



# Noelle Industries, Inc.

Adhesives • Coatings • Conductives • Encapsulants

76 Treble Cove Road, Unit C - N. Billerica, MA 01862  
United States of America  
Phone: (978) 439-9841 - Fax: (978) 439-9842  
**Website:** [www.noelleindustries.com](http://www.noelleindustries.com)  
Email: [info@noelleindustries.com](mailto:info@noelleindustries.com)



## TECHNICAL DATA SHEET 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. 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.

#### **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 of 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).

	80%	100%	or	100%
Cure Temp:	25°C	25°C		85°C
Cure Time:	8 hrs	16 hrs		4 hrs
<b>Pot Life</b> (450 grams) @ 25°C				45 min

#### **Cured Properties:**

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

**Storage and Handling:**

Normal storage and handling is at room temperature. Use standard mixing and house keeping 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.**