



tesa HAF[®] 8402

Product Information



125µm amber reactive HAF mounting tape

Product Description

tesa[®] HAF 8402 is a reactive heat activated film based on phenolic resin and nitrile rubber. This amber double sided tape has no backing. It is protected by a strong paper liner and can easily be slit and die cut.

At room temperature tesa[®] HAF 8402 is not tacky. It is activated for pre-lamination by heat and starts to become tacky at 90 °C. In a second application step heat and pressure is applied over a certain period of time.

After curing tesa[®] HAF 8402 reaches:

- *Very high bonding strength
- *High temperature resistance
- *Excellent chemical resistance
- *Bonds remain flexible and elastic

Application Fields

It is suitable for bonding of all thermal resistant materials such as metal, glass, plastic, wood and textiles.

- *High-strength splicing (overlap splice)
- *Structural bonding
- *Magnet bonding in electric motors
- *Friction liners for clutches

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 | none | • Total thickness | 125 µm |
| • Type of adhesive | nitrile rubber / phenolic resin | • Color | amber |
| • Type of liner | glassine | | |

Properties/Performance Values

- | | | | |
|------------------------------------|----------------------|-------------------------------|----------------------|
| • Bonding strength (dynamic shear) | 12 N/mm ² | • Bonding strength (push-out) | 12 N/mm ² |
|------------------------------------|----------------------|-------------------------------|----------------------|

Additional Information

Processing:

1.Pre-lamination:

tesa[®] HAF 8402 is laminated before curing. For this process we recommend a temperature between 120 °C and 140 °C.

For latest information on this product please visit <http://l.tesa.com/?ip=08402>



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2. Bonding:

The bonding conditions temperature, pressure and time depend on the application. Following parameters can be regarded as a guideline:

Splicing application:

*Temperature: 120-220 °C

*Pressure: >2bar

2bar

*Time: 15 – 90 s.

Friction liners for clutches:

*Temperature: 180 – 230 °C

*Pressure: > 8 bar

8 bar

*Time: 3 min – 30 min

Magnet bonding:

*Temperature: 140 – 180 °C

*Pressure > 6-10 bar

6-10 bar

*Time: 2 min - 5 min

Structural bonding:

*Temperature: 180 – 220 °C

*Pressure: > 10-15 bar

10-15 bar

*Time: > 3 - 30 min

3 - 30 min

Bonding strength values were obtained under standard laboratory conditions. Value is guaranteed clearance limit checked with each production batch (Material: Etched aluminium test specimen / Bonding conditions: Temp. = 120 °C; p = 10 bar; t = 8 min)

To reach maximum bonding strength surfaces should be clean and dry. Storage conditions according to tesa[®] HAF shelf life concept.



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