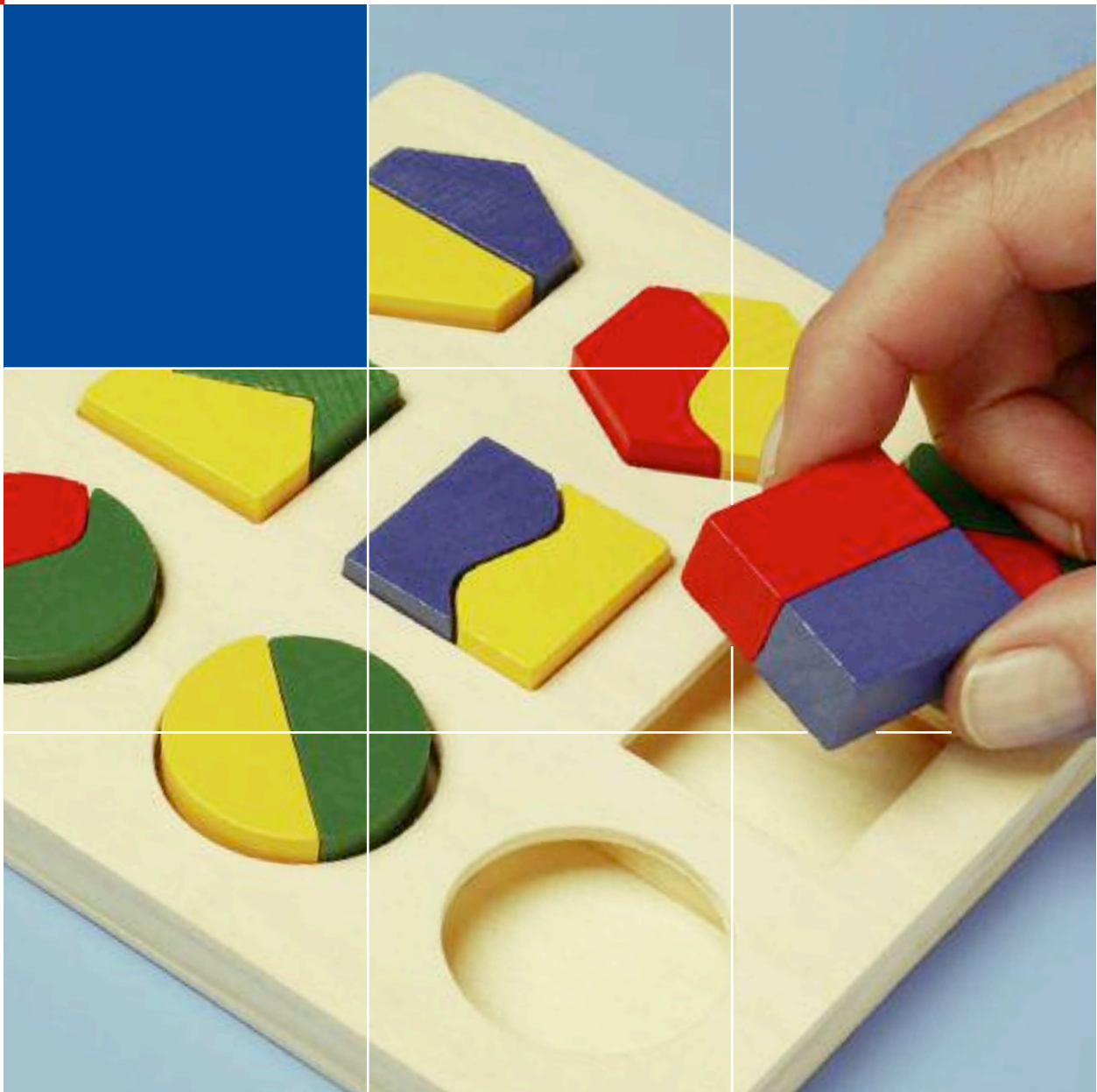


There Is More Than One Solution For Your Fastening Needs

tesa Double-Sided Tapes for Industrial Fastening Applications



The Product Mix

The new tesa Double-Sided Tape Assortment consists of numerous specialized tapes. These products are segmented into two groups:

- 1) Core Assortment – consisting of 11 tapes
- 2) Complementary Products – 19 alternative tape solutions

The following table shows the material combinations which can be bonded with the 11 core products (product numbers noted in each box). The colors indicate the different types of backing material.

Decision Guide – Material Mix	
Painted Surfaces Wood Glass Foam Cardboard/Paper Plasticized PVC¹ PVC Polyethylene ABS² EPDM³ Polypropylene Polyester Polystyrene Polycarbonate Rubber Textile Leather Concrete Aluminum Steel	4965
	4970 4964
	FOAM 4965 4965
	4959 4965 4959 4985
	4965 51571 4965 4970 64621
	4970 4965 4959 4965 4970 4965
	4970 FOAM 4970 4985 51571 4959 4970
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	4965 4964 FOAM 4965 4959 4965 4970 4959 4965 51571 4970 4965 4965 4965 51571 4959 4965 4934 4965 51571
Substrates Painted Surfaces Wood Glass Foam Cardboard/Paper Plasticized PVC PVC Polyethylene ABS EPDM Polypropylene Polyester Polystyrene Polycarbonate Rubber Textile Leather Concrete Aluminum Steel	



	Film Tapes
	Non-woven Tapes
	Cloth Tapes

	Foam Tapes
	Transfer Tapes

- 1 - Polyvinyl Chloride
- 2 - Acrylonitrile Butadiene Styrene
- 3 - Ethylene Propylene Diene Monomer

tesa Double-Sided Tapes

Core Tapes	Backing	Adhesive	Thickness (mils)	Peel Adhesion (oz/inch) to steel (mm-14 days)	Temp. Resistance short-term/long-term
tesa® 4965	PET	modified acrylic	8	90	392°F/176°F
tesa® 4970	PVC	modified acrylic	9	110	160°F/140°F
tesa® 64621	PP	synthetic rubber	3.5	73	160°F/140°F
tesa® 62932	PE Foam	modified acrylic	20	>155	176°F/176°F
tesa® 62934	PE Foam	modified acrylic	32	>155	176°F/176°F
tesa® 62936	PE Foam	modified acrylic	64	>173	176°F/176°F
tesa® 4959	Non-Woven	modified acrylic	4	56	392°F/176°F
tesa® 51571	Non-Woven	synthetic rubber	6.3	138	160°F/140°F
tesa® 4985	Transfer	modified acrylic	2	50	392°F/176°F
tesa® 4964	Cloth	natural rubber	15	40	212°F/140°F
tesa® 4934	Cloth	synthetic rubber	11	91	160°F/140°F
Complementary Tapes	Backing	Adhesive	Thickness [mils]	Peel Adhesion [oz/in] to steel (mm-14 days)	Temp. Resistance short-term/long-term
tesa® 4968	PVC	modified acrylic	12.5	180	160°F/140°F
tesa® 4980	PET	modified acrylic	3.1	70	392°F/176°F
tesa® 4982	PET	modified acrylic	4	68	392°F/176°F
tesa® 51970	PP	modified acrylic	9	100	302°F/158°F
tesa® 51977	PP	modified acrylic	9.5	105	302°F/158°F
tesa® 64620	PP	synthetic rubber	7	89	160°F/140°F
tesa® 4952	PE Foam	modified acrylic	46	>73	176°F/176°F
tesa® 4976	PUR Foam	modified acrylic	22	109	392°F/176°F
tesa® 4977	PUR Foam	modified acrylic	32	82	392°F/176°F
tesa® 51930	PUR Foam	modified acrylic	32	100	212°F/140°F
tesa® 62872	PE Foam	pure acrylic	20	>180	176°F/176°F
tesa® 62875	PE Foam	pure acrylic	36	>200	176°F/176°F
tesa® 64958	PE Foam	synthetic rubber	40	>36	176°F/176°F
tesa® 4961	Non-Woven	synthetic rubber	9.2	54	212°F/140°F
tesa® 4962	Non-Woven	modified acrylic	7	95	392°F/176°F
tesa® 51575	Non-Woven	water-based acrylic	3.5	40	400°F/176°F
tesa® 4987	Transfer	modified acrylic	5	81	392°F/176°F
tesa® 4900	Transfer	pure acrylic	2	30	400°F/176°F
NOPI™ 7002	Transfer	modified acrylic	1.6	25	360°F/32°F



The tesa Double-Sided Tape Assortment Offers Professional Solutions

As a market leader in many regions, tesa has developed a wide range of professional solutions for many industrial fastening applications. tesa's own research and development experts and production specialists in plants around the world have a wealth of experience and know exactly which combination of backing, adhesive, and liner works best!



Backings

tesa Double-Sided Tapes are available in five different backing materials. Each of these, in combination with the most appropriate adhesive, fits the specified application perfectly.

Thin backings leave space for more adhesive at the same total thickness and generate a higher flexibility of the product, as well as better peel adhesion.

Backing Material	Main Characteristics
Film Polypropylene (PP) Polyester (PET) Polyvinyl Chloride (PVC)	- Dimensionally stable - Very conformable - Flexible, extremely conformable - Conformable - High thickness, damping effect
Foam	
Non-woven	
Transfer	
Cloth Polyethylene (PE)	

Acrylic Adhesives

- Polymers are industrially synthesized
- Precise adjustment of polymers allows control of adhesive properties
- Polymerization, compounding, and coating by tesa
- Suitable for permanent and outdoor applications

Natural Rubber Adhesives

- Natural polymers
- Compounding and coating by tesa
- Suitable for bonding non-polar surfaces and general-purpose applications

Synthetic Rubber Adhesives

- Synthetic polymers, industrially manufactured by well-known producers
- Synthetic rubber adhesives are thermoplastic
- Suitable for bonding non-polar surfaces and general-purpose applications

Adhesives

Advantages +	Limitations -
- Adheres well to polar substrates (Polyester, polycarbonate, glass, metals) - Temperature resistant - Age resistant - Resistant to environmental elements - Usually higher shear resistance at elevated temperatures	- Ultimate adhesion strength is reached after dwell time, so the tapes are repositionable - Low, immediate peel adhesion - Lower adhesion level on non-polar substrates

Advantages +	Limitations -
- High initial tack or "grab" - High initial bond to substrate - Excellent adhesion to non-polar surfaces, such as PP, PE, or EPDM - Lower raw material costs than acrylics	- Lower resistance to elevated temperatures - Lower aging resistance - Lower environmental resistance - Lower chemical resistance - Lower humidity resistance

PP - Polypropylene / PE - Polyethylene / EPDM - Ethylene Propylene Diene Monomer

It's Very Easy to Identify the Right tesa Product!

tesa Film Tapes (PET, PVC, PP) <small>Polyester (PET), Polyvinyl Chloride (PVC), Polypropylene (PP)</small>		tesa Foam Tapes (PE, PU) <small>Polyethylene (PE), Polyurethane (PU)</small>		
Core	Complementary	Core	Complementary	
 <p>tesa® 4965 Converter's Friend Premium PET</p> <ul style="list-style-type: none"> • Modified Acrylic <p><i>Available Liners:</i></p> <ul style="list-style-type: none"> • MOPP Film • Glassine Paper • PE-Coated Paper 	<p>tesa® 4968 Premium PVC</p> <ul style="list-style-type: none"> • Modified Acrylic <p><i>Available Liners:</i></p> <ul style="list-style-type: none"> • MOPP Film • Glassine Paper • PE-Coated Paper 	 <p>tesa® 62932 Constructive Bonding</p> <ul style="list-style-type: none"> • White/Black PE Foam • Closed Cell • Modified Acrylic • 20 mils <p><i>Available Liners:</i></p> <ul style="list-style-type: none"> • Red MOPP Film • Glassine Paper • PE-Coated Paper (Black only) • Blue PE Film (Black only) 	<p>tesa® 4952 General Bonding</p> <ul style="list-style-type: none"> • White PE Foam • Closed Cell • Modified Acrylic • 46 mils <p><i>Available Liner:</i></p> <ul style="list-style-type: none"> • Glassine Paper 	<p>tesa® 4976 Constructive Bonding</p> <ul style="list-style-type: none"> • Black PUR Foam • Closed Cell • Modified Acrylic • 22 mils <p><i>Available Liner:</i></p> <ul style="list-style-type: none"> • Glassine Paper
 <p>tesa® 4970 Premium PVC</p> <ul style="list-style-type: none"> • Modified Acrylic <p><i>Available Liner:</i></p> <ul style="list-style-type: none"> • Glassine Paper 	<p>tesa® 4980 Smooth Lamination PET</p> <ul style="list-style-type: none"> • Modified Acrylic <p><i>Available Liner:</i></p> <ul style="list-style-type: none"> • Glassine Paper 	 <p>tesa® 62934 Constructive Bonding</p> <ul style="list-style-type: none"> • Black PE Foam • Closed Cell • Modified Acrylic • 32 mils <p><i>Available Liners:</i></p> <ul style="list-style-type: none"> • Red MOPP Film • Glassine Paper • PE-Coated Paper 	<p>tesa® 4977 Constructive Bonding</p> <ul style="list-style-type: none"> • White PUR Foam • Closed Cell • Modified Acrylic • 32 mils <p><i>Available Liner:</i></p> <ul style="list-style-type: none"> • Glassine Paper 	<p>tesa® 51930 Constructive Bonding</p> <ul style="list-style-type: none"> • Grey PUR Foam • Closed Cell • Modified Acrylic • 32 mils <p><i>Available Liner:</i></p> <ul style="list-style-type: none"> • Green Film
 <p>tesa® 4970 Premium PVC</p> <ul style="list-style-type: none"> • Modified Acrylic <p><i>Available Liner:</i></p> <ul style="list-style-type: none"> • Glassine Paper 	<p>tesa® 4982 Strong Lamination PET</p> <ul style="list-style-type: none"> • Modified Acrylic <p><i>Available Liners:</i></p> <ul style="list-style-type: none"> • MOPP Film • Glassine Paper 	 <p>tesa® 62936 Constructive Bonding</p> <ul style="list-style-type: none"> • Black PE Foam • Closed Cell • Modified Acrylic • 64 mils <p><i>Available Liners:</i></p> <ul style="list-style-type: none"> • Red MOPP Film • Glassine Paper 	<p>tesa® 62872 Constructive Bonding</p> <ul style="list-style-type: none"> • Black PE Foam • Closed Cell • Pure Acrylic • 20 mils <p><i>Available Liner:</i></p> <ul style="list-style-type: none"> • Glassine Paper 	<p>tesa® 62875 Constructive Bonding</p> <ul style="list-style-type: none"> • Black PE Foam • Closed Cell • Pure Acrylic • 36 mils <p><i>Available Liner:</i></p> <ul style="list-style-type: none"> • Glassine Paper
<p>tesa® 64621 Economy PP</p> <ul style="list-style-type: none"> • Synthetic Rubber <p><i>Available Liner:</i></p> <ul style="list-style-type: none"> • Glassine Paper 	<p>tesa® 51977 Performance PP</p> <ul style="list-style-type: none"> • Modified Acrylic <p><i>Available Liner:</i></p> <ul style="list-style-type: none"> • Glassine Paper 	<p>tesa® 64958 General Bonding</p> <ul style="list-style-type: none"> • White PE Foam • Closed Cell • Synthetic Rubber • 40 mils <p><i>Available Liner:</i></p> <ul style="list-style-type: none"> • Glassine Paper 		
	<p>tesa® 64620 Standard Grade PP</p> <ul style="list-style-type: none"> • Modified Acrylic <p><i>Available Liner:</i></p> <ul style="list-style-type: none"> • Glassine Paper 			

**tesa
Non-woven Tapes**

Core

Complementary



tesa® 4959

Premium Tissue

- Modified Acrylic

Available Liners:

- MOPP Film
- Glassine Paper
- PE-Coated Paper



tesa® 51571

High-Performance Tissue

- Synthetic Rubber

Available Liner:

- Glassine Paper

tesa® 4961

Performance Tissue

- Synthetic Rubber

Available Liner:

- Glassine Paper

tesa® 4962

High Grade Tissue

- Modified Acrylic

Available Liners:

- MOPP Film
- Glassine Paper
- PE-Coated Paper

tesa® 51575

Economy Tissue

- Water-based Acrylic

Available Liner:

- Glassine Paper

**tesa
Transfer Tapes**

Core

Complementary



tesa® 4985

Premium Unsupported

- Modified Acrylic
- Normal Wind 3" Core
- Reverse Wound 1" Core

Available Liner:

- Glassine Paper

tesa® 4987

Premium Reinforced

- Modified Acrylic
- Normal Wind 3" Core
- Reverse Wound 1" Core

Available Liner:

- Glassine Paper

tesa® 4900

Unsupported

- Pure Acrylic
- Normal Wind 3" Core
- Reverse Wound 1" Core

Available Liner:

- Glassine Paper

NOPI™ 7002

Economy Grade

- Modified Acrylic
- Reverse Wound 1" Core

Available Liner:

- Glassine Paper

**tesa
Cloth Tapes**

Core



tesa® 4964

High-Performance

- Natural Rubber

Available Liner:

- Glassine Paper



tesa® 4934

Economy Grade

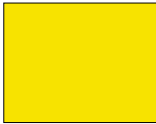

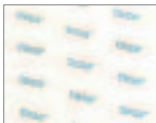

- Synthetic Rubber

Available Liner:

- Glassine Paper

Liners

Features and Technical Details of Available Liners

Product Features	Liner Thickness	Weight	Color
 <p>Glassine Paper Liner + Cost efficient + Low compression due to hard paper core - Limited humidity resistance</p>	2.8 mils	49 lbs/ream	Mustard Yellow
 <p>Polypropylene Film Liner + Very narrow thickness tolerance + Translucent for visual inspection + Low electrical charge - High elongation</p>	3.2 mils	44 lbs/ream	Tango Red, Translucent
 <p>Polyethylene-Coated Paper Liner + Excellent humidity resistance + PE layer against paper fiber emission - Higher cost</p>	4.8 mils	74 lbs/ream	White, Printed Logo
 <p>Polyethylene Film Liner + Very narrow thickness tolerance + Low electrical charge - High elongation</p>	3.2 mils	56 lbs/ream	Blue

Liner Functionality

	Glassine Paper Liner	PP Film Liner	PE-Coated Paper Liner	PE Film Liner (for foam only)
Kiss Cutting	-	+	+	+
Die Cutting	+	+	o	+
Tensile Strength	o	+	+	o
Knife Dulling	+	o	+	o
Hand Tearable	+	-	+	o
Transparency	-	+	-	-
Moisture Resistance	-	++	+	++
Appearance	-	+	+	+

- = Below Average o = Average + = Above Average

tesa - Professional Tape Technology

For over a century, tesa has pioneered the development of pressure-sensitive adhesive tape technologies. This rich tradition of innovation dates back to 1882 when the company's founder patented a method for manufacturing medical adhesive dressings. Today, the worldwide tesa enterprise services customers in over 100 countries around the globe and holds numerous product patents. At tesa, our charter is to provide our customers with service levels and applications expertise that go well beyond the roll of tape.



- tesa affiliate
- tesa production plant

UNITED STATES & CANADA

tesa tape, inc.

5825 Carnegie Boulevard
Charlotte, NC 28209
Phone: 704 554 0707
Toll Free: 800 426 2181
Fax: 800 852 8831
Email: customercare@tesatape.com
Website: www.tesatape.com

MEXICO

Technical Tape México S.A. de C.V.

Av. Santa Fe No. 170
German Centre P 6-3-3Col.
Lomas de Santa Fe
Mexico D.F. C.P. 01210
Phone: +52 (55) 5292 6978
Fax: +52 (55) 5292 6977

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