

## **CAPPING CEMENT SPECIFICATION**

**Grade Name: K165/M**

**Applications:** High performance grade for compact fluorescent lamps

**Physical appearance:**

Powder appearance: Fine off white powder  
Paste appearance: Dark green coloured paste  
Cured appearance: Straw/yellow 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: 0.9 - 1.1 g/cm<sup>3</sup> (tapped)  
Paste density: 1.9 - 2.1 g/cm<sup>3</sup>  
Average expansion: 100 - 120 %  
Moisture resistance: excellent  
Paste storage life: 8 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)

CFL single tube	1.0 - 1.5 g
CFL double tube	2.0 - 3.0 g
CFL triple tube	3.0 - 5.0 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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