



# 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 (g/cc): 1.11 – 1.21  
Viscosity @ 25°C (cP): 7,000 – 9,500

#### **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 (mW/cm <sup>2</sup> ):	35-45
Bond line (mils):	1-2
Cure time (seconds):	5-10

#### **Depth of Cure:**

UV Energy Exposure (ml/cm <sup>2</sup> )	Depth of Cure
1000	0.05 in. (1.38 mm)
3000	>0.50 in (>12.5 mm)
6000	>0.50 in (>12.5 mm)
Light Source Metal Halide (Fusion D)	

#### **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.

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