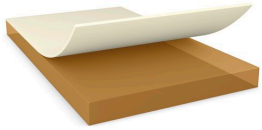
tesa HAF® 8400

Product Information



270µm amber reactive HAF mounting tape

Product Description

tesa 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 HAF® 8400 is not tacky. It is activated for pre-lamination by heat and starts to become tacky at 90 °C/194° F. In a second application step heat and pressure is applied over a certain period of time.

After curing tesa 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 10.6 mils
• 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:

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

tesa HAF® 8400

Product Information

Additional Information

tesa HAF® 8400 is laminated before curing. For this process we recommend a temperature between 120 °C/248° F and 140 °C/284 °F.

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 (248-428 °F)
- Pressure: > 2 bar
- Time: 15 – 90 s.

Friction liners for clutches:

- Temperature: 180 – 230 °C (356-446 °F)
- Pressure: > 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/248° F; 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

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