productinformation

tesa® 58493
83µm double sided black reactive HAF mounting tape

tesa® HAF 58493 is a reactive heat activated film based on phenolic resin and nitrile rubber. This black double sided tape has a PET backing. It is protected by a strong paper liner.

tesa® HAF 58493 is free of halogen and compliant with current ROHS standards.

At room temperature tesa® HAF 58493 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
*Extremely low oozing ratio
*Very good dimension stability and easy die-cut handling
*PET backing provides barrier function in mesh bonding applications
*Suitable for long-term applications that are exposed to heavy stress
*Bonds remain elastic

Main Application

tesa® HAF 58493 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
*Speaker mesh mounting
*Button fixation
*Camera lens and bezel mounting
*Bonding of decorative metal components

Technical Data

▪ Backing material	PET	▪ Type of adhesive	nitrile rubber / phenolic resin
▪ Color	black		
▪ Total thickness	83 µm	▪ Type of liner	glassine
		▪ Bonding strength	6 N/mm²

For latest information on this product please visit http://l.tesa.com/?ip=58493

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Additional Information

Technical recommendations:
tesa® HAF 58493 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[1] 90 – 120 °C
- Pressure[2] 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[1] 180 – 220 °C
- Pressure[2] 2 – 10 bar
- Time 3 – 10 s

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

[1] 'Pre-lamination' and 'Bonding' temperature refer to the data that is measured at the surface of heating jig.
[2] '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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