



1. Park distance control (PDC)
2. Rocker panel
3. Door edge molding
4. Body side molding
5. Window frame
6. Roof ditch trim
7. Doorsill trim



PRIMERLESS MOUNTING OF ATTACHMENT PARTS

tesa® ACX^{plus} and PE Foam Tape – No Primer Required!

**Reduce Total Process Cost and Complexity!
Achieve Healthier and More Environmentally Friendly Production!**

The introduction of our primerless product solutions can help you eliminate the primer in your processes! Its high-performance adhesive creates an efficient and secure bond to typical attachment parts made of LSE* (like PP and PP/EPDM) and MSE** (like ABS) plastics without primer. In addition, our products also have excellent adhesive properties when it comes to different types of OEM clear coats.

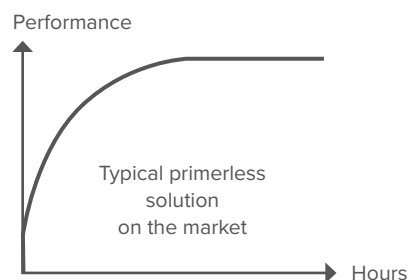
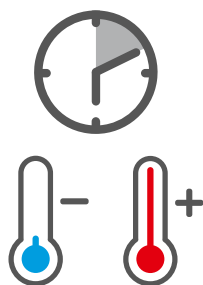
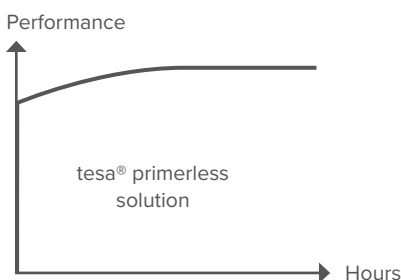
* Low surface energy ** Medium surface energy



No primer needed

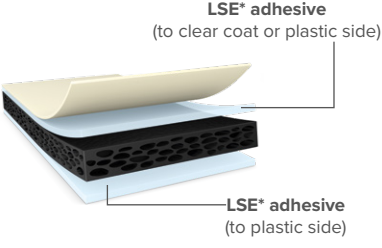
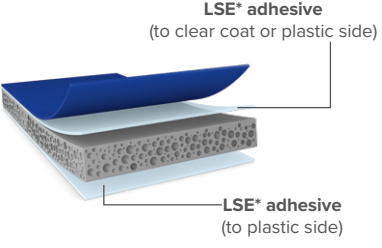
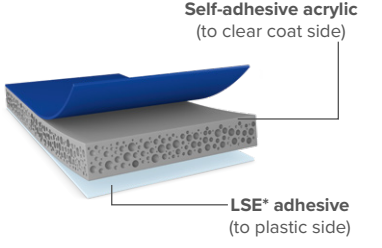
**Robust Application Over a Wide Temperature Range!
Excellent Performance Within the First Minute!**

No matter whether it is a low temperature down to 5°C or a high temperature up to 40°C, within the first minute after application, our primerless products reach a near-ultimate peel-adhesion level on most substrates, whereas the typical solutions on the market need time to set.



Note: For glass and soft rubber seals, primer is still recommended.

Our primerless product solutions

Product	tesa® 649XX PE foam tape	tesa® ACX ^{plus} 778XX acrylic foam tape	tesa® ACX ^{plus} 777XX acrylic foam tape										
Product design	<p>Three layers with PE foam core</p> 	<p>Three layers with pure acrylic foam core</p> 	<p>Two layers with pure acrylic foam core</p> 										
Total thickness (mm)	1.2	0.8, 1.1, 1.5	0.8, 1.1, 1.5										
Application	<table border="1"> <tr> <td>LSE/MSE* plastic part</td> <td>Difficult-to-bond clear coat</td> </tr> <tr> <td>LSE/MSE* plastic part</td> <td>LSE/MSE* plastic part</td> </tr> </table>	LSE/MSE* plastic part	Difficult-to-bond clear coat	LSE/MSE* plastic part	LSE/MSE* plastic part	<table border="1"> <tr> <td>LSE/MSE* plastic part</td> <td>Difficult-to-bond clear coat</td> </tr> <tr> <td>LSE/MSE* plastic part</td> <td>LSE/MSE* plastic part</td> </tr> </table>	LSE/MSE* plastic part	Difficult-to-bond clear coat	LSE/MSE* plastic part	LSE/MSE* plastic part	<table border="1"> <tr> <td>Easy-to-bond clear coat</td> </tr> <tr> <td>LSE/MSE* plastic part</td> </tr> </table>	Easy-to-bond clear coat	LSE/MSE* plastic part
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* LSE = low surface energy, MSE = medium surface energy

Technical data

Product	Backing	Liner	Thickness [mm]	Adhesion on PP, initial (1 min.) at RT [N/cm]	Adhesion on PP, 72 h. at RT [N/cm]	Adhesion on PP, initial (1 min.) at 5°C [N/cm]	Adhesion on PP, 72 h. at 5°C [N/cm]	Static shear on steel, 25 × 25 mm, 200 g load, > 10,000 min.
77808	Pure acrylic foam	PE film	0.8	29	30	14	29	90°C
77811	Pure acrylic foam	PE film	1.1	33	38	19	32	90°C
77815	Pure acrylic foam	PE film	1.5	34	44	18	43	90°C
77708	Pure acrylic foam	PE film	0.8	24	30	16	30	90°C
77711	Pure acrylic foam	PE film	1.1	24	30	13	30	90°C
77715	Pure acrylic foam	PE film	1.5	30	42	15	33	90°C
64912	PE foam	Paper	1.2	20	20	9	20	90°C**

Note: For adhesion value, refer to open side of the tape.

** 80 g load

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 mentioned above 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.