



TECHNICAL DATA SHEET

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

NOELLE 804-53

A Two Component Pourable Liquid

Description:

Noelle 804-53 System is a two component (A + B) **aluminum filled**, room temperature curing, Pourable Liquid.

Advantages and Applications:

Noelle 804-53 features exceptional adhesion, strength and durability, along with ease of application. Noelle 804-53 is machineable with standard metal working tools. Noelle 804-53 has fair chemical resistance. Noelle 804-53 can be used as mold or pattern making or where a Pourable liquid is preferred over a putty. Noelle 804-53 is recommended where a non-rusting, metallic finish is required.

Physical Properties:

	<u>Resin</u>	<u>Hardener</u>
	804-53A	804-53B
Color:	Aluminum	Amber
Specific Gravity:	1.68	0.98
Combined:	1.51	
Mix Ratio:		
(By Volume):	3.00	1.00
(By Weight):	5.56	1.00

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 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 (Light Gray). To insure best results the material 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 8 hour period after application @ 25°C will yield 80% of the systems full potential. An additional 8 hours @ 25°C will yield the systems full potential. Post curing or forced air curing for 4 hours 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):	8	16	4

Pot Life (450 grams) @ 25°C = 45 minutes

Cured Properties:

Shore Hardness, measured @ 25°C:	>80D
Lap Shear, Tensile Strength	
Al/Al ASTM D-1002 (psi):	>2000
Compressive Strength, (psi):	>10000
Flexural Strength, (psi):	>7000
Coefficient of Linear Thermal Expansion,	
(in. / in. °C):	80 x 10 ⁻⁶
(in. / in.):	0.01
Cured Shrinkage,	
Operating Temperature Range:	0°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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