

tesa® HAF 8401

Heat activated film

PRODUCT INFORMATION

Product Description

tesa® HAF 8401 is a double-sided thermosetting brown adhesive film without backing, based on phenolic resin and nitrile rubber.

At room temperature, tesa® HAF 8401 is not tacky. It is activated for pre-lamination by heat and becomes tacky at 90 °C. In the second step of application, heat and pressure is applied over a certain period of time.

After curing, tesa® HAF 8401 reaches a very high bonding strength, high temperature stability and excellent chemical resistance. Because of the rubber components, tesa® HAF 8401 remains flexible and elastic.

tesa® HAF 8401 is supplied with a strong paper liner and 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	none	■ Bonding strength	12 N/mm ²
■ Color	amber		1740.5 lbs/in ²
■ Total thickness	200 µm	■ Shelf life time (packed) < 5°C	18 months
	7.9 mils	■ Shelf life time (packed) < 15°C	15 months
■ Type of adhesive	nitrile rubber / phenolic res	■ Shelf life time (packed) < 25°C	12 months
■ Type of liner	glassine		

Additional Info

Processing:

1. Pre-lamination:

tesa® HAF 8401 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 - 200 °C
- Pressure: > 2 bar
- Time: 15 sec - 90 sec

Friction liners for clutches:

- Temperature: 180 - 230 °C
- Pressure: > 6 bar
- Time: 5 min - 30 min

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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