



# tesa HAF<sup>®</sup> 8400

## Product Information



270µm amber reactive HAF mounting tape

## Product Description

tesa<sup>®</sup> HAF 8400 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<sup>®</sup> HAF 8400 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<sup>®</sup> HAF 8400 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)
- \*Friction liners for clutches
- \*Recommended for bonding of very rough materials due to its high thickness

## 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 | 270 µm |
| • Type of adhesive | nitrile rubber /<br>phenolic resin | • Color           | amber  |
| • Type of liner    | glassine                           |                   |        |

## Properties/Performance Values

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

## Additional Information

Processing:

1. Pre-lamination:

tesa<sup>®</sup> HAF 8400 is laminated before curing. For this process we recommend a temperature between 120 °C and 140 °C.

2. Bonding:

For latest information on this product please visit <http://l.tesa.com/?ip=08400>



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### Additional Information

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: > 2 bar

2 bar

\*Time: 15 – 90 s.

Friction liners for clutches:

\*Temperature: 180 – 230 °C

\*Pressure: > 6 - 10 bar

6 - 10 bar

\*Time: 3 min – 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.

### Disclaimer

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