

## **CAPPING CEMENT SPECIFICATION**

### **Grade Name: K116**

#### **Applications:**

High performance grade for compact fluorescent lamps utilising Trioxane or Ethanol.

#### **Physical appearance:**

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

#### **Physical properties:**

Solvent:	ethanol (94%)	
Powder:solvent ratio:	8	L/100Kg powder @ 23°C
Viscosity:	275 - 325 (+/- 5)	10ths/mm paste penetration @ 23°C
Powder density:	0.9-1.05	g/cm <sup>3</sup> (tapped)
Paste density:	1.9 -2.0	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

<b><u>Recommended quantity of paste by cap type*:</u></b> <u>(for guidance only)</u>	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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