



TECHNICAL DATA SHEET

Noelle Industries, Inc.

Adhesives • Coatings • Conductives • Encapsulants

NOELLE 804-11 System

A Two Component Tooling Compound

Description:

Noelle 804-11 System is a gray two component (A + B) high performance, room temperature curing, tooling compound.

Advantages:

Noelle 804-11 will cure at temperatures above 15°C (60°F) in a moderate period of time. Noelle 804-11 is an excellent mold making, metal filled tooling compound.

Physical Properties:

	<u>Resin</u>	<u>Hardener</u>
	804-11A	804-11B
Color:	Gray	Clear
Specific Gravity:	1.63	0.98
Mix Ratio		
(By Weight):	100.0	7.0

Shelf Life: (Sealed containers)

One Year @ 25°C (both A+B). Hand agitation of the Resin component is recommended after long standing to insure best results.

Instructions:

Combine the Resin and the Hardener in the ratio listed above. Mix by hand or mechanical mixer until material is uniform in appearance.

Cure Schedules:

16 hours @ 25°C (77°F) will yield 80% of the systems full potential. An additional 48 hours @ 25°C (77°F) will yield the systems full potential.

% Full Cure:	80%	100%
Cure Temperature:	25°C	25°C
Cure Time (hours):	16	66

Pot Life (100 grams) @ 25°C 70 minutes

Cured Properties:

Shore Hardness, measured @ 25°C: 84D
Operating Temperature Range: -20°C to +100°C

Storage and Handling:

Normal storage and handling is at room temperature. Use standard mixing and housekeeping procedures to minimize the risk of spills and contact with the surrounding materials.

All values reported above are typical values, and are reported as a means of reference. Individual testing should be done to determine actual results, tested at specific conditions.

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