

# tesa HAF® 8402

## Product Information



Heat activated film

### Product Description

tesa® HAF 8402 is a double-sided thermosetting brown adhesive film, without backing, based on phenolic resin and nitrile rubber.

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 a very high bonding strength, high temperature stability and excellent chemical resistance. Because of the rubber components tesa® HAF 8402 remains flexible and elastic.

tesa® HAF 8402 is supplied with a strong paper liner and can easily be slit and die cut.

### Application Fields

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

### Technical Information (average values)

The values in this section should be considered representative or typical only and should not be used for specification purposes.

### Product Construction

|                    |                                    |                   |        |
|--------------------|------------------------------------|-------------------|--------|
| • Backing material | none                               | • Total thickness | 125 µm |
| • Type of adhesive | nitrile rubber /<br>phenolic resin | • Colour          | amber  |
| • Type of liner    | glassine                           |                   |        |

### Properties/Performance Values

|                                    |                      |                               |                      |
|------------------------------------|----------------------|-------------------------------|----------------------|
| • Bonding strength (dynamic shear) | 12 N/mm <sup>2</sup> | • Bonding strength (push-out) | 12 N/mm <sup>2</sup> |
|------------------------------------|----------------------|-------------------------------|----------------------|

### Additional Information

Processing:

1. Pre-lamination:

tesa® HAF 8402 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:

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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)

### Disclaimer

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