



TECHNICAL DATA SHEET

Noelle Industries, Inc.

Adhesives • Coatings • Conductives • Encapsulants

NOELLE 904-40

Acrylic Resins & Activators

Description:

The **904-40 SERIES** acrylic resins are rapid setting, high peel adhesive systems that cure at room temperature and possess a tremendous affinity toward dissimilar substrates. The proper selection of resin and activator can insure a high performance system that is used for permanent magnet (ceramic, Samarium, Alinco, and others) motor bonding, loud-speaker bonding, and a large selection of plastic to metal bonding applications.

Advantages:

These systems provide high and low temperature capabilities, coupled with ease of handling and application. No mixing is required; simply apply the resin to one substrate and activator to the other substrate and mate the two part.

PHYSICAL PROPERTIES:

	RESINS			ACTIVATORS			
Uncured Properties	R1	R2	R2T	A1	A2	A3	A4
Viscosity @ 25 ^o C (cP)	1500	22,000	50,000	60	60	60	60
Color	Translucent	Translucent	Translucent	Amber	Amber	Amber	Amber
Specific Gravity (20/20 ^o C)	0.98	1.02	1.00	0.98	0.98	0.98	0.99
Flash Point (°F)	86	86	86	275	275	275	275
Cure Speed (sec)	---	---	---	230	60	35	25
Fillers (%)	0	0	0	0	0	0	0
Solvents (%)	0	0	0	0	0	0	0
Cured Properties							
Tensile Shear (PSI)	2,600	2,400	2,400				
Peel -D-3167 (PLI)	12	12	22				
Percent solids	100%	100%	100%				
Operating temperature (°F)	-40 - 300	-40 - 300	-40 - 300				

TYPICAL CURE SPEED:

% Ultimate Strength	Time
50	15 minutes
90	4 hours
100	24 hours

SHELF LIFE:

3 months at 25 °C when stored and sealed in original containers.

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.

• 76 Treble Cove Road, Building # 3, Unit C, North Billerica, MA 01862

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6 months when refrigerated at or below -40°C.

Noelle Acrylic Activator

Selector Guide

DESCRIPTION:

Noelle reactive acrylic activators are designed to provide fast fixture speed. These products have the capability to produce tough, durable bonds with outstanding impact and peel strength.

TYPICAL APPLICATIONS:

These activators are used to cure Noelle reactive acrylic adhesives (R1, R2, R2T and 904-45). These products were designed for permanent tough bonds for DC motors, speakers and other structural components.

Activator	Fixture Time	Recommended Gap	Specific		
			Gravity	Color	Viscosity
A1	2 min.	0.010 or less	.98	Amber	<100 cps
A2	60 sec.	0.010 or less	.99	Amber	<100 cps
A3	30-45 sec.	0.010 or less	.99	Amber	<100 cps
A4	20-30 sec.	0.010 or less	.99	Amber	<100 cps

Typical Cure Speed

50% Ultimate Strength	15 minutes
90% Ultimate Strength	4 hours
100% Ultimate Strength	24 hours

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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