

KÖRAFORM K 12 2 part casting compound

Description

Notch-resistant, condensation crosslinking silicone filling compound

Key Features

- Very good flowing behaviour
- Is convincing through the accurate reproducibility of the moulding
- Very good elastic properties
- Low hardness Shore A

Use and Cure Information

Stir up KÖRAFORM K 12 well before processing so that any deposited filling substances are homogeneously distributed. KÖRAFORM B 132 is added to KÖRAFORM K 12 at a mixing ratio of 3 : 100 according to weight and mixed with the spatula or stirring unit until the mass is homogeneous. With this mixing process, the potlife starts by which time KÖRAFORM K 12 has to be processed (casting or painting with the brush). Demoulding can be done after 20 hours. For an absolutely bubble-free vulcanisate the mixed silicone gel must be degassed using vacuum prior to the casting process (max. 5 minutes at 10 - 20 mbar). By adding up to 1 weight percent of KÖRAFORM TM C to the catalysed mass, the viscosity can be increased up to stability. When moulding difficult substrates such as glass, the separation behaviour has to be verified in own tests and perhaps by adding a silicone-free separation agent.

Solvents and cleaning agents

For removing fresh mass KÖRASOLV GL must be applied. Residues in the stirring or casting vessel can be easily removed by letting them cure in order to scrape them off afterwards.

Storage

KÖRAFORM K 12 can be optimally processed for at least nine months if stored between 5 °C and 30 °C in tightly closed original containers.
KÖRAFORM B 132 can be optimally processed for at least six months if stored between 5 °C and 30 °C in tightly closed original containers.

Health & Safety

Safety

Please observe our safety data sheets and the safety remarks on our container labels when handling our products. The dangerous goods regulations and the accident prevention regulations of the professional associations must be particularly observed. Keep the safety data sheet of the applied product at hand since it provides you with useful instructions for the safe use and disposal of the product as well as for actions to be taken in case of accidents.

Delivery units

KÖRAFORM K 12: 22 kg hobbocks or 220 kg drums
KÖRAFORM B 132: 0.5 kg PET bottles

Revision Date 29 Apr 2021
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Property

Uncured Product

Color A

White

Color B

Colourless /
yellowish

Cure Type

Condensation

De-mould Time / Full Cure
at 23°C/73°F

20 hrs

Density A

DIN 53 479

1.08

Density B

DIN 53 479

1.04

Mix Ratio By Weight

100:3

Pot Life mins at
23°C/73°F

90 mins

Viscosity A

Brookfield
HBTD

14000 cP

Viscosity B

Brookfield
HBTD

20 cP

Viscosity Mixed

Brookfield
HBTD

13500 cP

Cured Product

Standard climate DIN 50 014 - 23/50-2. Vulcanizate
tested after 7 days at room temperature

Color

White/yellowish

Elongation at Break

DIN 53 504, S
3 A

380 %

Hardness Shore A

DIN 53 505

12

Linear Shrinkage (%)

0.5 %

Tear Resistance (N/mm)

ASTM D 624,
Die B

380 N/mm / 2189
ppi

Tensile Strength

DIN 53 504, S
3 A

2.40 N/mm² / 348
psi

Storage

Max Storage
Temperature

30 °C / 86 °F

Min Storage Temperature

5 °C / 41 °F

Shelf Life

9 mths

The content set out in the technical data sheet does not contain information upon which you should rely. It is provided for general information purposes only and does not constitute a product specification. You must obtain professional or specialist advice before taking any action based on the information provided in the technical data sheet.

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The CHT technical service department is available to offer further information and advice and should it be needed to look at modifying current products or custom formulate a new one to meet your specific requirements. Please contact the technical service department.

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