



tesa HAF® 8402

Product Information



Heat activated film

Product Description

tesa® HAF 8402 is a double-sided thermosetting brown adhesive film, without backing, based on phenolic resin and nitrile rubber.

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 a very high bonding strength, high temperature stability and excellent chemical resistance. Because of the rubber components tesa® HAF 8402 remains flexible and elastic.

tesa® HAF 8402 is supplied with a strong paper liner and can easily be slit and die cut.

Application Fields

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

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 material | none | • Total thickness | 125 µm |
| • Type of adhesive | nitrile rubber / phenolic resin | • Colour | 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 90 °C and 110 °C.

2. Bonding:

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

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Splicing application:

- Temperature: 120 - 200 °C
- Pressure: > 2 bar
- Time: 15 sec - 90 sec

Friction liners for clutches:

- Temperature: 180 - 230 °C
- Pressure: > 6 bar
- Time: 5 min - 30 min

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

Note: Bonding strength values were obtained under standard laboratory conditions (Mean values). 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)

Disclaimer

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