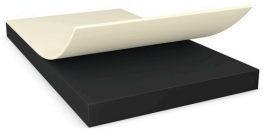
tesa HAF® 58469

Product Information



10µm black reactive HAF mounting tape

Product Description

tesa HAF® 58469 is a reactive heat activated film based on phenolic resin and nitrile rubber. This black double sided tape has no backing. It is covered by a PET double liner solution.

tesa HAF® 58469 is free of halogen and compliant with current RoHS standards.

At room temperature tesa HAF® 58469 is not tacky. It is activated by heat and pressure applied during the assembly process.

Special Features:

* Reliable and ageing-resistant bonds

* Extremely high performance, even on small bonding areas and thin design gaps

* Very low oozing ratio

* Suitable for long-term applications that are exposed to heavy stress

* Bonds remain elastic

Application Fields

tesa HAF® 58469 is especially recommended for bonding of metal components to various plastic or metal surfaces, e.g. SUS or AL to PMMA, PC or ABS:

* Constructive bonding inside electronic devices

* Button fixation

* Camera lens and bezel mounting

* Bonding of decorative metal components

* FPC mounting

For latest information on this product please visit http://l.tesa.com/?ip=58469

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Product Information

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: PET
- Total thickness: 10 µm
- Color: black

Properties/Performance Values

- Bonding strength (push-out): 9 N/mm²

Additional Information

Technical recommendations:

tesa HAF® 58469 is not self adhesive. It is activated by heat and pressure over a certain interval. The following values are recommendations for bond line parameters to start with.

1. Pre-lamination:

During pre-lamination, the adhesive tape is laminated onto the metal substrate. This step does not affect the shelf life time of the adhesive tape. Pre-laminated components can be stored over the same period of time as the adhesive tape.

Setting:

* Temperature[1] 95-120 °C

* Pressure[2] 2-6 bar

* Time 3-10 s

2. Bonding:

Remove the liner from tape after pre-lamination step. Place the plastic part onto the metal component. Apply sufficient temperature while applying pressure for the bonding time to reach sufficient bonding strength.

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Additional Information

Setting:

* Temperature[1] 120-250 °C

* Pressure[2] 5-30 bar

* Time 5-180 s

To achieve optimum performance a cooling step (while applying pressure) directly after the bonding step is recommended.

[1] 'Pre-lamination' and 'Bonding' temperature refer to the data that is measured in the bond line.

[2] 'Pre-lamination' and 'Bonding' pressure refer to the force that is transformed from jig surface directly to the bonding area.

Bonding strength values were obtained under standard laboratory conditions. (Material: etched aluminum test specimen / bonding conditions: temperature = 180 °C; pressure = 10 bar; time = 7 sec).

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

Disclaimer

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