

KÖRAFORM 97067 A 2 part casting compound

Description	Property	Test Method	Value
Condensation crosslinking silicone casting compound for pad printing, shore A 6	Uncured Product		
Key Features	Color A		brick red
<ul style="list-style-type: none"> 100:3 mix ratio Low viscosity Suited printing pad manufacture Shore A 6 	Cure Type		Condensation
Application	De-mould Time / Full Cure at 23°C/73°F		24 hrs
PAD printing	Mix Ratio By Weight		100:3
Use and Cure Information	Pot Life mins at 23°C/73°F		60 mins
Prior to processing thoroughly stir up KÖRAFORM 97067 A to homogeneously distribute possibly deposited fillers. To KÖRAFORM 97067 A KÖRAFORM B 128 K is added at a mixing ratio of 100 : 3 according to weight and then mixed with a spatula or stirrer until the compound is homogeneous.	Viscosity A	Brookfield	5000 cP
With this mixing the potlife of 60 min starts where KÖRAFORM 97067 A must be processed (casting or brushing). Demoulding can be effected after 24 hours. For an absolutely bubble-free vulcanizate the mixed silicone gel must be degassed using vacuum prior to the casting process (5 min at the most at 10 – 20 mbar). The viscosity can be increased up to strength by adding up to 1 weight per cent KÖRAFORM TM C to the catalyzed compound. When casting critical grounds, e.g. glass, check the release behaviour with your own trials. A silicone-free release agent may have to be applied.	Viscosity B	Brookfield	14 cP
	Cured Product		
	Color		Brick Red
	Hardness Shore A	DIN 53 505	6
	Linear Shrinkage (%)		0.5 %
	Storage		
	Max Storage Temperature		30 °C / 86 °F
	Min Storage Temperature		5 °C / 41 °F
	Shelf Life		6 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.

	KÖRAFORM 97067 A component A	KÖRAFORM B 128 K component B		
Colour	brick red	colourless		
Viscosity	5,000	14	mPa·s	Brookfield HBTD ¹⁾
Density		0.99	g/cm ³	DIN 53 479 ¹⁾
Mixing ratio	Mixture 100 : 3		according to weight	
Mixing viscosity	16,000			
Potlife	60		min	
Demouldable after	24		hours	
Hardness shore A	Vulcanizate 6			DIN 53 505 ²⁾
Tensile strength	not stated		N/mm ²	DIN 53 504 S 3 A ²⁾
Elongation at break	not stated		%	DIN 53 504 S 3 A ²⁾
Res. to further tearing	not stated		N/mm	ASTM D 624 Form B ²⁾
Linear shrinkage	0.5		%	after 7 days
¹ = Measured under standard climate DIN 50 014-23/50-2				
² = Vulcanizate, measured after 7 days of storage at room temperature				

Storage

KÖRAFORM 97067 A can be optimally processed for at least six months if being stored at 5 °C – 30 °C in tightly closed original containers. KÖRAFORM B 128 K can be optimally processed for at least six months if being stored at 5 °C – 30 °C in tightly closed original containers.

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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

KÖRAFORM 97067 A:

22 kg hobbocks

20 kg pails

5 kg pails

KÖRAFORM B 128 K:

0.5 kg PE bottles

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