

**CAPPING CEMENT SPECIFICATION****Grade Name: K64/M****Applications:**

High performance incandescent grade upto 150 watts with 2500 hours lamp life. Can also be used for decorative and reflector lamps.

**Physical appearance:**

Powder appearance: Slightly gritty off white powder  
 Paste appearance: Smooth light green coloured paste  
 Cured appearance: Light straw coloured expanded solid

**Physical properties:**

Solvent:	ethanol (94%)	
Powder:solvent ratio:	10.0	L/100Kg powder @ 23°C
Viscosity:	275 - 325 (+/- 5)	10ths/mm paste penetration @ 23°C
Powder density:	1.15	g/cm <sup>3</sup> (tapped)
Paste density:	1.9 - 2.1	g/cm <sup>3</sup>
Average expansion:	65	%
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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