



# tesa HAF® 8402

## Product Information



125µm/4.9 mils amber reactive HAF mounting tape

## Product Description

tesa HAF® 8402 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® 8402 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® 8402 reaches:

- Very high bonding strength
- High temperature resistance
- Excellent chemical resistance
- 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

- |                    |                                    |                   |                   |
|--------------------|------------------------------------|-------------------|-------------------|
| • Type of liner    | glassine                           | • Total thickness | 125 µm            |
| • Backing material | none                               | • Color           | 4.9 mils<br>amber |
| • Type of adhesive | nitrile rubber /<br>phenolic resin |                   |                   |

## Properties/Performance Values

- |                                    |                      |
|------------------------------------|----------------------|
| • Bonding strength (dynamic shear) | 12 N/mm <sup>2</sup> |
|------------------------------------|----------------------|

## Additional Information

Processing:

1.Pre-lamination:

For latest information on this product please visit <http://l.tesa.com/?ip=08402>



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### Additional Information

tesa HAF® 8402 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 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.

### Disclaimer

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