

## CAPPING CEMENT SPECIFICATION

### Grade Name: K12/M

#### Applications:

Grade for linear fluorescent lamps and standard incandescent up to 100 watts with 1000 hours life. Ideal where customers wish to use one grade for both fluorescent and incandescent.

#### Physical appearance:

Powder appearance: Fine off white powder  
Paste appearance: Smooth dark green coloured paste  
Cured appearance: Dark straw coloured expanded solid

#### Physical properties:

Solvent: ethanol (94%)  
Powder:solvent ratio: 11.0 L/100Kg powder @ 23°C  
Viscosity: 275 - 325 (+/- 5) 10ths/mm paste penetration @ 23°C  
Powder density: 1.05 g/cm<sup>3</sup> (tapped)  
Paste density: 1.9 - 2.1 g/cm<sup>3</sup>  
Average expansion: 70 - 90 %  
Moisture resistance: good  
Paste storage life: 6 weeks Stored in sealed containers @ 21°C  
(Note - Higher temperatures reduce life)  
Powder storage life: 12 months

**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.

## Capping cement information

**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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