

## tesa® HAF 8490 Heat activated film

tesa® HAF 8490 is a thermosetting single-sided adhesive film (brown) that is based on phenolic resin and nitrile rubber. It has a white cotton fabric carrier.

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 a very high bonding strength, high temperature stability and excellent chemical resistance. Because of the rubber components HAF 8490 remains flexible and elastic.

tesa® HAF 8490 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 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 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°C - 200°C
- Pressure: > 2 bar
- Time: 15 sec - 90 sec

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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