

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/cm³ (tapped)
Paste density: 1.9 - 2.1 g/cm³
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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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
Directors: ME Cordell Managing Director, PJ Randell, RJ Randell, DJ Randell (M.I.M)
Glassbond (NW) Ltd. Registered office: West Side Industrial Estate
Registered in England No 1378679