

## KÖRAFORM K 65 2 part casting compound

### Description

Low viscosity, temperature stable, condensation crosslinking silicone casting compound

### Key Features

- Low viscosity
- High hardness (Shore A)
- Convincing by reproduction and detail exactness of the moulding
- Moulding of simple geometric parts

### Use and Cure Information

Prior to processing KÖRAFORM K 65 has to be stirred well so that perhaps deposited filling agents are homogeneously distributed. Add to KÖRAFORM K 65 KÖRAFORM B 132 in a mixing ratio of 100 : 2.5 according to weight and mix with a spatula or the mixer until the compound is homogeneous. With mixing the potlife starts in which KÖRAFORM K 65 is to be processed (casting or painting with a brush). The demoulding can start after 8 hours. For an absolutely bubble-free vulcanisate the mixed silicone must be degassed using vacuum prior to the casting process (maximal 5 minutes under 10 - 20 mbar). In case of moulding on difficult mouldings, e.g. glass, the demoulding behaviour has to be checked in tests by yourself. A silicone free demoulding agent has to be applied in case of need. During curing alcohol is separated which has to escape completely out of the vulcanisate before the mould can be heated by temperatures > 70 °C. For accelerating the mould can be tempered at max. 70 °C in the air recirculating heating chamber. The mould has to be tempered per 1 cm thickness by storing in a ventilated heating chamber at approx. 60 - 70 °C.

### 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

Stored in tightly closed original containers at temperatures between 5 °C and 30 °C KÖRAFORM K 65 is optimally processible for at least nine months (stir well before use).

Stored in tightly close original containers at temperatures between 5 °C and 30 °C KÖRAFORM B 132 is optimally processible for at least six months.

### 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 unit

KÖRAFORM K 65: 5 kg pail  
KÖRAFORM B 132: 0.5 kg PE bottle

Revision Date 29 Apr 2021  
Revision No 1  
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### Property

#### Uncured Product

Color A

**Red**

Color B

**Colourless to yellowish**

Cure Type

**Condensation**

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

**8 hrs**

Density A

DIN 53 479

**1.40**

Density B

DIN 53 479

**1.04**

Mix Ratio By Weight

**100 : 2.5**

Pot Life mins at 23°C/73°F

**100 mins**

Viscosity A

Brookfield  
HBTD

**12500 cP**

Viscosity B

Brookfield  
HBTD

**20 cP**

Viscosity Mixed

Brookfield  
HBTD

**10000 cP**

#### Cured Product

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

Color

**Red**

Elongation at Break

DIN 53 504, S  
3 A

**80 %**

Hardness Shore A

DIN 53 505

**60**

Linear Shrinkage (%)

**0.5 %**

Tear Resistance (N/mm)

ASTM D 624,  
Die B

**4.0 N/mm / 23 ppi**

Tensile Strength

DIN 53 504, S  
3 A

**4.0 N/mm<sup>2</sup> / 580 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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