

# tesa HAF® 8405



## product information

### 30µm amber reactive HAF mounting tape

tesa HAF® 8405 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® 8405 is not tacky. It is activated by heat and starts to become tacky at 90 °C for pre-lamination. In a second application step heat and pressure is applied over a certain period of time.

After curing tesa HAF® 8405 reaches:

- Very high bonding strength
- High temperature resistance
- Excellent chemical resistance
- Bonds remain flexible and elastic

### Main Application

It is suitable for bonding of all thermal resistant materials such as metal, glass, plastic, wood and textiles.

- Friction liner 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.

#### Technical Data

|                    |                                    |                          |                      |
|--------------------|------------------------------------|--------------------------|----------------------|
| • Backing material | none                               | • Bonding strength       | 12 N/mm <sup>2</sup> |
| • Color            | amber                              | • Shelf life time < 5°C  | 18 months            |
| • Total thickness  | 30 µm                              | • Shelf life time < 15°C | 15 months            |
| • Type of adhesive | nitrile rubber /<br>phenolic resin | • Shelf life time < 25°C | 12 months            |
| • Type of liner    | glassine                           |                          |                      |

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### Additional Information

Processing:

#### 1. Pre-lamination:

tesa HAF® 8405 is laminated before curing. For this process we recommend a temperature between 120 °C and 140 °C.

#### 2. Bonding:

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

Friction liners for clutches:

- Temperature: 180 – 230 °C
- Pressure: > 8 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; 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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