

## tesa® HAF 8402

### 125µm amber reactive HAF mounting tape

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. 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

## 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)
- \*Structural bonding
- \*Magnet bonding in electric motors
- \*Friction liners for clutches

## Technical Data

▪ Backing material	none	▪ Bonding strength	12 N/mm <sup>2</sup>
▪ Color	amber	▪ Shelf life time (packed) < 5°C	18 months
▪ Total thickness	125 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=08402>

tesa® products prove their impressive quality day in, day out in demanding conditions and are regularly subjected to strict controls. All information and recommendations are provided to the best of our knowledge on the basis of our practical experience. Nevertheless tesa SE can make no warranties, express or implied, including, but not limited to any implied warranty of merchantability or fitness for a particular purpose. Therefore, the user is responsible for determining whether the tesa® product is fit for a particular purpose and suitable for the user's method of application. If you are in any doubt, our technical support staff will be glad to support you.

# tesa® HAF 8402

## 125µm amber reactive HAF mounting tape

### Additional Information

#### Processing:

##### 1. Pre-lamination:

tesa® HAF 8402 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: >2bar

2bar

\*Time: 15 – 90 s.

#### Friction liners for clutches:

\*Temperature: 180 – 230 °C

\*Pressure: > 8 bar

8 bar

\*Time: 3 min – 30 min

#### Magnet bonding:

\*Temperature: 140 – 180 °C

\*Pressure > 6-10 bar

6-10 bar

\*Time: 2 min - 5 min

#### Structural bonding:

\*Temperature: 180 – 220 °C

\*Pressure: > 10-15 bar

10-15 bar

\*Time: > 3 - 30 min

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; 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.

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

tesa® products prove their impressive quality day in, day out in demanding conditions and are regularly subjected to strict controls. All information and recommendations are provided to the best of our knowledge on the basis of our practical experience. Nevertheless tesa SE can make no warranties, express or implied, including, but not limited to any implied warranty of merchantability or fitness for a particular purpose. Therefore, the user is responsible for determining whether the tesa® product is fit for a particular purpose and suitable for the user's method of application. If you are in any doubt, our technical support staff will be glad to support you.