

# tesa® HAF 8490

Heat activated film

## PRODUCT INFORMATION

### Product Description

tesa® HAF 8490 is a thermosetting single-sided adhesive film (brown) that is based on phenolic resin and nitrile rubber. It has a white cotton fabric carrier.

At room temperature, tesa® HAF 8490 is not tacky. It is activated for pre-lamination by heat and becomes tacky at 90°C. In a second application step heat and pressure is applied over a certain period of time.

After curing, tesa® HAF 8490 reaches a very high bonding strength, high temperature stability and excellent chemical resistance. Because of the rubber components, HAF 8490 remains flexible and elastic.

tesa® HAF 8490 can easily be slit and die-cut.

### Main Application

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

### Technical Data

■ Backing material	cotton fabric	■ Type of liner	none
■ Color	amber	■ Shelf life time (packed) < 5°C	18 months
■ Total thickness	315 µm 12.4 mils	■ Shelf life time (packed) < 15°C	15 months
■ Type of adhesive	nitrile rubber / phenolic res	■ Shelf life time (packed) < 25°C	12 months
■ Tensile strength	90 N/cm 51.4 lbs/in		

### Additional Info

Processing:

1. Pre-lamination:

tesa® HAF 8490 is laminated before curing. For this process we recommend a temperature between 90 °C and 110 °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°C - 200°C
- Pressure: > 2 bar
- Time: 15 sec - 90 sec

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

Note: Bonding strength values were obtained under standard laboratory conditions (Mean values). 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)

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