

ALPA-SIL 18101 2 part Silicone Moulding Rubber

Description	Property	Test Method	Value
Notch-resistant, condensation crosslinking silicone filling compound particularly for casting polyester resin.	Uncured Product		
Key Features	Appearance		Translucent
<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 A		Translucent
Application	Cure Type		Condensation
casting polyester resin, printing pads, block moulds and skin moulds with strong undercuts	De-mould Time / Full Cure at 23°C/73°F		18 h hrs
Use and Cure Information	Density A	DIN 53 479	1.09
Stir up components A and B well before processing!	Density B	DIN 53 479	1.04
KÖRAFORM B 132 is added to ALPA-SIL 18101 at a mixing ratio of 100 : 3 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 ALPA-SIL 18101 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.	Mix Ratio By Weight		100:3
	Pot Life mins at 23°C/73°F		100 mins
	Viscosity A	Brookfield HBTD	30000 cP
	Viscosity B	Brookfield HBTD	20 cP
	Viscosity Mixed	Brookfield HBTD	29000 cP
	Cured Product		
	Standard climate DIN 50 014 - 23/50-2. Vulcanizate tested after 7 days at room temperature		
	Color		Transparent
	Elongation at Break	DIN 53 504, S 3 A	350 %
	Hardness Shore A	DIN 53 505	18
	Linear Shrinkage (%)		0.5 %
	Tear Resistance (N/mm)	ASTM D 624, Die B	17 N/mm / 98 ppi
	Tensile Strength	DIN 53 504, S 3 A	3,5 N/mm² / 435 psi
	Storage		
	Max Storage Temperature		30 °C / 86 °F
	Min Storage Temperature		5 °C / 41 °F
	Shelf Life		9 mths
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.			

	ALPA-SIL 18101 Component A	KÖRAFORM B 132 Component B		
Colour	transparent	colourless/yellowish		
Viscosity	30,000	20	mPa·s	Brookfield HBTD ¹⁾
Density	1.09	1.04	g/cm ³	DIN 53 479 ¹⁾
	Mixture			
Mixing ratio	100 : 3		according to weight	
Viscosity	29,000		mPa·s	Brookfield HBTD ¹⁾
Potlife	100		minutes	
Demouldable after	18		hours	
	Vulcanisate			
Hardness Shore A	18			DIN 53 505 ²⁾
Tear strength	3.5		N/mm ²	DIN 53 504 S 3 A ²⁾
Elongation at break	350		%	DIN 53 504 S 3 A ²⁾
Tear propagation resistance	17		N/mm	ASTM D 624 'Form B ²⁾
Linear shrinking	0.5		%	after 7 days
¹ = Measured under standard climate DIN 50 014-23/50-2				
² = Vulcanisate, measured after 7 days of storage at room temperature				

Storage

ALPA-SIL 18101 can be optimally processed for at least nine months if stored between 5°C and 30°C in tightly closed containers.
KÖRFOARM B 132 can be optimally processed for at least six months if stored between 5 °C and 30 °C in tightly closed containers.

Health & Safety

Safety

Please observe our EC 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 EC 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

ALPA-SIL 18101: 22 kg hobbocks
KÖRAFORM B 132: 0.5 kg PET bottles

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