

Tape Specialists core assortment

High-quality products and expert adhesive support



Table of contents

By your side		4
Tape expertise		8
Core assortment		10
Mounting solutions		11
	Technical basics	12
	Product overview	19
	Acrylic core tapes	20
	Double-sided foam tapes	24
	Double-sided filmic tapes	28
	Double-sided non-woven tapes	32
	Double-sided transfer tapes	36
	Double-sided cloth tapes	40
	Structural Bonding (HAF)	42
Masking and Surface Protection		44
Repairing solutions		56
Packaging products		60
Ancillary products		68
Inspiration – Targeted Industries and Application Fields		72
Alliance Partner Program		74
Customer Solution Center		76



By your side

About us



- 1 Company headquarters
- 6 Regional headquarters
- 10 Plants & Production sites
- 9 Customer Solution Center
- 61 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.

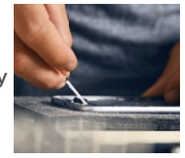
Circularity and reduction of waste



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.



Product excellence and market intimacy across industries

By partnering with tesa as a Tape Specialist 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 Tape Specialist 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.



Partners beyond tape



Product excellence
Access to the broadest tesa product portfolio, including a selection of 60+ products handpicked for our Tape Specialist 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 Tape 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 and 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

Reliable solutions across industries



Transportation



Building industry



Advertising, events and entertainment



Laminators



Security and protection



Energy

By combining your market expertise with our high-quality products and expert adhesive consultancy, you can provide the best suitable products for all market needs.

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)

Targeted services we offer to our Tape Specialist Partners:



Demand generation
- Trainings on markets, application and products
- Trainings on sales techniques
- Industry selling cheat sheet
- Lead Gen Campaigns
- (Co) visit to end-user by our Sales Engineers



Product offering
- Targeted Core Assortment - all relevant products for your customer
- The flexibility to adapt or add new products if needed
- Product Sampling
- Lead Gen Campaigns
- High quality guaranteed in product and deliveries

Further services our partners can count on:



Technical support
- Application Engineering Expertise
- Cutting-edge testing capacity
- Swift quality support



Sales excellence
- Joint planning for every year, setting goals, investments and priorities
- Regular business review



Marketing and online support
- Application Engineering Expertise
- Cutting-edge testing capacity
- Swift quality support



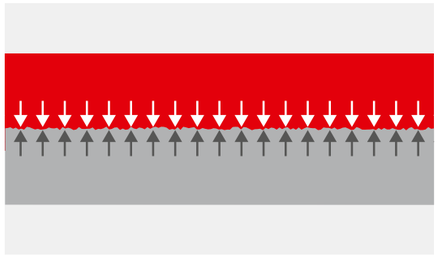
Financial attractiveness
- Rebate schemes
- Price-Product segmentation (commercial, performance, specialty)



Technical basics

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.

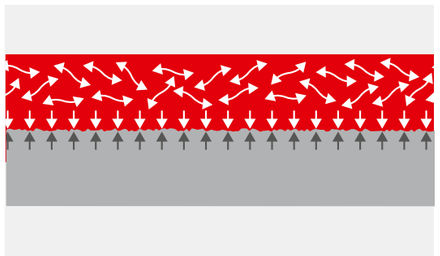
Tack refers to an adhesive's ability to wet a surface quickly without pressure, but it doesn't indicate bond strength. Adhesives with low tack can endure high stresses due to strong final adhesion and shear strength.

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.

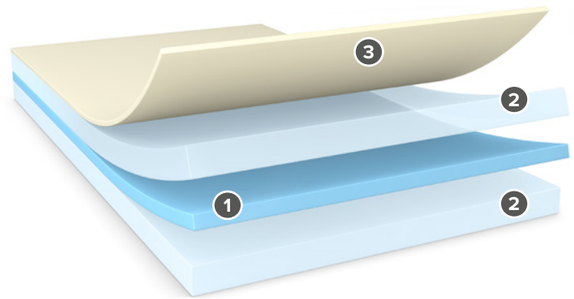
Adhesive strength



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.

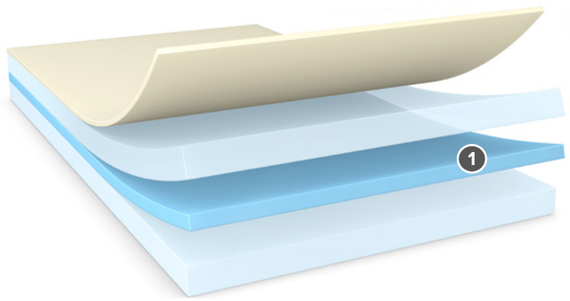
Substrate Pressure-sensitive adhesive

Double-sided tape main components



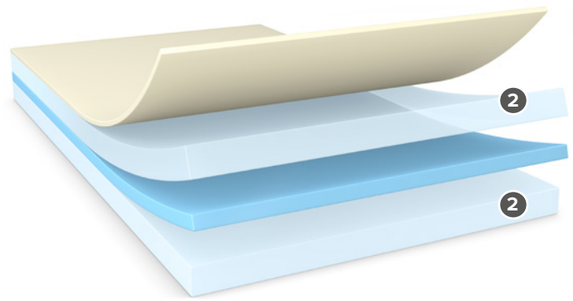
1 Backing	2 Adhesive	3 Liner
• The backing provides structural support for the adhesive. • Backing properties can vary and have an impact on the tape's strength, durability, flexibility, and ability to fill gaps. • The thickness and strength can vary based on application requirements.	• It allows the 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

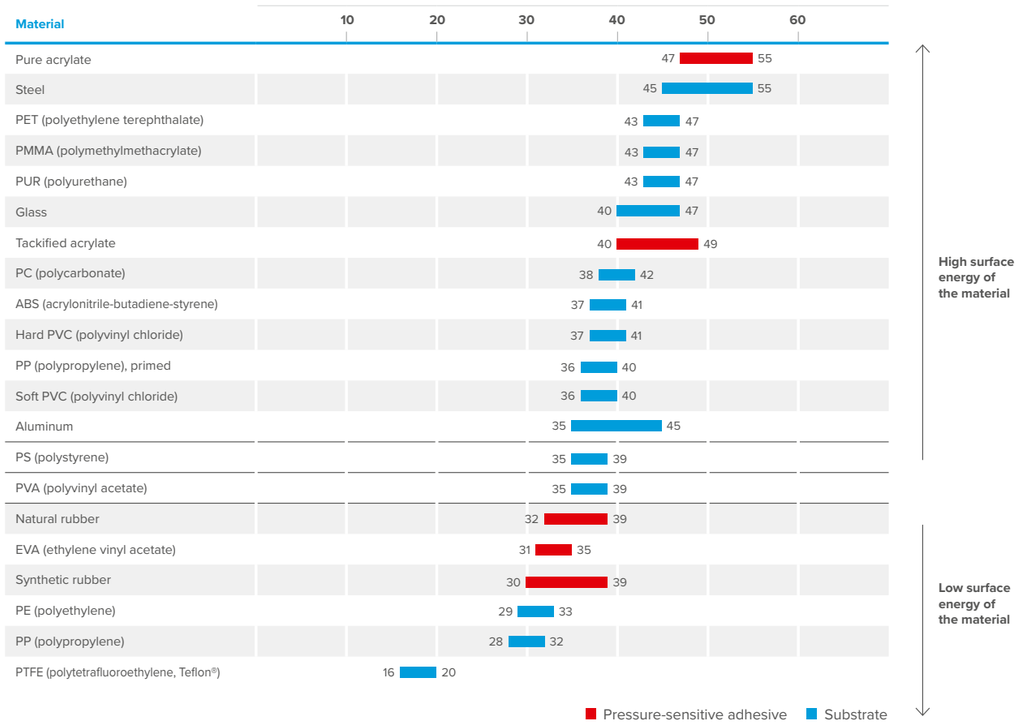
In order to achieve sufficient contact points for the formation of high adhesion forces, the pressure-sensitive adhesive must be able to sufficiently wet the substrate to be bonded. Wetting largely depends on the surface tension or energy of the substrate and the pressure-sensitive adhesive.

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.

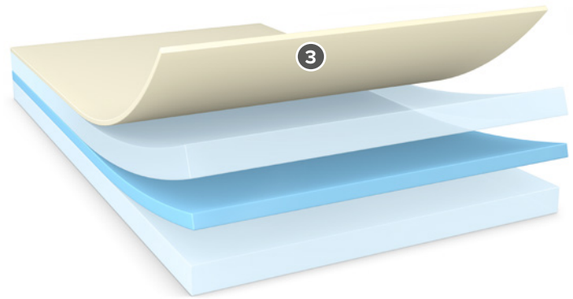
The boundary between low-energy and high-energy surfaces is usually drawn in the range of a surface energy of 36 – 38 mN/m. Therefore, the bondability for surface tensions above this range is usually problem-free, whereas at values below this range a pretreatment of the surface to be bonded should be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

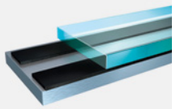
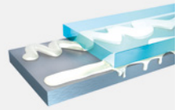
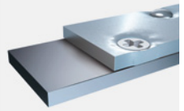
The world of double-sided tapes

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



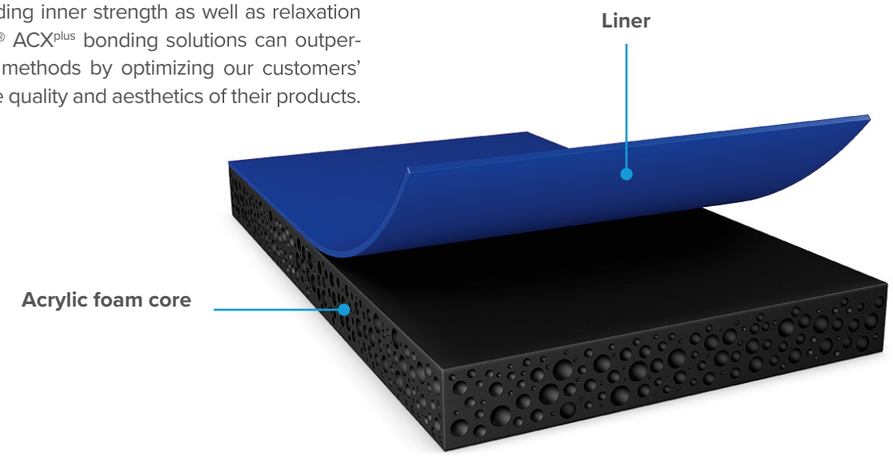
Product overview

Application	Category	Tapes	Page
Mounting solutions	Acrylic core tapes ACXplus	4506x, 707x, 921xx, 6105x, 704x, 705x, 706x, 778xx, 725x, 727x	20
	Double-sided foam tapes	4952, 6293x, 6262x, 45001, 65610, 4957, 649xx, 625xx, 629xx, 636xx, 64956, 64958, 55576, 62455	24
	Double-sided filmic tapes	88665, 49652, 45051, 4968, 4950, 51977, 4965, 59625, 4953, 4945, 4970, 51970, 51966, 51964, 51962, 6462x, 88676	28
	Double-sided non-woven tapes	4914, 58375, 4962, 4959, 58323, 4940, 60975, 60996, 4943, 51570, 51571	32
	Double-sided transfer tapes	74515, 75515, 75507, 75505, 52110, 52105	36
	Double-sided cloth tapes	4964, 4939, 5938, 5939, 4934	40
	Structural Bonding (HAF)	8401, 8410	42

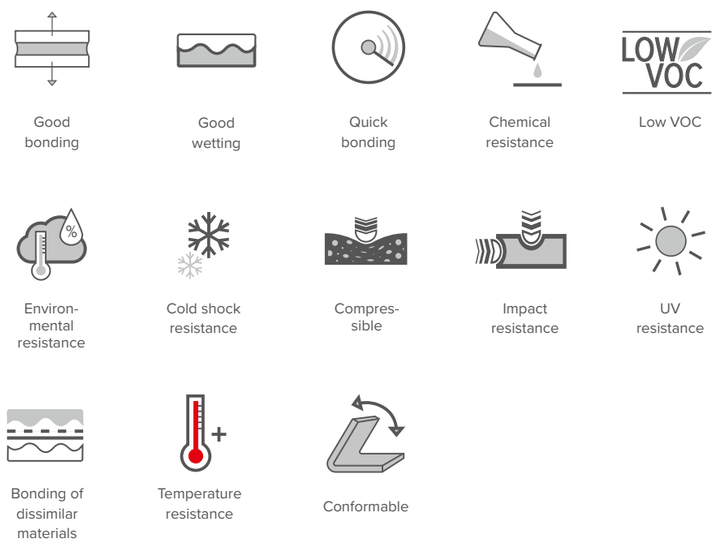


ACX Acrylic core tapes

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



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	
Performance	**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® 705x series	Acrylic foam	Acrylic core	Solid pure acrylic	499 - 3000	○	Glassine Filmic-blue Filmic-white	26.0	Upon request	Upon request	Upon request	High transparent acrylic core tape and ideal for bonding of transparent or translucent materials, such as glass or acrylic. It is suitable for indoor, as well as outdoor applications	
	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*
	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
Commercial	**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	
	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.	

* More information regarding our UL certificate can be found on page 77

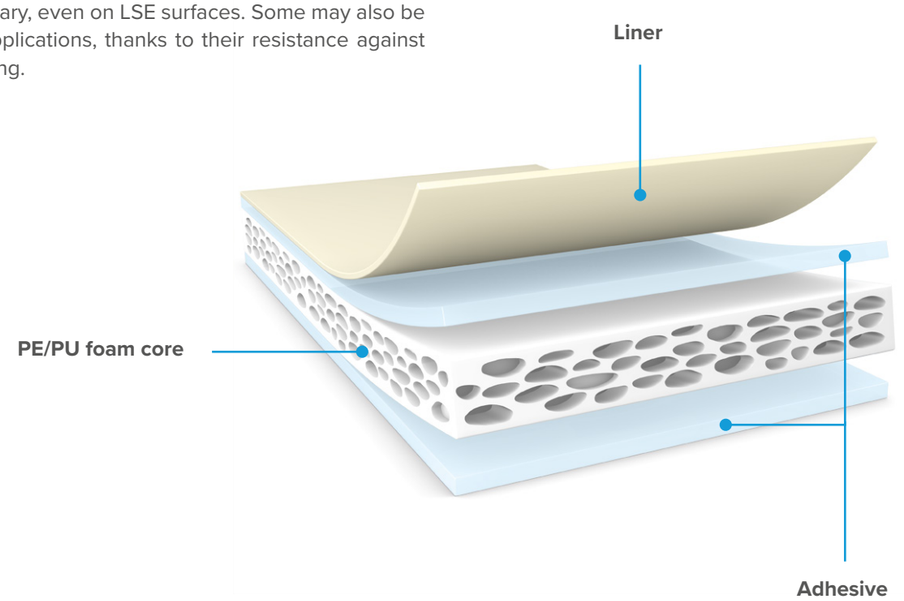
** Product is designed to be low emission to meet the VOC requirements set forth in the JAMA and VDA278 test methods used by automotive OEMs and tier suppliers.



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

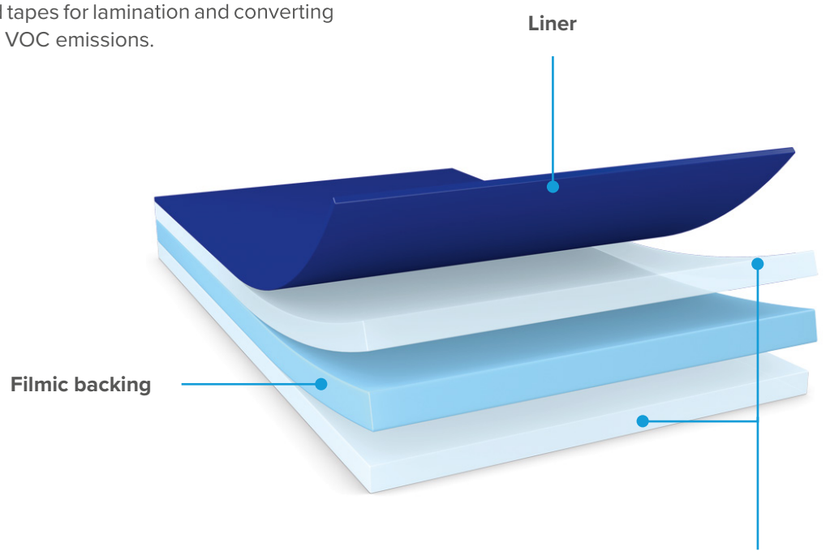
	Product	Description	Backing	Adhesive	Thickness [µm]	Color	Liner	Adhesion to steel – Ultimate [N/cm]	Adhesion to PE – Ultimate [N/cm]	Adhesion to PVC – Ultimate [N/cm]	Temperature resistance short / long term [°C]	Features/ applications	Certificates / test reports / comments
Specialty	tesa® 4952	Double 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*
	tesa® 65610	Double sided Foam tape	PE	Tackified acrylic	1200	○	PET	4.0	Upon request	3.0	80 / 80	One-time removable foam tape for solid surfaces	
Performance	tesa® 4957	Double sided Foam tape	PE	Tackified acrylic	1100	●○	Glassine PP PE	4.0	1.7 (initial) / 2.2 (14 days)	4.0	80 / 80	Tape for general mounting applications.Consists of a highly conformable PE foam backing and a tackified acrylic adhesive.	
	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)	
	tesa® 636xx series	Double sided foam tape	PE	Tackified acrylic	500 - 3000	●○	Glassine PP PE PET	11.0	1.1	11	80 / 80	For versatile mounting applications. Key features are high ultimate adhesion, conformability, and outdoor durability.	
Commercial	tesa® 64956	Double sided foam tape	PE	Synthetic rubber	800	●○	Glassine	15.0	12.0	15.0	60 / 40	High bonding strength even on low surface energy substrates, on rough or uneven surfaces. Multi-purpose tape suitable for hand or automatic application.	
	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.	

* More information regarding our UL certificate can be found on page 77



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 VOC
- Transparent bonding

Double-sided filmic tapes

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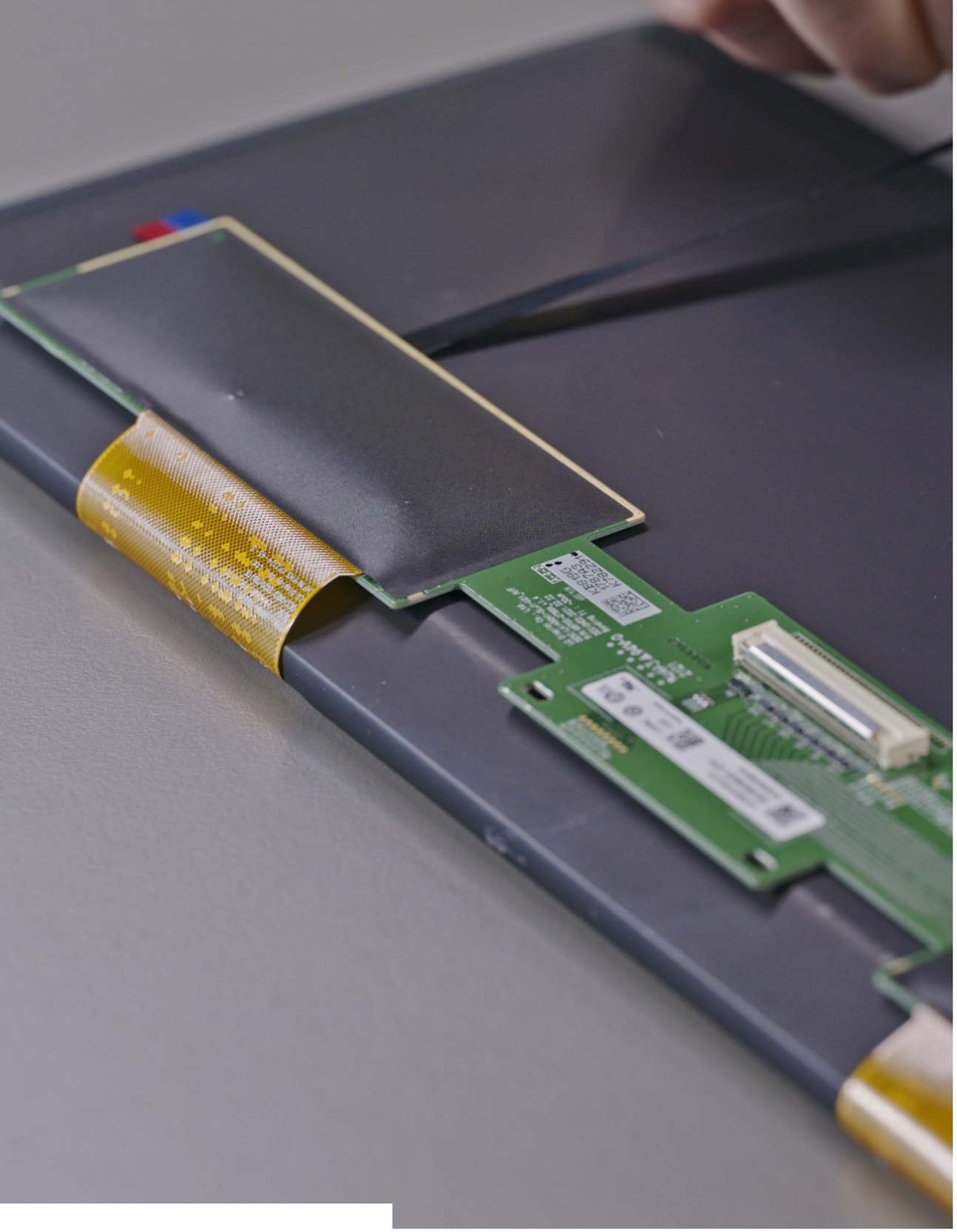
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	Product	Description	Backing	Adhesive	Thickness [µm]	Color	Liner	Adhesion to steel – Ultimate [N/cm]	Adhesion to PE – Ultimate [N/cm]	Adhesion to PVC – Ultimate [N/cm]	Temperature resistance short / long term [°C]	Features/ applications	Certificates / test reports / comments
Specialty	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	UL94 VTM-0*
	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® 45051	Double-sided flame retardant tape	PET	FR tackidied acrylic	200	⊗	MOPP	12.0	Upon request	Upon request	UL 94 V-0	Flame-retardant, halogen-free double-sided PET film tape for permanent mounting on various surfaces, especially in building, elevator, automotive, appliance, marine, and train applications.	
	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® 4950	Double-sided transparent film tape	PET	Tackified acrylic	100	⊗	Glassine PE	7.5	5.0	Upon request	200 / 100	For demanding mounting applications, including LSE substrates. It offers strong tack and high shear strength.	
	tesa® 51977	Double-sided film tape	PP	Tackified acrylic	240	◯	Glassine	12.8	8.0	13	120 / 60	For mounting and fixing applications. It offers high tack and secure bonding on critical and rough surfaces.	
Performance	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 / 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**
	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**
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	
	tesa® 6462x series	Double-sided film tape	PP	Synthetic rubber	90 - 185	⊗◯	Glassine	12.0	Upon request	Upon request	80 / 40	For general purpose fixing and mounting applications and offers high tack, good immediate adhesion, and reliable handling.	
	tesa® 88676	Double-sided transparent film tape	PET	Tackified acrylic	170	⊗	PE-coated paper	13.5	9.0	Upon request	150 / 95	For permanent bonding on LSE and hard-to-bond materials, without primer.	

* More information regarding our UL certificate can be found on page 77

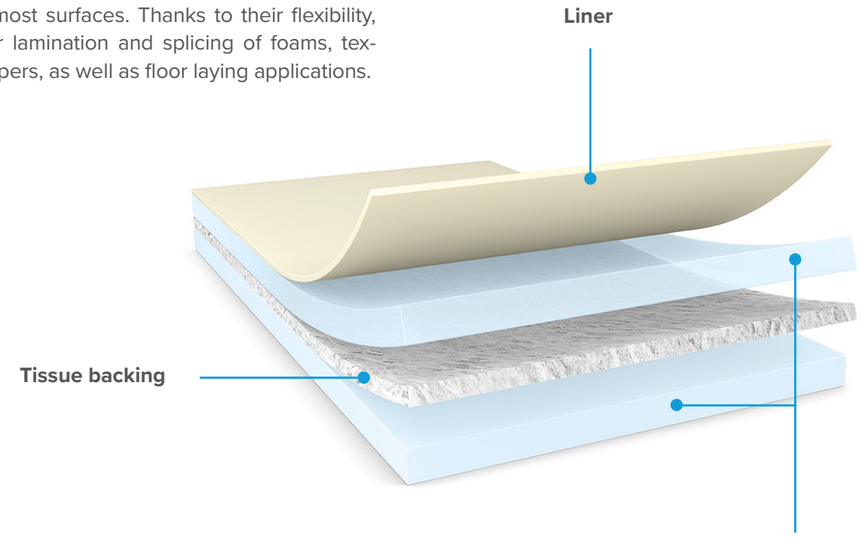
** Product is designed to be low emission to meet the VOC requirements set forth in the JAMA and VDA278 test methods used by automotive OEMs and tier suppliers.



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
- Low VOC
- Conformable
- Good for lamination
- Hand tearable
- Good die-cutting

Double-sided non-woven tapes

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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	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® 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).
Performance	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.	
	tesa® 4940	Double-sided	Non-woven	Tackified acrylic	160	⊗	PE-coated paper	10.3	3.3	Upon request	150 / 80	High adhesion level on various kinds of foams, plastic and metal surfaces. Excellent temperature resistance performance. Good repulsion resistance.	
	tesa® 60975	Double-sided	Non-woven	Tackified acrylic	100	⊗	PE-coated paper	7.7	3.5	Upon request	150 / 80	Good adhesion values on polar substrates. Good temperature resistance performance. For lamination of foam and felt and mounting of nameplates.	
	tesa® 60996	Double-coated tissue tape	Non-woven	Tackified acrylic	130	⊗	PE-coated paper	11.5	3.7	Upon request	Upon request	Excellent wetting property on different kinds of foam and felt material. For lamination of foam and feltand applications requiring very high bonding strength.	
Commercial	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.	
	tesa® 51570	Double-sided	Non-woven	Synthetic rubber	110	⊗	Glassine	12.5	6.2	11	80 / 40	The thick layer of adhesive bonds well on uneven surfaces and has a very high initial bond. For general purpose mounting.	
	tesa® 51571	Double-sided	Non-woven	Synthetic rubber	160	⊗	Glassine	12.7	8.2	12.5	80 / 40	Bonds extremely well on uneven surfaces. Very high initial bond. Used for permanent mounting of metal and plastic materials, e.g. aluminium, polystyrene, ABS.	

* More information regarding our UL certificate can be found on page 77

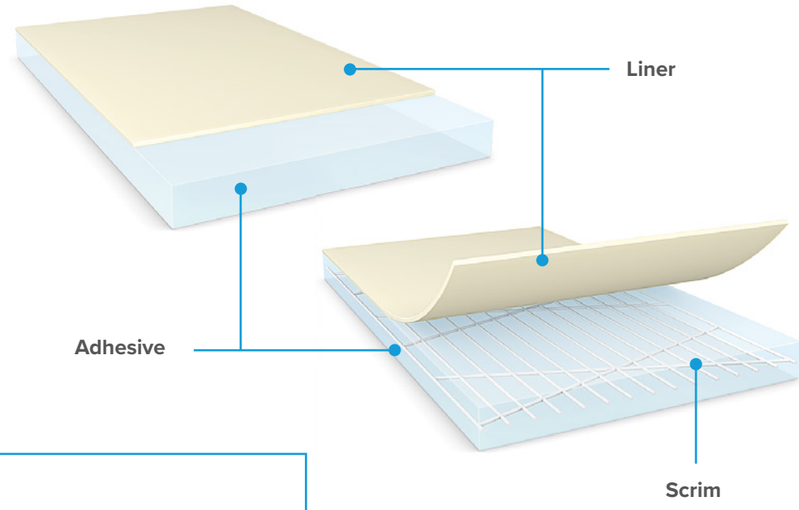
** Product is designed to be low emission to meet the VOC requirements set forth in the JAMA and VDA278 test methods used by automotive OEMs and tier suppliers.



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 VOC
- Transparent bonding

Double-sided transfer tapes

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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	Certificates / test reports / comments
Specialty	tesa® 74515 NEW	LSE transparent transfer tape	None	Tackified acrylic	125	⊗	PE-coated PET	9.0	5.5	Upon request	200 / 100	Primerless bonding to plastics and coated surfaces. Thick adhesive adapts to surface irregularities. For long-term mounting on hard-to-bond materials e.g. gaskets, molded components.	Low VOC: Tested to VDA 278 for cleaner indoor air.** UL Certification: In accordance with UL standard 969. UL file: MH 18055.*
Performance	tesa® 75515	High shear double-sided 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-sided transfer tape	None	Tackified acrylic	75	⊗	Glassine PET PE-Coated Paper	11.0	4.5	13.0	200 / 100		
	tesa® 75505	High shear double-sided 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		

* More information regarding our UL certificate can be found on page 77

** Product is designed to be low emission to meet the VOC requirements set forth in the JAMA and VDA278 test methods used by automotive OEMs and tier suppliers.



Double-sided cloth 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 in many cases suitable for 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 for floor-laying applications.



Main features

Chemical resistance · Conformable · Good for lamination · Quick bonding · Hand tearable

	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
Specialty	tesa® 4964	Double-sided	Cloth	Natural rubber	390	○	Glassine	7.5	5.3	6.9	110 /	The adhesive has a high coating weight making it well suited for mounting applications on irregular surfaces. Can be removed in most cases without leaving adhesive residues from sound surfaces.
	tesa® 4939	Double-sided	Cloth	Synthetic rubber	235	○	Glassine	6.5	2.2	Upon request	80 / 40	Combines high initial bonding power with residue free removability up to 14 days from the most common surfaces. (Needs to be tested individually!)
Performance	tesa® 5938	Double-sided	Cloth	Synthetic rubber	190	●	Glassine	11.0	Upon request	Upon request	80 / 60	Very good initial adhesion to a wide variety of substrates. Excellent conformability due to flexible and strong PET-cloth backing.
	tesa® 5939	Double-sided	PET cloth	Synthetic rubber	190	○	Glassine	14.0	Upon request	Upon request	80 / 60	Very good initial adhesion to a wide variety of substrates. Excellent conformability due to flexible and strong PET-cloth backing. Good hand tearability.
Commercial	tesa® 4934	Double-sided	Cloth	Synthetic rubber	200	○	Glassine	19.5	8.2	18.2	60 / 40	Due to the flexible fabric backing and the high coating weight it is particularly suited for mounting on rough, fibrous surfaces, for example carpet laying.



Structural bonding (HAF)

At room temperature tesa® HAF products are not tacky. They are activated for pre-lamination by heat and start to become tacky at 90 °C. In a second application step heat and pressure is applied over a certain period of time. It is suitable for bonding of all thermally resistant materials such as metal, glass, plastic, wood and textiles.



Main features

- Strong bonding strength
- Temperature resistance
- Chemical resistance
- Resistance against oil and solvents
- Bonds remain flexible and elastic

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® 8401	Heat reactive structural bonding film	None	Nitrile rubber / phenolic resin	200	Amber	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	Heat reactive structural bonding film	None	Nitrile rubber / phenolic resin	60	Amber	Glassine	12 N/mm²	Upon request	Upon request	Upon request	



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

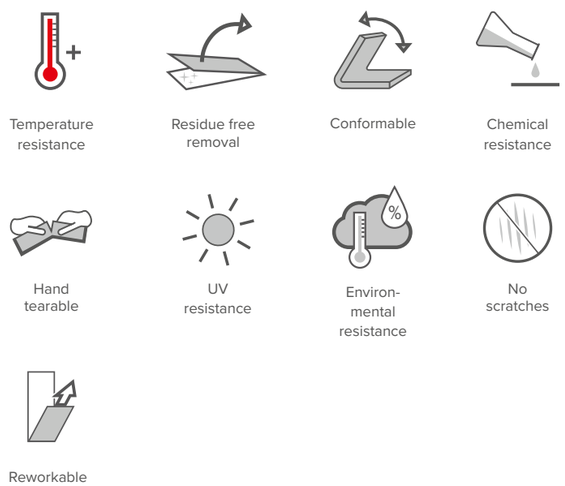
Our tapes with a paper or film backing have a low elongation and are therefore perfect when straight paint edges are required, for example, for two-tone applications. Due to their good quick-stick properties, the paper masking tapes can also be used to securely fix masks that protect surrounding areas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

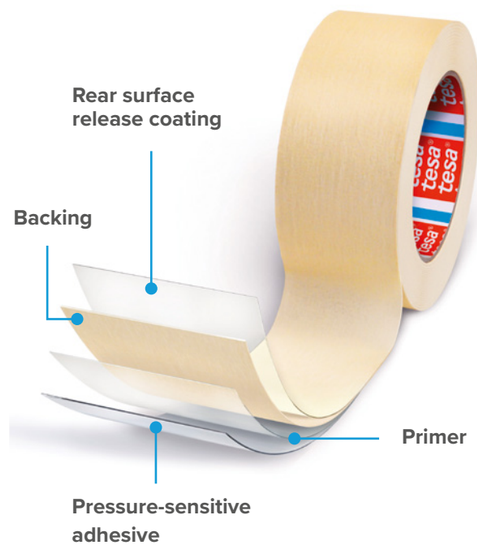
Surface protection tapes are essential tools in various industries, designed to shield surfaces from potential damage during manufacturing, transportation, or storage. Temporary adhesive surface protection tapes are ideal for short-term applications, providing a barrier against abrasions, debris, and 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

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	Product	Description	Backing	Adhesive	Thickness [µm]	Adhesion to steel [N/cm]	Temperature resistance [°C/30 min.]	Tensile Strength [N/cm]	Elongation at break [%]	Features/applications
Specialty	tesa® 4174	Fineline	PVC	Natural rubber	110	3.7	150	25	200	Fineline tape for design painting in the automotive industry, most suitable for curved designs
	tesa® 4319	Paper masking	Highly-creped paper	Natural rubber	375	4.5	<120	24	58	High creped backing for taping curves & 3D objects
	tesa® 4331	Paper masking	PET / non-woven	Silicone	110	4.0	180	53	100	Special laminate for high tear resistance & no curling
	tesa® 4334	Paper masking	Washi paper	Acrylic	90	1.8	150	30	Upon request	High grade painting tape with balanced, constant adhesive strength for highly reliable adhesion - very supple and easy to remove.Outdoor up to 6 weeks
	tesa® 4341	Paper masking	Slightly-creped paper	Natural rubber	190	4.7	120-160	53	13	Temperature-resistant masking tape, ideal for demanding masking tasks during spray painting can be used with various surfaces like metal, rubber, glass, and plastic
	tesa® 51407	Filmic masking	Polyimide	Silicone	62	2.5	260	40	35	Masking during powder-coating processes where the tape enables sharp color edges and offers excellent paint anchorage. 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	3.4	<100	38	10	The fine crepe paper backing, which is extremely flexible and conformable, and a natural rubber adhesive system. The adhesive features good adhesive power to various surfaces, as well as challenging surfaces such as painted metal or rubber.
	tesa® 4338	Paper masking	slightly-creped paper	natural rubber	145	3,5	120	43	13	The smooth green paper backing offers high visibility, excellent handling and conformability, clean paint edges, and good quick stick with clean removal after drying cycles up to 120 °C. It is designed for demanding paint masking applications, especially spray painting with oven drying, and is suitable for transportation applications such as marine, train, and truck.
	tesa® 4434	Paper masking	Flat paper	Natural rubber	670	3.5	100	180	6	High Grade Paper Stencil Masking Tape for Sandblasting, Protection and Reinforcement
	tesa® 5008	Paper masking	Slightly-creped paper	Natural rubber	140	2.6	80	29	6	Provides good conformability, while the natural rubber adhesive offers good adhesion to multiple surfaces, good tack, and reliable paint anchorage. The tape is hand-tearable, suitable for oven drying up to 80 °C, and designed for light-duty spray painting as well as general masking, holding, sealing, and fixing applications.
	tesa® 5010	Paper masking	slightly-creped paper	Natural rubber	140	3,5	100	27	6	The bright yellow paper backing ensures good visibility and conformability, while the tape offers good adhesion, tack, hand-tearability, high tear resistance, clean removal, and reliable paint and filler anchorage. It is designed for performance spray painting and general masking as well as holding, sealing, fixing, and color coding, with oven drying resistance up to 100 °C.
	tesa® 5012	Paper masking	slightly-creped paper	Natural rubber	140	3,2	3,2	35	6	The tape offers good conformability, adhesion, tack, excellent paint anchorage, hand-tearability, clean removal, and suitability for high drying temperatures. It is designed for spray painting with elevated drying temperatures and general masking, as well as holding, sealing, fixing, and color coding; the Expert variant is also suitable for transportation applications.
	tesa® 50600	Filmic masking	PET green	Silicone	80	4.0	220	75	110	Suited for masking off areas that are to be protected during powder-coating processes

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Masking

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	Product	Description	Backing	Adhesive	Thickness [µm]	Adhesion to steel [N/cm]	Temperature resistance [°C/30 min.]	Tensile Strength [N/cm]	Elongation at break [%]	Features/applications
Performance	tesa® 50650	Filmic masking	PET blue	Silicone	55	3.3	220	50	120	Suited for masking off areas that are to be protected during powder-coating processes
	tesa® 4323	Paper masking	Slightly-creped paper	Natural rubber	125	3	80	33	10	The tape offers good conformability, adhesion to multiple surfaces, tack, paint anchorage, hand-tearability, and suitability for light spray painting with oven drying up to 80 °C. It is designed for light spray painting and general masking, as well as holding, sealing, and fixing.
	tesa® 4432	Paper masking	Flat paper	Natural rubber	330	8.0	100	93	6	Ultra sharp paint lines and no rework
	tesa® 4342	Paper masking	Washi paper	Acrylic	85	1.5	150	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
Commercial	tesa® 4349	Paper masking	Slightly-creped paper	Natural rubber	110	2.0	Upon request	33	10	The creped paper backing provides good conformability, while the tape offers good adhesion and tack on various surfaces such as metal, glass, and rubber. It is a versatile solution for general applications including marking, holding, sealing, fixing, and light packaging.
	tesa® 5006	Paper masking	Slightly-creped paper	Natural rubber	120	2.7	60	23	6	The tape offers good conformability, adhesion to multiple surfaces, tack, hand-tearability, and suitability for light spray painting with oven drying up to 60 °C. It is designed for light spray painting, multi-purpose masking, holding, sealing, and fixing.
	tesa® 50620	Filmic masking	PET green	Silicone	70	3.6	200	75	110	Suited for masking off areas that are to be protected during powder-coating processes
	tesa® 50625	Filmic masking	PET	Silicone	50	3.2	200	50	130	The tape offers residue-free removal, good conformability, a thin backing for sharp paint edges, and heat resistance up to 200 °C for 30 minutes due to its silicone adhesive. It is designed for masking in powder coating processes, protecting areas during high-temperature processes, surface protection, and bonding on non-polar materials.

Surface protection

	Product	Description	Backing	Adhesive	Thickness [µm]	Adhesion to steel [N/cm]	Tensile strength [N/cm]	Elongation at break [%]	Features/ applications
Temporary									
Specialty	**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
Performance	**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
	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.
Commercial	**tesa® 4921**	Temporary protection	PE film / LDPE	Acrylic	35	0.8	6	200	The film is translucent blue, easy to apply by hand, weather- and UV-resistant for up to 6 months, and removes cleanly without tearing or residue. It is designed for temporary protection of window glass during construction as well as aluminum and PVC profiles.

	Product	Description	Backing	Adhesive	Thickness [µm]	Color	Liner	Adhesion to steel [N/cm]	Temperature Resistance [°C/30 min.]	Tensile strength [N/cm]	Features/ applications
Permanent											
Specialty	**tesa® 52995**	Permanent protection	Top coated PU-Film	Pure acrylic	330 / 280	Optically clear	PET	Upon request	90	>60	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 e.g.
	tesa® 52994	Permanent protection	PU-film	Pure acrylic	360 / 260 / 187	Optically clear	PET	Upon request	90	>60	
	tesa® 51206	Permanent protection	PE-UHMW	Pure acrylic	114	⊗	Glasine	4.3	90	43	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 gliding propoerties



Repairing solutions

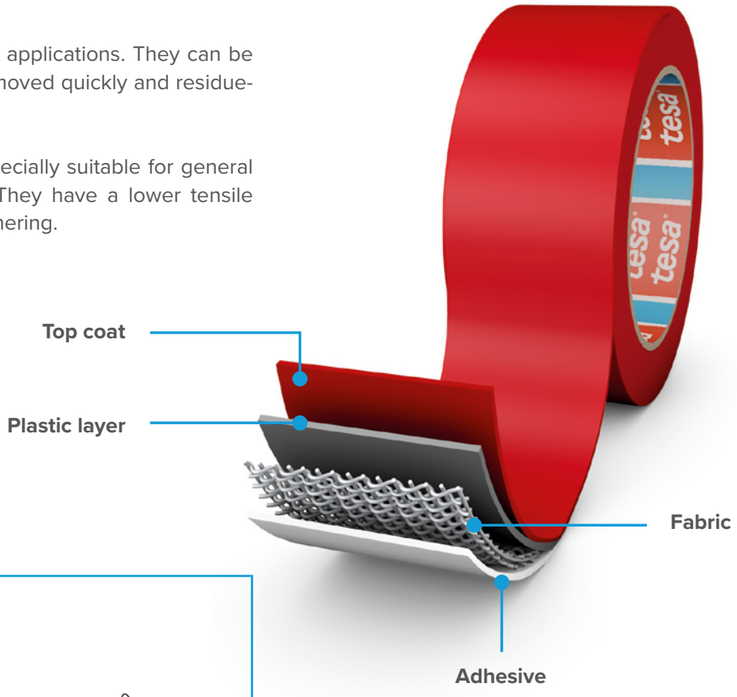
Cloth tapes

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.

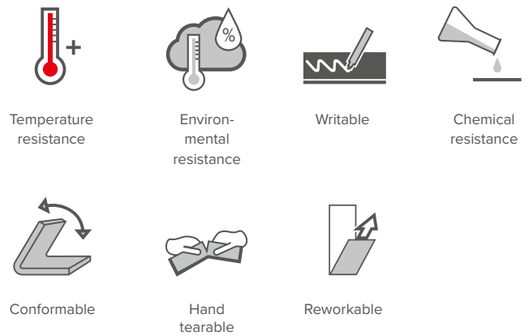
Specialties and Premium tapes: For sophisticated applications with a high level of properties: highly temperature- resistant, excellent abrasion resistance, and straight longitudinal and horizontal tear edges.

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

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	Product	Description	Backing type	Adhesive	Thickness [µm]	Color	Mesh [#/inch²]	Liner available	Temperature resistance [°C]	Clean removable	Abrasion resistance	For rough surface	Sustainability	Features/ applications
Specialty	tesa® 4541	Uncoated cloth	Uncoated cloth	Natural rubber	270	● ○	145	No	130	Yes	●●●	●●●●	> 80% bio-based	It offers good adhesion on rough and oily surfaces, conforms without creasing, and is easy to write on. It is used for protective gear, reinforcement, and fastening applications.
	tesa® 4651	Alrounder	Acrylic coated cloth	Natural rubber	310	● ○ ● ● ● ● ●	145	Glassine	130	Yes	●●●●	●●●●	> 60% bio-based	It offers high abrasion resistance, high tensile strength, strong adhesion, high tack, and precise hand tearability. It is used for masking, bundling, reinforcing, sealing, labeling, and color coding.
	tesa® 4657	High temperature	Acrylic coated cloth	Natural rubber	290	● ●	145	Glassine	180	Yes	●●●●	●●●●	> 60% bio-based	It offers high strength, strong adhesion, and resistance to heat, paints, solvents, abrasion, and water. It is used for heat-resistant masking, hole covering, cable fastening, and splicing.
	tesa® 4660	Printable	Acrylic coated cloth	Natural rubber	260	● ●	145	Glassine	180	Yes	●●●●	●●●	> 60% bio-based	It offers high adhesion, residue-free removal, excellent printability, high temperature resistance, and very high tensile strength. It is used for wire and cable marking, labeling, bundling, and identification in electrical applications.
Performance	tesa® 4671	Neon gaffer	Acrylic coated cloth	Natural rubber	280	● ○ ● ● ● ●	120	No	140	Yes	●●●	●●●	> 50% bio-based	It offers high adhesion, residue-free removal, and reflective neon colors. It is used for gaffer work, stage marking, covering sharp edges, and indoor event applications.
	tesa® 4688	Robust starter	PE-extruded cloth	Natural rubber	260	● ○ ● ● ● ● ●	55	No	110	Yes	●●●	●●●	No	It offers strong adhesion, waterproofness, and easy unwinding. It is used for marking, masking, surface protection, bonding films, and bundling cables.
	tesa® 60462	Heavy-duty duct tape	PE-laminated cloth	Synthetic rubber	215	● ●	27	No	60	No	●●●●	●●●●	> 30% recycled	It offers strong adhesion, easy handling, hand tearability, water repellency, and high durability. It is used for sealing, fastening, masking, and surface protection.
Commercial	tesa® 4615	PCR duct tape	PE-laminated cloth	Hotmelt SR	175	● ●	27	No	60	No	●●	●●	> 30% recycled	It offers high adhesion, easy hand tearability, and water-repellent durability. It is used for holding, fastening, bundling, sealing, marking, and masking.
	tesa® 4687	Cloth tape	PE-extruded cloth	Natural Rubber	260	● ○ ●	55	No	80	Yes	●●●	●●●	No	It offers strong hold, weather resistance, and easy handling. It is used for masking, attaching protective films, bundling wires, and temporary fastening.
	tesa® 53949	Matt gaffer tape	PE-extruded cloth	Natural Rubber	310	● ○ ●	80	No	125	Yes	●●●	●●●●	No	It offers a non-reflective surface, good adhesion, abrasion resistance, and easy removal. It is used for stage work, cable fixing, covering shiny surfaces, sealing joints, and floor marking.

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

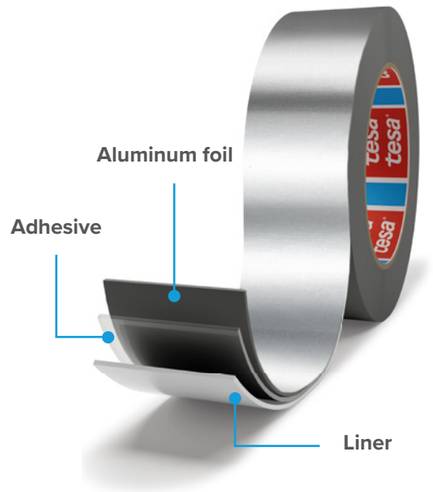


Aluminum tapes

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.

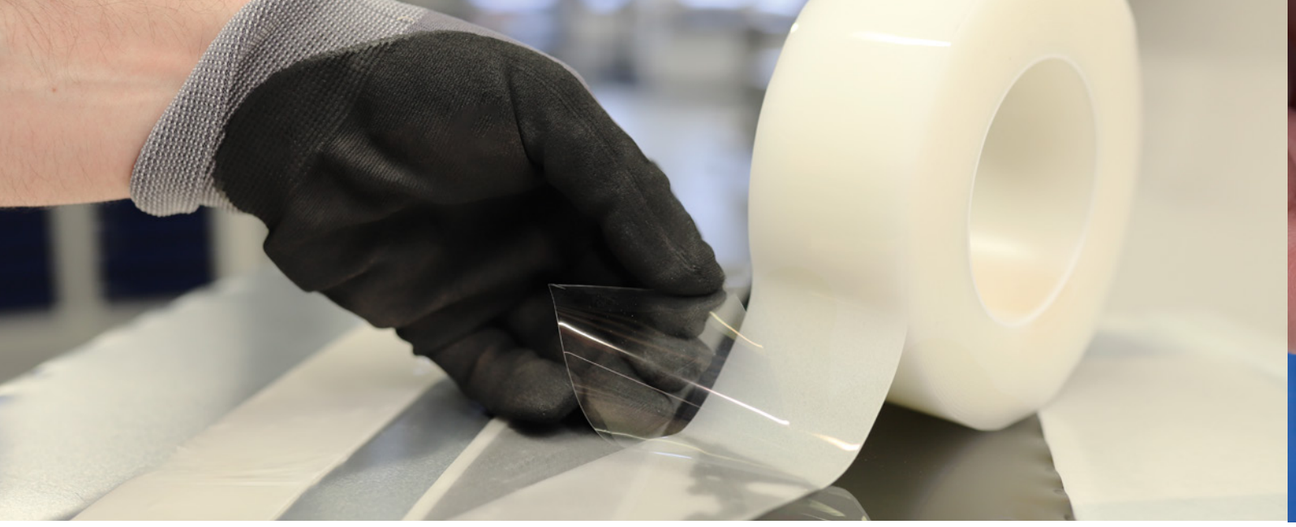


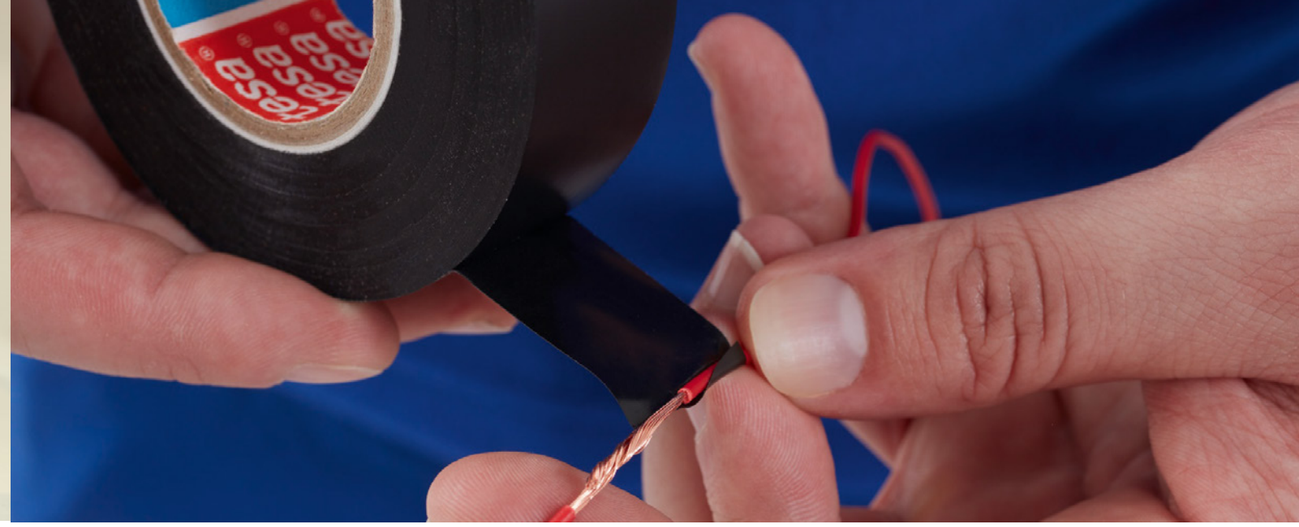
Main features

Temperature resistance · Environ-mental resistance · Writable · Chemical resistance · Hand tearable · Thermal conductivity · Conformable

	Product	Description	Backing	Adhesive	Thickness [µm]	Color	Adhesion to steel – Ultimate [N/cm]	Adhesion to PE – Ultimate [N/cm]	Adhesion to PVC – Ultimate [N/cm]	Tensile strength [N/cm]	Features/applications	Certificates / test repots / comments
Specialty	tesa® 60670	Aluminum tape	Aluminum foil	Acrylic	125		10	5.5	7	60	It is stable, easy to unwind, and suitable for permanent applications. It is used for repairs, sealing insulation, and conductive or heat-reflective applications.	• DIN 4102 B1 and UL 510A*
	tesa® 60672	Aluminum tape	Aluminum foil	Acrylic	125		10	6	4	60	It is stable, easy to handle, and suitable for permanent applications. It also offers barrier properties, conductivity, and reflectivity.	• DIN 4102, class B1 and UL 510A and UL723*
Performance	tesa® 60650	Aluminum tape	Aluminum foil	Acrylic	90		9	4.5	6	40	It is stable, conformable, and suitable for permanent applications. It is used for mounting, sealing insulation, and conductive or heat-reflective applications.	• DIN 4102, class B1 and UL 510A*
	tesa® 60652	Aluminum tape	Aluminum foil	Acrylic	90		9	5	6	40	It is stable, conformable, and easy to handle. It is used for mounting, sealing insulation, and conductive or heat-reflective applications.	• DIN 4102, class B1 and UL510A and UL723*
Commercial	tesa® 60630	Aluminum tape	Aluminum foil	Acrylic	65		8	4	5.5	25	It is conformable, easy to unwind, and suitable for permanent applications. It is used for mounting, sealing insulation, and conductive or heat-reflective applications.	• DIN 4102, class B1 and UL 510A*
	tesa® 60632	Aluminum tape	Aluminum foil	Acrylic	65		8	4	6	25	It is conformable, easy to handle, and suitable for permanent applications. It is used for mounting, sealing insulation, and conductive or heat-reflective applications	• DIN 4102, class B1 and UL 510A*

* More information regarding our UL certificate can be found on page 77





Complementary repair solutions

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Repair and seal

	Product	Description	Backing	Adhesive	Thickness [µm]	Color	Liner	Adhesion to steel – Ultimate [N/cm]	Adhesion to PE – Ultimate [N/cm]	UV resistance (weeks)	Tensile strength [N/cm]	Features/applications
Specialty	tesa® 54411	High performance sealer	Ionomer film	Acrylic	1100	⊗	Siliconised PET	11	Upon request	104	35	For fast and durable sealing of joints, seams, rivets, and plastic repairs. Highly conformable, instantly bonding, paintable, and PFAS-free.
Performance	tesa® 4646	Greenhouse repairing tape	PE film	Acrylic	180	⊗	No	4.4	2.1	52	45	Transparent tape for fast and durable greenhouse film repair. Excellent UV and weather resistance for permanent outdoor use.
Commercial	tesa® 4648	Repairing tape for silage cover films	PE film	Natural rubber	120	●	No	2.2	1.5	52	20	Reliable tape for repairing and sealing damaged silage cover films. Instant bond, hand-tearable, weather-resistant, and recyclable.

Electrical insulation

	Product	Description	Backing	Adhesive	Thickness [µm]	Color	Adhesion to steel – Ultimate [N/cm]	Tensile strength [N/cm]	Features/applications	Certificates / test repots / comments
Performance	tesa® 4251	Multipurpose soft PVC tape	PVC film	Natural rubber	200	●○●●●●⊗	1.6	27.4	A flexible soft PVC tape with good adhesion to many surfaces. It is ideal for electrical installation, repairing, splicing, bundling, marking, and color-coding.	
Commercial	tesa® 51608	PET fleece tape	PET fleece	Rubber based	280	●	3	40	Noise-damping tape for flexible wire harnessing in the passenger compartment. Abrasion-resistant, hand-tearable, and highly adhesive for durable performance.	
	tesa® 53988	PVC insulation tape	Soft PVC	Natural rubber	150	●○◐●●◐◑	2.5	25	High dielectric strength up to 7,000 V for reliable electrical insulation. Heat-resistant up to +90°C, ensuring dependable performance in demanding environments.	• VDE, IMQ, SEMKO, IEC 60454-3-1





Floor marking

	Product	Description	Backing	Adhesive	Thickness [µm]	Color	Adhesion to steel – Ultimate [N/cm]	Tensile strength [N/cm]	Features/applications
Specialty	tesa® 4169	Premium soft PVC floor marking tape	Soft PVC	Acrylic	187	●○●●●●●	2	42.5	Durable and abrasion-resistant floor marking tape for high-traffic areas. Flexible for curved applications and available in safety colors for workshops, warehouses, and factories.
	tesa® 60960	Durable and scratch-resistant floor marking tape	PET film	Synthetic rubber	175	●○●●●●●	4.5	175	Premium floor marking tape for permanent use in high-traffic and heavy-duty areas. Bright, long-lasting colors ensure high visibility and withstand forklift traffic.
Commercial	tesa® 60760	Floor marking tape	Soft PVC	Natural rubber	150	○●●●●●	2	33	Flexible floor marking tape for temporary marking in high-traffic areas. Durable, hand-tearable, and available in safety colors for clear workplace organization.

Anti slip tapes

	Product	Description	Backing	Adhesive	Thickness [µm]	Color	Adhesion to steel – Ultimate [N/cm]	Tensile strength [N/cm]	Chemical resistance	Features/applications	Certificates / test repots / comments
Specialty	tesa® 60955	Conformable anti-slip tape for irregular surfaces	Aluminum carrier coated with mineral particles	Acrylic	750	●●●	8	60	Good	Conformable anti-slip tape for irregular surfaces requiring secure footing. Strong visibility, reliable adhesion, and resistance to chemicals, weather, and temperatures up to 120°C.	• Slip resistance R13 according to DIN 51130. Aerospace-certified, Airbus approval according to AIMS/AIPS 10-08-004-01 and ABS 5092.
	tesa® 60973	Anti-slip tape for permanent indoor and outdoor applications	PVC film	Modified acrylic	900	●	11	30	Good	Durable anti-slip tape with strong adhesion and long-lasting abrasive particles for reliable grip. Ideal for industrial areas, walkways, and 5S applications where safe footing is required.	• Lateral flame spread certified according to railway standard EN 45545-2/ ISO 5658-2
Performance	tesa® 60943	Anti-slip tape	PVC film	Acrylic	680	●●●●	7.3	29	Good	Durable anti-slip tape with good adhesion and resistance to chemicals and salt water. It is ideal for indoor and outdoor areas where safe footing is required.	
	tesa® 60950	Anti-slip tape	PVC film coated with mineral particles	Acrylic	900	●	5.8	30	Good	Durable anti-slip tape for safe footing indoors and outdoors. Highly resistant to wear, chemicals, and weather, while remaining easy to apply and remove.	• DIN 51130

Packaging products



Filmic packaging products

Secure packaging is the primary requirement to ensure that a product reaches its destination intact. For the recipient, it provides en route protection from a variety of factors. Whether the carton is light or heavy, traveling a short distance by rail or taking a long journey by ship – we have developed our current packaging tape range to meet every requirement for the reliable sealing of cartons.

Our tesa® PVC tapes have been setting the standard in traditional premium packaging tapes for decades. The backing combined with our natural rubber adhesive offers unique material properties such as a smooth haptic, silent unwinding, and printability. This assortment offers high immediate adhesion and high closure safety for medium to heavy cartons.

Our packaging tapes are made from a chlorine-free **BOPP** backing. They are available with either water-based acrylic adhesive for controlled, silent unwinding or rubber adhesive when easy unwinding is required. They are suitable for light- to heavy-weight packages.

Packaging tape dispensers

Packaging tape dispensers are typically used in the commerce industry to close carton boxes. As already mentioned, packaging tape can be put into either handheld tape dispenser guns or automatic tape dispensers. It depends on what you intend to use it for and how much space you have. Tape dispensers for packaging feature a sharp edge to cut the tape.





Filmic packaging tapes

	Product	Description	Backing	Adhesive	Thickness [µm]	Color	Adhesion to steel – Ultimate [N/cm]	Tensile strength [N/cm]	Elongation at break (%)	Manual application	Automatic application	Features/applications
Specialty	tesa® 4122	Heavy duty carton sealing tape	PVC film	Natural rubber	88	● ○ ● ● ● ● ● ⊗	2.0	65	100	Yes	Yes	Strong packaging tape for securely sealing very heavy cartons and hazardous goods. High tensile strength and shock resistance ensure reliable performance during transport and handling.
	tesa® 64007	Tamper-evident carton sealing tape	BOPP	Water-based acrylic	62	● ●	2.8	42.0	150	Yes	Yes	Security packaging tape that helps reduce pilferage during transport and storage. Ideal for sealing cartons containing valuable or confidential goods such as electronics, branded products, tobacco, and documents.
	tesa® 64044	Heavy duty PP packaging tap	PP film	Acrylic	85	⊗	3.5	70	170	Yes	Yes	Heavy-duty packaging tape for securely sealing cartons over 30 kg and hazardous goods.Temperature- and ageing-resistant, ensuring reliable performance in manual and automated applications.
Performance	tesa® 4012	General purpose polypropylene carton sealing tape	BOPP	Water-based acrylic	65	● ⊗	2.8	49	170	Yes	Yes	Reliable packaging tape for medium-weight cartons and high-volume sealing applications. Suitable for manual and automated use on all common dispensers and machines.
	tesa® 4120	General purpose packing tape for closing medium-weight ship-ping boxes	PVC film	Natural rubber	49	○ ● ⊗	2	43	75	Yes	Yes	Reliable packaging tape for manual and automated sealing of medium-weight cartons. Strong adhesion, quiet unwinding, and fast bonding ensure efficient packaging operations.
	tesa® 4124	Premium carton sealing tape	PVC film	Natural rubber	65	○ ● ⊗	3.2	60	60	Yes	Yes	Premium packaging tape for securely sealing medium- to heavy-weight cartons. Strong adhesion, high tear resistance, and smooth, quiet unwinding ensure reliable manual and automated application
	tesa® 60404	Colored packaging adhesive film to securely seal boxes	PVC film	Natural rubber	67	● ● ● ● ●	3.6	43	90	Yes	Upon request	Reliable packaging tape with strong adhesion, even on recycled cartons and in demanding environments. Quiet unwinding and long-lasting performance make it ideal for sealing, bundling, and marking applications.
Commercial	tesa® 4011	General purpose polypropylene carton sealing tape	BOPP	Water-based acrylic	52	● ⊗	2.1	Upon request	140	Yes	Yes	Reliable packaging tape for sealing light to medium-weight cartons. Strong initial hold and suitable for manual or automated application.
	tesa® 4089	General purpose carton sealing tape	PP film	Natural rubber	46	⊗	2.2	43	145	Yes	Yes	Packaging tape for light to medium-weight cartons with strong, instant adhesion. Easy to unwind and suitable for manual or automated sealing on a wide range of surfaces.
	tesa® 64014	Low noise packing tape	PP film	Acrylic	45	● ⊗	2.4	35	140	Yes	Upon request	Low-noise packaging tape for sealing light to medium-weight cartons. Durable, age-resistant, and environmentally friendly with reliable long-term adhesion.

Dispenser

	Product	Description	Roll width max	Max roll length	Max. core diameter	Material	Features/applications
Performance	tesa® 6300	Hand dispenser	55 mm	66 m	3	Metal	Ergonomic hand dispenser with adjustable tension control for smooth and reliable tape application. Integrated blade protection ensures safe handling during carton sealing.



Paper packaging tapes

Paper-based adhesive tape solutions: designed for recycling

Our new paper-based adhesive tape solutions can help you to reach your sustainability goals and boost consumer perception. They are designed for recycling while maintaining tape performance. It's not just packaging. It's a future-proofed range.



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	Product	Description	Backing	Adhesive	Thickness [µm]	Color	Adhesion to steel – Ultimate [N/cm]	Tensile strength [N/cm]	Elongation at break (%)	Hand tearability	Automatic application	Features/applications
Specialty	tesa® 4313	High-performance paper carton sealing tape	Paper	Synthetic rubber	107		7.5	60	6	Very good	Yes	More environmentally friendly paper packaging tape for sealing light to medium-weight cartons. Strong adhesion, high tear resistance, and suitable for manual or automated application.
	tesa® 60013	Self-adhesive reinforced paper tape	Paper	Synthetic rubber	210		12	125	6.0	No	yes	High-performance paper tape for securely sealing heavy-duty cartons up to 25 kg. Fiberglass reinforcement provides excellent tear resistance and strong adhesion, even on demanding surfaces.
Performance	tesa® 4513	Superior paper packaging tape	Paper	Synthetic rubber	105		8.5	70	3	Yes	Yes	Strong packaging tape for securely sealing cardboard boxes up to 15 kg. Very high adhesion and initial tack ensure reliable manual and automated application.
	tesa® 60408	Bio-based paper packing tape	Paper	Natural rubber	125		2.8	60	8	Yes	Yes	More sustainable paper packaging tape for sealing cardboard boxes up to 20 kg. Strong adhesion, hand-tearable, printable, and suitable for manual or automated applications.
Commercial	tesa® 4713	Packaging tape with paper from responsible sources	Paper	Natural rubber	125		2.8	30	10	Very good	Yes	More sustainable paper tape for sealing lightweight cartons up to 10 kg, even in demanding and cold environments. Suitable for manual and automated application, with recycling-friendly and bio-based materials.
	tesa® 4903	Packaging tape with paper from responsible sources	Paper	Synthetic rubber	140		5.5	50	2	Very good	Yes	Robust packaging tape with high adhesion for securely sealing lightweight cartons. Printable, and suitable for manual or automated application, even on recycled cardboard.



rPET tapes



Stronger carton sealing. Less plastics. Makes sense.

We understand that today's customers demand more from their packaging solutions. You seek strength and reliability, but also need more - more packaging security, more user comfort, more value for money, and more sustainability. Our adhesive packaging solutions have long been trusted by many different businesses to deliver an outstanding performance. Today, that quality is of the same high standard, but is now achieved with a significant reduction in virgin plastic. So even something as not immediately apparent as packaging tapes can now help contribute towards your own sustainability goals.

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	Product	Description	Backing	Adhesive	Thickness [µm]	Color	Adhesion to steel – Ultimate [N/cm]	Tensile strength [N/cm]	Elongation at break (%)	Hand tearability	Automatic application	Features/applications
Specialty	tesa® 60412	Recycled polyester packaging tape	PET	Water-based acrylic	56	○●⊗	3.0	60	130	Low	Yes	More sustainable packaging tape with a backing made from 90% recycled PET for sealing light to medium-weight cartons up to 30 kg. Strong, tear-resistant, and quietly unwinding, with a recycling-friendly adhesive and printable surface.
Performance	tesa® 60416	Silent recycled polyester packaging tape	PET film	Acrylic	42	○●⊗	3.0	45	100	No	Yes	More sustainable packaging tape for medium-weight cartons up to 30 kg, including hazardous goods packaging. Quiet unwinding, strong adhesion, and a high recycled content ensure reliable and environmentally friendly sealing.
	tesa® 60418	Thin recycled PET packaging tape	PET	Synthetic rubber	36	○●⊗	6.0	38	120	No	Yes	More sustainable packaging tape for sealing light to medium-weight cartons up to 25 kg. Easy to unwind, suitable for automated applications, and made with recycled content and a recycling-friendly adhesive.
Commercial	tesa® 60432	Recycled polyester packaging tape	PET	Water-based acrylic	30	⊗	Upon request	22	120	No	Yes	Versatile packaging tape for sealing lightweight cartons up to 15 kg. Smooth unwinding and suitable for manual or automated application, including printed branding solutions.



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

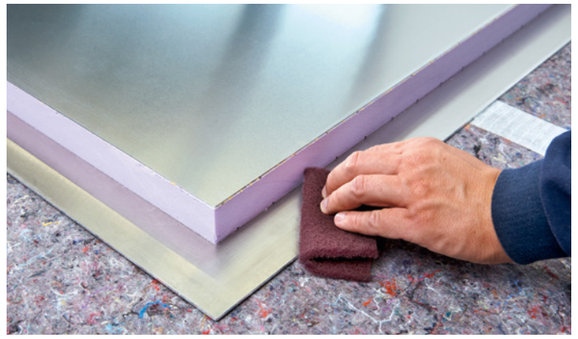


Water-soluble impurities can be removed with water and detergents. Other impurities, for example, oil traces, grease, wax, and release agents, can strongly reduce the bonding capacity of the surface. Special care must be taken to remove such impurities. Suitable solvents for this are:

- **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

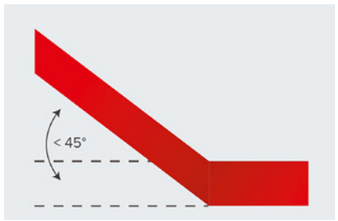


Adhesive remover

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.



Targeted Industries and Application Fields – Inspiration

Industry-specific application overviews

Industry sheets provide a concise overview of the typical applications and requirements within a specific industry. They help illustrate how different use cases are structured in practice and make complex industrial environments easier to understand. This allows you to quickly identify relevant areas and navigate topics efficiently.

Following sides will show examples out of the main Targeted Industries for Tape Specialist Partners:



Transportation



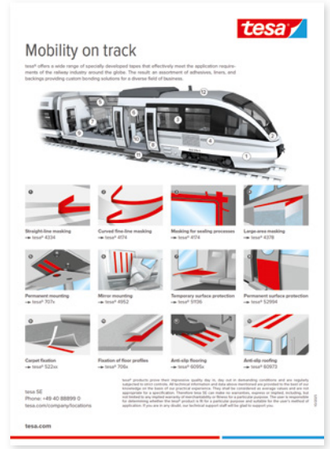
Building industry



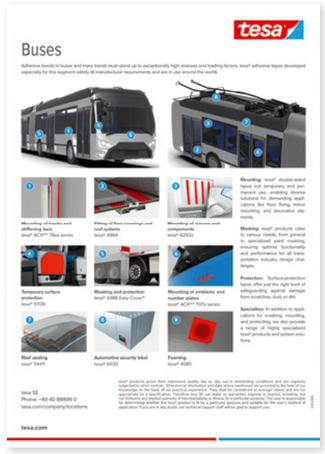
Advertising, events and entertainment

Explore applications across industries

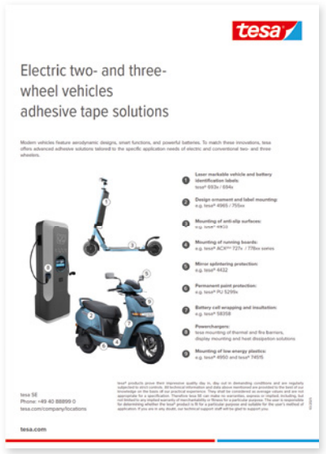
Discover industry-specific application examples designed to provide a clear overview of typical use cases, requirements, and bonding solutions across different market segments. These examples help illustrate relevant application areas and make it easier to identify suitable solutions for specific industry needs.



Railway



Transportation



Two-wheelers



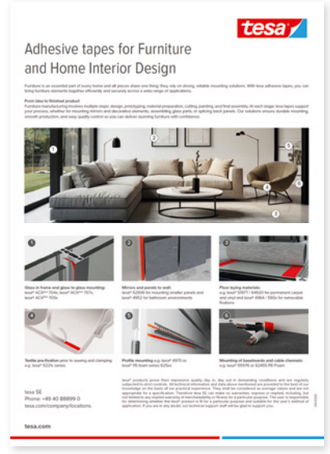
Marine



Advertising, event and entertainment



Building industry



Interior

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 PLATINUM TAPE SPECIALISTS PARTNER

tesa® Platinum Tape Specialists Partner benefits & requirements

Benefits:

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

Requirements:

- Successful local assessment and classification as Platinum Tape Specialists 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

tesa GOLD TAPE SPECIALISTS PARTNER

tesa® Gold Tape Specialists 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 Tape Specialists 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 SILVER TAPE SPECIALISTS PARTNER

tesa® Silver Tape Specialists Partner benefits & requirements

Benefits:

- Sales, marketing and technical support
- Conditional eligibility to participate in sales incentive program - tesa Rewards
- Access to world class adhesive products and solutions

Requirements:

- Successful local assessment and classification as Silver Distributor Partner
- Leads with tesa in specified market(s)/customers
- Investment in tesa through internal trainings, inventory management and/or sales campaigns
- 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

Certificate:

Statement on certificate:

Product iQ | UL Solutions



10/2026

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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