



# TECHNICAL DATA SHEET

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

## NOELLE 808-48 System

### A Two Component Urethane Adhesive

#### Description:

Noelle 808-48 System is a two component high performance, flexible, room temperature, urethane adhesive.

#### Advantages:

Noelle 808-48 System features ease of mixing and ease of use along with a reasonable working time. Noelle 808-48 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 808-48 System is widely used in the bonding application of plastics and dissimilar substrates used in a variety of industries.

#### Physical Properties:

	<u>Curative</u>	<u>Pre-polymer</u>
	808-48A	808-48B
Color:	Lt. Amber	Translucent
Specific Gravity		
Cured system:		1.05
Mixed Viscosity Cp @ 25°	20,000	
Mix Ratio		
(By Weight)	62.0	100
(By Volume)	1.0	2.0

#### 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 pre-polymer 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 = 45 Minutes

#### Cured Properties:

Shore Hardness, measured @ 25°C	>90A
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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