

## Acrylic Foam Tape Assortment (November 2022)

Product family	tesa® ACX <sup>plus</sup> 772XX Base Line	tesa® ACX <sup>plus</sup> 78XX Black Line	tesa® ACX <sup>plus</sup> 771XX	tesa® ACX <sup>plus</sup> 773XX	tesa® ACX <sup>plus</sup> 776XX	tesa® ACX <sup>plus</sup> 777XX Primerless Line	tesa® ACX <sup>plus</sup> 778XX Primerless Line <sup>1)</sup>	
Product design								
Construction	Single layer	Single layer	Three layers	Two layers	Two layers	Two layers	Three layers	
Construction	Pure acrylic foam	Modified acrylic foam	Pure acrylic foam core with tackified acrylic adhesive	Pure acrylic foam core with acrylic adhesive	Pure acrylic foam core with covered side LSE adhesive	Pure acrylic foam core with open side LSE adhesive	Pure acrylic foam core with both sides LSE adhesive	
Color	Gray	Deep black	Black	Gray	Gray	Gray	Gray	
Thickness [mm]	0.4	tesa® 77204						
	0.5		tesa® 7805				tesa® 77805	
	0.6	tesa® 77206						
	0.8	tesa® 77208	tesa® 7808	tesa® 77108	tesa® 77308 coming soon	tesa® 77608	tesa® 77708	
	1.0	tesa® 77210						
	1.1		tesa® 7811		tesa® 77311	tesa® 77611	tesa® 77711	
	1.2	tesa® 77212	tesa® 7812	tesa® 77112				
	1.5		tesa® 7815	tesa® 77115	tesa® 77315 coming soon	tesa® 77615	tesa® 77715	
2.0		tesa® 7820						
Liner and tabbing	PV31 – white film liner • Thickness: 110 µm • Both sides siliconized • Tabbing solution: 50099 and 50699 adhesive tabbing • Not available for 77204 PV34 – white film liner • Thickness: 80 µm • Single side siliconized (open side) • Tabbing solution: 50699 adhesive tabbing • Available for 77204 and 77208 only PV04 – white PE coated paper liner • Thickness: 140 µm • Both sides siliconized • Available for 77204 only	PV29 – blue film liner • Thickness: 130 µm • Siliconized only on tape side • Tabbing solution: 50999 heat tabbing, 50099, 50988 and 50699 adhesive tabbing PV25 – white paper liner • Thickness: 122 µm • Both sides siliconized	PV28 – blue film liner • Thickness: 160 µm • Silicone free film • Tabbing solution: 50999 heat tabbing, 50988 adhesive tabbing PV26 – white paper liner • Thickness: 160 µm Both sides siliconized	PV15 – blue film liner • Thickness: 100 µm • Both sides siliconized • Tabbing solution: 50699 adhesive tabbing	PV15 – blue film liner • Thickness: 100 µm • Both sides siliconized • Tabbing solution: 50699 adhesive tabbing	PV15 – blue film liner • Thickness: 100 µm • Both sides siliconized • Tabbing solution: 50699 adhesive tabbing	PV15 – blue film liner • Thickness: 100 µm • Both sides siliconized • Tabbing solution: 50099 and 50699 adhesive tabbing	
Special features	<ul style="list-style-type: none"> <li>• Good initial adhesion on MSE<sup>2)</sup> substrates</li> <li>• Good shear resistance at elevated temperatures</li> </ul>	<ul style="list-style-type: none"> <li>• High bonding power on MSE<sup>2)</sup> substrates, outstanding on PC and PMMA</li> <li>• Excellent with primer on LSE<sup>3)</sup> plastics especially on ribbed surfaces</li> <li>• Deep black color for invisible bond lines</li> </ul>	<ul style="list-style-type: none"> <li>• Excellent wet-out for high initial bonding power on MSE<sup>2)</sup> substrates</li> <li>• Strong with primer on LSE<sup>3)</sup> plastics especially on ribbed surfaces</li> <li>• Excellent shear resistance at elevated temperatures</li> </ul>	<ul style="list-style-type: none"> <li>• High bonding strength on various clear coats</li> <li>• High temperature resistance up to 90 °C</li> <li>• Good wet-out</li> </ul>	<ul style="list-style-type: none"> <li>• Good performance within the first minute of application on easy-to-bond clear coats</li> <li>• Outstanding performance at an application temperature as low as 5 °C</li> </ul>	<ul style="list-style-type: none"> <li>• High initial adhesion to LSE<sup>3)</sup> plastics</li> <li>• Full performance at an application temperature as low as 5 °C</li> </ul>	<ul style="list-style-type: none"> <li>• High initial adhesion to LSE<sup>3)</sup> plastics and clear coats</li> <li>• Full performance at an application temperature as low as 5 °C</li> </ul>	
Adhesion after 72 h		tesa® 77212	tesa® 7812	tesa® 77112	tesa® 77311	tesa® 77611	tesa® 77711	
	Steel	27 N/cm	32 N/cm	28 N/cm	Open side: 30 N/cm Liner side: 30 N/cm	Open side: 26 N/cm Liner side: 31 N/cm	Open side: 31 N/cm Liner side: 26 N/cm	35 N/cm
	ABS	12 N/cm	24 N/cm	26 N/cm	Open side: 12 N/cm Liner side: 48 N/cm	Open side: 12 N/cm Liner side: 28 N/cm	Open side: 28 N/cm Liner side: 12 N/cm	31 N/cm
PP	37 N/cm <sup>4)</sup>	90 N/cm <sup>4)</sup>	73 N/cm <sup>4)</sup>	50 N/cm <sup>4)</sup>	37 N/cm <sup>4)</sup>	Open side: 36 N/cm	38 N/cm	
Temperature range	-40 to +80 °C	-40 to +80 °C	-40 to +90 °C	-40 to +90 °C	-40 to +80 °C	-40 to +80 °C	-40 to +80 °C	
Static shear resistance at heat	90 °C > 10,000 min	90 °C > 10,000 min	100 °C > 10,000 min	90 °C > 10,000 min	90 °C > 10,000 min	90 °C > 10,000 min	90 °C > 10,000 min	

### Test methods:



Adhesion after 72 h:  
Peel test in 90° angle  
test speed: 300 mm/min



Static shear resistance  
area: 25 mm x 25 mm  
on steel, load: 200 g

- 1) 778XX roll with blue core, the rest products with white core
- 2) MSE: medium surface energy (38 - 50 mN/m)
- 3) LSE: low surface energy (29 - 37 mN/m)
- 4) Using tesa® 60153 primer

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