

9410

Product Information



60µm amber reactive HAF mounting tape

Product Description

tesa HAF® 9410 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® 9410 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® 9410 reaches:

- *Very high bonding strength
- *High temperature resistance of up to 350°C
- *Excellent chemical resistance
- *Resistance against oil and solvents
- *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.



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Product Construction

• Backing	none	• Total thickness	60 µm
• Type of adhesive	nitrile rubber / phenolic resin	• Color	amber
• Type of liner	glassine		

Properties/Performance Values

• Bonding strength (dynamic shear)	12 N/mm ²
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Additional Information

Processing:

1. Pre-lamination:

tesa HAF® 9410 is laminated before curing. For this process we recommend a temperature between 90°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:

Friction linings for synchronizer rings:

*Temperature: 180 – 230°C

*Pressure: > 6 bar

*Time: 3 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.

For latest information on this product please visit <http://l.tesa.com/?ip=09410>



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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.

Disclaimer

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