-	4,0	75	110	Suitable for masking off areas to be protected during various versatile coating applications
	tesa® 50620	Filmic masking	PET green	Silicone	70	200	-	3,6	75	110	Suitable for general powder coating applications of flat surfaces
	tesa® 50650	Filmic masking	PET blue	Silicone	55	220	-	3,3	50	120	Suitable for versatile coating applications for non- flat surfaces due to high conformability

Surface protection

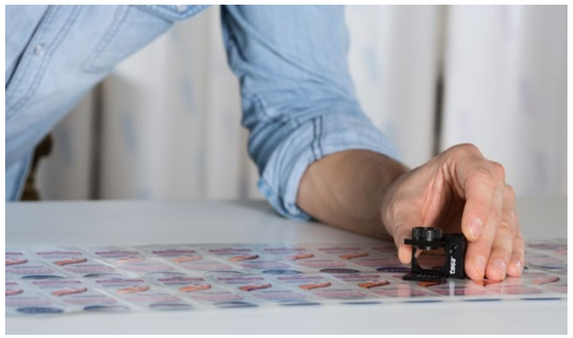
	Product	Description	Backing	Adhesive	Thickness [µm]	Color	Adhesion to steel [N/cm]	Tensile strength [N/cm]	Elongation at break [%]	Features/ applications
Temporary										
Specialty	tesa 5053x series	Temporary Protection	Polyolefin	EVA	71 / 61	○	0,9	30	800	tesa Bodyguard® 50530 PV3 is the best protection solution for freshly painted car bodies up to 6 month.. Applied after the painting process, tesa Bodyguard® 50530 PV3 provides reliable protection for painted surfaces susceptible to damage.
	tesa 7133	Temporary Protection	PP	Natural Rubber	80	●	1,8	133	30	tesa® 7133 can also be used as a temporary and removable interior surface protection tape without UV resistance. For this application the target substrates are glass surfaces and high energy plastic parts, such as PC or ABS.
Performance	tesa 51136	Temporary Protection	PE	Acrylic	105	●	2,4	19	300	tesa® 51136 PV0 is used for masking large areas of plastic parts during professional automotive painting processes and for the protection of various surfaces in automotive interiors made of plastic or textiles against dirt and damage during storage, assembly, and transportation
	tesa 51134	Temporary Protection	PE	Acrylic	84	⊗	2,4	15	200	tesa® 51134 is suitable for the protection of various surfaces in the automotive interior made of plastic or textiles like dashboards and door sills against dirt and damage during storage, assembly, and transportation.
	tesa 51132	Temporary Protection	PE	Acrylic	85	⊗	2,8	15	250	tesa® 51132 is a premium grade self adhesive film that has been developed for the protection of various surfaces, especially interior parts of automobiles like carpets, dashboards and door sills during storage, assembly and transportation
Commercial	tesa 4848	Temporary Protection	PE	Acrylic	48	⊗	0,8	12	200	The surface protection film is easy to use and protects sensitive surfaces (e.g. glass) from paint droplets, many chemicals, moisture, damage and contamination of any kind. The surface protection film is UV resistant, can be used for 4 weeks

	Product	Description	Backing	Adhesive	Thickness [µm]	Color	Liner	Adhesion to steel [N/cm]	Tensile strength [N/cm]	Temperature Resistance [°C/30 min.]	Features/ applications
Permanent											
Specialty	**tesa® 52995**	Permanent protection	Top coated PU-Film	Pure acrylic	330 / 280	Optically clear	PET	Upon request	>60	90	tesa® 5299x is applied to permanently protect sensitive surfaces against strong mechanical forces in interior and exterior applications. It is specially designed for permanent paint protection against stone chipping, abrasion, scratches and corrosion in automotive applications.
	tesa® 52994	Permanent protection	PU-film	Pure acrylic	360 / 260 / 187	Optically clear	PET	Upon request	>60	90	
	tesa® 51206	Permanent protection	PE-UHMW	Pure acrylic	114	⊗	Glasine	4,3	43	90	tesa® 51206 is especially designed for interior anti-squeak and abrasion protection at the assembly line to ensure a reliable. Self-lubricating backing with excellent spelling properties
	tesa® 51217	Permanent protection	PE-UHMW	Pure acrylic	154	●	Glasine	4,3	63	90	tesa® 51217 is especially designed for interior anti-squeak and abrasion protection at the assembly line to ensure a reliable. Self-lubricating backing with excellent gliding prpoerties. Very good UV resistance: > 1000h WOM Florida test

Plate mounting solutions for flexographic label printing

Plate mounting

Increasing demands on print quality and process efficiency call for specifically tailored plate mounting tapes. Our tesa® Softprint assortment provides distinctive product lines for Converter Partners and label printers to fulfill each and every requirement.



tesa® Softprint 380 µm/15 mil category*

	X-Soft	Soft	Medium	Medium-Hard	Hard	
	Product color code					
	Print motif					
Classic product design						
tesa® Softprint STM	tesa® 52018	tesa® 52017	tesa® 52016	tesa® 52015	tesa® 52014	High tack adhesive for plate mounting in unclean and cold conditions. Secure bonding with excellent resistance to edge lifting.
tesa® Softprint TP	tesa® 52118	tesa® 52117	tesa® 52116	tesa® 52115	tesa® 52114	Medium tack adhesive for reliable plate mounting under most conditions. Secure bonding with excellent resistance to edge lifting.
tesa® Softprint SEC	tesa® 52818	tesa® 52817	tesa® 52816	tesa® 52815	tesa® 52814	Low tack adhesive for easy and fast plate mounting in clean and standardized conditions. Secure bonding with excellent resistance to edge lifting.
Flex product design						
tesa® Softprint FE	tesa® 53418	tesa® 53417	tesa® 53416	tesa® 53415	tesa® 53414	Compensating product design for demanding sleeve/cylinder surfaces. Very low tack adhesive for easy and fast plate mounting in clean and standardized conditions. Secure bonding with excellent resistance to edge lifting.

*also available: tesa® Softprint 500 µm/20 mil category

Product	Tape characteristics and application examples	Backing	Adhesive	Thickness category [µm/mil]	Color
tesaprint® plate mounting for versatile use					
tesa® 52310	100 µm tape category for various plate mounting applications (e.g. letterpress plate mounting, plate mounting on compressible sleeves, dry offset blanket mounting)	PVC	Natural rubber	100/4	⊗
tesa® 52315	150 µm tape category for various plate mounting applications	PVC	Natural rubber	150/6	●
tesa® 52320	200 µm tape category for various plate mounting applications	PVC	Natural rubber	200/8	○
tesa® 52325	250 µm tape category for various plate mounting applications	PVC	Natural rubber	250/10	●

Products for roll-to-roll processing

Efficiency is key to profitability. Our complementary solutions based on pressure-sensitive adhesive technology speed up changeovers, prevent machine stops, and facilitate everyday tasks.. With our high-quality process tapes we supply the best possible solution to be successful in producing your required level of quality. Our broad assortment is developed based on your individual needs.

Product	Special feature	Backing	Adhesive	Thickness [µm/mil]	Color
Splicing					
tesa® 51904	d/s tape with high tack, high adhesion for flying splice	Non-woven	Synthetic rubber	110/4	
tesa® 64620	d/s tape with low tack, medium adhesion for flying splice	PP	Synthetic rubber	185/7	
tesa® 60404	s/s tape for butt splicing	PVC	Natural rubber	67/3	
tesa® 4122	s/s tape with high tear strength for butt splicing	PVC	Natural rubber	88/3	
tesa® 4137	s/s tape for butt splicing and inductive detection	PET	Acrylic	50/2	
Roller wrapping					
tesa® Printer's Friend 4863	Embossed surface	Cloth	Natural rubber	620/24	
tesa® Printer's Friend 4563	Smooth surface	Cloth	Natural rubber	380/15	
Edge sealing					
tesa® 4174	Flexible s/s tape	PVC	Natural rubber	110/4	
tesa® 60404	Rigid s/s tape	PVC	Natural rubber	67/3	
Core starting					
tesa® 60404	s/s tape for safe bonding on paper and PE cores	PVC	Natural rubber	67/3	
tesa® 51194	Splittable d/s tape for flying splice labelling applications	Splittable paper	Synthetic rubber/acrylic	120/5	
tesa® 52307	d/s tape for safe bonding and easy release	PVC	Acrylic	70/3	
Failure flagging					
tesa® 60404	Different colors to mark material imperfections	PVC	Natural rubber	67/3	
End tabbing					
tesa® 60404	Safe bonding on all kind of materials	PVC	Natural rubber	67/3	
Additional tools					
tesa® 52064	Plate cleaning				
tesa® 52065	Rubber roller				

Roller wrapping

Our decades of experience as the pioneering manufacturer of roller wrapping tapes have made our tesa® Printer's Friend tapes a benchmark. They support a variety of manufacturing and printing processes that utilize roller systems and process materials such as films, textiles, paper, and more.

Ever striving for the highest quality and optimal solutions, the well-proven tape design has been improved even further over the years, ensuring maximum process reliability and efficiency. The tape design allows for clean and accurate application, while at the same time ensuring easy removal. Applied on the roller, the tape will securely keep its position, even at elevated temperatures.

Our tesa® Printer's Friend roller wrapping tapes:

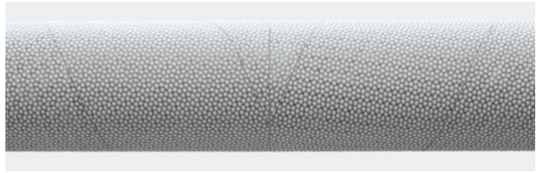
- Offer outstanding grip and traction to provide tension in the web being processed
- Repel a variety of substances involved in the process (e.g. adhesives or inks)
- Are highly resistant to wear
- Are easily removable, even after a prolonged period of time
- Are exceptionally temperature resistant

Wrap the tape once around the roller at the desired angle and mark the point where the end of the roll meets the second turn of the tape.

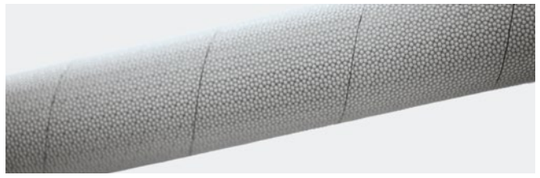
Put the tape on a flat surface and cut it diagonally from the end of the roll to the marked point of the tape.

Remove the liner and start applying the tape, starting from the edge of the roller.

Keep on wrapping the roller with the tape at even angles, leaving no gaps in between the layers.



Complete roller spiral wrapped, providing grip and a nonstick surface.



Alternative design, starting from the middle and wrapping to the ends aids in pulling the material evenly across the roller to eliminate creases.

Product	Description	Backing	Adhesive	Liner	Thickness [%]	Color	Standard log roll width	Core material / diameter	Adhesion to steel steel – Ultimate [N/cm]
tesa® Printer's Friend 4863	Cloth tape with embossed silicone coated surface, which offers reliable "grip." Designed for roller wrapping in a variety of manufacturing, converting, and printing processes.	Silicone-coated cloth	Natural rubber	PP red	620		100	Cardboard / 3"	3
tesa® Printer's Friend 4563	Designed for roller wrapping in a variety of manufacturing and printing processes that utilize roller systems to process web-based materials, such as films, textiles, paper, and more.	Silicone-coated cloth	Natural rubber	PP red	380		100	Cardboard / 3"	3

Ancillary products

Surface cleaning

The surfaces to be bonded must be clean, dry, and free of dust, grease, oil, and release agents. For cleaning, only use clean cloths and material-compatible cleaning agents. The components must be adapted to the ambient climate for a sufficient period to prevent the formation of condensation on the surfaces.

Prior to bonding, the surfaces are cleaned and thus all impurities removed. These include:

- Dust
- Release agents
- Greases
- Waxes
- Plasticizers
- Oxidation layers, e.g. rust

Coarse, dusty or grainy, impurities can best be removed with a brush or a white lint-free cloth.

Cleaning with water and solvent

Water-soluble impurities can be removed with water and detergents. Other impurities, for example, oil traces, grease, wax, and release agents, can strongly reduce the bonding capacity of the surface. Special care must be taken to remove such impurities. Suitable solvents for this are:

- **tesa® 60040 Industry Cleaner**
- **Isopropanol**
- **Isopropanol + water (1:1)**
- **Acetone or methyl ethyl ketone (butanone)**

Determining which solvent is required is ultimately dependent on the surface to be cleaned. It is recommended to follow the manufacturer's cleaning recommendations. During cleaning, please make sure to use a lint-free cloth and always wipe in one direction. The rags should be changed several times until complete removal of all impurities. Thereafter, the solvent must evaporate completely.

Mechanical cleaning

If the above cleaning agents are not sufficient, the surface can be prepared for bonding by means of mechanical treatment. Loose oxides (such as rust) and poorly adhering coatings are removed with a suitable abrasive, for example, Mirlon Sanding Fleece VF 360.

The surface should only be roughened slightly and remain flat. Corrosion protection coatings must not be damaged. Thereafter, the surface must be cleaned again to remove the grinding dust with a brush or a white lint-free cloth.

tesa® 60040 Industry Cleaner
Cleaning of surfaces for optimum bonding results with adhesive tapes and spray glues.

- Evaporates without leaving residues
- Excellent cleaning results on machinery and many different surfaces like plastic and metal
- Color: Transparent

Adhesive remover

Detaching a single-sided adhesive tape

When removing single-sided adhesive tapes, you should proceed as follows:

- Peel off adhesive tape at an acute angle to the substrate. Ideal: 45° angle. Then the risk that residues will be left behind is at its lowest.
- Always pull slowly and evenly. Thus, residue and tearing of the adhesive tape can be avoided.
- When peeling off, the substrate temperature should be >10°C. The carrier material and the adhesive mass will otherwise become brittle and the tendency of the adhesive tape to tear increases.
- If an adhesive tape is difficult to remove, it may help to heat the tape briefly with a hair dryer.

Detaching a double-sided adhesive tape

When peeling off, the substrate temperature should be >10°C. The carrier material and the adhesive mass will otherwise become brittle and the tendency of the adhesive tape to tear increases. If an adhesive tape is difficult to remove, it may help to heat the tape briefly with a hair dryer.

If the adhesive joint is sufficiently accessible, then interconnected surfaces can be separated again by cutting the adhesive tape. This is especially possible with thick products such as foam adhesive tapes or tesa® ACX^{plus}.

For this we recommend, for example, the use of an automatic sealing compound cutter or a knife with a sharp and stable blade in combination with a lever tool. Carefully cut through the adhesive tape with these tools.

Removing pressure-sensitive adhesive residues

In practice, adhesive mass residues may remain if an unsuitable adhesive tape has been used or one has waited too long to remove the tape. In this case, proceed as follows:

- Dab residues with the adhesive side of a more adhesive product, such as tesa® 4651.
- Use tesa® 60042 Adhesive Remover, which removes most adhesive residues on glass, metal, and plastic surfaces reliably.
- Alternatively use mineral spirits, isopropanol, or similar: Thoroughly soak and expel the adhesive mass with a plastic spatula to avoid damage. Please test solvent on concealed area first.

tesa® 60042 Adhesive Remover
Reliable removal of glue residues from plastic parts and glass and metal surfaces.
- Evaporates without leaving residues
- Easy removal of labels
- Color: Transparent

Adhesion promoters

For bonding – especially outdoors and on challenging surfaces – we recommend the use of a bonding agent (adhesion promoter). Bonding agents form a layer on the surface to which the pressure-sensitive adhesive adheres particularly well. This layer also prevents water from entering the adhesive joint and thus enables consistent outdoor bonding.

tesa® Adhesion Promoter 60150 – Universal

Our universal adhesion promoter is recommended for a broad variety of substrates including zinc, steel, and PP/EPDM. Its UV-traceability allows easy quality control during the application process.

tesa® Adhesion Promoter 60151 – Glass

This highly transparent adhesion promoter was specifically developed to ensure permanent bonding and moisture resistance on glass substrates.

tesa® Adhesion Promoter 60153 – Fast Cure

Our fast-curing adhesion promoter can be used on various surfaces, including PP/EPDM***. Its UV-traceability allows easy quality control during the application process.

* PU = Polyurethane ** HPVC = Hard Polyvinyl chloride *** PP/EPDM = Polypropylene diene monomer

When using our adhesion promoters, the following instructions should be observed:

Surface	tesa® Adhesion Promoter	Repositionability	Application	Tools	Evaporation time	Time window for subsequent bonding
Plastic and metal surfaces (PP, EPDM, zinc, paints)	tesa® 60150, tesa® 60153	tesa® 60150: Yes tesa® 60153: No (high initial bond strength	Apply thinly	Line-free cloth, brush, application pen	30 sec. to 5 min.	Several hours/days
Glass	tesa® 60151	No	Apply thinly and wipe with a clean cloth	Line-free cloth, brush, application pen	30 sec. to 5 min.	15 min.

Physical pretreatment

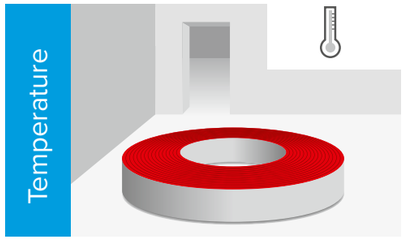
The surfaces of the material to be bonded and the pressure-sensitive adhesive ideally have a similar surface energy. By means of physical methods such as flame treatment, corona discharge, or plasma treatment, the surface energy of an object is increased short-term by the attachment of polar and reactive molecular groups.

However, such activated surfaces can easily and quickly become deactivated by contact with gases and dust from the ambient climate. The application of physical methods to increase the surface energy should therefore take place immediately before the bonding. It is especially suitable for continuous processing operations.

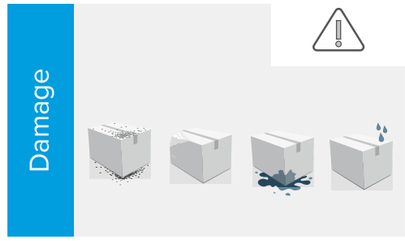
Ask your application consultant for our technical customer service, who will gladly assist you in implementing physical pretreatment methods.

Tips before and after converting

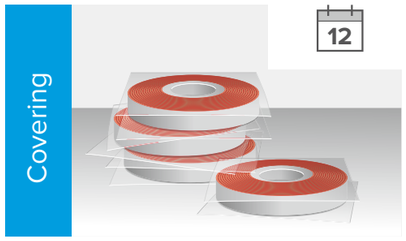
The storage or transport of adhesive tapes is best done at normal room temperature and low air humidity. The rolls are to be covered individually with release film.



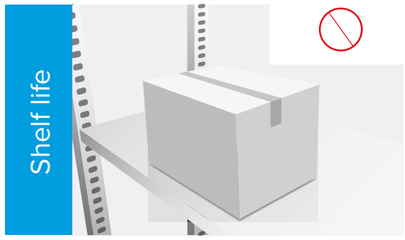
tesa® adhesive tapes are best stored at temperatures between 15–35°C and at normal relative humidity between 50–70%.



Ensure during transport and storage that the packaging is not damaged or deformed. The packaging should be resealed after parts removal so that the adhesive tapes are protected against dust, moisture, and dirt.



In the case of side-tacky products, the side surfaces of the rolls must be covered with appropriate silicone-coated release sheets. When stacking several rolls on top of each other, a double layer of release sheets is recommended.



If all transport and storage recommendations are adhered to, the minimum shelf life of tesa® products is usually twelve months from the date of delivery.

Grow your business -
Become a tesa® Alliance Partner

We are excited to introduce you to the tesa Alliance Partner Programme, specifically tailored to bring significant value to your business as a converter. Here's why joining our programme is a game-changer:

Cutting-edge adhesive solutions:
Stay ahead with exclusive access to tesa's innovative adhesive technologies, helping you deliver superior products to your clients.

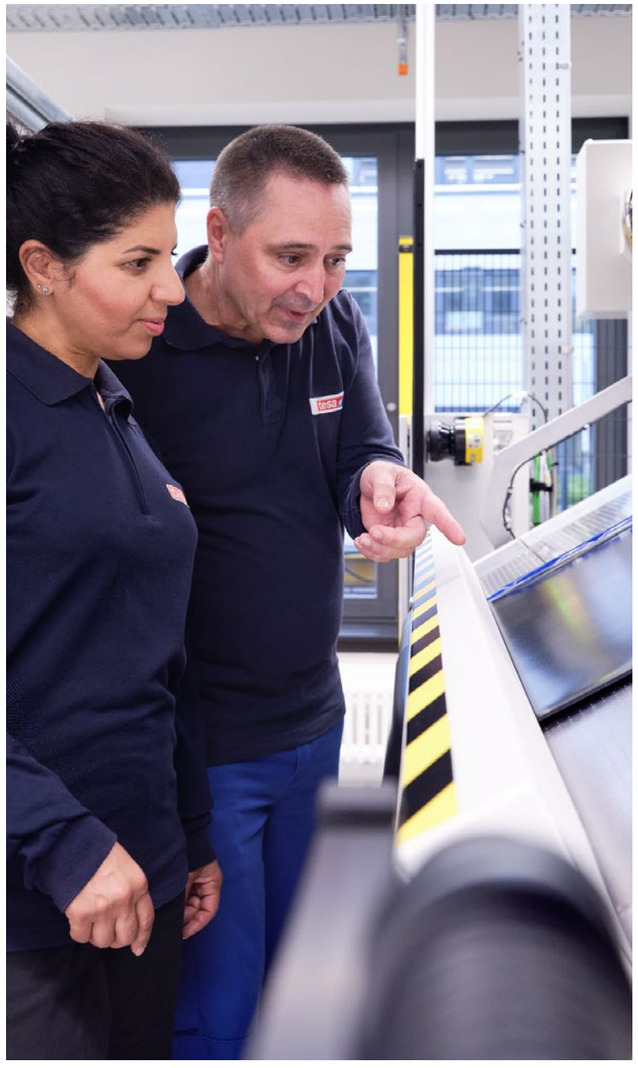
Enhanced technical support:
Receive expert technical support and personalized guidance from our dedicated team, ensuring seamless integration and application of tesa products.

Comprehensive training:
Empower your team with specialized training and workshops designed to enhance their expertise in adhesive solutions and applications.

Marketing and sales boost:
Leverage our extensive marketing resources, co-branding opportunities, and sales tools to enhance your market presence and drive conversions.

Strategic collaboration:
Connect with a network of industry leaders and like-minded businesses for valuable collaboration, knowledge-sharing, and growth opportunities.

By joining the tesa Alliance Partner Programme, you gain a competitive edge, access to top-tier resources, and the support needed to exceed your customers' expectations.



Let's work together to achieve remarkable success.

tesa GOLD CONVERTER PARTNER

tesa® Gold Converter Partner Benefits & requirements

Benefits:
- Strong level of sales, marketing and technical support
- Strong level of incentives including rebates and Market Development Funds (MDF)
- Access to certifications and approvals
- Eligible to participate in sales incentive program - tesa Rewards

Requirements:
- Successful local assessment and classification as Platinum Converter Partner
- Leads with tesa in specified market(s)/ customers
- Joint Alignment Planning and | Plan Execution/ Quarterly Reviews
- Adheres to Partner Policy including the tesa Code of Conduct

tesa PLATINUM CONVERTER PARTNER

tesa® Platinum Converter Partner Benefits & requirements

Benefits:
- Highest level of sales, marketing and technical support
- Highest level of incentives including rebates and Market Development Funds (MDF)
- Engioss to participate in sad approvals incentive program - tesa Rewards
- Advance notification of new product launches
- Priority access to new leads

Requirements:
- Successful local assessment and classification as Platinum Converter Partner
- Leads with tesa in specified market(s)/ customers
- In-depth joint Alignment Planning and Plan Execution / Quarterly Reviews
- Adheres to Partner Policy including the tesa Code of Conduct

Technical customer service is our top priority

We offer you a wide range of products supporting you in all of your business fields. Many options often require a closer look into the specific application. At the Customer Solution Center we can support you by taking into account your specific materials, their application process, and the operating conditions for the product in use.

From a range of several hundred adhesive tape solutions, we select the right product for your customers' application while considering their specific requirements.

In our Customer Solution Centers we analyze customers' materials, in combination with our adhesive tape products, depending on the application-specific demands, such as bonding power, shock absorption, resistance to environmental impacts, removability, and much more.

During on-site visits, we assist you in detecting such requirements and translate those into appropriate test programs.

Not only do we recommend the suitable products, we also support the implementation stage of our solutions into your customers' process with application tools and equipment.

Based on our modular training program, we individually teach you and your customers about the adhesive tape technology, along with our products, their applications, and corresponding tools. This can either be done at our technical training facilities or even as on-site training on your premises.

Our global network of application engineers collaborate closely to provide short response times and close customer contact, offering you many years of experience and expertise in adhesive tape products and applications.

Our Sales team will assist you in directing your inquiries to our Customer Solution Centers.

Learn more
Scan or click the QR code to learn more about the Customer Solution Center

02/2025

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

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