



# TECHNICAL DATA SHEET

**Noelle Industries, Inc.**

Adhesives • Coatings • Conductives • Encapsulants

## NOELLE 806-73 System

### A Two Component Paste Adhesive and Tooling Compound

#### **Description:**

Noelle 806-73 System is a two component (A + B) high performance, room temperature curing, steel filled, paste adhesive and tooling compound for metal to metal or metal to plastic bonding.

#### **Advantages:**

Noelle 806-73 mixed system features a moderate set up time at room temperature above 65°F.

#### **Physical Properties:**

	<b><u>Resin</u></b> 806-73A	<b><u>Hardener</u></b> 806-73B
Color:	Black	Black
Specific Gravity:	2.21	2.21
Mix Ratio		
(By Volume):	1.0	1.0
(By Weight):	1.0	1.0

#### **Shelf Life:** (Sealed containers)

One Year @ 25°C (both A+B). Hand agitation of the Rein 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:**

Overnight or 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.

% Full Cure:	80%	100%
Cure Temperature:	25°C (77°F)	25°C (77°F)
Cure Time (hours):	16	112

**Pot Life** (100 grams) @ 25°C = 120 minutes

#### **Cured Properties:**

Shore Hardness, measured @ 25°C: 85D  
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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