CAPPING CEMENT SPECIFICATION

Grade Name: K35M

Applications: Incandescent grade up to 100 watts with 1000 hours life, with modified processing characteristics.

Physical appearance:

Powder appearance:	Slightly gritty off white powder
Paste appearance:	Slightly gritty light coloured paste
Cured appearance:	Straw coloured expanded solid

Physical properties:

Solvent:	ethanol (94%)	
Powder:solvent ratio:	7.5	L/100Kg powder @ 23°C
Viscosity:	310 - 340 ($^{+}/_{-}$ 5)	10ths/mm paste penetration @ 23°C
Powder density:	1.10	g/cm^3 (tapped)
Paste density:	2.0 - 2.2	g/cm^3
Average expansion:	90 - 110	%
Moisture resistance:	good	
Paste storage life:	not specified	Stored in sealed containers @ 21°C (Note - Higher temperatures reduce life)
Powder storage life:	12 months	See below

The above properties are given for guidance purposes only. Individual customer requirements should be assessed prior to the use of cement. Technical assistance and test methods are available on request.

Health and Safety data sheets are available upon request

The information contained on this specification sheet is given in good faith and does not constitute a warranty or guarantee for the customer. Customers are advised to ensure that all products are thoroughly tested to ensure suitability for the intended application.

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Registered in England No. 1378679

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Capping cement information

Powder Storage conditions	Keep containers tightly closed, store in a cool dry place out of direct sunlight. Under normal conditions (21ºC) a shelf life of 12 months is possible. Higher temperatures and humidity will reduce shelf life resulting in poor paste formation and may cause the powder to form lumps.
Recommended cleaning solvent:	Ethanol, isopropanol
Recommended mixing sequence:	1. Place alcohol in mixing vessel 2. Add half of powder 3. Mix for 5 minutes* 4. Add remainder of powder 5. Mix for a further 15 minutes* 6. Allow to stand for 1 hour before use *mixing times vary
Recommended mixing machines:	Hobart Winkworth Z Blade type Bowers Molteni

Recommended quantity of paste by cap type*: (for guidance only)

B22d	1.5 - 1.7 g
E27	1.6 - 1.8 g
B22d	1.2 - 1.4 g
E14	0.9 - 1.0 g
B15d	0.9 - 1.0 g
T8	0.8 - 1.2 g
T10	1.3 - 1.5 g
T12	1.6 - 2.0 g

Curing Parameters:

As cement curing is influenced by paste weight, curing temperature and time, precise figures cannot be given. For guidance purposes:

2 grams of paste @200°C will cure in 35 - 40 seconds
2 grams of paste @160°C will cure in 150 - 160 seconds

Prolonged exposure of curing cement to temperatures above 250°C should be avoided

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