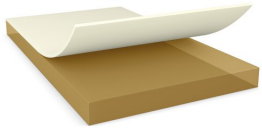
# tesa HAF® 8472

## Product Information



Heat Activated FilmSolutions for the Consumer Electronics Industry

### Product Description

tesa® HAF 8472 is a thermosetting film based on phenolic resin and nitrile rubber. This brown double-sided tape has no backing. It is protected by a strong paper liner.

tesa® HAF 8472 is free of halogen and compliant with current ROHS standards.

At room temperature tesa® HAF 8472 is not tacky. It is activated by heat and pressure during defined intervals.

tesa® HAF 8472 enables extremely strong and ageing-resistant bonds between different materials.

tesa® HAF 8472 features especially:

- Very thin adhesive layer ensures close contact between smooth surfaces
- Produces very low oozing ratio
- Reliable and ageing-resistant bonds between plastic and metal surfaces, even on very small bonding areas
- Suitable for long-term applications that are exposed to heavy stress
- Bonds remain elastic

### Application Fields

tesa® HAF 8472 is especially recommended for bonding of metal components to various plastic or metal surfaces, e.g. SUS or AL to PMMA, PC or ABS:

- Bonding of speaker parts in mobile phones
- Constructive bonding inside digital cameras

## 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 | 60 µm |
| • Type of adhesive | nitrile rubber / phenolic resin | • Colour | amber |
| • Type of liner | glassine | | |

### Properties/Performance Values

| | |
|---|---|
| • Bonding strength (push-out) | 11 N/mm$^2$ |

### Additional Information

Technical recommendations:

**For latest information on this product please visit http://l.tesa.com/?ip=08472**

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## Additional Information

tesa® HAF 8472 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 1,5 – 3,0 s

2. Bonding:
Remove the liner from tape after pre-lamination step. Place the plastic part onto the metal component. Apply sufficient temperature through the metal part 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 3,0 – 10,0 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 mould.
[2] 'Pre-lamination' and 'Bonding' pressure refer to the force that is transformed from mould surface directly to the bonding area.

Storage conditions according to tesa® HAF shelf life concept.

Note: Bonding strength values (mean values) were obtained under standard laboratory conditions. (Material: AL & AL test specimen / Bonding conditions: Temperature = 180 °C; Pressure = 10 bar; Time = 7 sec).

## Disclaimer



**For latest information on this product please visit http://l.tesa.com/?ip=08472**