

# 9401

## Product Information



Double-sided reactive heat activated film

### Product Description

tesa HAF® 9401 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® 9401 is not tacky. It is activated by heat and starts to become tacky at 90 °C for pre-lamination. In a second application step heat and pressure is applied over a certain period of time.

After curing tesa HAF® 9401 reaches:

- \*Very high bonding strength
- \*High temperature resistance
- \*Resistance against oil and solvents
- \*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

### Application Fields

It is suitable for bonding of all thermal resistant materials such as metal, glass, plastic, wood and textiles.

- \*Friction linings for clutch discs
- \*Friction linings for synchronizer rings

### Technical Information (average values)

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



# 9401

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### Product Construction

• Backing	none	• Total thickness	200 µm
• Type of adhesive	nitrile rubber / phenolic resin	• Color	amber
• Type of liner	glassine		

### Properties/Performance Values

• Bonding strength (dynamic shear)	12 N/mm <sup>2</sup>
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### Additional Information

Processing:

#### 1. Pre-lamination:

tesa HAF® 9401 is laminated to the first substrate. For this process we recommend a temperature between 120 °C and 140 °C and a slight pressure of 0.5 - 2.5 bar for 3 - 10 sec.

#### 2. Bonding:

The liner is removed from the tape after pre-lamination. The bonding conditions depend on the application. Following parameters can be regarded as a guideline:

\*Temperature: 180 – 230 °C

\*Pressure: > 8 bar

\*Time: 3 min – 30 min

#### 3. Tempering (optional)

To reach the maximum bonding strength the bonded parts can be tempered at 180 - 230°C for 30 - 60 min without pressure.

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 °C; p = 10 bar; t = 8 min)

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

For latest information on this product please visit <http://l.tesa.com/?ip=09401>



# 9401

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### Disclaimer

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For latest information on this product please visit <http://l.tesa.com/?ip=09401>