

tesa HAF 8402 Heat Activated Film

Product Description/ Application:

tesa HAF 8402 is a thermosetting double sided film based on phenolic resin and nitrile rubber. It is suitable for the bonding of virtually all materials such as metal, glass, plastic, wood, paper and textiles. The surface of the materials should not be too rough and porous.

At room temperature tesa HAF 8402 is not self adhesive. It is activated by pressure and heat and becomes tacky at 70°. Once activated tesa

HAF 8402 reaches high bonding strength, good chemical resistance and high temperature stability. Because of the rubber components contained in the film, bonds with tesa HAF 8402 remain flexible and elastic over years.

tesa HAF 8402 has no carrier and is protected by a paper liner. It can easily be slit and die-cut.

Processing

1. Prelamination:
tesa HAF 8402 can be laminated before the curing. For this process we recommend a

temperature between 70° and 100° and a pressure of more than 0,2 bar.

2. Bonding:

The bonding parameters temperature, pressure and time depend on the application and the materials. Following parameters can be regarded as a guideline:

- temperature 120° - 250°
- pressure > 0,2 bar
- time 4 sec - 30 min

To reach maximum bonding strength surfaces should be clean, dry and free of oil, grease and solvents.

Dimensions:

Stock Items	
Length:	25 m
Widths:	9 - 1.020 mm

Other dimensions on enquiry.

Technical Data (mean values)

Backing	Adhesive	Liner	Weight	Adhesive strength*	Best before
none	nitrile rubber/ phenolic resin	release paper	140 g/m ²	≥ 12 N/mm ²	<div>12 months at ≤ 25° C</div> <div>15 months at ≤ 15° C</div> <div>18 months at ≤ 5° C</div>

*Adhesive strength can be increased to approx. 30 N/mm² by increasing curing time, curing temperature and application pressure.

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tesa self-adhesive tapes are used successfully in many sectors to solve a variety of problems. Our publications contain numerous examples of such uses, intended to help towards a solution of your particular problems. Each tesa product has been developed for a particular range of applications. Nevertheless, experience has shown that even for one and the same objective, the exact requirements may differ from case to case. We, therefore, recommend that you carry out your own tests in each case, to confirm that the tesa self-adhesive tape which you envisage using is appropriate for your particular application. The Advisory Section of our Technical Service Department will be happy to assist. All information and recommendations are given by us in good faith, on the basis of practical experience, but without warranty.