

tesa® HAF 8400

270µm amber reactive HAF mounting tape

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. 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

Main Application

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 Data

▪ Backing material	none	▪ Bonding strength	12 N/mm ²
▪ Color	amber	▪ Shelf life time (packed) < 5°C	18 months
▪ Total thickness	270 µm	▪ Shelf life time (packed) < 15°C	15 months
▪ Type of adhesive	nitrile rubber / phenolic resin	▪ Shelf life time (packed) < 25°C	12 months
▪ Type of liner	glassine		

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

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Additional Information

Processing:

1. Pre-lamination:

tesa® HAF 8400 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:

Splicing application:

*Temperature: 120 – 220 °C

*Pressure: > 2 bar

2 bar

*Time: 15 – 90 s.

Friction liners for clutches:

*Temperature: 180 – 230 °C

*Pressure: > 6 - 10 bar

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; 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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