



TECHNICAL DATA SHEET

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

NOELLE 804-54

A Two Component Epoxy Putty

Description:

Noelle 804-54 System is a two component (A + B) **aluminum** filled, room temperature curing, thixotropic Epoxy and putty.

Advantages and Applications:

Noelle 804-54 features exceptional adhesion, strength and durability, along with ease of application. Noelle 804-54 is capable of curing in the vertical position and is machine able with standard metal working tools. Noelle 804-54 has fair chemical resistance. Noelle 804-54 can be used to repair metal pipes, tanks, metal castings, valves, pumps, engine repairs, water jackets and radiators. Noelle 804-54 is recommended where a non-rusting, metallic finish is required.

Physical Properties:

	<u>Resin</u>	<u>Hardener</u>
	804-54A	804-54B
Color:	Aluminum	Cream
Specific Gravity:	1.84	1.04
	Combined:	1.71
Mix Ratio:		
(By Volume):	3.00	1.00
(By Weight):	9.00	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.

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 (Dark Gray). For best results the surface should be sanded or grit blasted with a grinding wheel or stiff wire brush to prepare 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 min

Cured Properties:

Shore Hardness, measured @ 25°C	>80D
Lap Shear, Tensile Strength	
Al/Al ASTM D-1002 (psi):	>3500
Compressive Strength (psi):	>9600
Flexural Strength (psi):	>7800
Coefficient of Linear Thermal Expansion	
(in/in°C):	70 x 10 ⁻⁶
Operating Temperature Range:	0°C to +100°C
Cured Shrinkage (inch/inch):	0.001

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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