

## tesa® HAF 58471

### 30µm black reactive HAF mounting tape

tesa® HAF 58471 is a reactive heat activated film based on phenolic resin and nitrile rubber. This black double sided tape has no backing. It is protected by a strong paper liner.

tesa® HAF 58471 is free of halogen and compliant with current ROHS standards.

At room temperature tesa® HAF 58471 is not tacky. It is activated by heat and pressure applied during the assembly process.

#### Special Features:

- \*Reliable and ageing resistant bonds
- \*Extremely high performance, even on small bonding areas and thin design gaps
- \*Very low oozing ratio
- \*Suitable for long-term applications that are exposed to heavy stress
- \*Bonds remain elastic

## Main Application

tesa® HAF 58471 is especially recommended for bonding of metal components to various plastic or metal surfaces, e.g. SUS or AL to PMMA, PC or ABS:

- \*Constructive bonding inside electronic devices
- \*Button fixation
- \*Camera lens and bezel mounting
- \*Bonding of decorative metal components

## Technical Data

▪ Backing material	none	▪ Type of adhesive	nitrile rubber / phenolic resin
▪ Color	black	▪ Type of liner	glassine
▪ Total thickness	30 µm	▪ Bonding strength	7 N/mm <sup>2</sup>

For latest information on this product please visit <http://l.tesa.com/?ip=58471>

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### Additional Information

#### Technical recommendations:

tesa® HAF 58471 is not self adhesive. It is activated by heat and pressure over a certain interval. The following values are recommendations for machine parameters to start with.

#### 1. Pre-lamination:

During pre-lamination, the adhesive tape is laminated onto the metal substrate. This step does not affect the shelf life time of the adhesive tape. Pre-laminated components can be stored over the same period of time as the adhesive tape.

#### Machine setting:

- Temperature<sup>1</sup> 90 – 120 °C
- Pressure<sup>2</sup> 2 – 6 bar
- Time 1 – 3 s

#### 2. Bonding:

Remove the liner from tape after pre-lamination step. Place the plastic part onto the metal component. Apply sufficient temperature while applying pressure for the bonding time to reach sufficient bonding strength.

#### Machine setting:

- Temperature<sup>1</sup> 180 – 220 °C
- Pressure<sup>2</sup> 2 – 10 bar
- Time 3 – 10 s

To achieve optimum performance a cooling step (while applying pressure) directly after the bonding step is recommended.

<sup>1</sup> 'Pre-lamination' and 'Bonding' temperature refer to the data that is measured at the surface of heating jig.

<sup>2</sup> 'Pre-lamination' and 'Bonding' pressure refer to the force that is transformed from jig surface directly to the bonding area. Bonding strength values were obtained under standard laboratory conditions. (Material: etched aluminum test specimen / bonding conditions: temperature = 180 °C; pressure = 10 bar; time = 7 sec).

To reach maximum bonding strength surfaces should be clean and dry. Storage conditions according to tesa® HAF shelf life concept.

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