

KÖRAFORM K 18 2 part casting compound

Description	Property	Test Method	Value
Notch-resistant, condensation crosslinking silicone filling compound particularly for casting polyester resin	Uncured Product		
Key Features	Color A		White
<ul style="list-style-type: none"> Good flowing behaviour Very good elastic properties Outstanding stability to polyester resins Suitable for block moulds and skin moulds with strong undercuts 	Color B		Colourless / yellowish
Use and Cure Information	Cure Type		Condensation
Stir up components A and B well before processing!	De-mould Time / Full Cure at 23°C/73°F		18 hrs
KÖRAFORM B 132 is added to KÖRAFORM K 18 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 18 has to be processed (casting or painting with the brush). Demoulding can be done after 18 hours. For an absolutely bubble-free vulcanisate the mixed silicone must be degassed using vacuum prior to the casting process (max. 5 minutes at 10 - 20 mbar). 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.	Density A	DIN 53 479	1.09
	Density B	DIN 53 479	1.04
	Mix Ratio By Weight		100:3
	Pot Life mins at 23°C/73°F		100 mins
	Viscosity A	Brookfield HBTD	25000 cP
	Viscosity B	Brookfield HBTD	20 cP
	Viscosity Mixed	Brookfield HBTD	24000 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	350 %
	Hardness Shore A	DIN 53 505	18
	Linear Shrinkage (%)		0.5 %
Solvents and cleaning agents	Tear Resistance (N/mm)	ASTM D 624, Die B	17 N/mm / 97 ppi
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.	Tensile Strength	DIN 53 504, S 3 A	3.5 N/mm ² / 508 psi
Storage	Storage		
KÖRAFORM K 18 can be optimally processed for at least nine months if stored between 5 °C and 30 °C in tightly closed original containers.	Max Storage Temperature		30 °C / 86 °F
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.	Min Storage Temperature		5 °C / 41 °F
	Shelf Life		9 mths
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 18: 22 kg hobbocks			
KÖRAFORM B 132: 0.5 kg PET bottles			

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