



# 8400

## Product Information



270µm amber reactive HAF mounting tape

### Product Description

tesa HAF® 8400 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® 8400 is not tacky. It is activated for pre-lamination by heat and starts to become tacky at 90 °C/194° F. In a second application step heat and pressure is applied over a certain period of time.

After curing tesa HAF® 8400 reaches:

- Very high bonding strength
- High temperature resistance
- 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.

- High-strength splicing (overlap splice)
- Friction liners for clutches
- Recommended for bonding of very rough materials due to its high thickness

### 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	270 µm
• Type of adhesive	nitrile rubber / phenolic resin	• Color	10.6 mils amber
• Type of liner	glassine		

For latest information on this product please visit <http://l.tesa.com/?ip=08400>



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### Properties/Performance Values

- |                                    |                      |                          |              |
|------------------------------------|----------------------|--------------------------|--------------|
| • Bonding strength (dynamic shear) | 12 N/mm <sup>2</sup> | • Shelf life time < 25°C | _NULL months |
| • Shelf life time < 15°C           | _NULL months         | • Shelf life time < 5°C  | _NULL months |

### Additional Information

Processing:

#### 1.Pre-lamination:

tesa HAF® 8400 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: > 2 bar
- Time: 15 – 90 s.

Friction liners for clutches:

- Temperature: 180 – 230 °C (356-446 °F)
- Pressure: > 6 - 10 bar
- Time: 3 min – 30 min

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/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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