

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 ²
▪ Color	amber		1740.5 lbs/in ²
▪ 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>

tesa® products prove their impressive quality day in, day out in demanding conditions and are regularly subjected to strict controls. All information and recommendations are provided to the best of our knowledge on the basis of our practical experience. Nevertheless tesa SE can make no warranties, express or implied, including, but not limited to any implied warranty of merchantability or fitness for a particular purpose. Therefore, the user is responsible for determining whether the tesa® product is fit for a particular purpose and suitable for the user's method of application. If you are in any doubt, our technical support staff will be glad to support you.

tesa® HAF 8402

Heat activated film

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)

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

tesa® products prove their impressive quality day in, day out in demanding conditions and are regularly subjected to strict controls. All information and recommendations are provided to the best of our knowledge on the basis of our practical experience. Nevertheless tesa SE can make no warranties, express or implied, including, but not limited to any implied warranty of merchantability or fitness for a particular purpose. Therefore, the user is responsible for determining whether the tesa® product is fit for a particular purpose and suitable for the user's method of application. If you are in any doubt, our technical support staff will be glad to support you.