tesa HAF® 8440
40µm translucent HAF mounting tape

tesa HAF® 8440 is a heat activated, double-sided translucent adhesive film based on thermoplastic copolyamide.

Special Features:

* Reliable chip module bonding
* Suitable for PVC, ABS and PC cards
* Good workability on all common implanting lines
* Good ageing resistance
* Invisible on assembled card

Main Application

tesa HAF® 8440 is especially designed for the embedding of chip-modules into smart cards.

Technical Data

- Backing material: none
- Total thickness: 40 µm
- Type of adhesive: copolyamide
- Type of liner: glassine
- Bonding strength: 12 N/mm²

For latest information on this product please visit [http://l.tesa.com/?ip=08440](http://l.tesa.com/?ip=08440)
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Additional Information

Technical Recommendations:
The following values are recommendation for machine parameters to start with. Please note that optimum parameters strongly
depend on the type of machine, particular materials for card bodies and chip-modules as well as customer requirements.

1. Pre-lamination:
During pre-lamination, the adhesive tape is laminated onto the module belt. This step can be performed inline or offline. The pre-
lamination step does not effect the shelf life time of the adhesive tape.

Machine setting:
- Temperature 130 - 140 °C
- Pressure 2 - 3 bar
- Time 2.5 m/min

2. Module Embedding:
During module embedding, the pre-laminated modules are die cut from the module belt, positioned into the card cavity and
permanently bonded to the card body by heat and pressure. For this step, the exact handling depends on the type of the
implanting line used. Single step and multiple step can be used. Today, multiple step is common:

Single step process - Machine setting :
- Temperature¹ 180 – 220 °C
- Pressure 65 - 75 N/module
- Time 1.5 s

Multiple step process (2 or more heating stamps) - Machine setting:
- Temperature¹ 180 – 220 °C
- Pressure 65 - 75 N/module
- Time 2 x 0,7 s. /3 x 0.5 s

¹ Temperature as measured inside the heating stamp. Different temperature settings are recommended for different card
material:
*PVC 180 - 190 °C
*ABS 180 - 190 °C
*PC 200 - 220°C

For applicants other than chip module implanting, different machine parameters should be used.
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; p = 10 bar; t = 8 min)

Storage conditions according to tesa HAF® shelf life concept.

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tesa® products prove their impressive quality day in, day out in demanding conditions and are regularly subjected to strict controls. All technical
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glad to support you.