

tesa HAF® 8402

125µm amber reactive HAF mounting tape

tesa HAF® 8402 is a reactive heat activated film based on phenolic resin and nitrile rubber. This amber double sided tape has no backing. It is protected by a strong paper liner and can easily be slit and die cut.

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:

- Very high bonding strength
- High temperature resistance
- Excellent chemical resistance
- Bonds remain flexible and elastic

Main Application

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

- High-strength splicing (overlap splice)
- Structural bonding
- Magnet bonding in electric motors
- Friction liners for clutches

Technical Data

▪ Backing material	none	▪ Bonding strength	12 N/mm ²
▪ Color	amber	▪ Shelf life time (packed) < 5°C	18 months
▪ Total thickness	125 µm	▪ Shelf life time (packed) < 15°C	15 months
▪ Type of adhesive	nitrile rubber / phenolic resin	▪ Shelf life time (packed) < 25°C	12 months
▪ Type of liner	glassine		

For latest information on this product please visit <http://l.tesa.com/?ip=08402>

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Additional Information

Processing:

1. Pre-lamination:

tesa HAF® 8402 is laminated before curing. For this process we recommend a temperature between 120 °C and 140 °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: 120-220 °C
- Pressure: >2bar
- Time: 15 – 90 s.

Friction liners for clutches:

- Temperature: 180 – 230 °C
- Pressure: > 8 bar
- Time: 3 min – 30 min

Magnet bonding:

- Temperature: 140 – 180 °C
- Pressure > 6-10 bar
- Time: 2 min - 5 min

Structural bonding:

- Temperature: 180 – 220 °C
- Pressure: > 10-15 bar
- Time: > 3 - 30 min

Bonding strength values were obtained under standard laboratory conditions. 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).

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

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