

tesa® HAF 8401



product information

Heat activated film

tesa® HAF 8401 is a double-sided thermosetting brown adhesive film, without backing, based on phenolic resin and nitrile rubber.

At room temperature tesa® HAF 8401 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 8401 reaches a very high bonding strength, high temperature stability and excellent chemical resistance. Because of the rubber components tesa® HAF 8401 remains flexible and elastic.

tesa® HAF 8401 is supplied with a strong paper liner and can easily be slit and die cut.

Main Application

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

Technical Information (average values)

The values in this section should be considered representative or typical only and should not be used for specification purposes.

Technical Data

• Backing material	none	• Bonding strength	12 N/mm ²
• Color	amber	• Shelf life time (packed) < 5°C	18 months
• Total thickness	200 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		

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Additional Information

Processing:

1. Pre-lamination:

tesa® HAF 8401 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
- Time: 15 sec - 90 sec

Friction liners for clutches:

- Temperature: 180 - 230 °C
- Pressure: > 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)

Disclaimer

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.



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