

tesa® HAF 58480

50µm black low temperature reactive HAF mounting tape

tesa® HAF 58480 is a reactive mounting tape activated at moderate temperatures. This black double sided tape has no backing. It is protected by a PE-coated paper liner.

tesa® HAF 58480 is free of halogen and compliant with current RoHS directive.

At room temperature tesa® HAF 58480 is not tacky. It is activated by moderate heat and pressure applied during the assembly process.

Special Features:

- Extremely high bonding performance and reliability, even on slim bonding areas and thin design gaps
- Activated at low temperature and pressure
- Excellent shock resistance
- Sebum resistant
- Very low oozing ratio

Main Application

tesa® HAF 58480 is especially recommended for structural bonding of temperature sensitive substrates:

- Bonding of anodized aluminium
- Bonding of plastics
- Mounting of sensitive electronic parts

Technical Data

▪ Backing material	none	▪ Type of liner	PE-coated paper
▪ Color	black	▪ Bonding strength (push-out)	5.5 N/mm ²
▪ Total thickness	50 µm	▪ Shelf life time < 25°C	6 months
▪ Type of adhesive	low temperature activated reactive adhesive		

Properties

- Low VOC ●●●●

Evaluation across relevant tesa® assortment: ●●●● very good ●●● good ●● medium ● low



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For latest information on this product please visit <http://l.tesa.com/?ip=58480>

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Additional Information

Technical recommendations:

tesa® HAF 58480 is not self adhesive. It is activated by heat and pressure over a certain interval. The following values are recommendations for machine parameters to start with.

1. Pre-lamination:

During pre-lamination, laminate the adhesive tape onto the first component.

Machine setting:

- Temperature¹ 70 °C (50-60 °C bond-line)
- Pressure² 1 – 3 bar
- Time 5 – 20 s

Short-time exposure to 60°C bond-line temperature during pre-lamination does not impact final bonding potential.

2. Bonding:

Remove the liner from tape after the pre-lamination step.

Position the second component. Apply temperature and pressure for the bonding time to reach sufficient bonding strength.

Machine setting:

- Temperature¹ 80 – 120 °C (min. 75 °C bond-line)
- Pressure² 2 – 4 bar
- Time 10 – 480 s

Short cycle times can be achieved at 120 °C jig temperature. For activation at lower temperatures, increase the heat-press time or combine a short heat-press step with oven curing.

To reach maximum bonding strength, surfaces should be clean and dry. Allow at least 1-2 hours dwell-time after bonding before performance testing. Final bonding strength will be reached after 24 hours.

Bonding strength values were obtained under standard laboratory conditions. (Material: PC/PC / bonding conditions: temperature = 90 °C; pressure = 5 bar; time = 120 sec).

Storage:

tesa recommends storage in original packaging in cool and dry conditions.

Low Temperature Reactive HAF should not be exposed to more than 35°C before bonding (during transport, storage and converting).

The minimum guaranteed shelf life is 6 months after delivery to customers. For the actual shelf life please refer to the best before date on the label in the log roll core.

¹ 'Pre-lamination' and 'Bonding' temperature refer to the data that is measured at the surface of heating jig.

² 'Pre-lamination' and 'Bonding' pressure refer to the force that is transferred from jig surface directly to the bonding area.

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