



# TECHNICAL DATA SHEET

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

## NOELLE 904-43-1 System

### A Two Component Heat Cured Silicone Potting Compound

#### **Description:**

Noelle 904-43-1 System is a two component, flowable liquid that cures into a tough elastomer after curing with heat.

#### **Advantages:**

Noelle 904-43-1 System features easy air release properties and minimal shrinkage along superior adhesion to a variety of substrates.

Noelle 904-43-1 System offers a wide range of service temperatures; excellent chemical resistance and a fully cured end product will not undergo reversion until normal operating conditions. Noelle 904-43-1 mixed system features convenient one to one mix ratio along with a moderate set up time at temperatures above 20°C, but require additional heat to achieve final cured results. Cures and setup times are directly related to the mass of the potting.

#### **Applications:**

Noelle 904-43-1 System is widely used in the manufacture of flexible molding and roller applications along with use in potting and encapsulating applications.

#### **Physical Properties:**

	<u>Part A</u>	<u>Part B</u>
	904-43-1A	904-43-1B
Color:	Black	Gray
Mixed Viscosity Cp @ 25°		1,500
Mix Ratio		
(By Weight)	100.0	100.0

#### **Shelf Life:** (Sealed containers)

Six Months @ 25°C (both A+B). Hand agitation of the individual components recommended after long standing to insure best results.

#### **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. Reseal containers immediately after using. This is a recommended procedure after each use.

#### **Instructions:**

Combine equal parts of A + B. 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 40% of the systems full potential. An additional 1 hour @ 121°C (250°F) will yield the systems full potential).

	100% or	100%
Cure Temp:	80°C	121°C
Cure Time:	3 hrs	1hr
<b>Pot Life</b> (200 grams) @ 25°C =>	120 Minutes	

#### **Cured Properties:**

Shore Hardness, measured @ 25°C	15-45 A
Tensile Strength ASTM D638:	>800 psi.

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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