



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 parts.

PHYSICAL PROPERTIES:

RESINS

ACTIVATORS

Uncured Properties	R1	R2	R2T	A1	A2	A3	A4
Viscosity @ 25°C (cP)	1500	22,000	50,000	60	60	60	60
Color	Translucent	Translucent	Translucent	Amber	Amber	Amber	Amber
Specific Gravity (20/20°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:

% Full Cure:	50 %	90 %	100 %
Cure Time:	15 minutes:	4 hours	24 hours

SHELF LIFE:

3 months at 25 °C when stored and sealed in original containers.
6 months when refrigerated at or below -40°C.

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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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.

Specific

Activator	Fixture Time	Recommended Gap	Gravity	Color	Viscosity
A1	120 seconds	0.010 or less	0.99	Amber	<100 cP
A2	60 seconds	0.010 or less	0.99	Amber	<100 cP
A3	30-45 seconds	0.010 or less	0.98	Amber	<100 cP
A4	20-30 seconds	0.010 or less	0.99	Amber	<100 cP

Typical Cure Speed:

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

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