

## **CAPPING CEMENT SPECIFICATION**

**Grade Name: K99/M**

**Applications:**

Grade for incandescent and HEI lamps of up to 500 watts with a life of upto 2500 hours at a working temperature of 210°C.

**Physical appearance:**

Powder appearance: Fine 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: 8.5 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: 110 - 130 %  
Moisture resistance: good  
Paste storage life: 6 weeks Stored in sealed containers @ 21°C  
(Note - Higher temperatures reduce life)  
Powder storage life: 12 months See below

**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**

### **Powder Storage conditions**

Keep containers tightly closed, store in a cool dry place out of direct sunlight. Under normal conditions (21°C) a shelf life of 12 months is possible. Higher temperatures and humidity will 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\*
  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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