



74608 Seal Line



Product Information

0.8 mm heat activatable acrylic foam tape for mounting seals e.g. for anti-pinch, sunroof and trunk-seal applications

Product Description

tesa® ACX^{plus} 74608 Seal Line is a deep black acrylic foam tape for permanent mounting of seals. It has a heat-activatable adhesive on the non-liner side. The adhesive gets activated by hot air or near-infrared when applying it onto the PP/EPDM, PP, TPV, or TPE seals.

Compared to the conventional process with primer, tesa® ACX^{plus} 74608 Seal Line ensures a highly secure bond to the rubber profile, enables a higher application speed than using primer, and improves the operational safety during the production process.

The acrylic foam core ensures outstanding dimensional stability even at high temperatures and loads. At the same time, by its viscoelastic properties, tesa® ACX^{plus} 74608 Seal Line absorbs and dissipates dynamic and static loads. This also allows compensation of extreme physical stress caused by the different thermal elongation of bonded parts in rapidly changing temperatures.

The pressure sensitive adhesive side exhibits high adhesion values by itself but is also compatible with tesa adhesion promoters tesa® 60151 and tesa® 60153.

The deep black color provides an enhanced appearance and high design flexibility.

Product Features

- Efficient and secure bonding of the heat-activatable layer to seals
- Enhanced temperature resistance
- Robust shear performance even at high temperatures
- PFAS / PFOS free product
- Strong bonding of the heat-activatable layer to the acrylic core that withstands humidity and heat
- Closed cell acrylic foam core for reliable sealing to prevent water penetration
- High humidity and UV resistance
- Excellent cold shock performance

Application Fields

tesa® ACX^{plus} 74608 Seal Line can be widely used for all kinds of automotive seal applications within a temperature range of -40 °C to 90 °C.



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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

• Backing	foamed acrylic	• Color	deep black
• Type of adhesive	acrylic	• Color of liner	blue
• Type of liner	PE/PP protection film	• Type of adhesive to glass	acrylic
• Total thickness	8000 µm	• Type of adhesive to seal	heat-activatable

Properties/Performance Values

• Elongation at break	600 %	• Ageing resistance (UV)	very good
• Tensile strength	17 N/cm	• Humidity resistance	very good

Adhesion to Values

• Glass (covered side, after 20 min)	29 N/cm	• Steel (covered side, after 3 days)	4 N/cm
• Glass (covered side, after 3 days)	29 N/cm	• TPE (T-Peel, after 3 days warm / humid)	27 N/cm
• Steel (covered side, after 20 min)	4 N/cm	• TPE (T-Peel, after 3 days)	30 N/cm

Additional Information

- PV29 = filmic liner in royal blue, siliconized to adhesive side and silicone free to tabbing side, works with both heat and adhesive tabbing tapes
- Adhesion to glass: glass is primed with black 1K isocyanate primer; measured at 90°, 50mm/min.
- Adhesion to steel: measured at 90°, 300 mm/min
- T-Peel test: heat-activatable adhesive to standard TPE seal, 300 mm/min
- Warm/humid storage: 72 h at 40°C and 100% r.h. test 30min after storage



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