



tesa HAF® 8401

Product Information



200 µm / 7.9 mils amber reactive structural bonding film

Product Description

tesa HAF® 8401 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.

It is activated by heat and pressure applied over a certain period of time.

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.

- High-strength splicing (overlap splice)
- Structural bonding
- Magnet bonding in electric motors
- Friction liners for clutches

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 | • Total thickness | 200 µm |
| • Type of adhesive | nitrile rubber /
phenolic resin | • Color | 7.9 mils
amber |
| • Type of liner | glassine | | |

Properties/Performance Values

- | | | | |
|------------------------------------|----------------------|-------------------------------|----------------------|
| • Bonding strength (dynamic shear) | 12 N/mm ² | • Bonding strength (push-out) | 12 N/mm ² |
|------------------------------------|----------------------|-------------------------------|----------------------|

Additional Information

Processing:

For latest information on this product please visit <http://l.tesa.com/?ip=08401>



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Product Information

Additional Information

1. Pre-lamination:

tesa HAF® 8401 is laminated before curing. For this process we recommend a temperature between 120 °C/248 °F and 140 °C/284 °F.

2. Bonding:

The bonding conditions temperature, pressure and time depend on the application. Following parameters can be regarded as a guideline:

Splicing application:

- Temperature: 120-220 °C (248-428 °F)
- Pressure: >2bar
- Time: 15 – 90 s

Friction liners for clutches:

- Temperature: 180 – 230 °C (356-446 °F)
- Pressure: > 8 bar
- Time: 3 min – 30 min

Magnet bonding:

- Temperature: 140 – 180 °C (284-356 °F)
- Pressure: > 6-10 bar
- Time: 2 min - 5 min

Structural bonding:

- Temperature: 180 – 220 °C (356-428 °F)
- Pressure: > 10-15 bar
- Time: > 3 - 30 min

Bonding strength values were obtained under standard laboratory conditions. Value is guaranteed clearance limit checked with each production batch (Material: Etched aluminum test specimen / Bonding conditions: Temp. = 120 °C/248 °F; 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.



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