



# 8402

## Product Information



Heat activated film

### Product Description

tesa® HAF 8402 is a double-sided thermosetting brown adhesive film, without backing, based on phenolic resin and nitrile rubber.

At room temperature tesa® HAF 8402 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® HAF 8402 reaches a very high bonding strength, high temperature stability and excellent chemical resistance. Because of the rubber components tesa® HAF 8402 remains flexible and elastic.

tesa® HAF 8402 is supplied with a strong paper liner and can easily be slit and die cut.

### Product Features

- Very high bonding strength
- High temperature resistance
- Excellent chemical resistance
- Resistance against oil and solvents
- 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.

### 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 material | none                               | • Total thickness | 125 µm |
| • Type of adhesive | nitrile rubber /<br>phenolic resin | • Colour          | amber  |
| • Type of liner    | glassine                           |                   |        |

### Properties/Performance Values

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

### Additional Information

Processing:

For latest information on this product please visit <http://l.tesa.com/?ip=08402>



# 8402

## Product Information

### Additional Information

#### 1. Pre-lamination:

tesa® HAF 8402 is laminated before curing. For this process we recommend a temperature between 90 °C and 110 °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 - 200 °C
- Pressure: > 2 bar
- Time: 15 sec - 90 sec

#### Friction liners for clutches:

- Temperature: 180 - 230 °C
- Pressure: > 6 bar
- Time: 5 min - 30 min

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

Note: Bonding strength values were obtained under standard laboratory conditions (Mean values). 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)

### Disclaimer

tesa® products prove their impressive quality day in, day out in demanding conditions and are regularly subjected to strict controls. All information and recommendations are provided to the best of our knowledge on the basis of our practical experience. Nevertheless tesa SE can make no warranties, express or implied, including, but not limited to any implied warranty of merchantability or fitness for a particular purpose. Therefore, the user is responsible for determining whether the tesa® product is fit for a particular purpose and suitable for the user's method of application. If you are in any doubt, our technical support staff will be glad to support you.



For latest information on this product please visit <http://l.tesa.com/?ip=08402>