



Glassbond (N.W.) Ltd.

West Side Industrial Estate,
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GRADE P966 CAPPING CEMENT

P966 Lamp Capping Cement is a high temperature grade specifically designed for high wattage **G.L.S.** 'Candle Lamps' and specials.

Paste Manufacture - A satisfactory paste can be produced using conventional mixing equipment of the '**Z-Blade**' or '**Hobart**' types by the use of *Ethanol*. The quantity of spirit required to produce a suitable paste will depend on the type of pasting equipment used, but as a guide, approx. 1 litre of spirit is required per 10Kgs of **P966** powder. Heat sensitive dyes, e.g. '**Malachite Green**', may be added in the usual way by predissolving in the Ethanol prior to mixing with the cement powder.

Paste Characteristics - The paste, so produced, can be used in automatic cap pasting machines of the pressurised or non-pressurised type. Some adjustment of paste viscosity is normal from one lamp manufacturer to another to suit his particular applications. This is achieved of course, by slight variation in the Ethanol content.

1. **Storage Life** - The paste will be suitable from use from 2 hours after initial mixing and up to 48 hours when stored under normal temperature and humidity conditions.
2. **Curing Time** - To produce optimum bond strength between cap and glass, the cement has to be cured adequately. In general, the higher the temperature achieved on the cap during lamp manufacture, the shorter the time required, e.g. at 200°C the time to cure should be 40 - 50 secs., whilst at 140°C this may extend up to 1 - 1½ minutes. Over baking above 200°C should be avoided, since this reduces the torque strength of the bond.

Packaging - The material can be supplied in 25Kgs cardboard boxes or paper sacks, normally 40 per tonne pallet, 50Kgs fibre kegs or 125Kgs steel drums as required. In all cases a polythene liner is used.

Shelf Life - **P966** Lamp Capping Cement powder has an indefinite shelf life when stored in cool dry conditions.

Health & Safety - The powder is inert and non-toxic, presenting no special hazard to the user. The usual precautions should be taken when handling fine powders.



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SHEET 1 OF 2

SPEC. NO. GBS 966 ISSUE 1

PRODUCT SPECIFICATION

MATERIAL	Lamp Capping Cement
GRADE	P966
TYPE	High silicone modified phenolic resin based powder
APPLICATION	High temperature resistant G.L.S. Lamps
PHYSICAL CHARACTERISTICS	Pink buff fine powder
CHEMICAL COMPOSITION	Phenol/formaldehyde novolac resin) Approx Hexamethylene tetramine curing agent) 15 - 20% Shellac) Silicone resin) Lithopone) Approx Calcium Carbonate) 80 - 85%
PASTE CHARACTERISTICS	400 grams P966 + 40 mls 94/95% Ethanol
APPEARANCE	Smooth lump free paste

ISSUE NO									
ISSUE DATE									
APPROVED TECH									
APPROVED MANU									
APPROVED QC									

