productinformation

tesa HAF® 8490

315µm single sided amber reactive HAF mounting tape

tesa HAF® 8490 is a reactive heat activated film based on phenolic resin and nitrile rubber. This amber single sided tape has a cotton fabric backing. It can easily be slit and die cut.

At room temperature tesa HAF® 8490 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® 8490 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 (single-side butt splice)

Technical Data

Backing material	cotton fabric	Type of liner	none
Color	amber	Shelf life time (packed) < 5°C	18 months
Total thickness	315 µm	Shelf life time (packed) < 15°C	15 months
Type of adhesive	nitrile rubber / phenolic resin	Shelf life time (packed) < 25°C	12 months
Tensile strength	90 N/cm		

For latest information on this product please visit http://l.tesa.com/?ip=08490

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Additional Information

Processing:
1.Pre-lamination:
tesa HAF® 8490 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: > 2 bar
- Time: 15 – 90 s.

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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