tesa HAF® 8401

Product Information

200 µm amber reactive HAF mounting tape

Product Description

tesa® HAF 8401 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 8401 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 8401 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	200 µm
• Type of adhesive	nitrile rubber / phenolic resin	• Color	amber
• Type of liner	glassine		

Properties/Performance Values

• Bonding strength (dynamic shear)	12 N/mm²	• Bonding strength (push-out)	12 N/mm²

Additional Information

Processing:
1.Pre-lamination:
tesa® HAF 8401 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=08401

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Additional Information

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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