

# MOUNTING OF SEALS

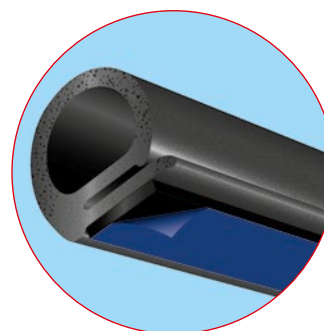
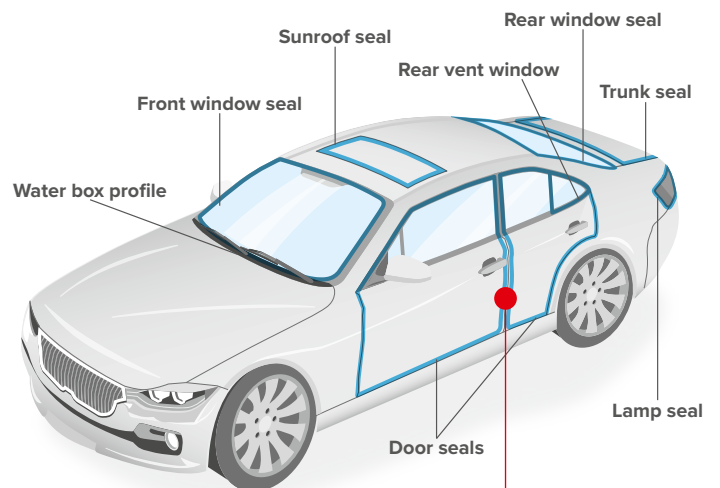
## tesa® ACX<sup>plus</sup> Seal Line – Our Solutions for Door Seals, Sunroof Seals, Weather Strips, and More

Seals are a functional design element for passenger cars. Thanks to the unique viscoelastic feature of acrylic foam tape and our individual adhesive formulation, tesa® ACX<sup>plus</sup> shows excellent performance in temperature and humidity cycle tests according to OEM specifications. It proves to be a reliable and efficient solution for mounting seals onto different areas of the cars.

### Various seals and substrates

Type of seals	Seals mounted to
Door seal	Clear coat
Sunroof seal	Clear coat or E coat
Water box profile	Glass
Window lace	Glass
Obstacle detection system (ODS)	ABS or other plastic

Depending on the machine setup, you can choose between tesa® ACX<sup>plus</sup> Seal Line for the heat lamination process and other product ranges that can be laminated with primer treatment on the seals.



## Product finder

<b>Seal material</b>	EPDM and TPE rubber	EPDM, TPE rubber, and PVC		
<b>Lamination method</b>	Heat lamination without primer	Lamination with tesa® 60153 Adhesion Promoter		
<b>Product</b>	<b>tesa® ACX<sup>plus</sup> Seal Line</b> <ul style="list-style-type: none"> <li>• Efficient and secure bonding of the heat-activatable layer to seals</li> <li>• Outstanding dynamic T-block performance</li> <li>• Superior dynamic and static shear resistance</li> <li>• Strong bonding that withstands humidity and heat</li> <li>• Accurate positioning on seals thanks to the higher rigidity</li> <li>• No lift up on curved surfaces</li> <li>• Deep black color for design flexibility</li> </ul>	<b>tesa® ACX<sup>plus</sup> Black Line</b> <ul style="list-style-type: none"> <li>• High humidity and UV resistance</li> <li>• Excellent cold shock performance</li> <li>• Accurate positioning on seals thanks to the higher rigidity</li> <li>• Deep black color for design flexibility</li> </ul>	<b>tesa® ACX<sup>plus</sup> 776XX Series</b> <ul style="list-style-type: none"> <li>• Excellent performance within the first minute of application on clear coats</li> <li>• Outstanding performance at an application temperature as low as 5°C</li> </ul>	
<b>Thickness of tape</b>	1.2 mm	tesa® ACX <sup>plus</sup> 74512 PV29/28	tesa® ACX <sup>plus</sup> 7812 PV29/28	
	1.1 mm		tesa® ACX <sup>plus</sup> 7811 PV29/28	tesa® ACX <sup>plus</sup> 77611 PV15
	0.8 mm	tesa® ACX <sup>plus</sup> 74508 PV29/28	tesa® ACX <sup>plus</sup> 7808 PV29/28	tesa® ACX <sup>plus</sup> 77608 PV15
	0.5 mm		tesa® ACX <sup>plus</sup> 7805 PV29/28	

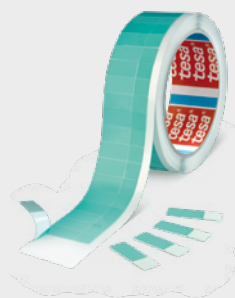
## Complementary solutions

### Tabbing

tesa® 50999  
Heat tabbing film  
for PV28 liner and PV29

tesa® 54999  
Adhesive tabbing tape  
for PV29

tesa® 54988  
Adhesive tabbing tape  
for 771XX PV28 liner



### Adhesion promoter (primer)

tesa® 60153 Fast Cure

- Surface: universal (e.g. PP/EPDM)
- Application techniques: clean the surface and uniformly coat the bonding surface with a felt-tipped applicator
- Drying time: 30 sec. to 5 min. (solvent has to be flashed off)
- Application time: up to 7 days (surface has to stay free of dust)



tesa® products prove their impressive quality day in, day out in demanding conditions and are regularly subjected to strict controls. All technical information and data above mentioned are provided to the best of our knowledge on the basis of our practical experience. They shall be considered as average values and are not appropriate for a specification. Therefore 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. 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.