



TECHNICAL DATA SHEET

Noelle Industries, Inc.

Adhesives • Coatings • Conductives • Encapsulants

NOELLE 804-50 System

A Two Component Epoxy Adhesive

Description:

Noelle 804-50 is a clear two component (A + B) high performance, room temperature curing, epoxy adhesive that will cure at temperatures above 16°C in a relative short period of time.

Advantages:

Noelle 804-50 featured a long working time and low viscosity.

Physical Properties:

	<u>Resin</u>	<u>Hardener</u>
	804-50A	804-50B
Color:	Clear	Clear
Specific Gravity	1.16	0.98
Mix Ratio		
(By Volume):	10.0	1.0
(By Weight):	10.0	1.0

Shelf Life: (Sealed containers)

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

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 8 hours @ 25°C (77°F) will yield the systems full potential). Acceleration of the set-up time can be accomplished by the use of ovens, conveyor zed heat tunnels, or heated molds.

% Full Cure	80%	100%
Cure Temperature:	25°C	25°C
Cure Time (hours):	16	112

Pot Life (100 grams) @ 25°C = 45 min

Cured Properties:

Shore Hardness, measured @ 25°C: 80D
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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