



**Product Information** 



# 200 $\mu$ m amber reactive HAF mounting tape

#### **Product Description**

tesa<sup>®</sup> HAF 8401 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 8401 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 8401 reaches: \*Very high bonding strength \*High temperature resistance \*Excellent chemical resistance \*Bonds remain flexible and elastic

## **Product Features**

- Very high bonding strength
- High temperature resistance
- Excellent chemical resistance
- Resistance against oil and solvents
- Bonds remain flexible and elastic

## **Applications**

It is suitable for bonding of all thermal resistant materials such as metal, glass, plastic, wood and textiles. \*High-strength splicing (overlap splice) \*Structural bonding \*Magnet bonding in electric motors \*Friction liners for clutches

#### Technical Information (average values)

The values in this section should be considered representative or typical only and should not be used for specification purposes.

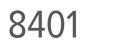
## **Applications**

Type of liner

- Backing
- Type of adhesive
- none nitrile rubber / phenolic resin glassine
- Total thickness
- Color

200 µm amber





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#### **Properties/Performance Values**

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

#### **Additional Information**

Processing: 1.Pre-lamination: tesa® HAF 8401 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:>2bar 2bar \*Time: 15 – 90 s. Friction liners for clutches: \*Temperature: 180 – 230 °C \*Pressure: > 8 bar 8 bar \*Time: 3 min – 30 min Magnet bonding: \*Temperature: 140 – 180 °C \*Pressure: > 6-10 bar 6-10 bar \*Time: 2 min - 5 min Structural bonding: \*Temperature: 180 – 220 °C \*Pressure: > 10-15 bar 10-15 bar \*Time: > 3 - 30 min 3 - 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. =  $120 \degree$ C; p =  $10 \degree$  bar; t = 8

min)

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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