



GLAZING SOLUTIONS

tesa tapes For the Glazing Industry

OUR GLAZING TAPES

For Ensuring a Reliable Seal, Time and Time Again

The rapid advancement in modern window designs and installations requires the latest technology to ensure positive and reliable seals in glazing. Traditional methods which incorporate putties, caulks and mastics have proven to be unreliable. tesa have developed a range of “dry” easy to apply, self-adhesive foam sealants which provide a higher performance weather seal than traditional methods. tesa tapes also eliminate the time consuming clean-up problems experienced with those outdated systems.

tesa tapes for the Glazing Industry

Our range of self-adhesive foam glazing sealants includes foam with adhesive on either one or both sides of the foam. The products are suitable for use either as a primary glazing seal, or secondary “back-up” seal and are widely used in both the domestic and commercial glazing industry.

The prolific variety of frame/sash/glass combinations in the Australian glazing industry has created the necessity for a highly diverse range of sealants. We supply our glazing tapes in thicknesses from 1.6 to 19 mm, in custom widths from 6 to 1448 mm.

In addition, we supply a range of protection tapes, which are designed to protect the frame and glass during assembly, transportation and the installation process.

From offering UV resistance outdoors for up to 12 months, to removing cleanly without leaving behind any residues, our range ensures that window frames and glass are kept scratch and blemish free, even in the toughest conditions.



DOMESTIC GLAZING

Tapes for the Domestic Glazing Industry

Domestic Glazing Foam

To seal between the glass and aluminium frame of fixed lights in domestic windows, tesa PVC foam tape coated with adhesive on one side is recommended as a secondary seal. tesa® 60202 1.6 mm thick PVC foam tape in black or grey is ideal for this application.

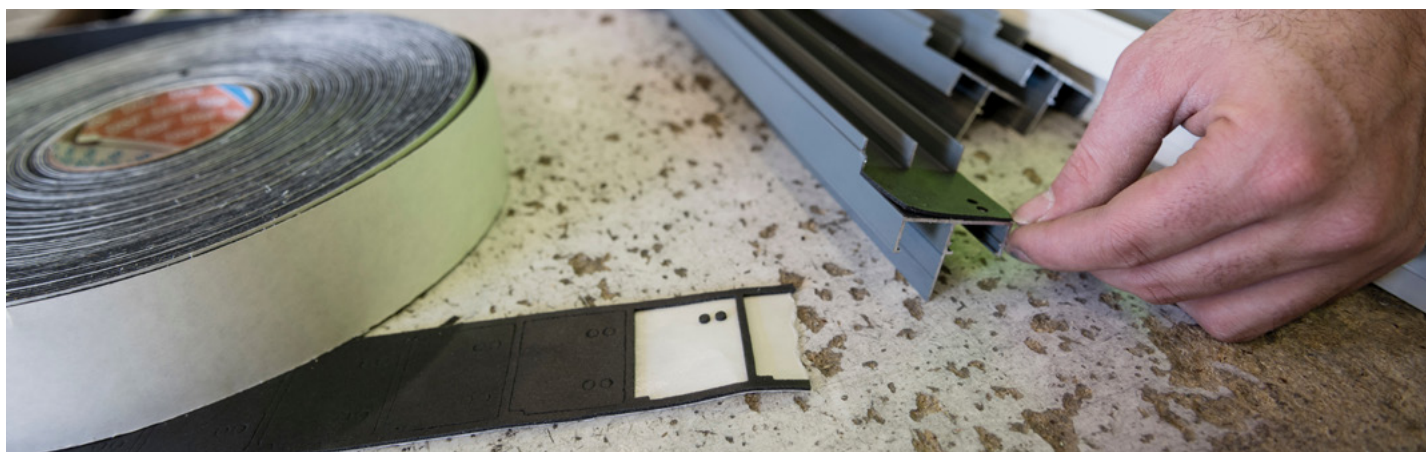
Normally applied to the internal side of the assembly the foam tape assists in preventing the ingress of water and drafts, while also allowing pressure to be maintained on the external wedge or bead.

Reglazing is also made easy since the foam tape is adhered to the frame only. tesa® 60202 and 60402 PVC foam tapes are also used in the form of die cut gaskets to seal corner or transom joints in window frames.

A corner joint sealed with tesa glazing foam tape is easier to assemble and neater than a joint sealed by gunnable small joint sealants. Another feature of our foam tape is that the joint can be disassembled easily should refabrication be required.

tesa® 604 Series double-sided high density PVC foam tape is used in glazing domestic windows in areas where a high performance, completely weatherproof primary seal is required. It is ideal for fixed bottom lights, for example, where drain holes cannot be incorporated into the design of the frame.

tesa® 604 Series fully complies with Industry Standards (AAMA 810.1-85) and glazed units in which tesa® 604 Series has been used as a primary seal have been tested and found to meet the requirements of AS2047-1977 code for aluminium windows.



COMMERCIAL GLAZING

Tapes for the Commercial Glazing Industry

Our Tapes for Commercial Glazing

The commercial glazing industry is more varied in styles and types of window and door designs than the domestic glazing industry. This includes both glazing of low-rise such as shop-fronts, and a greater degree of high-rise glazing such as multi-story office blocks. Curtain-wall construction has become extremely popular with many new high-rise buildings incorporating this form of architectural design.

Many old buildings are being reglazed with curtain-wall facades to give them a modern appearance. Hence there is generally a need for the glazing seal used in commercial glazing to be designed to a very high performance criteria given the wider extremes of weather conditions likely to be encountered.

Many commercial glazing applications can be sealed completely using tesa® 604 Series as an external primary seal and tesa® 6110 Series as a secondary “back-up” seal, on the inside of the glass.



tesa® 60402 seals and cushions the glass onto the frame

tesa® 604 Series PVC Double-sided Foam Tape

Designed specifically for commercial and domestic glazing applications where it is used as a primary seal between the glass and the window frame. It fully complies with the American Architectural Manufacturers Association Standard 810.1-85 Type 1 in which testing simulates 20,000 160 kilometre per hour wind gusts with alternating rain and heat cycles performed on an aluminium framed window with 3.9 square metres of 6 mm glass.

The tape is applied easily by hand from the roll where a paper liner protects the acrylic adhesive until the tape is in place. Once applied there is no oozing even under extreme expansion and contraction of the window glass and frame as the high density closed cell PVC foam is self shimming.

When compared with the more traditional butyl strip sealant, tesa® 604 Series has several advantages:

1. It is “self-shimming”, has a powerful adhesive on both sides, and will not run or ooze under high temperature conditions which means that it will not “pump” or “walk” out of the glazing channel.
2. The edge is “dry” and will not pick up dust, dirt, insects or metal or wood swarf during storage or handling.
3. It is easier to use because:
 - (a) the paper liner is flush with the edge of the foam allowing easier alignment on the glazing leg
 - (b) the foam can be either hand torn or cut with scissors
 - (c) longer roll lengths are available
4. tesa® 604 Series requires less storage space and is packed with silicone paper interleavers between the rolls to prevent the rolls from sticking together.



tesa® 6110 Series EPDM Single-sided Foam Tape

Made from heavy duty EPDM rubber, the foam is designed to retain its properties even when subjected to extreme weathering. It has high resistance to both UV and ozone and is the ideal “back-up” partner for tesa 604 Series.

Although both tapes are 100% watertight at less than 10% compression, we recommend they be compressed by 25% to allow for fluctuations in the width of the glazing channel caused by variations in weather conditions to which glazed unit may be subjected.

For example, excessive wind buffeting can result in further compression of either the primary or secondary glazing seals and consequent variations in the width of the glazing channel.

Therefore, if the glazing channel or rebate is 14 mm wide and the glass is 6 mm thick the external primary seal should be 60405 (4.8 mm thick) and the “back-up” seal should be 61104 (6.4 mm thick).

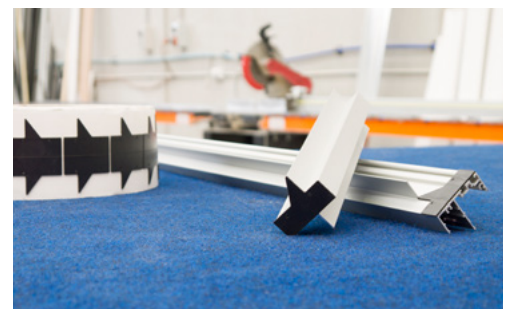
| Product | 602 Series | 604 Series | 6110 Series |
|-------------------------------------------------|----------------------------------|----------------------------------------|-------------------------------------------------------------------|
| Backing Material | PVC foam | PVC foam | EPDM foam |
| Colour | Grey, white, black | Black | Black |
| Adhesive type | Acrylic | Acrylic | Acrylic |
| Adhesive power | 2.8 N/cm | 7.84 N/cm | 12 N/cm |
| Nominal density | 180 kg/m ³ | 245 kg/m ³ | 120 kg/m ³ |
| Hardness (shore-00) | 28 | 40 | 37 |
| Force to compress 25% | 0.351 kg/cm ² | 0.562 kg/cm ² (ASTM D-1667) | 0.245 kg/cm ² |
| Compression set (% from original) | 2.0 % | 7.0 % | 2.0% |
| Water tightness | 100 % at 30 % compression | 100% at < 10 % compression | 100% at < 10 % compression |
| Water absorption (% by volume) | 1.3 % | 1.0 % | |
| Tensile strength | 3.5 kg/cm ² | 5.6 kg/cm ² | 5.6 kg/cm ² |
| Thermal conductivity (Sq.ft[hr] ² F) | 0.28 btu/in | 0.3 btu/in | 0.3 btu/in |
| Temperature resistance | -35 to 90 °C | -35 to 90 °C | -40 to 105 °C |
| Standard tape thickness | 1.6, 3.2, 4.8, 6.4, 9.5, 12.7 mm | 1.6, 3.2, 4.8, 6.4 mm | 1.6, 3.2, 4.8, 6.4, 9.5, 12.7 mm |
| Resistant to | Fungi, oxidation, UV, Ozone | Fungi, oxidation, UV, Ozone | UV, Ozone |
| Special Properties | Silicone compatible | Silicone compatible | Non-toxic, non-carcinogenic, flame retardant, silicone compatible |



tesa® 60402 applied to aluminium frame



tesa® 60202 die-cut



tesa® 60202 die-cut

STRUCTURAL GLAZING

Ensuring Blemish Free Surfaces

Our Tapes for Structural Glazing

Structural glazing is a modern facade manufacturing technique that opens new perspectives in glass architecture. Characterized by having a large glass pane area almost without visible framework, it satisfies architects' increasing desire to maximize natural daylight into the interior of the building. To achieve this, the glass pane is silicone-bonded to a metal frame. Our spacer tapes are used to maintain the defined distance between glass pane and metal frame prior to applying the structural silicone.

tesa® 6005 series spacer tape is a double-sided high density PU foam tape designed with open cell structure allowing air and moisture to transport through the tape, permitting optimum silicone curing.

Product Features

- Designed as a spacer element for two-sided and four-sided structural silicone glazing
- Chemically compatible with all major silicone systems
- High compression resistance to endure consistent thickness of silicone bead
- Low thermal conductivity to minimize heat transfer through the facade



Product Specifications

| Product | tesa® 60053 | tesa® 60056 | tesa® 60057 | tesa® 60057 | tesa® 60059 |
|------------------|----------------|----------------|----------------|----------------|----------------|
| Backing Material | PU Foam | PU Foam | PU Foam | PU Foam | PU Foam |
| Thickness | 3.2 mm | 4.8 mm | 6.63 mm | 7.9 mm | 9.5 mm |
| Colour | Black | Black | Black | Black | Black |
| Adhesive type | Acrylic | Acrylic | Acrylic | Acrylic | Acrylic |
| Available widths | 6 mm - 1372 mm | 6 mm - 1372 mm | 6 mm - 1372 mm | 6 mm - 1372 mm | 6 mm - 1372 mm |

PROTECTION TAPE

Ensuring Blemish Free Surfaces

Our Protection Tapes

tesa® 51008 PE Protection Tape

Manufactured with a tough, tear and scuff resistant polyethylene film backing, tesa® 51008 protection tape is designed for protecting aluminium window frames. UV resistance of 12 months makes outdoor storage of the window frame possible. The tape has good conformability and adheres well to complex shapes. Available in black and white.

tesa® 51485 PVC Protection Tape

Manufactured from tough, flexible, black plasticised PVC film, which conforms easily to many window extrusion designs. The low tack adhesive removes cleanly from the window frame. The tape also exhibits low curl characteristics when unwinding, which allows easy application in long strips. Offers residue-free removal for up to 6 months.

tesa® 4848 PE Protection Film

Constructed with a low tack, transparent, UV resistant film, tesa® 4848 is ideal for the protection of window glass during transportation and installation. It is available in widths up to 1240mm and can be unwound easily and applied to large areas.



Product Specifications

| Product | tesa® 51008 Black | tesa® 51008 White | tesa® 51485 | tesa® 4848 |
|----------------------|-------------------|-------------------|-------------|-------------|
| Backing Material | PE film | PE film | PVC film | PE film |
| Adhesive | Acrylic | Acrylic | Rubber | Acrylic |
| Thickness | 125 µm | 80 µm | 115 µm | 48 µm |
| Colour | Black | White | Black | Transparent |
| Adhesion to steel | 1.7 N/cm | 2.28 N/cm | 0.8 N/cm | 0.8 N/cm |
| Residue free removal | 12 months | 12 months | 6 months | 4 weeks |



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

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 SE 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 support you.

For more information on our industry solutions,
visit our website www.tesatape.com.au

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