



TECHNICAL DATA SHEET

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

NOELLE 807-07 System

A Two Component Liquid Adhesive and Tooling Compound

Description:

Noelle 807-07 System is a two component (A + B) high performance, room temperature curing liquid adhesive and metal filled tooling compound for metal to metal bonding.

Advantages:

Noelle 807-07 mixed system features a moderate set up time at room temperature above 65°F.

Physical Properties:

| | <u>Resin</u> 807-07A | <u>Hardener</u> 807-07B |
|-------------------|--------------------------------|-----------------------------------|
| Color: | Black | Black |
| Specific Gravity: | 2.52 | 3.00 |
| Mix Ratio | | |
| (By Volume): | 5.0 | 4.0 |
| (By Weight): | 100.0 | 100 |

Shelf Life: (Sealed containers)

One Year @ 25°C (both A+B). Hand agitation of the Rein component is recommended after long standing to ensure 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 (500 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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