



TECHNICAL DATA SHEET

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

NOELLE 804-80

A Two Component Epoxy Putty

Description:

Noelle 804-80 System is a two component (A + B) bronze filled, room temperature curing, thixotropic Epoxy and putty.

Advantages and Applications:

Noelle 804-80 features exceptional adhesion, strength and durability, along with ease of application. Noelle 804-80 is capable of curing in the vertical position and is machine able with standard metal working tools. Noelle 804-80 has good chemical resistance. Noelle 804-80 can be used to repair brass pipes, metal castings, valves, pumps, and other metal equipment. . Noelle 804-80 is often used in the foundry and boat industry

Physical Properties:

	<u>Resin</u>	<u>Hardener</u>
Color:	Bronze	Cream
Specific Gravity:	3.05	1.04
Combined:	2.54	
Viscosity @ 25°C:	Thixo Paste	Soft Paste
Combined Viscosity (cP):	400,000 to 600,000	
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 (Bronze). To insure best results the surface should be sand or grit blasted. A grinding wheel or stiff wire brush can be used on the surface and fallowed 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 (100 grams) @ 25°C = 45 min

Cured Properties:

Shore Hardness, measured @ 25°C	>85D
Lap Shear, Tensile Strength	
Al/Al ASTM D-1002 (psi):	>3500
Compressive Strength (psi):	>7800
Flexural Strength (psi):	>5600
Coefficient of Linear Thermal Expansion	
(inch/inch°C):	59 x 10 ⁻⁶
Operating Temperature Range:	-20°C to +121°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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