tesa –
always a fitting solution

As a globally leading supplier of adhesive tapes tesa offers a wide assortment of adhesive solutions for paper production.

The ability to understand our customers’ processes and their requirements and to provide specific solutions is tesa’s focus – and our customers’ benefit. tesa Solutions are used by leading paper producers and have proven their high quality level in daily operations.

Re-reeler

1 End tabbing
- 4441 Very good adhesion on all paper grades for secure closing of jumbo rolls. Features a very high shear resistance and high stretching properties making it suitable for changing environmental conditions.
- 4445 Very strong single-sided tape with excellent tack, high tensile strength and good shear resistance for closing jumbo rolls of heavy paper and demanding surfaces.
- 51446 Good adhesion values on coated and uncoated papers for closing jumbo rolls in uncritical conditions.

2 Hole Patching
- 51455 Very thin single-sided tape with a slit liner for excellent printing quality.
- 54210 Oval shaped die cut with a liner for excellent printing quality and easy application.

3 Permanent Splice
- Single covered overlapped splice
- Covered Butt splice

51464 EasySplice WinderLine
Extremely thin 50 µm single-sided tape with a splitting strip for easy preparation of butt splices on jumbo rolls and improved run-ability at coaters, calenders and printers.
Also available in 80 µm for increased resistance against web tension – 51465 EasySplice WinderLine.

4447 Preparation of butt splices without a liner. Very high tensile strength for splicing heavy webs.
- 51913 Very thin double-sided tape for preparation of thin overlapped splices with excellent shear resistance for high web tension and secure run-ability in further processes.
- 51444 Extremely thin 50 µm single-sided cover tape for sealing permanent splices against bleeding of adhesive to the next paper layer and strengthening the splice.
Also available in 80 µm for heavier paper grades and higher web tension – 51445.

4 Flying Splice – EasySplice Products

51150 EasySplice FastLine The world leading straight line flying splice tape at offline coaters for higher splice security, faster splice preparation and higher splicing speed.

51157 EasySplice FastLine Heat
The EasySplice solution for high drying temperatures and long residence times in the dryer.

51152 EasySplice CoaterLine
The EasySplice solution for small offline coaters with lower splicing speeds.
### Offline Calender

#### 7 Flying Splice

- **51170 EasySplice CalenderLine** The straight line flying splice solution for reducing waste paper, avoiding label residues, storable reels and splicing with closed nips.

- **51913** Very shear resistant double sided tape for traditional flying splices at offline calenders. Also suitable for zero-speed splices. Alternatively, **51914** as a high tack solution for demanding paper surfaces.

- **54287** Butterfly shaped die cut with liner for fixing the top layer of the new paper roll.

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**Flying Splice – Traditional Splice Patterns**

- **51914** Double sided tape with very high tack properties for high splice security. Alternatively **51917** for critical adherence conditions.

- **54287** Butterfly shaped die cut with liner for fixing the top layer of the new paper roll.

- **54216** Trapezoidal die cut with liner for fixing the top layer of the new paper roll with sawtooth profiles.

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**5 Web Feeding**

- **4445** Single sided tape with a thick backing for easy tearing of paper along the edge of the tape and preparing stable kites.

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**6 Roll Catching**

- **4445** Very high tensile strength for secure catching of expiring web after cutting.
8 Permanent Splice

51464 EasySplice Winder-Line
Extremely thin 50 µm single-sided tape with a splitting strip for easy preparation of high quality jumbo-to-jumbo butt splices and preparation of splices on wide customer rolls for less damage to printing blankets and highest printing quality for printers. Also available in 80 µm for splicing heavy webs and high web tension – 51465 EasySplice WinderLine

51454 – Slit liner
Same as 51464 but without splitting strip as positioning aid for preparing very thin butt splices on customer rolls. Also available in 80 µm – 51455.

4447 Preparation of butt splices without a liner. Very high tensile strength for splicing heavy webs.

51913 Very thin double-sided tape for preparation of thin overlapped splices. Features an excellent shear resistance for high web tension and preventing web breaks when printing.

51444 Extremely thin 50 µm single-sided 50 µm cover tape for sealing permanent splices against bleeding of adhesive to the next paper layer and strengthening the splice for avoiding web breaks at printers. Also available in 80 µm for heavier paper grades and higher web tension – 51445.

9 Core Starting

51913 Excellent adhesion properties to ensure a secure fixing of the web to the core. Alternatively 51917 with very high tack for rough paper surfaces and cores.

51916 – Transfer tape
Transfer tape with very good adhesion values and excellent tack to provide a secure fixing of the web to the core.

51446 Single-sided tape with good tack for secure fixing of web to core.

51190 EasySplice Core Starting
Special tear-away backing ensures a reliable opening without adhesive residues on core or web.

10 End Tabbing

4441 Very good adhesion on all paper grades for secure closing of customer rolls. Features a very high shear resistance and high stretching properties making it suitable for changing environmental conditions.

4445 Very strong single-sided tape with excellent tack, high tensile strength and good shear resistance for closing rolls of heavy paper, demanding surfaces and difficult storage conditions.

51446 Good adhesion values on coated and uncoated papers for closing customer rolls in uncritical conditions.

51916 – Transfer tape
Transfer tape with very good adhesion values and excellent tack for secure roll closing.

Sheeter

11 Static Splice

51913 Very shear resistant double-sided tape for zero-speed splices at sheeters. Alternatively a high tack solution for demanding paper surfaces – 51914.
### tesa Tapes for Paper Production at a Glance

#### EasySplice Products for Flying Splices

<table>
<thead>
<tr>
<th>Product</th>
<th>Material</th>
<th>Colour</th>
<th>Thickness</th>
<th>Tensile Strength</th>
<th>Elongation at break</th>
<th>Adhesion on paper</th>
<th>Shear Resistance</th>
<th>Tack</th>
<th>Heat Resistance</th>
</tr>
</thead>
<tbody>
<tr>
<td>tesa 51150</td>
<td>Paper</td>
<td>blue</td>
<td>110 µm</td>
<td>75 N / 25 mm</td>
<td>6 %</td>
<td>++</td>
<td>+</td>
<td>++</td>
<td>+</td>
</tr>
<tr>
<td>tesa 51157</td>
<td>Paper</td>
<td>blue</td>
<td>110 µm</td>
<td>75 N / 25 mm</td>
<td>6 %</td>
<td>++</td>
<td>++</td>
<td>++</td>
<td>++</td>
</tr>
<tr>
<td>tesa 51152</td>
<td>Paper</td>
<td>blue</td>
<td>110 µm</td>
<td>75 N / 25 mm</td>
<td>6 %</td>
<td>++</td>
<td>+</td>
<td>++</td>
<td>+</td>
</tr>
<tr>
<td>tesa 51170</td>
<td>Paper</td>
<td>blue</td>
<td>100 µm</td>
<td>75 N / 25 mm</td>
<td>6 %</td>
<td>++</td>
<td>++</td>
<td>+</td>
<td>++</td>
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</table>

#### Double-sided tapes

<table>
<thead>
<tr>
<th>Product</th>
<th>Material</th>
<th>Colour</th>
<th>Thickness</th>
<th>Adhesion on paper Covered Side / Open Side</th>
<th>Shear Resistance</th>
<th>Tack</th>
<th>Heat Resistance</th>
</tr>
</thead>
<tbody>
<tr>
<td>tesa 51913</td>
<td>Paper</td>
<td>blue colourless</td>
<td>65 µm</td>
<td>++ ++</td>
<td>++</td>
<td>+</td>
<td>++</td>
</tr>
<tr>
<td>tesa 51914</td>
<td>Paper</td>
<td>blue colourless</td>
<td>85 µm</td>
<td>++ +</td>
<td>+</td>
<td>++</td>
<td>+</td>
</tr>
<tr>
<td>tesa 51916</td>
<td>Transfer</td>
<td>blue colourless</td>
<td>50 µm</td>
<td>+ ++</td>
<td>+</td>
<td>++</td>
<td>+</td>
</tr>
<tr>
<td>tesa 51917</td>
<td>Paper</td>
<td>blue colourless</td>
<td>115 µm</td>
<td>++ ++</td>
<td>+</td>
<td>++</td>
<td>+</td>
</tr>
<tr>
<td>tesa 51910</td>
<td>Paper</td>
<td>white</td>
<td>120 µm</td>
<td>+ o</td>
<td>+</td>
<td>+</td>
<td>+</td>
</tr>
</tbody>
</table>

#### Single-sided tapes with liner

<table>
<thead>
<tr>
<th>Product</th>
<th>Material</th>
<th>Colour</th>
<th>Thickness</th>
<th>Tensile Strength</th>
<th>Elongation at break</th>
<th>Adhesion on paper</th>
<th>Shear Resistance</th>
<th>Heat Resistance</th>
<th>Additional Features</th>
</tr>
</thead>
<tbody>
<tr>
<td>tesa 51464</td>
<td>Paper</td>
<td>blue</td>
<td>50 µm</td>
<td>26,7 N / 25 mm</td>
<td>6 %</td>
<td>+</td>
<td>++</td>
<td>++</td>
<td>Splitting Strip, Slit Liner</td>
</tr>
<tr>
<td>tesa 51465</td>
<td>Paper</td>
<td>blue</td>
<td>80 µm</td>
<td>85 N / 25 mm</td>
<td>6 %</td>
<td>++</td>
<td>++</td>
<td>++</td>
<td>Splitting Strip, Slit Liner</td>
</tr>
<tr>
<td>tesa 51454</td>
<td>Paper</td>
<td>blue</td>
<td>50 µm</td>
<td>26,7 N / 25 mm</td>
<td>6 %</td>
<td>+</td>
<td>++</td>
<td>++</td>
<td>Slit Liner</td>
</tr>
<tr>
<td>tesa 51455</td>
<td>Paper</td>
<td>blue</td>
<td>80 µm</td>
<td>85 N / 25 mm</td>
<td>6 %</td>
<td>++</td>
<td>++</td>
<td>++</td>
<td>Slit Liner</td>
</tr>
<tr>
<td>tesa 51444</td>
<td>Paper</td>
<td>blue</td>
<td>50 µm</td>
<td>26,7 N / 25 mm</td>
<td>6 %</td>
<td>+</td>
<td>++</td>
<td>++</td>
<td>-</td>
</tr>
<tr>
<td>tesa 51445</td>
<td>Paper</td>
<td>blue</td>
<td>80 µm</td>
<td>85 N / 25 mm</td>
<td>6 %</td>
<td>++</td>
<td>++</td>
<td>++</td>
<td>-</td>
</tr>
</tbody>
</table>

#### Single-sided tapes without liner

<table>
<thead>
<tr>
<th>Product</th>
<th>Material</th>
<th>Colour</th>
<th>Thickness</th>
<th>Tensile Strength</th>
<th>Elongation at break</th>
<th>Adhesion on paper</th>
<th>Shear Resistance</th>
<th>Tack</th>
</tr>
</thead>
<tbody>
<tr>
<td>tesa 4441</td>
<td>Paper</td>
<td>light blue white</td>
<td>140 µm</td>
<td>196 N / 25 mm</td>
<td>11,75 %</td>
<td>+</td>
<td>+</td>
<td>++</td>
</tr>
<tr>
<td>tesa 4445</td>
<td>Paper</td>
<td>light blue</td>
<td>190 µm</td>
<td>200 N / 25 mm</td>
<td>7,5 %</td>
<td>++</td>
<td>++</td>
<td>++</td>
</tr>
<tr>
<td>tesa 4447</td>
<td>Paper</td>
<td>blue</td>
<td>90 µm</td>
<td>100 N / 25 mm</td>
<td>10 %</td>
<td>+</td>
<td>++</td>
<td>o</td>
</tr>
<tr>
<td>tesa 51446</td>
<td>Paper</td>
<td>light blue</td>
<td>100 µm</td>
<td>150 N / 25 mm</td>
<td>2,5 %</td>
<td>+</td>
<td>+</td>
<td>+</td>
</tr>
</tbody>
</table>

The results were obtained under laboratory conditions. o = limited, + = good, ++ = very good.
All tesa tapes for paper production are repulpable according to TAPPI UM 213 A.
tesa Solutions for Paper Production at a Glance.

Detailed Information

For more detailed information, please refer to the following brochures:

- EasySplice FastLine
- Butt Splicing Solutions
- EasySplice CalendarLine

tesa products prove their impressive quality day in, day out in demanding conditions and are regularly subjected to strict controls. All information and recommendations are provided to the best of our knowledge on the basis of our practical experience. Nevertheless tesa AG can make no warranties, express or implied, including, but not limited to any implied warranty of merchantability or fitness for a particular purpose. Therefore, 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 advise you.