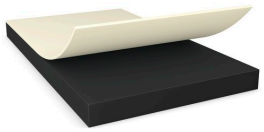
tesa® HAF 58435

Product Information



Product Description

tesa® HAF 58435 is a reactive heat activated structural bonding film based on phenolic resin and nitrile rubber. This black double sided tape has no backing. It is protected by a strong paper liner.

It is activated by heat and pressure applied during the assembly process.

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: none
- Type of adhesive: nitrile rubber / phenolic resin
- Type of liner: glassine
- Total thickness: 125 µm
- Color: black

Properties/Performance Values

- Bonding strength (push-out): 11 N/mm^2

Additional Information

Processing

tesa® HAF 58435 is not self adhesive. It is activated by heat and pressure over a certain interval. The following values are recommendations for machine parameters to start with. Please note that optimum parameters strongly depend on the type of machine, particular materials as well as customer requirements.

1. Pre-lamination: tesa® HAF 58435 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.

Friction liners for clutches:

- Temperature: 180–230 °C
- Pressure: > 8 bar
- Time: 3 –30 min

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Magnet bonding:

- Temperature: 140–180 °C
- Pressure: > 6-10 bar
- Time: 2-5 min

Structural bonding:

- Temperature: 180–220 °C
- Pressure: > 10-15 bar
- Time: > 3-30 min

Bonding strength values were obtained under standard laboratory conditions. Value is guaranteed clearance limit checked with each production batch (Material: SUS test specimen / bonding conditions: temperature = 180 °C; pressure = 10 bar; time = 30 sec). To reach maximum bonding strength surfaces should be clean and dry.

Disclaimer

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