

A woman with blonde hair tied back, wearing a red zip-up jacket with the tesa logo on the left chest, is holding a large roll of red double-sided adhesive tape. She is looking off to the side with a focused expression. The background shows an industrial manufacturing environment with various machines and equipment.

Advanced mounting and bonding with double-sided adhesive tapes

Industrial double-sided tape innovations



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By your side

About us



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 commitment. 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.

Boosting product quality and process efficiency



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 different 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.

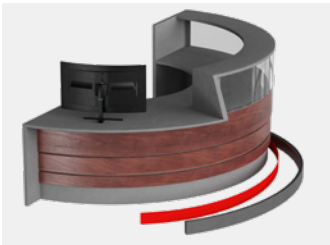


Testing & benchmarking

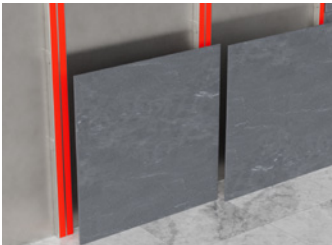
Technical consultants will support you on-site and remotely from our labs, resorting to state-of-the-art equipment to perform:

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

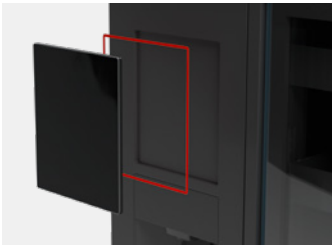
Mounting tapes: Improving products, optimizing processes



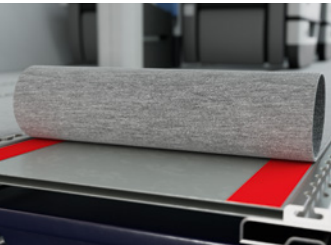
Trim & furniture



Mounting of panels



Display mounting



Floor laying



Emblem mounting



Fixation of floor profiles



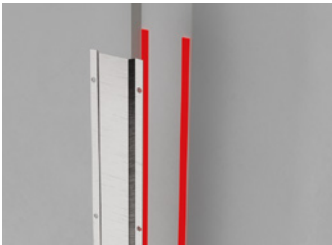
Deco panel mounting



Honeycomb milling



Control panel mounting



Profile mounting



POS trim mounting



Insulation mounting

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 Industry Approvals)
- High variations of log roll sizes, liner versions
- Short lead time, stock items, MOQ1



Commercial offer

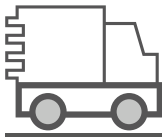
- Product for lower technical requirements
- Commercially attractive and high-volume products
- Standardized product offering (few dimensions, certificates, liner variations)



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

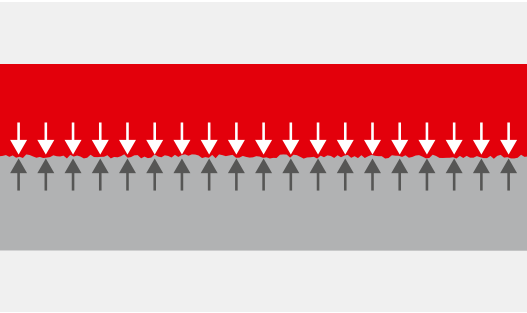
A woman with long dark hair is wearing a blue and black VR headset. She has her mouth open in a surprised or excited expression and her hands are raised in front of her. The background is a soft-focus bokeh of colorful lights in shades of yellow, orange, blue, and pink. The overall mood is futuristic and immersive.

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.

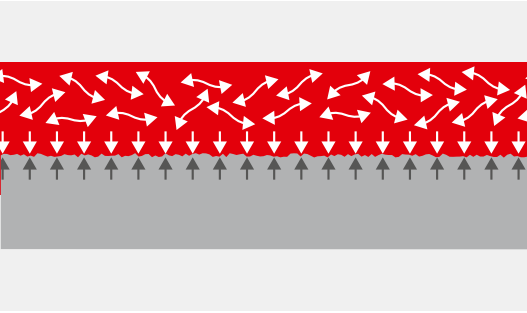
Tack refers to an adhesive’s ability to wet a surface quickly without pressure, but it doesn’t indicate bond strength. Adhesives with low tack can endure high stresses due to strong final adhesion and shear strength.

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.

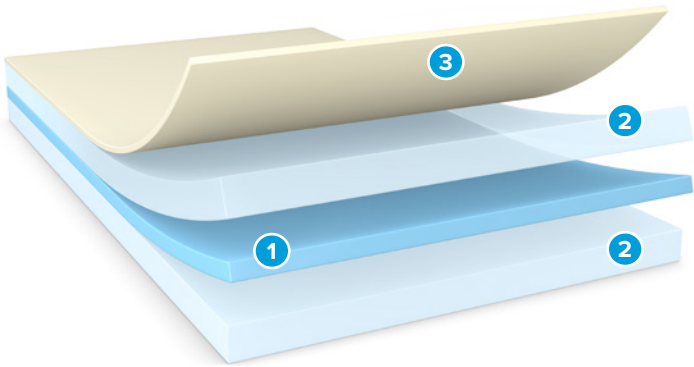
Adhesive strength



■ Substrate ■ Pressure-sensitive adhesive

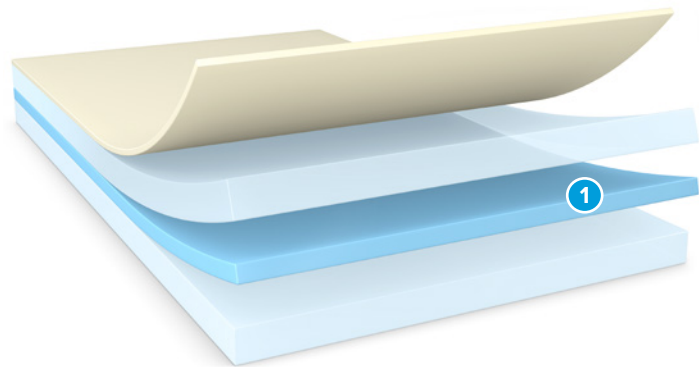
Adhesive strength his described by the interplay of adhesion and cohesion, i.e. only through a certain combination of adhesion and internal strength is an adhesive bond able to withstand the stresses that act on it.

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 applica- tion 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

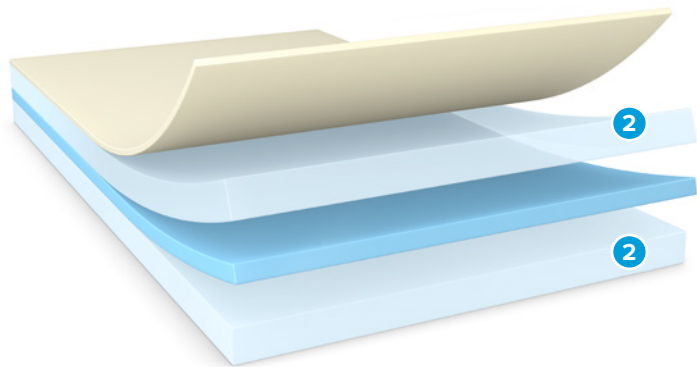
Backing – Choosing the right double-sided tape



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

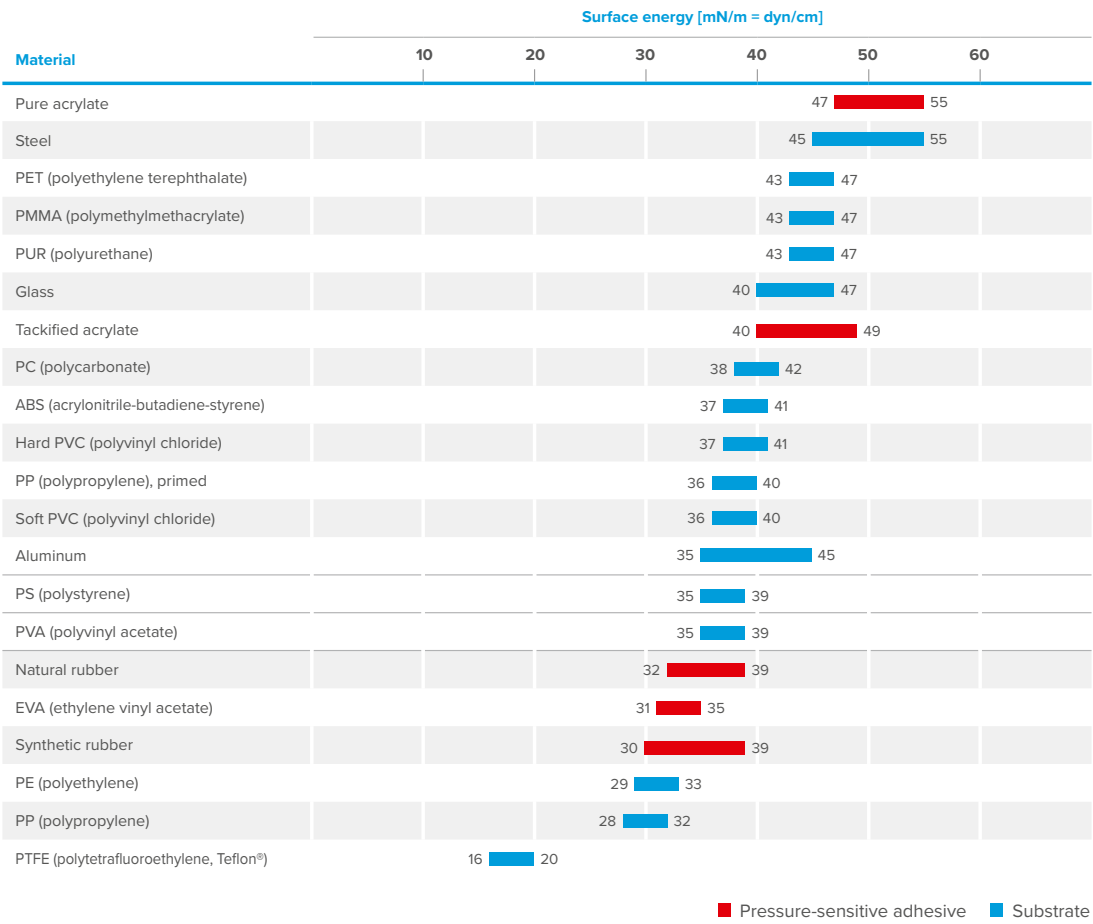
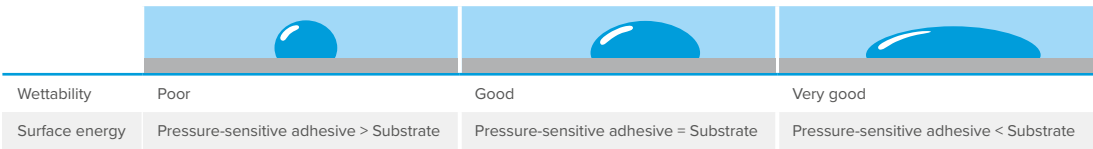
Acrylic	• Good bonding on pure acrylic, tackified acrylic can also bond to MSE and LSE • High temperature resistance • High aging resistance • High shear resistance (at room and high temperatures) • Limited removability
Natural rubber	• Good bonding on polar substrates • Moderate bonding on non-polar 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

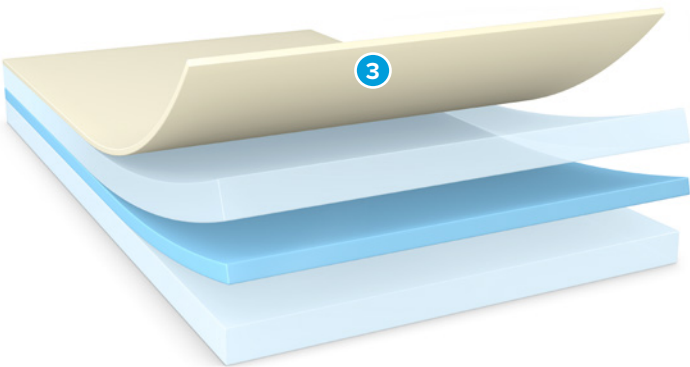
Surface tension

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



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

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

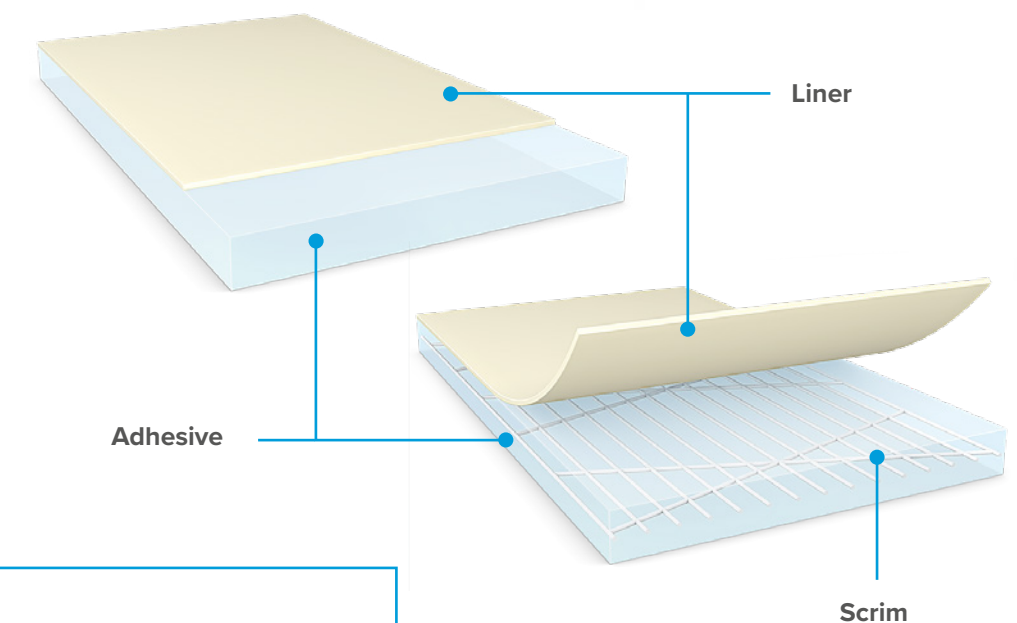
			Double-sided tape	Liquid glue	Mechanical fastening (e.g. rivets, screws, nails)
Design		Improved visual appearance – no damage to the material		...	.
		Invisible fastening – mounting of transparent materials		...	.
Assembly		Fast application process – elimination of curing time and reduction of complexity		.	..
		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

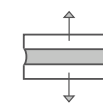
Double-sided transfer tapes

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 re-positioning. 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



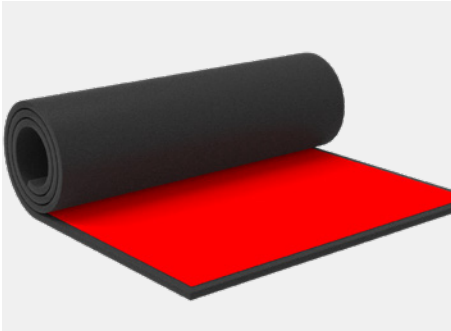
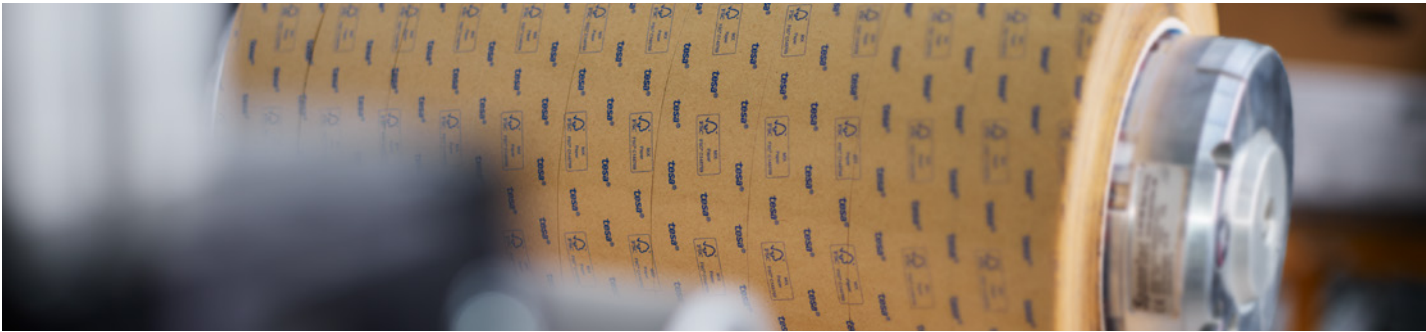
Transparent bonding

Double-sided transfer tapes

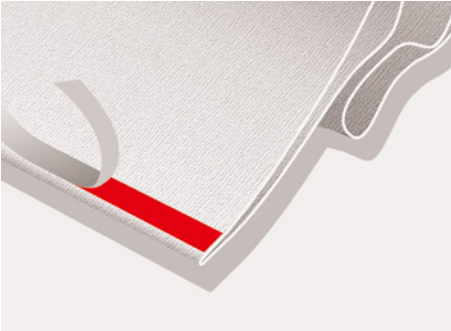
Thin and flexible for lamination and lightweight mounting

	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
	 tesa® 74515	LSE double-side	None	Tackified acrylic	125	⊗	More sustainable glassine PE-coated paper	10.9	6.9	11.6	200 / 100	High tack and primerless bonding to LSE substrates ensure strong immediate adhesion.	• In accordance with UL standard 969. UL file: MH 18055* • Low VOC - measured according to VDA 278 analysis
	tesa® 75515	High shear double-sided transfer	None	Tackified acrylic	125	⊗		12	6	15	200 / 100		• 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-sided transfer	None	Tackified acrylic	75	⊗	More sustainable glassine PET PE-coated paper	11	4.5	13	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.	
	tesa® 75505	High shear double-sided transfer	None	Tackified acrylic	50	⊗		8.5	3.5	11	200 / 100		
	 tesa® 52110	Double-sided transfer	None	Water-based acrylic	100	⊗	Glassine	11.5	Upon request	Upon request	Upon request	Suitable for lightweight mounting and laminations.	• 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	None	Water-based acrylic	50	⊗	Glassine	9.2	Upon request	Upon request	Upon request		

* More information regarding our certificates can be found on page 51



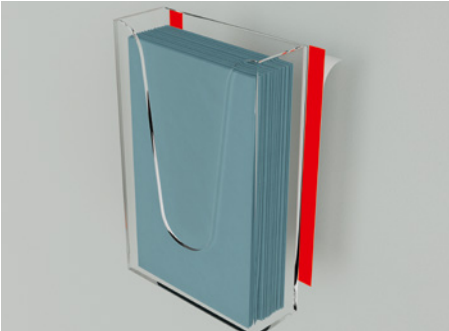
Foam lamination
e.g. with tesa® 755xx, tesa® 521xx



Fabric and textile mounting
e.g. with tesa® 755xx



Lightweight mounting
e.g. with tesa® 74515, tesa® 755xx



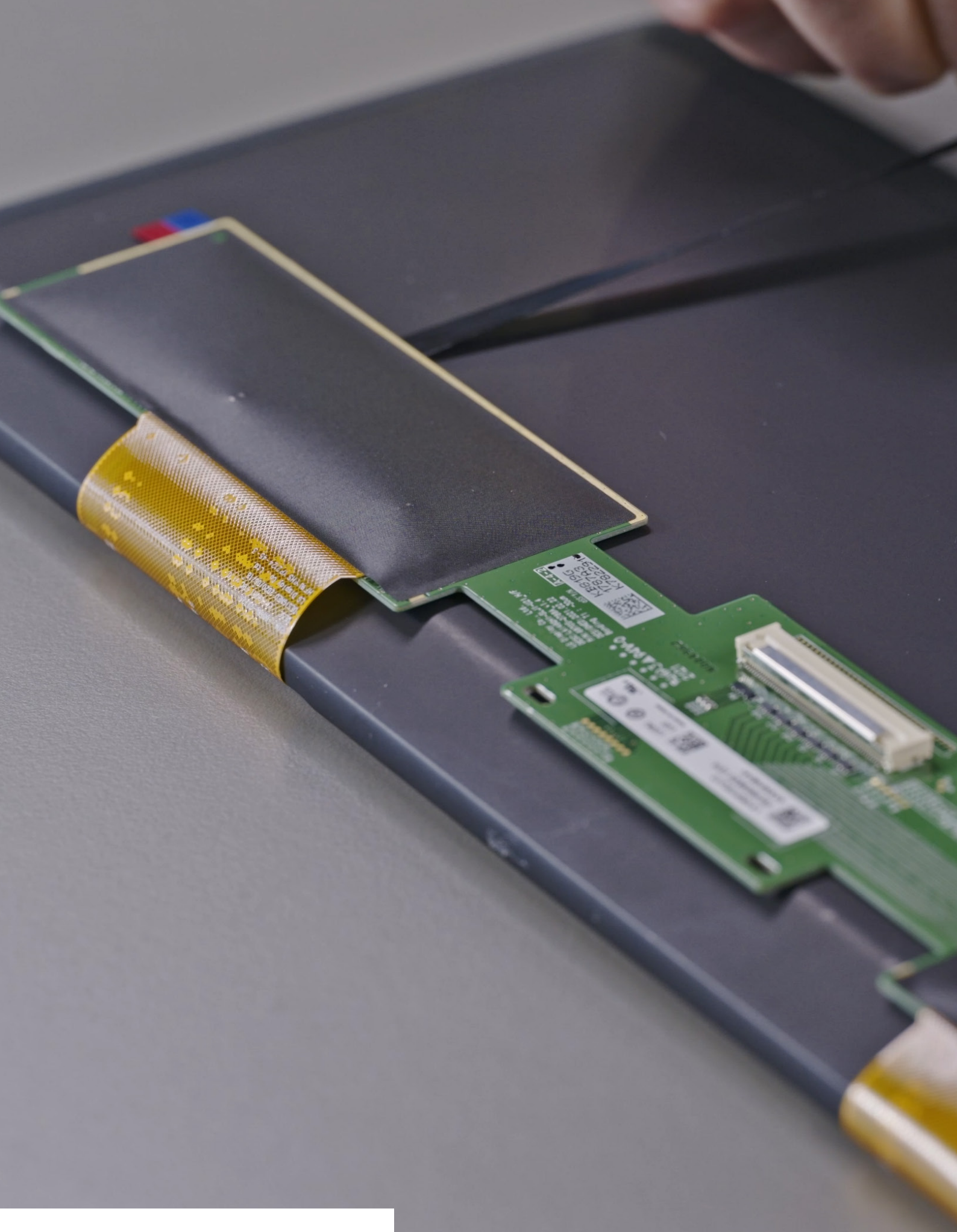
e.g. with tesa® 74515



Membrane switch mounting
e.g. with tesa® 755xx, tesa® 74515



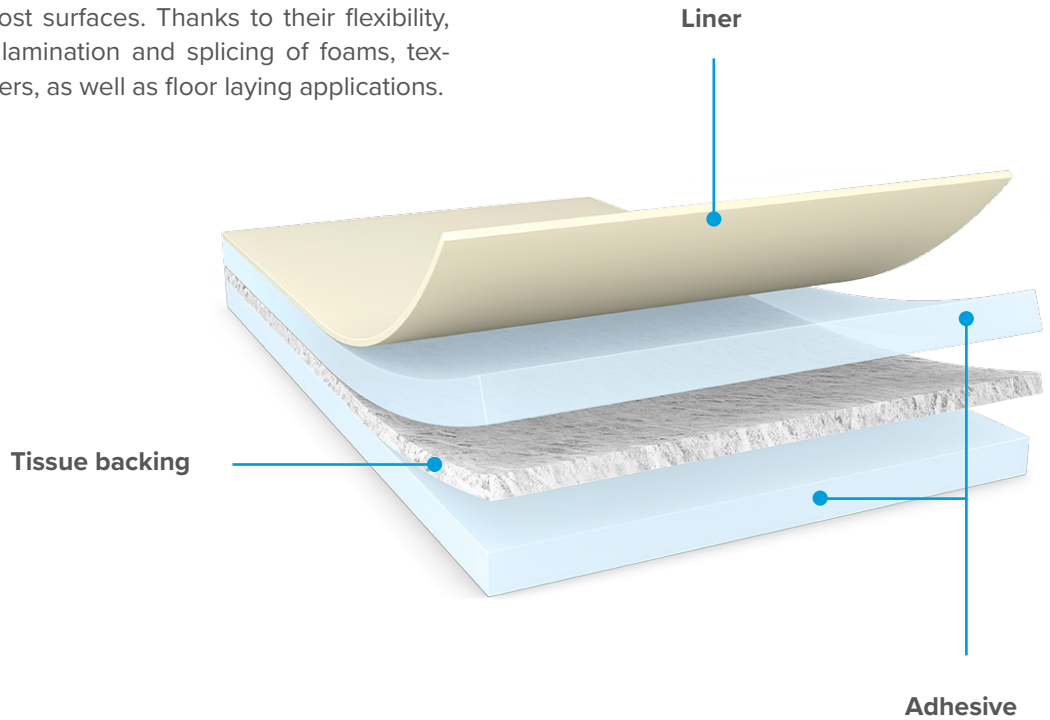
Mounting of emblems and decorative trims
e.g. with tesa® 755xx



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

High bonding

Good wetting

Quick bonding

Chemical resistance

Conformable

Good for lamination

Hand tearable

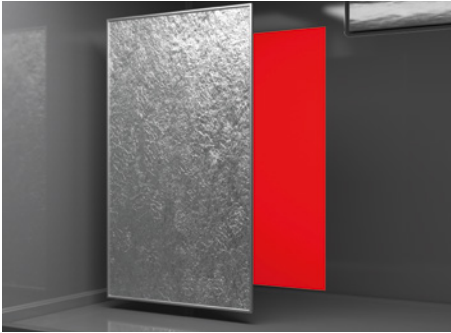
Good die-cutting

Double-sided non-woven tapes

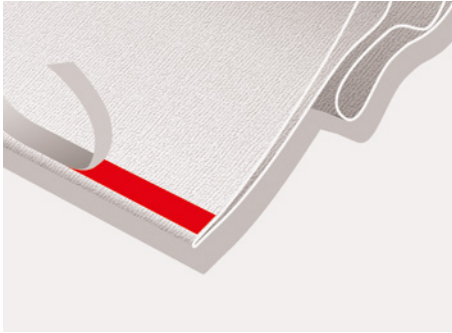
Easily tearable and conformable

	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
	tesa® 4914	Double-sided asymmetrical tape	Non-woven	Tackified acrylic	250	⊗	MOPP	9.3 covered side	7.8 covered side	7.8 covered side	140°C / 80°C	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® 4962	Double-sided non-woven	Non-woven	Tackified acrylic	160	○	More sustainable glassine	12.0	7	15	200°C / 80°C	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	Non-woven	Tackified acrylic	100	○		8.5	4.5	14	200°C / 80°C		
	tesa® 51571		Non-woven	Synthetic rubber	160	⊗	Glassine	12.5			80°C / 40°C	Good bonding on uneven surfaces, very high initial bond.	
	tesa® 51570		Non-woven	Synthetic rubber	110	⊗	Glassine	13			80°C / 40°C	Good bonding on uneven surfaces, very high initial bond.	
	tesa® 4943		Non-woven	Tackified acrylic	100	⊗	PE-coated paper	8.1	Upon request	10.8	100°C / 70°C	General purpose, provides a high initial tack and a good shear resistance.	
	tesa® 52215		Non-woven	Water-based acrylic	150	⊗	Glassine	12.0	5	8.6	190°C / 80°C	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		Non-woven	Water-based acrylic	100	⊗	Glassine	11.2	3	8.5	200°C / 80°C		

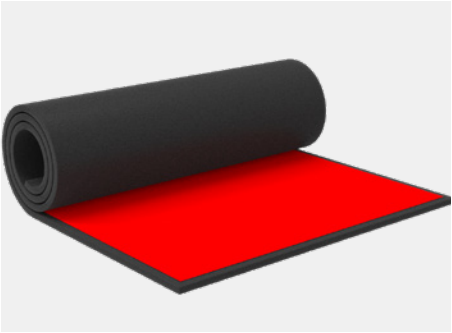
* More information regarding our certificates can be found on page 51



Mounting of insulation materials
e.g. with tesa® 4962, tesa® 5157x



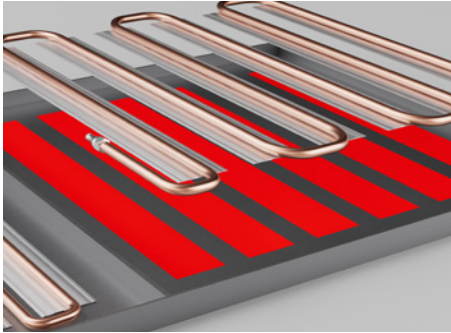
Fabric and textile mounitng
e.g. with tesa® 4959, tesa® 4962



Foam lamination
e.g. with tesa® 5221x



Lightweight mounting
e.g. with tesa® 4943



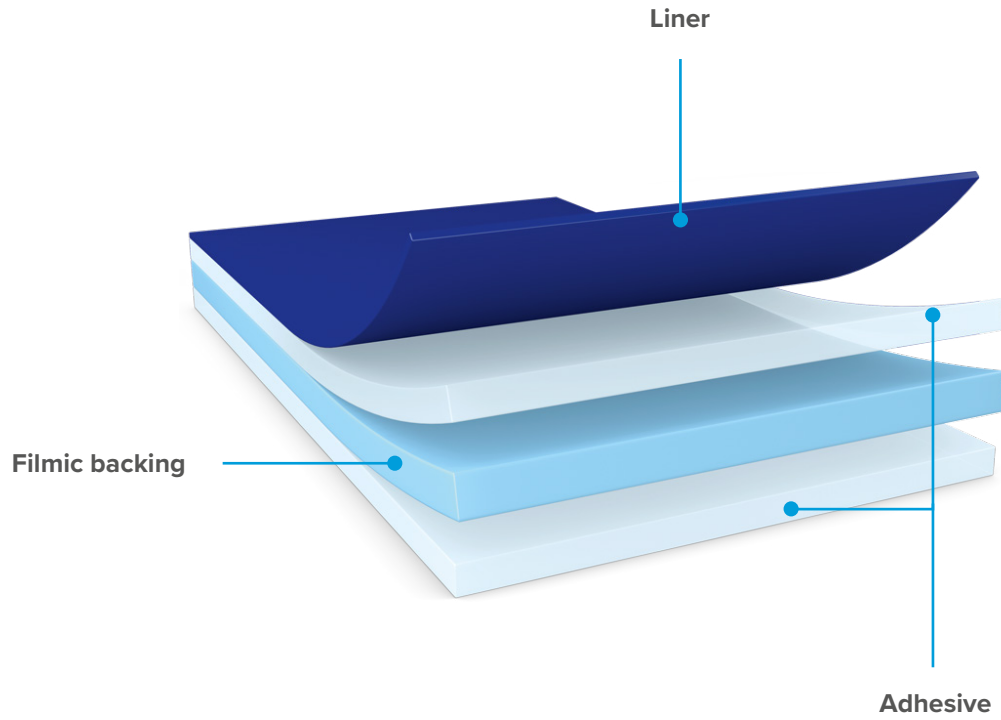
Evaporator mounting
e.g. with tesa® 51571



Leather mounting and lamination
e.g. with tesa® 4962, tesa® 51571



Double-sided filmic tapes



Main features

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

Double-sided filmic tapes – PET

Ideal for bonding to flat, smooth surfaces

	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
	tesa® 59651	Double-sided thick	PET	Tackified acrylic	300	⊗	Glassine	14.5			200 / 100	Superior bonding strength to critical surfaces, high holding power at elevated temperatures.	• Skin contact certification according to ISO 10993-5 and ISO 10993-10* • Low VOC according to VDA 278 analysis
	tesa® 59652	High shear double-sided transparent film tape	PET	Tackified acrylic	205	●	Glassine	14	6.6	12.8	200 / 100	Contributes to light management in interior designs.	• Skin contact certification according to ISO 10993-5 and ISO 10993-10* • In accordance with UL standard 969. UL file: MH 18055* • Low VOC – measured according to VDA 278 analysis
	tesa® 49652	Double-sided transparent film tape with double liner	PET	Tackified acrylic	205	⊗	PET / glassine	11.8	6.9	Upon request	200 / 100	4965 Original Next Gen with double liner for improved transparency.	
	tesa® 51865	Film tape with double liner	PET	Tackified acrylic	165	⊗	Filmic	14.5			200 / 100	Team 4965 Differential, asymmetrical product design.	• Skin contact certification according to ISO 10993-5 and ISO 10993-10* • Low VOC according to VDA 278 analysis
	tesa® 45051	Double-sided flame retardant tape	PET	FR tackidied acrylic	200	⊗	MOPP	12			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® 4950	LSE double-sided transparent film tape	PET	Tackified acrylic	100	⊗	More sustainable glassine / PE-coated	9.4	5.5		200 / 100	Primerless bonding to LSE substrates with high shear strength and tack ensures durable, immediate adhesion.	• In accordance with UL standard 969. UL file: MH 18055* • Low VOC - measured according to VDA 278 analysis
	tesa® 45020	tesa® flameXtinct 45020 – flame retardant, halogene-free and removable carpet tape	PET	FR tackified acrylic	190	⊗	PET white	4	Upon request	Upon request	FAR 25.853 (a) app. F part 1	tesa® flameXtinct 45020 is compliant with FAR 25.853 (a) app. F part 1 and therefore fulfills the highest industry standards. Due to the differential product design, repositioning is possible during installation. If necessary a fast and efficient carpet exchange is possible due to residue free removability.	• FAR 25.853 (a) app. F part 1
	tesa® 4965	High shear double-sided transparent film tape	PET	Tackified acrylic	205	⊗	MOPP 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 and ISO 10993-10* • 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® 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 and ISO 10993-10* • 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	Reliable bond, often also on low surface energy surfaces, immediate usability right after assembly.	• Skin contact certification according to ISO 10993-5 and ISO 10993-10* • In accordance with UL standard 969. UL file: MH 18055* • Low VOC – measured according to VDA 278 analysis
	tesa® 51966	High tack double-sided	PET	Tackified acrylic	200	⊗	Glassine	11.0	7.5	13	80 /40	High tack, solvent free, general purpose fixing tape.	

* More information regarding our certificates can be found on page 51

Double-sided filmic tapes – Filmic and others

Ideal for bonding to flat, smooth surfaces

	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
	tesa® 4968	Double-sided transparent film tape	PVC	Tackified 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	Tackified acrylic	225	○	More sustainable 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	Tackified acrylic	220	⊗	More sustainable glassine	13.5	8	17.5	130 / 80	Mounting plastic or wooden trims.	• Low VOC – measured according to VDA 278 analysis
	tesa® 64620	Transparent film tape PET	PP	Synthetic rubber	90	⊗	Glassine	15			80 / 40	High tack, solvent free, general purpose fixing tape.	
	tesa® 51966	High tack double-sided	PET	Synthetic rubber	90	⊗	Glassine	15			80 / 40	High tack, solvent free, general purpose fixing tape.	

* More information regarding our certificates can be found on page 7



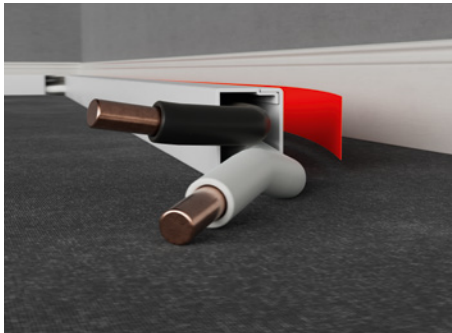
Point of sale trim mounting
e.g. with tesa® 51865, tesa® 4965



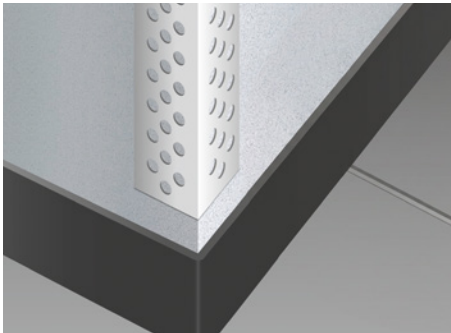
Control panel mounting
e.g. with tesa® 4950, tesa® 4953



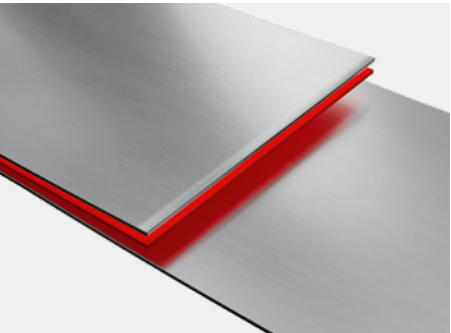
Mounting of emblems and decorative trims
e.g. with tesa® 51970



Mounting of cable channels
e.g. with tesa® 4970



Mounting of corner profiles
e.g. with tesa® 4965 Original



Splicing of lightweight metal materials
e.g. with tesa® 4953



Double-sided cloth tapes

Double-sided cloth tapes combine a strong, conformable cloth/fabric backing with high-performance adhesive systems, enabling reliable mounting even on rough or uneven surfaces. At the same time, double-sided cloth tapes remain easy to handle during installation and are hand-tearable.

Depending on the adhesive — natural rubber, synthetic rubber, or acrylic — they provide high cohesion, strong initial adhesion, or excellent aging and softener resistance, supporting both temporary and permanent applications.

Variants with differential adhesives ensure secure carpet fixing while allowing easier removal from the floor, ideal for exhibitions and temporary setups.

Robust, flexible, and easy to apply, double-sided cloth tapes offer dependable performance across a wide range of mounting and flooring applications.

Top coat

The type of top coat has a big influence on the following tape properties:

- Level of gloss: shiny or matt
- Ability to write, print, or coat the tape
- Resistance against solvents/ moisture/humidity
- Unwinding behavior

Plastic layer

The layer affects major characteristics of the cloth tape:

- Color
- Barrier function
- Creates abrasion resistance
- Stiffness

Fabric

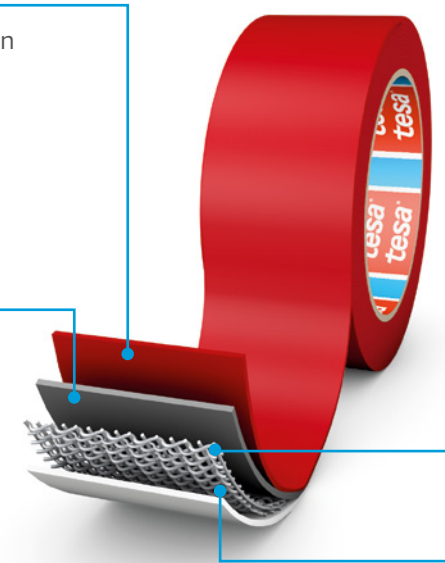
The backing is responsible for different features of the adhesive tape:

- Flexibility and conformability
- Mechanical properties, such as tensile or elongation
- Abrasion resistance
- Enables the removal of the tape

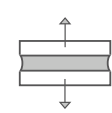
Adhesive system

Depending on the specific adhesive system the following features are affected:

- Adhesion/peel resistance
- Cohesion/shear resistance
- Initial bond/tack



Main features



High bonding



Excellent on smooth surfaces



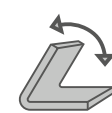
Quick bonding



Hand tearable



LSE



Conformable

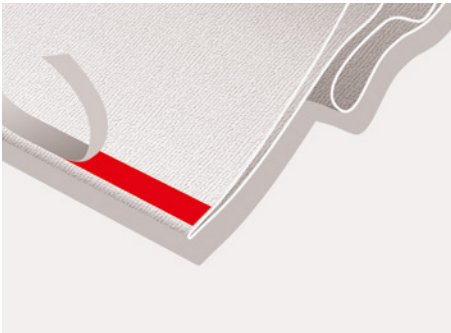


Removable bonding

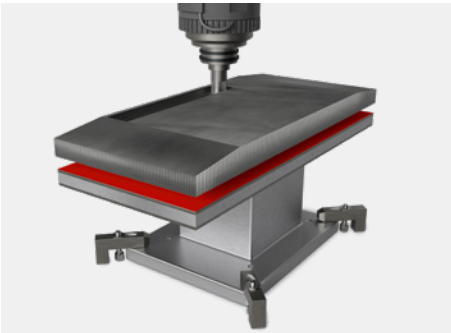
Double-sided cloth tapes

For Rough Surface and removable applications

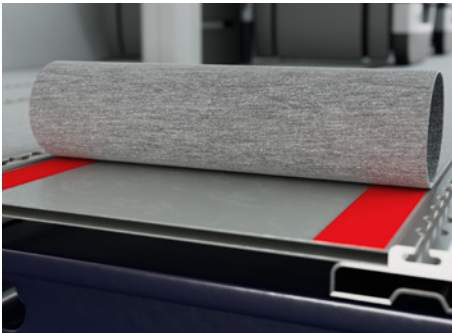
	Product	Description	Backing	Adhesive	Thickness [µm]	Color	Liner	Adhesion to steel – Ultimate [N/cm]	Adhesion to PE – Ultimate [N/cm]	Adhesion to PVC – Ultimate [N/cm]	Temperature resistance short / long term [°C]	Features/ applications	Certificates / test reports / comments
	tesa® 51960	Carpet laying tape for professional users - removable	PP film reinforced by fabric	Tackified acrylic	248	○	Paper	6.6 / 13.7	Upon request	Upon request	120 / 60	Removable from sensitive surfaces (parquet, PVC / CV floorings) without residues and discoloration.	Removability: Up to 5 years
	tesa® 4964	Double-sided tape with fabric backing	Cloth	Natural rubber	390	○	Glassine	7.6	Upon request	Upon request	110 / -	High coating weight for irregular surfaces, removable up to 1 month, transportation (marine, automotive).	Removability: Up to 1 month
	tesa® 5938	Double-sided black cloth tape	Cloth	Synthetic rubber	190	●	Glassine	14	Upon request	Upon request	80 / 60	Black color for invisible gaps when using dark carpets.	Removability: Up to 14 days
	tesa® 5939	Double-sided white cloth tape	Cloth	Synthetic rubber	190	○	Glassine	14	Upon request	Upon request	80 / 60		Removability: Up to 14 days
	tesa® 4934	Double-sided	Cloth	Synthetic rubber	200	○	Glassine	24	Upon request	Upon request	60 / 40	High tack and high coating weight – for mounting on rough, fibrous surfaces.	Permanent, not removable



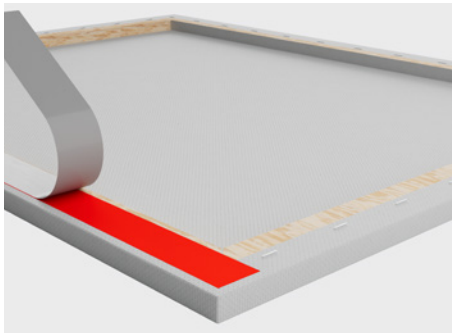
Mounting of fabrics
e.g. with tesa® 4934



Honeycomb milling
e.g. with tesa® 4964



Floor laying
e.g. with tesa® 51960 and tesa® 593x



Mounting of pictures and posters
e.g. with tesa® 4964 and tesa® 4934



Sewing aid for leather in the manufacturing of shoes and bags
e.g. with tesa® 4934



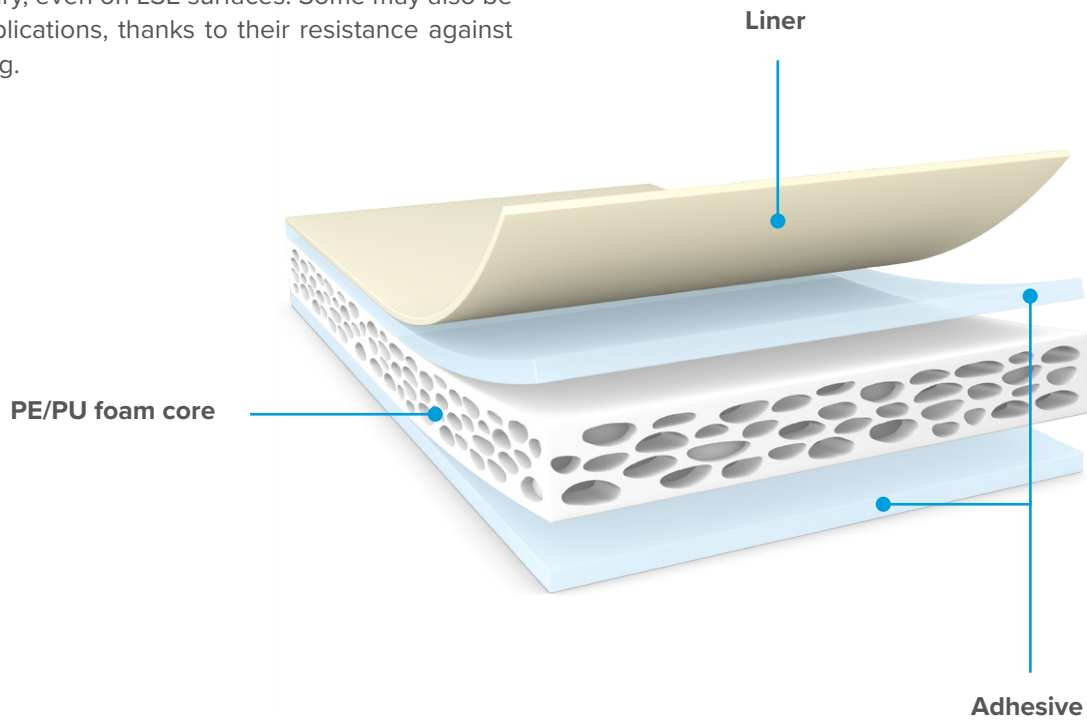
Bonding of POS materials
e.g. with tesa® 593x and tesa® 4964



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

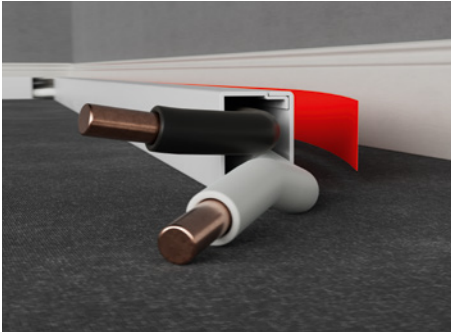
Good bonding	Reworkable	Quick bonding	Chemical resistance	Conformable
Good wetting	Bonding of dissimilar materials	Impact resistance	Compressible	

Double-sided foam tapes

Bond different surfaces, seal gaps and absorb shock

	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
	tesa® 4952	Double-sided foam tape	PE	Tackified acrylic	1,150	○	Glassine	8	2.8	8	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 - 1,600	● ○	Glassine PP PE-coated paper PE	17	3	17	80 / 80	PE foam tape for constructive mounting applications (indoor and exterior).	
	tesa® 4957	Double-sided foam tape	PE	Tackified acrylic	1,100	● ○	Glassine PP PE MOPP	13	4	4	80 / 80	Highly conformable foam backing provides excellent shock resistance (indoor and exterior).	• Approved by IFT institute for window bar mounting IFT report number 509 30742/1
	tesa® 45001	Double-sided flame retardant foam tape	PE	Tackified acrylic	1,000	○	MOPP	22	Upon request	Upon request	80 / 80	Tape comprises of a flame retardant acrylic adhesive and flame retardant PE-foam with excellent bonding strength.	
	tesa® 625xx series	Double-sided foam tape	PE	Tackified acrylic	400 – 3,000	●	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).	• 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® 64958 series	Indoor double-sided foam tape	PE	Synthetic rubber	1,050	○	Glassine	4	4	4	60 / 40	General mounting.	
	tesa® 55576	Indoor double sided foam tape	PE	Tackified acrylic	1,200	○	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	1,000	○	Glassine	Upon request	Upon request	6	80 / 80	Medium-density, conformable PE foam and is equipped with an acrylic adhesive.	

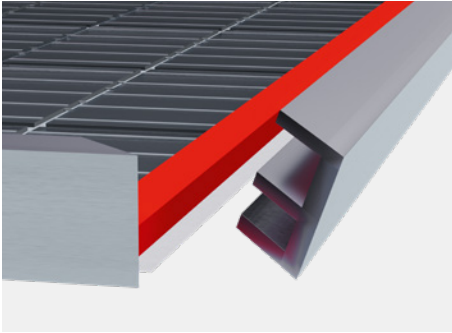
* More information regarding our certificates can be found on page 51



Cable channel mounting
e.g. with tesa® 64958



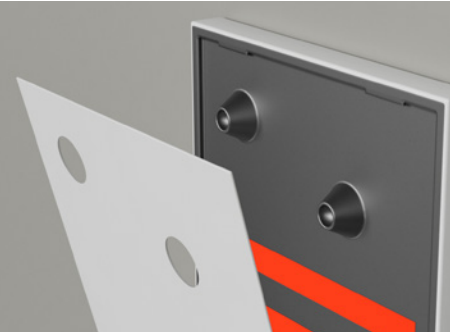
Mirror mounting
e.g. with tesa® 4952



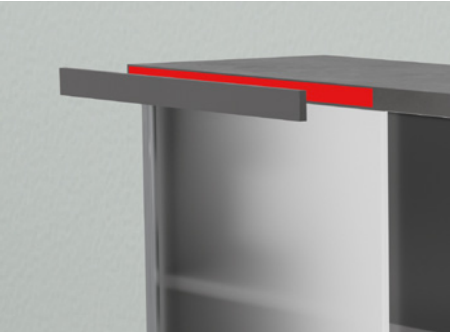
Solar frame mounting
e.g. with tesa® 62510



Profile mounting
e.g. with tesa® 6293x and tesa® 625xx



Permanent mounting
e.g. with tesa® 6293x

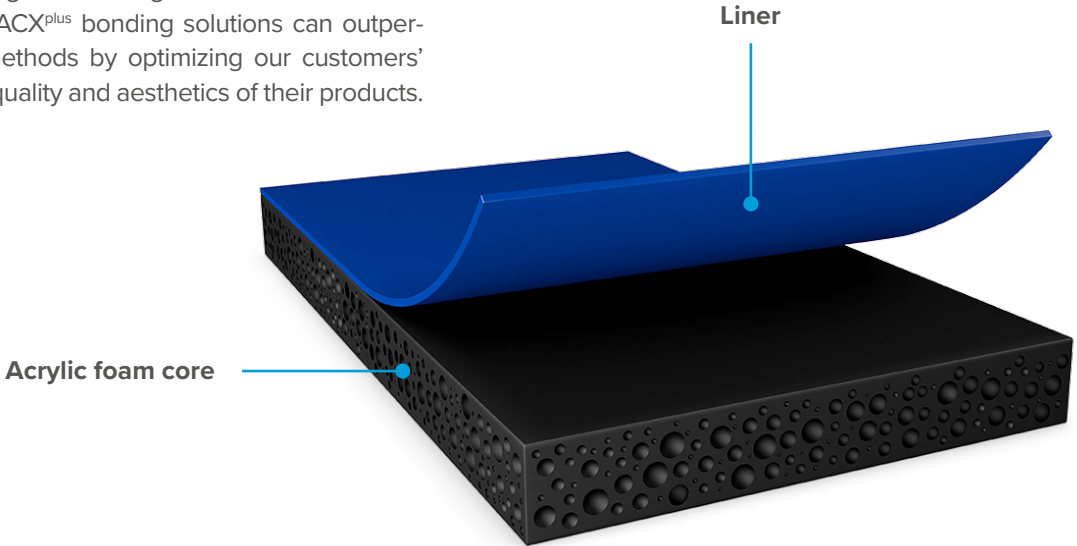


Mounting of decorative profiles
e.g. with tesa® 4957 and tesa® 6293x



ACX Acrylic core tapes

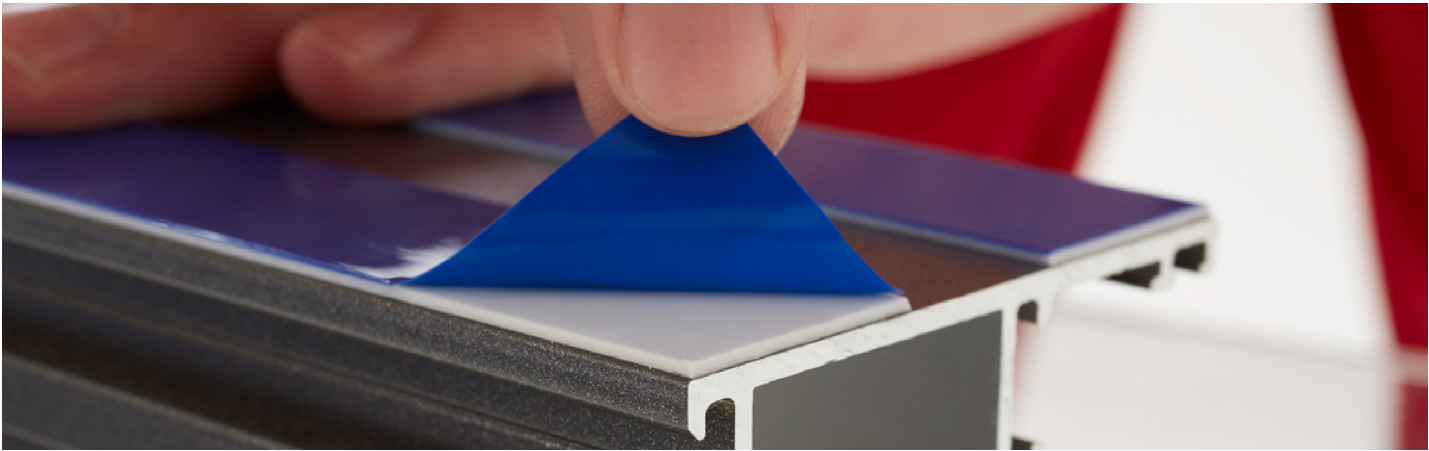
Constructive bonding is a key element in every industry and can be very challenging. Traditional mechanical fasteners like rivets, welds, screws, or liquid glue may not be suitable or can even damage the substrates. That is where our high-performance bonding tapes come into play. tesa® ACX^{plus} is 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.



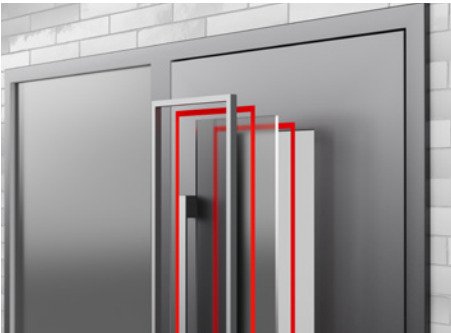
Main features

 Good bonding	 Good wetting	 Quick bonding	 Chemical resistance
 Conformable	 Environmental resistance	 Cold shock resistance	 Compressible
 Impact resistance	 UV resistance	 Bonding of dissimilar materials	 Temperature resistance

	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® 707x series	Acrylic foam	Acrylic core	Pure acrylic	500 – 4,000	●	Glassine PE-blue	32	Upon request	Upon request	220 / 110	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® 731xx series	Acrylic foam	Acrylic core	Pure acrylic	640 – 1,200	●	PE	40	Upon request	17	220 / 150	Excellent temperature resistance for bonding before powder coating.	
	tesa® 732xx series	Acrylic foam	Acrylic core	Pure acrylic	500 – 1,000	⊗	PE-coated paper	25	Upon request	15	180 / 100	Designed for durable and reliable bonding of transparent materials as well as all other applications where a transparent bond is required.	
	tesa® 733xx series	Acrylic foam	Acrylic core	Pure acrylic	500 – 1,100	●	PE-coated paper	35	Upon request	45	160 / 100	Excellent adhesion on most powder-coated paints, metals, glass, sealed wood, acrylic, polycarbonate, and ABS.	
Commercial	tesa® 704x series	Acrylic foam	Acrylic core	Pure acrylic	500 –2,000	○●	Glassine Filmic-blue Filmic-white	36	Upon request	34	220 / 110	Mounting applications in different industries (e.g. extruder, appliances, interior fit-out, signage).	



Energy rotor blade
e.g. with tesa® 707x



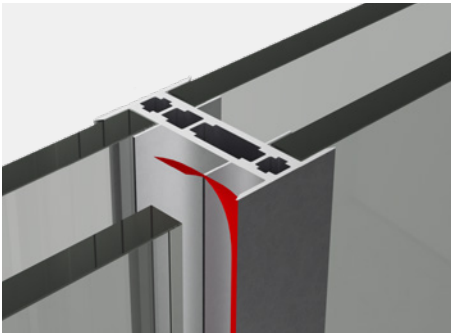
Deco glass mounting
e.g. with tesa® 73210



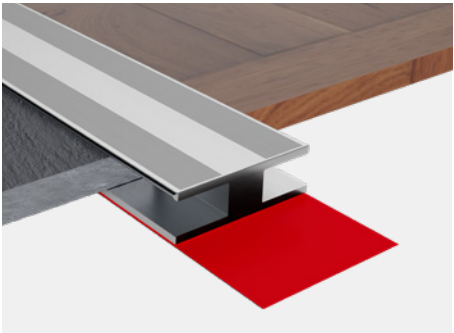
Decorative trim mounting
e.g. with tesa® 733xx



Design panel mounting
e.g. with tesa® 731xx



Bonding to profiles
e.g. with tesa® ACX^{plus} 707x



Mounting of H-shaped profiles
e.g. with tesa® 731xx and tesa® 704x

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

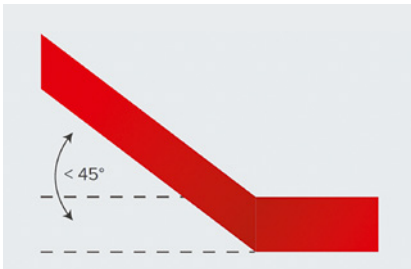


Adhesive remover

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 ad-

hesive 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.



Customer Solution Center

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



Certificates:

Statement
on certificates:



Skin
contact



Product iQ |
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Certifications

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

Please find more information regarding our certifications at:
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Phone: +49 40 88899 0

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