

8414

Product Information



Cinta adhesiva doble cara de transferencia térmica , conductiva

Descripción del producto

Tesa® HAF 8414 es una película adhesiva translúcida activada por calor que contiene partículas eléctricamente conductoras.

Características especiales:

- Enlace de módulo de chip y conectividad eléctrica en un solo paso
- Buena trabajabilidad en todas las líneas de implante comunes
- Adecuado para tarjetas de PVC, ABS y PC (Dual Interface (D.I.) y tarjetas sin contacto)
- Adecuado para sustratos de tinta plateada y antena de alambre

Diámetro medio de las partículas: 40 µm

Características

- Chip module bonding and electrical connectivity in one step
- Good workability on all common implanting lines
- Suitable for PVC, ABS and PC cards (Dual Interface (D.I.) and contactless cards)
- Suitable for silver ink substrates and wire antenna
- Mean particle diameter: 40 µm

Aplicación

tesa HAF® 8414 is designed for all applications where reliable electrical connections and strong bonds are required. Lead applications are chip module embedding in Dual Interface (DI) cards and for RFID tags.

Información Técnica: (valores promedio)

Los valores en esta sección son considerados solamente como representativos o típicos y no deben usarse para propósitos específicos.

Composición del producto

- | | | | |
|-----------------------|-------------|---------------------|-------------|
| • Material de soporte | ninguno | • Tipo de protector | glassine |
| • Tipo de adhesivo | copoliámida | • Color | translúcido |

Additional Information

Processing:

Please note that optimal parameters strongly depend on the type of machine, particular materials for card bodies, antenna material or chip-modules as well as individual customer requirements. The bonding time depends on the heat transition of the used substrates. Additionally we recommend a cooling step directly after the bonding step. Thereby pressure should be applied until film temperature decreases below softening temperature (approx. 110 °C).

The following data are recommendations for the initial set-up of machine parameters.

For latest information on this product please visit <http://l.tesa.com/?ip=08414>



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Additional Information

1. Pre-lamination:

During pre-lamination, the adhesive tape is laminated onto the module belt. An accurate pre-lamination is in particular important for tesa HAF® 8414 in order to ensure a good adhesion and a good conductivity inside of the final product.

Machine setting:

- Temperature 130 - 150 °C
- Pressure 3 - 4 bar
- Time 2.5 m/min.

2. Conductive Bonding:

During module embedding, the pre-laminated modules are die-cut from the module belt, positioned into the card cavity and permanently bonded to the card body by heat and pressure. Depending on the type of the implanting line, single step or multiple step process can be used. Today, most implanting machines have multiple heat press steps.

Single step process - Machine setting:

- Temperature¹ 160 – 220 °C
- Pressure 65 - 130 N/module
- Time 1.5 s

Multiple step process (2 or more heating stamps) - Machine setting:

- Temperature¹ 180 – 220 °C
- Pressure 65 - 130N/module
- Time 2 x 0,7 s. / 3 x 0.5 s.

¹Temperature recommendations refer to what can be measured inside the heating stamp. Different temperature settings are recommended for different card material:

- PVC 180 – 190 ° C
- ABS 180 – 190 ° C
- PET 190 – 200 ° C
- PC 200 – 220 °C

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



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Disclaimer

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