



TECHNICAL DATA SHEET

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

NOELLE 808-46-30 System A Two Component Urethane Adhesive

Description:

Noelle 808-46-30 System is a two component high performance, very flexible, room temperature, urethane adhesive.

Advantages:

Noelle 808-46-30 System features a ease of mixing and use along with a reasonable working time. Noelle 808-46-30 mixed system features a moderate set up time at temperatures above 20°C. All gel and cure times are directly related to the mass of the material

Applications:

Noelle 808-46-30 System is widely used in the bonding application of electrical components and modules used in the telecommunication industry.

Physical Properties:

	<u>Curative</u>	<u>Resin</u>
	808-46-30A	808-46-30B
Color:	Lt. Amber	Off White
Specific Gravity	Cured system: 1.11	
Mixed Viscosity cP@ 25°	20,000	
Mix Ratio		
(By Weight)	57.0	100
(By Volume)	1.00	2.00

Shelf Life: (Sealed containers)

Six Months @ 25°C (both A+B). Hand agitation of the Resin component is recommended after long standing to insure best results.

Instructions:

Combine the Curative and Resin 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 80 hours @ 25°C (77°F) will yield the systems full potential).

	80%	100%	or	100%
Cure Temp:	25°C	25°C		80°C
Cure Time:	16 hrs	96 hrs		4 hrs
Pot Life (50 grams) @ 25°C	30 Minutes			

Cured Properties:

Shore Hardness, measured @ 25°C	>35A
Tensile Strength ASTM D638:	<1000 psi.
Elongation %:	450

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 individuals and the surrounding materials. A required storage temperature 20 to 30°C. Upon opening and using the individual components wipe the rim of the containers and blanket each component with dry air or nitrogen. Reseal containers immediately after blanketing. This is a recommended procedure after each use.

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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