



TECHNICAL DATA SHEET



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

NOELLE 807-45

A Two Component Epoxy Paste Adhesive

Description:

Noelle 807-45 System is a two component (A + B) mineral filled, room temperature fast curing, paste epoxy adhesive

Advantages and Applications:

Noelle 807-45 features exceptional adhesion, strength and durability, along with ease of application. Noelle 807-45 is formulated for fast set up and is capable of curing in the vertical position. Noelle 807-45 has good chemical resistance.

Physical Properties:

| | <u>Resin</u> | <u>Hardener</u> |
|------------------|--------------|-----------------|
| | 807-45A | 807-45B |
| Color: | Lt Gray | Tan |
| Specific Gravity | 1.51 | 1.54 |
| Combined | 1.53 | |
| Mix Ratio | | |
| (By Volume) | 2.00 | 1.00 |
| (By Weight) | 2.00 | 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.

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 (Lt Gray). For best results the surface of the material should be sand or grit

blasted. A grinding wheel or stiff wire brush can be used on the surface and followed with a solvent wipe.

Cure Schedules:

(Within an 16 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 2 hours at 65°C will yield a full cure and eliminate the additional waiting time at ambient temperature).

| | | | |
|----------------------------|--------|-------|---------|
| | 80% | 100% | or 100% |
| Cure Temp: | 25°C | 25°C | 65°C |
| Cure Time: | 16 hrs | 24hrs | 2 hrs |
| Pot Life (50 grams) @ 25°C | 20 min | | |

Cured Properties:

| | |
|--|-----------------------|
| Shore Hardness, measured @ 25°C | >78D |
| Lap Shear, Tensile Strength Al/Al ASTM D-1002: | >3000 psi. |
| Compressive Strength: | >8100 psi |
| Flexural Strength: | >6200 psi |
| Coefficient of Linear Thermal Expansion (in/in°C): | 35 x 10 ⁻⁶ |
| Operating Temperature Range: | 0°C to +100°C |
| Cured Shrinkage: | 0.05 in/in |

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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