

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	• Total thickness	125 µm
• Type of adhesive	nitrile rubber / phenolic resin	• Color	black
• Type of liner	glassine		

Properties/Performance Values

- Bonding strength (push-out) 11 N/mm²

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

For latest information on this product please visit <http://l.tesa.com/?ip=58435>

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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

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.



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