



# 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:                             | Light. Amber    | Translucent        |
| Specific Gravity,<br>Cured system: |                 | 1.05               |
| Mixed Viscosity @ 25° (cP):        | 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.

|                    |      |                |      |
|--------------------|------|----------------|------|
| % Full Cure:       | 80%  | 100% <b>or</b> | 100% |
| Cure Temperature:  | 25°C | 25°C           | 65°C |
| Cure Time (hours): | 16   | 96             | 4    |

Pot Life (50 grams) @ 25°C = 45 Minutes

#### Cured Properties:

|                                   |       |
|-----------------------------------|-------|
| Shore Hardness, measured @ 25°C:  | >90A  |
| Tensile Strength ASTM D638 (psi): | >1000 |
| 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. Required storage temperature is 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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