

## **CAPPING CEMENT SPECIFICATION**

### **Grade Name: K192**

**Applications:** Grade suitable for high wattage lamps, with a life of up to 12000 hours at 350°C.

**Physical appearance:**

Powder appearance:	White powder
Paste appearance:	White coloured paste
Cured appearance:	White coloured expanded solid

**Physical properties:**

Solvent:	ethanol (94%)	
Powder:solvent ratio:	8.0	L/100Kg powder @ 23°C
Viscosity:	275 - 325 (+/- 5)	10ths/mm paste penetration @ 23°C
Powder density:	not specified	g/cm <sup>3</sup> (tapped)
Paste density:	1.9 - 2.1	g/cm <sup>3</sup>
Average expansion:	80 - 90	%
Moisture resistance:	good	
Paste storage life:	8 weeks	Stored in sealed containers @ 21°C (Note - Higher temperatures <u>reduce</u> life)
Powder storage life:	6 months	Stored in sealed containers @ 30 °C

**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.**

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**

### **Powder Storage conditions**

Keep containers tightly closed, store in a cool dry place out of direct sunlight. At 21°C a shelf life of 12 months is expected and at 30 °C a shelf life of 6 months is possible. However, temperatures higher than 30 °C and/or high humidity will further 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 (mixing times vary)
4. Add remainder of powder
5. Mix for a further 15 minutes (mixing times vary)
6. Allow to stand for 1 hour before use, to ensure full dissolution of the resins.

### **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

### **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 @300°C will cure in 10 - 15 seconds  
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 350°C should be avoided

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### **Health and Safety data sheets are available upon request**

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