

## tesa® HAF 8402

### Heat activated film

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 the second step of application, 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.

## 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 <sup>2</sup>
▪ Color	amber		1740.5 lbs/in <sup>2</sup>
▪ Total thickness	125 µm 4.9 mils	▪ Shelf life time (packed) < 5°C	18 months
▪ Type of adhesive	nitrile rubber / phenolic resin	▪ Shelf life time (packed) < 15°C	15 months
▪ Type of liner	glassine	▪ Shelf life time (packed) < 25°C	12 months

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 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

2 bar

- Time: 15 sec - 90 sec

##### Friction liners for clutches:

- Temperature: 180 - 230 °C
- Pressure: > 6 bar

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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