



TECHNICAL DATA SHEET

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

NOELLE 808-55- Series

A Two Component Urethane Adhesive

Description:

Noelle 808-55 is a series of different set-up time, two component, high performance, very flexible, room temperature curing urethane adhesives.

Advantages:

Noelle 808-55 Series features ease of mixing and ease of use along with a multitude of cure times. All gel and cure times are directly related to the mass of the material and temperature when applied. These materials are packaged in easy to use dual barrel syringes or cartridges and dispensed through a static mixer using a dispensing gun.

Applications:

Noelle 808-55-Series is widely used in bonding applications that require specific cure times along with cured structural adhesive properties.

Physical Properties:

| | <u>Curative</u> | <u>Resin</u> |
|--------------------------|-------------------|--------------------|
| | 808-55-A | 808-55-B |
| Color: | Light Amber or | off White Black |
| Specific Gravity (g/cc): | 1.21 | 1.06 |
| Mixed: | 1.11 | |
| Mixed Viscosity @ 25°C: | Thixotropic paste | |
| Mix Ratio: | | |
| (By Weight): | 57.0 | 100 |
| (By Volume): | 1.0 | 2.0 |

Shelf Life: (Sealed containers)

Six Months @ 25°C (both A+B).

Instructions:

Apply the material to one substrate and bond to the second substrate within the specific time listed below.

Cure Schedules:

| Product #: | Working Time: | 80% Cure: | Full Cure |
|-----------------|---------------|-----------|-----------|
| Noelle 808-55-1 | 3 minutes | 2 hours | 4 hours |
| Noelle 808-55-2 | 25 minutes | 4 hours | 6 hours |
| Noelle 808-55-3 | 135 minutes | 16 hours | 96 hours |
| Noelle 808-55-4 | 10 minutes | 3 hours | 5 hours |

Cured Properties:

| | |
|------------------------------------|-------|
| Shore A, measured @ 25°C: | 55 |
| 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.

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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