



TECHNICAL DATA SHEET

Noelle Industries, Inc.
Adhesives • Coatings • Conductives • Encapsulants

NOELLE 804-42

A Two Component Epoxy Putty

Description:

Noelle 804-42 System is a two component (A + B) **mineral** filled, room temperature curing, thixotropic Epoxy and putty. Noelle 804-42 is designed to operate at high heat for short periods of time.

Advantages and Applications:

Noelle 804-42 features exceptional adhesion, tensile strength, compressive strength and durability, along with ease of application. Noelle 804-42 is also machineable with standard metal working tools. Noelle 804-42 has fair chemical resistance. Noelle 804-42 can be used to repair worn shafts, keyways, hydraulic rams and other metal surfaces or equipment.

Physical Properties:

	<u>Resin</u>	<u>Hardener</u>
	804-42A	804-42B
Color:	Gray	Lt. Green
Specific Gravity:	2.62	1.99
Combined:	2.46	
Mix Ratio		
(By Volume):	3.00	1.00
(By Weight):	4.00	1.00

Shelf Life: (Sealed container)

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

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.

Instructions and Surface Preparation:

Combine the Resin and the Hardener in the ratio listed above. Mix by hand or mechanical mixer until material is uniform in appearance and color (Gray). For best results, the surface should be sand or grit blasted. A grinding wheel or stiff wire brush can be used on the surface and followed with a solvent wipe.

Cure Schedules:

Within an 4 hour period after application @ 25°C will yield 80% of the systems full potential. An additional 12 hours @ 25°C will yield the systems full potential. Post curing or forced air curing for 1 hour at 85°C will yield a full cure and eliminate the additional waiting time at ambient temperature.

% Full Cure:	80%	100% or	100%
Cure Temperature:	25°C	25°C	85°C
Cure Time (hours):	4	16	1

Pot Life (100 grams) @ 25°C = 45 minutes

Cured Properties:

Shore Hardness, measured @ 25°C:	>85D
Lap Shear, Tensile Strength	
Al/Al ASTM D-1002 (psi):	>5000
Compressive Strength, (psi):	>12000
Flexural Strength, (psi):	>6500
Coefficient of Linear Thermal Expansion,	
(in/in°C):	75 x 10 ⁻⁶
Cured Shrinkage,	(in/in): 0.001
Operating Temperature Range:	0°C to +140°C

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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