

CAPPING CEMENT SPECIFICATION

Grade Name: P641/M

Applications:

Grade for incandescent and HEI lamps of up to 150 watts with a life of up to 2500 hours. Can also be used for decorative and reflector lamps.

Physical appearance:

Powder appearance:	Not applicable
Paste appearance:	Smooth light green coloured paste
Cured appearance:	Light straw coloured expanded solid

Physical properties:

Solvent:	ethanol (94%)	
Powder:solvent ratio:	not applicable	L/100Kg powder @ 23°C
Viscosity:	285 - 295 (+/- 5)	10ths/mm paste penetration @ 23°C
Powder density:	not applicable	g/cm ³ (tapped)
Paste density:	1.8 - 2.0	g/cm ³
Average expansion:	60	%
Moisture resistance:	good	
Paste storage life:	6 weeks	Stored in sealed containers @ 21°C (Note - Higher temperatures <u>reduce</u> life)
Powder storage life:	not applicable	

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: Not applicable

Recommended mixing machines: Not applicable

<u>Recommended quantity of paste by cap type*:</u> (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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