tesa® ACXplus 77615

Product Information

1.5 mm double-sided acrylic foam tape for mounting of automotive exterior parts

Product Description

tesa® ACX^{plus} 77615 is a 1.5 mm double-sided acrylic foam tape with an unique double layer product design, coated with low surface energy (LSE) adhesive on the covered side. Its high-performance LSE adhesive has excellent initial adhesive properties when it comes to different types of OEM clear coats and can reach near ultimate performance right after the application. Even at temperatures down to 5°C, tesa® ACX^{plus} 77615 shows excellent bonding strength on clear coat.

tesa® ACX^{plus} 77615 is specially recommended for mounting of primer-treated attachment parts including ribbed surfaces to difficult to bond clear coats. Thanks to its viscoelastic acrylic foam core, tesa® ACX^{plus} 77615 has the ability to absorb and dissipate dynamic and static loads.

Also available in thicknesses of 0.8 mm and 1.1 mm.

Main features

- Superior peel-adhesion level right after application
- Excellent bonding stability at an application temperature as low as 5°C to the clear coat side
- PFAS / PFOS free Product
- Efficient and robust application at OEM
- Viscoelastic acrylic foam core to compensate for different thermal elongation of bonded parts
- Outstanding wet-out property
- High humidity and UV resistance

Application Fields

tesa® ACX^{plus} 77615 is suitable for a wide range of permanent exterior mounting applications like:

- Body side moldings and decorative trims
- Emblems
- Spoilers
- Antennas
- Pillar appliqués

To ensure the highest performance possible, our aim is to fully understand your application in order to provide the right product recommendation.

For latest information on this product please visit http://l.tesa.com/?ip=77615

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Product Information

Technical Information (average values)

The values in this section should be considered representative or typical only and should not be used for specification purposes.

Product Construction

• Type of liner	PE	• Total thickness	1500 µm
• Backing material	foamed acrylic	• Color	gray
• Type of adhesive	tackified acrylic		

Properties/Performance Values

• Ageing resistance (UV)	good	• Temperature range	-40 to +80 °C
• Humidity resistance	very good	• Temperature resistance long term	80 °C
• Static shear resistance at 90°C	>10,000 minute		

Adhesion to Values

• ABS (initial)	8 N/cm	• Steel (initial)	12 N/cm
• ABS (after 3 days)	13 N/cm	• Steel (after 3 days)	26 N/cm
• ABS (covered side, after 3 days)	33 N/cm	• Steel (covered side, after 3 days)	37 N/cm
• ABS (covered side, initial)	27 N/cm	• Steel (covered side, initial)	31 N/cm

Additional Information

- Static shear resistance tested with 25 mm x 25 mm tape on steel, 200 g weight
- PV 15 = royal blue siliconized HDPE film liner
- Temperature range: values are load dependent

Disclaimer

tesa® products prove their impressive quality day in, day out in demanding conditions and are regularly subjected to strict controls. All information and recommendations are provided to the best of our knowledge on the basis of our practical experience. Nevertheless tesa SE can make no warranties, express or implied, including, but not limited to any implied warranty of merchantability or fitness for a particular purpose. Therefore, the user is responsible for determining whether the tesa® product is fit for a particular purpose and suitable for the user's method of application. If you are in any doubt, our technical support staff will be glad to support you.

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