



# TECHNICAL DATA SHEET

**Noelle Industries, Inc.**

Adhesives • Coatings • Conductives • Encapsulants

## NOELLE 905-12

### One Component UV Curable Adhesive

#### Description:

Noelle 905-12 is a UV / Visible Light curable plastic adhesive. It bonds to a variety of substrates including polycarbonate, PVC, and polyester. Noelle 905-12 cures very rapidly even under low intensity UV lamps (25 – 45 mW/cm<sup>2</sup>). The tack free finish and rapid cure make Noelle 905-12 a good choice for wire tacking applications on printed circuit boards.

#### Advantages:

Noelle 905-12 offers rapid cure, excellent cure depth, is solvent free, has a long shelf life, tack free finish, and automated dispensing is easily accomplished.

#### Uncured Properties:

Color: Light yellow to amber  
Specific gravity: 1.11 – 1.2 g/cc  
Viscosity @ 25°C: 7,000 – 9,500 cP

#### Storage and Shelf Life: (Sealed container)

Six months when stored at 25°C. This material is sensitive to UV/Visible light and therefore should always be stored in tightly sealed, UV-resistant containers away from sunlight and under cool dry conditions.

#### Cure Schedule:

Light Source: Metal Halide  
Irradiance: 35-45 mW/cm<sup>2</sup>  
Bond line: 1-2 mils  
Cure time: 5 – 10 seconds

#### Depth of Cure:

Light Source: Metal Halide (Fusion D)  
UV Energy Exposure (mJ/cm<sup>2</sup>)  
1000 0.05 in (1.38 mm)  
3000 >0.50 in (>12.5 mm)  
6000 >0.50 in (>12.5 mm)

#### Cured Properties:

Shore D Hardness, measured @ 25°C: 80-90  
Temperature Range: -20 to +125°C  
Refractive Index: 1.518  
Water Absorption (ASTM D-570) 24 hrs: <1.0%

#### Handling Recommendations:

Avoid prolonged contact with skin. Rubber gloves are advised. If swallowed do not induce vomiting. Call a physician immediately. In the case of eye contact flush eye with clear cold water for 15 minutes then consult a physician.

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

• Phone: (978) 439-9841 • Fax: (978) 439-9842 • Website: [www.noelleindustries.com](http://www.noelleindustries.com) • email: [info@noelleindustries.com](mailto:info@noelleindustries.com)