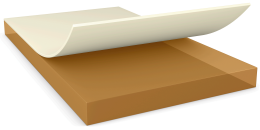
tesa® HAF 8471

Product Information



30µm amber reactive HAF mounting tape

Product Description

tesa® HAF 8471 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.

tesa® HAF 8471 is free of halogen and compliant with current ROHS standards.

At room temperature tesa® HAF 8471 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 8471 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

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 material	none
Type of adhesive	nitrile rubber / phenolic resin
Type of liner	glassine
Total thickness	30 µm
Color	amber, orange

Properties/Performance Values

Bonding strength	7 N/mm^2

For latest information on this product please visit http://l.tesa.com/?ip=08471

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Additional Information

Technical recommendations:
tesa® HAF 8471 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.

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.

Machine setting:

- Temperature[1] 90 – 120 °C
- Pressure[2] 2 – 6 bar
- Time 1 – 3 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.

Machine setting:

- Temperature[1] 180 – 220 °C
- Pressure[2] 2 – 10 bar
- Time 3 – 10 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 at the surface of heating jig.
[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.

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Disclaimer

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