



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



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## TECHNICAL DATA SHEET

### NOELLE 806-19-1 System

#### A Two Component Adhesive

#### **Description:**

Noelle 806-19-1 System is a clear two component (A + B) high performance, room temperature curing, adhesive and casting system. Noelle 806-19-1 has been modified to improve solvent and chemical resistance.

#### **Advantages:**

Noelle 806-19-1 will cure at temperatures above 15°C (60°F) in a moderate period of time. Noelle 806-19-1 has excellent chemical resistance.

#### **Physical Properties:**

	<b><u>Resin</u></b>	<b><u>Hardener</u></b>
	806-19-1A	806-19-1B
Color:	Clear	Clear
Specific Gravity	1.17	0.98
Mix Ratio (By Weight)	100.0	30.0

#### **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:**

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 96 hours @ 25°C (77°F) will yield the systems full potential).

	80%	100%
Cure Temp:	25°C (77°F)	25°C (77°F)
Cure Time:	16 hrs	112 hrs
<b>Pot Life</b> (100 grams) @ 25°C (77°F)	45 min	

#### **Cured Properties:**

Shore Hardness, measured @ 25°C 84D  
 Operating Temperature Range: -20°C to +100°C

#### **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.**