

# tesa HAF® 9472



## Product Information

### Reactive heat activated film tape

tesa HAF® 9472 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 be easily slit and die cut.

At room temperature tesa HAF® 9472 is not tacky. It is activated by heat and starts to become tacky at 90 °C for pre-lamination.

After curing tesa HAF® reaches:

- Reliable and ageing-resistant bonds
- Extremely high performance, even on small bonding areas
- Very low oozing ratio
- Suitable for long-term applications that are exposed to heavy stress
- Bonds remain flexible and elastic
- Resistance against oil and solvents

### Main Application

tesa HAF® 9472 is especially recommended for bonding of thermal resistant materials such as metal, glass, plastic and textiles.

\* Mounting of sensor plates

### Technical Information (average values)

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

#### Technical Data

- |                    |                                    |                          |                     |
|--------------------|------------------------------------|--------------------------|---------------------|
| • Backing material | none                               | • Bonding strength       | 7 N/mm <sup>2</sup> |
| • Color            | amber                              | • Shelf life time < 5°C  | 18 months           |
| • Total thickness  | 60 µm                              | • Shelf life time < 15°C | 15 months           |
| • Type of adhesive | nitrile rubber /<br>phenolic resin | • Shelf life time < 25°C | 12 months           |
| • Type of liner    | glassine                           |                          |                     |

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### Additional Information

Processing:

#### 1. Pre-lamination:

During pre-lamination, the adhesive tape is laminated onto the first substrate. For this process we recommend a temperature between 90 °C and 140 °C for 3 - 10 s and a pressure of 0.5 - 2.5 bar. 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.

#### 2. Bonding:

Remove the liner from the tape after pre-lamination. Position the second substrate and apply heat and pressure for the bonding. Following parameters can be regarded as a guideline:

\* Temperature<sup>1</sup> 180 - 230 °C

\* Pressure<sup>2</sup> >6 bar

\* Time 3 min

#### 3. Tempering (optional)

To reach maximum bonding strength the bonded parts can be tempered at 180 - 230 °C for 30 - 60 min.

<sup>1</sup> 'Pre-lamination' and 'Bonding' temperature refer to the data that is measured at the bond line.

<sup>2</sup> '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).

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<http://t.tesa.com/?ip=09472>

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

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