



tesa HAF® 8490

Product Information



Heat activated film

Product Description

tesa® HAF 8490 is a thermosetting single-sided adhesive film (brown) that is based on phenolic resin and nitrile rubber. It has a white cotton fabric carrier.

At room temperature tesa® HAF 8490 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 8490 reaches a very high bonding strength, high temperature stability and excellent chemical resistance. Because of the rubber components HAF 8490 remains flexible and elastic.

tesa® HAF 8490 can easily be slit and die-cut.

Application Fields

It is suitable for bonding of all thermally 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	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:

tesa® HAF 8490 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:

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



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Splicing application:

- Temperature: 120°C - 200°C
- Pressure: > 2 bar
- Time: 15 sec - 90 sec

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

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