



tesa HAF® 8444

Product Information

100µm transparent HAF mounting tape

Product Description

tesa® HAF 8444 is a copolyester based thermoplastic bonding film. This transparent double sided tape has no backing. It is protected by a strong paper liner.

tesa® HAF 8444 is free of halogen and compliant with current ROHS standards.

At room temperature tesa® HAF 8444 is not tacky. It is activated by heat while applying slight pressure.

Special Features:

- *Reliable and ageing resistant bonds
- *Very high bonding strength on large bonding areas
- *Low bonding pressure required
- *Bonds remain elastic

Application Fields

tesa® HAF 8444 is especially recommended for bonding of metal components to various plastic or metal surfaces, e.g. SUS or AL to PC, PMMA or ABS:

- *Bonding of decorative metal components
- *Bonding of logo to housing
- *Fabric bonding in accessories

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 | 100 µm |
| • Type of adhesive | copolyester | • Color | transparent |
| • Type of liner | glassine | | |

Properties/Performance Values

- | | |
|--------------------|-----------------------|
| • Bonding strength | 5.5 N/mm ² |
|--------------------|-----------------------|

Additional Information

Technical recommendations: tesa® 8444 is not self adhesive. It is activated by heat while applying slight pressure.

The following values are recommendations for machine parameters to start with:

For latest information on this product please visit <http://l.tesa.com/?ip=08444>



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Additional Information

1. Pre-lamination: During pre-lamination, the adhesive tape is laminated onto the metal substrate. This step does not affect the shelf life time of the adhesive tape. Pre-laminated components can be stored over the same period of time as the adhesive tape.

Machine setting:

- Temperature¹ 100 – 140 °C
- Pressure² 2 – 5 bar
- Time 2 – 5 s.

2. Bonding: Remove the liner from tape after pre-lamination step. Place the metal part onto the plastic component. Apply sufficient temperature through the metal part while applying pressure for the bonding time to reach sufficient bonding strength.

Machine setting:

- Temperature¹ 125 – 150 °C
- Pressure² 2 – 5 bar
- Time 5 – 15 s.

To achieve optimum performance a cooling step (while applying pressure) directly after the bonding step is recommended.

¹ 'Pre-lamination' and 'Bonding' temperature refer to the data that is measured at the jig of heating jig.

² 'Pre-lamination' and 'Bonding' pressure refer to the force that is transformed from mould surface directly to the bonding area.

Bonding strength values were obtained under standard laboratory conditions. (Material: AL & PC test specimen / Bonding conditions: Temperature = 150 °C; Pressure = 5 bar; Time = 7 sec).

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



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