

KÖRAFORM K 18 2 part casting compound

Description

Notch-resistant, condensation crosslinking silicone filling compound particularly for casting polyester resin

Key Features

- Good flowing behaviour
- Very good elastic properties
- Outstanding stability to polyester resins
- Suitable for block moulds and skin moulds with strong undercuts

Use and Cure Information

Stir up components A and B well before processing!

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.

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 18 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 18: 22 kg hobbocks
KÖRAFORM B 132: 0.5 kg PET bottles

Revision Date 29 Apr 2021
Revision No 1
Download Date 20 Oct 2021

Property

Uncured Product

Color A

Color B

Cure Type

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

Density A

Density B

Mix Ratio By Weight

Pot Life mins at 23°C/73°F

Viscosity A

Viscosity B

Viscosity Mixed

Cured Product

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

Color

Elongation at Break

Hardness Shore A

Linear Shrinkage (%)

Tear Resistance (N/mm)

Tensile Strength

Storage

Max Storage Temperature

Min Storage Temperature

Shelf Life

Test Method Value

**White
Colourless /
yellowish
Condensation**

18 hrs

DIN 53 479

DIN 53 479

1.09

1.04

100:3

100 mins

Brookfield
HBTD

Brookfield
HBTD

Brookfield
HBTD

25000 cP

20 cP

24000 cP

DIN 53 504, S
3 A

DIN 53 505

ASTM D 624,
Die B

DIN 53 504, S
3 A

White/yellowish

350 %

18

0.5 %

17 N/mm / 98 ppi

**3.5 N/mm² / 508
psi**

30 °C / 86 °F

5 °C / 41 °F

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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