



REPULPABLE TAPES FOR PAPER PRODUCTION EXCELLENCE

Reliable Partner for All Steps of the
Paper Production Process

YOUR RELIABLE PARTNER



Our repulpable tapes for excellent paper production

Because of our self-adhesive repulpable tape solutions and expertise, we have been a partner for the paper industry for more than 40 years.

By creating tailored products as well as our tesa EasySplice® and tesa CaRes® product ranges, we can offer paper producers all over the world highly innovative and cost saving tape solutions allowing measurable improvements in every production step.



The increasing usage of calcium carbonate (CaCO₃) as a filler or coating pigment in paper production generally proves a considerable challenge for repulpable tapes.

Calcium ions dissolve and migrate into the adhesive over time. As a consequence, the adhesive hardens, causing dramatically weaker bonding and an increase in mill splices breaking at the printer or paper converter.

Our tesa CaRes® tapes resolve this by offering a fully repulpable, calcium-resistant, and permanent adhesive. They keep their well-balanced properties until the paper reel is processed by your customer.

Benefits of tesa CaRes®

- Reliable permanent splices on CaCO₃-coated paper
- No compromises on repulpability
- Well-balanced adhesive properties

tesa EasySplice® tapes for flying splice

Product	Suitable for	Backing	Color	Total thickness [µm]	Opening force	Shear and heat resistance	Tack
tesa® 51150 PV0	High-speed coaters	Paper	Blue	100	High	••	•••
tesa® 51150 PV1	High-speed coaters & sophisticated papers	Paper	Blue	100	Medium	••	•••
tesa® 51152	Medium-speed coaters	Paper	Blue	100	Medium	••	•••
tesa® 51157	High-speed coaters	Paper	Blue	100	High	•••	•••
tesa® 61152	Medium-speed coaters	Paper	Blue	100	Medium	•••	•••
tesa® 61170	Lower-speed splicing at winders & calenders	Paper	Blue	80	Low	•••	•

tesa® double-sided repulpable tapes

Product	Suitable for	Backing	Color	Total thickness [µm]	Special features	Shear and heat resistance	Tack
tesa® 51912	Permanent splices of rough and heavy papers	Tissue paper	Blue	90	CaRes ³	•••	•
tesa® 51913	Permanent splices of most paper grades	Tissue paper	Blue	65	CaRes ³	•••	•
tesa® 51917	Flying splice or core starting of rough and heavy papers	Tissue paper	Blue or white	120	–	••	•••
tesa® 51914 ²	Flying splice or core starting of most paper grades	Tissue paper	Blue or white	90	–	••	•••
tesa® 61914 ^{1,2}	Flying splice or core starting of thin papers	Tissue paper	Blue	70	–	••	•••

tesa® double-sided repulpable tapes (specialties)

Product	Suitable for	Backing	Color	Total thickness [µm]	Special features	Shear and heat resistance	Tack
tesa® 51915	Robotic application (core starting, end tabbing, or static splicing)	None	Blue	50	Transfer tape	••	•••
tesa® 51916	Robotic application (core starting, end tabbing, or static splicing)	None	Blue	50	Transfer tape	•••	••
tesa® 51190	Core starting or end tabbing of most paper grades	Splittable paper	Blue	130	Low opening force	••	••
tesa® 51193	Core starting or end tabbing of heavy papers	Splittable paper	Blue	170	High opening force	•••	•••

tesa® single-sided repulpable tapes for butt splicing

Product	Suitable for	Backing	Color	Total thickness [µm]	Special features	Shear and heat resistance	Tack
tesa® 51465	Easy application	Paper	Blue	80	Additional splitting strip, CaRes ³	•••	•
tesa® 51455	Easy application	Paper	Blue	80	Slitted liner, CaRes ³	•••	•
tesa® 61445	Optical splice detection	Paper	Black	80	CaRes ³	•••	•
tesa® 51445	Most paper grades	Paper	Blue	80	CaRes ³	•••	•
tesa® 51444	Light paper grades or as cover tape	Paper	Blue	50	CaRes ³	•••	•
tesa® 4447	Robotic application	Paper	Blue	90	No liner	•••	•

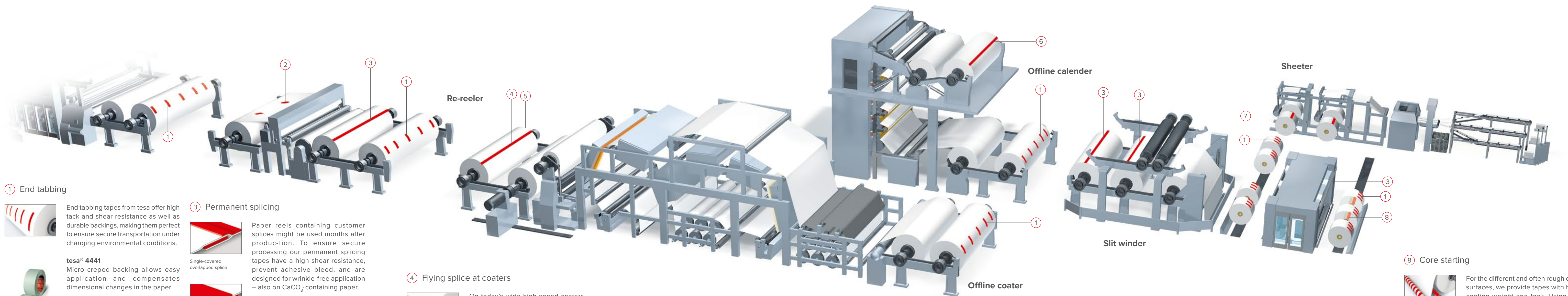
tesa® single-sided repulpable tapes for end tabbing

Product	Suitable for	Backing	Color	Total thickness [µm]	Special features	Shear and heat resistance	Tack
tesa® 4441	Most paper grades	Creped paper	Light blue or white	140	No liner	••	••
tesa® 4445	Heavy papers	Paper	Light blue	190	No liner	••	••
tesa® 51446	Light papers	Paper	Blue or white	100	No liner	••	••

The results were obtained under laboratory conditions. All tesa® tapes mentioned above are repulpable according to TAPPI UM 213 A.

¹ Non-repulpable liner, ² Differential adhesive, ³ tesa CaRes® (Calcium Resistant) for best results also on paper containing CaCO₃

••• Excellent •• Very good • Good



1 End tabbing

End tabbing tapes from tesa offer high tack and shear resistance as well as durable backings, making them perfect to ensure secure transportation under changing environmental conditions.

tesa® 4441
Micro-creped backing allows easy application and compensates dimensional changes in the paper

tesa® 4445
For heavy paper, demanding surfaces, and difficult storage conditions

tesa® 51446
For lightweight paper grades

No backing **tesa® 51915** and **tesa® 51916**
Tacky adhesive film, mainly for automatic end tabbing

2 Hole patching

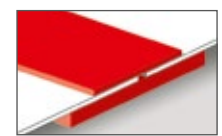
tesa® 54444
Very thin oval-shaped die cut of only 50 µm

tesa® 54445
Thin oval-shaped die cut of 80 µm

3 Permanent splicing



Single-covered overlapped splice



Covered butt splice

Paper reels containing customer splices might be used months after production. To ensure secure processing our permanent splicing tapes have a high shear resistance, prevent adhesive bleed, and are designed for wrinkle-free application – also on CaCO₂-containing paper.

Overlapped splice

tesa® 51912
For heavy or rough paper

tesa® 51913
Very thin tape for reliable splices

Butt splice

tesa® 51445
The standard tape for manual butt splicing

tesa EasySplice® 51465 WinderLine
Featuring a splitting strip and a slit liner easy application by hand

tesa® 51455
Featuring a slit liner for application by hand

Possible cover tape is **tesa® 51444**

4 Flying splice at coaters



On today's wide high-speed coaters every splicing failure means significant losses in efficiency and money. For more than 15 years tesa EasySplice® stands for top splice reliability at the highest speeds as well as easy and time-saving preparation.

tesa EasySplice® products

tesa EasySplice® 51150 FastLine
For high splicing speed and wide webs, or
tesa EasySplice® 51157 FastLine Heat
For very high drying temperatures

tesa EasySplice® 61152 CoaterLine Premium
For medium splicing speed and wide webs

tesa EasySplice® 51152 CoaterLine
Single split strip-solution for narrow webs and medium splicing speed

Double-sided products for traditional patterns

tesa® 51917
Extremely high tack for heavy and rough papers

tesa® 51914
Very high tack for high splice reliability

tesa® 61914
Good tack and suitable for thin papers

tesa® 54287 and **tesa® 54216**
Die cuts for top sheet fixing

5 Web feeding

For machine start-up or in the event of a web break, the easy handling of **tesa® 4445** or **tesa® 4447** helps to obtain a quicker threading of the paper web.

tesa® 4445
Easy tearing of the web along the edge

tesa® 4447
No sliding of the web at very high temperatures

6 Flying splice at calenders

Our calender splicing tapes have an optimized ratio between thickness and coating weight to avoid adhesive bleed and machine damage, also when running through closed nips.

tesa EasySplice® 61170 CalenderLine
Low-thickness tape for high-pressured nips and a splitting strip with smooth opening force

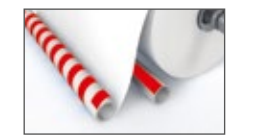
tesa EasySplice® 61152 CoaterLine Premium
for medium splicing speed and wide webs

7 Static splice

Our tapes for static splice such as **tesa® 61914** feature high tack properties and adhesion combined with good shear strength.

tesa® 61914
For all paper grades

8 Core starting



For the different and often rough core surfaces, we provide tapes with high coating weight and tack. Using the splittable **tesa® 51193** tape cores can be reused without cleaning.

Double-sided tapes

tesa® 51917
Highest coating weight and tack for rough cores

tesa® 51912
High coating weight for uneven cores

tesa® 51913
Secure web fixing on different cores

Special tapes

Splittable backing **tesa® 51193**
After splitting no sticky residues on the core

No backing **tesa® 51915** and **tesa® 51916**
Tacky adhesive film, mainly for automatic application core starting



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 above mentioned 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.



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Our management system is certified according to the standards ISO 9001, ISO/TS 16949, and ISO 14001.