



# tesa HAF® 58469

## Product Information

10µm black reactive HAF mounting tape

### Product Description

tesa HAF® 58469 is a reactive heat activated film based on phenolic resin and nitrile rubber. This black double sided tape has no backing. It is covered by a PET double liner solution.

tesa HAF® 58469 is free of halogen and compliant with current RoHS standards.

At room temperature tesa HAF® 58469 is not tacky. It is activated by heat and pressure applied during the assembly process.

#### Special Features:

- \* Reliable and ageing-resistant bonds
- \* Extremely high performance, even on small bonding areas and thin design gaps
- \* Very low oozing ratio
- \* Suitable for long-term applications that are exposed to heavy stress
- \* Bonds remain elastic

### Application Fields

tesa HAF® 58469 is especially recommended for bonding of metal components to various plastic or metal surfaces, e.g. SUS or AL to PMMA, PC or ABS:

- \* Constructive bonding inside electronic devices
- \* Button fixation
- \* Camera lens and bezel mounting
- \* Bonding of decorative metal components
- \* FPC mounting



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### 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	10 µm
• Type of adhesive	nitrile rubber / phenolic resin	• Color	black
• Type of liner	PET		

### Properties/Performance Values

• Bonding strength (dynamic shear)	6 N/mm <sup>2</sup>	• Bonding strength (push-out)	9 N/mm <sup>2</sup>
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### Additional Information

Technical recommendations:

tesa HAF® 58469 is not self adhesive. It is activated by heat and pressure over a certain interval. The following values are recommendations for bond line parameters to start with.

#### 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.

Setting:

\* Temperature<sup>1</sup> 95-120 °C

\* Pressure<sup>2</sup> 2-6 bar

\* Time 3-10 s

#### 2. Bonding:

For latest information on this product please visit <http://l.tesa.com/?ip=58469>



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### Additional Information

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

Setting:

\* Temperature<sup>1</sup> 120-250 °C

\* Pressure<sup>2</sup> 5-30 bar

\* Time 5-180 s

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

<sup>1</sup> 'Pre-lamination' and 'Bonding' temperature refer to the data that is measured in the bond line.

<sup>2</sup> 'Pre-lamination' and 'Bonding' pressure refer to the force that is transformed from jig surface directly to the bonding area.

Bonding strength values were obtained under standard laboratory conditions. (Material: etched aluminum test specimen / bonding conditions: temperature = 180 °C; pressure = 10 bar; time = 7 sec).

To reach maximum bonding strength surfaces should be clean and dry. Storage conditions according to tesa HAF<sup>®</sup> shelf life concept.



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### Disclaimer

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For latest information on this product please visit <http://l.tesa.com/?ip=58469>