



tesa HAF® 8490

Product Information



315 µm single sided amber reactive HAF mounting tape

Product Description

tesa HAF® 8490 is a reactive heat activated film based on phenolic resin and nitrile rubber. This amber single sided tape has a cotton fabric backing. It can easily be slit and die cut.

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.

Product Features

- Very high bonding strength
- High temperature resistance
- Excellent chemical resistance
- Bonds remain flexible and elastic
- At room temperature tesa HAF® 8490 is not tacky.

Application Fields

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

- High-strength splicing (single-side butt splice)

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 | cotton fabric | • Total thickness | 315 µm |
| • Type of adhesive | nitrile rubber / phenolic resin | • Color | amber |
| • Type of liner | none | | |

Properties/Performance Values

- | | | | |
|-----------------------------------|-----------|-----------------------------------|-----------|
| • Tensile strength | 90 N/cm | • Shelf life time (packed) < 25°C | 12 months |
| • Shelf life time (packed) < 15°C | 15 months | • Shelf life time (packed) < 5°C | 18 months |

Additional Information

Processing:

1. Pre-lamination:

For latest information on this product please visit <http://l.tesa.com/?ip=08490>



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tesa HAF® 8490 is laminated before curing. For this process we recommend a temperature between 120 °C and 140 °C.

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: > 2 bar
- Time: 15–90 s.

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: temperature = 120 °C; pressure = 10 bar; time = 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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