



TECHNICAL DATA SHEET

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

NOELLE 804-51 System

A Two Component Potting and Mold Making Material

Description:

Noelle 804-51 is a Black two component (A + B) high performance, room temperature curing, potting and mold making material.

Advantages:

Noelle 804-51 yields void free castings within a reasonable amount of time.

Physical Properties:

	<u>Resin</u>	<u>Hardener</u>
	804-51A	804-51B
Color	Black	Clear
Specific Gravity	1.63	0.98
Mix Ratio		
(By Volume)	4.0	1.0
(By Weight)	100.0	25.0

Shelf Life: (Sealed containers)

One Year @ 25°C (both A+B). Hand agitation of both (A + B) components 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 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 = 150 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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