



# TECHNICAL DATA SHEET

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

## NOELLE 808-27

### A Two Component Epoxy Adhesive

#### Description:

Noelle 808-27 System is a two component (A + B) unfilled, medium viscosity, epoxy system designed for adhesive and coating applications.

#### Advantages and Applications:

Noelle 808-27 features a moderate cure time and a convenient mix ratio. Noelle 808-27 is a durable adhesive that bonds to a variety of substrates and dissimilar materials. Noelle 808-27 System is 100% solids and undiluted which yields very low vapor transmission. Applications include medical devices, general purpose metal to metal bonding. Noelle 808-27 is resistant to galvanic corrosion, fuels, and mild acids.

#### Physical Properties:

	<u>Resin</u>	<u>Hardener</u>
	808-27A	808-27B
Color:	Clear	Amber
Specific Gravity:	1.16	1.58
Combined:	1.34	
Viscosity (cP):	14,000	10,000
Combined (cP)	12,000	
Mix Ratio		
(By Volume):	7	5
(By Weight):	1	1

#### 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 and color (Black).

#### Cure Schedules:

Within a 10 hour period after application @ 25°C will yield 80% of the systems full potential. An additional 6 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.

% Full Cure:	80%	100% <b>or</b>	100%
Cure Temperature:	25°C	25°C	65°C
Cure Time (hours):	10	16	2

**Pot Life** (100 grams) @ 25°C = 90 min

#### Cured Properties:

Shore Hardness, measured @ 25°C:	>80D
Dielectric Strength, (Volts per mil):	440
Lap Shear, Tensile Strength	
Al/Al ASTM D-1002 (M Pa):	34
Compressive Strength, (M Pa):	66
Flexural Strength, (M Pa):	54
Coefficient of Linear Thermal Expansion,	
(cm/cm/°C):	60 x 10 <sup>-6</sup>
(in/in)	0.001
Cured Shrinkage:	
Operating Temperature Range:	0°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.

• 76 Treble Cove Road, Building # 3, Unit C, North Billerica, MA 01862

• Phone: (978) 439-9841 • Fax: (978) 439-9842 • Website: [www.noelleindustries.com](http://www.noelleindustries.com) • email: [info@noelleindustries.com](mailto:info@noelleindustries.com)