

**CAPPING CEMENT SPECIFICATION****Grade Name: K6000/M****Applications:**

Basic grade for linear fluorescent lamps and standard incandescent lamps upto and including 100 watts with 1500 hours lamp life.

**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:	8.5	L/100Kg powder @ 23°C
Viscosity:	275 - 325 (+/- 5)	10ths/mm paste penetration @ 23°C
Powder density:	1.0 - 1.2	g/cm <sup>3</sup> (tapped)
Paste density:	2.1 - 2.2	g/cm <sup>3</sup>
Average expansion:	80 - 100	%
Moisture resistance:	good	
Paste storage life:	6 weeks	Stored in sealed containers @ 21°C (Note - Higher temperatures <u>reduce</u> 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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Glassbond (NW) Ltd, West Side Industrial Estate,  
Jackson Street, St Helens, Merseyside, WA9 3AT, England  
Tel: + 44 (0) 1744 730 334 Fax: +44 (0) 1744 453 242  
Website: [www.glassbond.co.uk](http://www.glassbond.co.uk)  
Directors : PJ Randell Managing Director, RJ Randell, DJ Randell (M.I.M)  
Glassbond (NW) Ltd. Registered office: West Side Industrial Estate  
Registered in England No 1378679

