



TECHNICAL DATA SHEET

Noelle Industries, Inc.

Adhesives • Coatings • Conductives • Encapsulants

NOELLE 804-59 System

A Two Component Mold Making / Tooling Compound

Description:

Noelle 804-59 System is a gray, mineral filled, two component (A + B) high performance, room temperature curing, Mold Making / Tooling Compound.

Advantages:

Noelle 804-59 will cure at temperatures above 15°C (60°F) in a moderate period of time. Noelle 804-59 has good chemical resistance and is machineable with standard metal working tools. Noelle 804-59 is a variable mix ratio material depending on final end properties desired.

Physical Properties:

	Resin	Hardener	
	804-59A	804-59B	
Color	White	Black	
Specific Gravity	1.62	1.38	
Mix Ratio			
(By Weight)	100	100	Semi-Flex
	100	50	Rigid

Shelf Life: (Sealed containers)

One Year @ 25°C (both A+B). Hand agitation of both (A + B) components are 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 48 hours @ 25°C (77°F) will yield the systems full potential.

% Full Cure	80%	100%
Cure Temperature:	25°C	25°C
Cure Time (hours):	16	64

Pot Life (100 grams) @ (25°C) = 30 min

Cured Properties:

Shore Hardness, measured @ 25°C:

(1 / 1 Rigid)	80D
(2 / 1 Semi-Flex)	70D

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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