



# TECHNICAL DATA SHEET

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

## NOELLE 904-38 System

### A Two Component Addition Cured Silicone Potting Compound

#### Description:

Noelle 904-38 System is a two components, thermally conductive, red, high performance, flexible, and room temperature addition curing silicone.

#### Advantages:

Noelle 904-38 System features easy air release properties and minimal shrinkage along with great mechanical and thermal end properties. Noelle 904-38 System offers a wide range of service temperatures; excellent chemical resistance and a fully cured end product that will not undergo reversion until normal operating conditions. Noelle 904-38 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 904-38 System is widely used in the manufacture of flexible molding and roller applications along with use in potting and encapsulating applications.

#### Physical Properties:

	<u>Resin</u>	<u>Curative</u>
	904-38A	904-38B
Color:	Red	Clear
Specific Gravity:	2.10	1.01
Mixed Viscosity, @ 25°C (cP):	10,000	
Mix Ratio		
(By Weight):	100.0	2.53

#### Shelf Life: (Sealed containers)

Six Months @ 25°C (both A+B). Hand agitation of the Pre-polymer components recommended after longstanding 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. Put mixed material in vacuum chamber and degas to a minimum of 29 inches for five minutes. Remove and pour into molds immediately.

#### 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%	100%
Cure Temp:	25°C	25°C	65°C
Cure Time (Hours):	16	96	1

Pot Life (50 grams) @ 25°C = 120 Minutes

#### Cured Properties:

Shore Hardness, measured @ 25°C:	>45A
Tensile Strength, ASTM D638 (psi):	>1000
Tear Strength, (ppi):	12
Elongation, (%):	>125

#### 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 °C to 30°C. Upon opening and using the individual components you should wipe the rim of the containers. Reseal containers immediately after using. 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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