

KÖRAFORM K 12 2 part casting compound

Description	Property	Test Method	Value
Notch-resistant, condensation crosslinking silicone filling compound	Uncured Product		
Key Features	Color A		White
<ul style="list-style-type: none"> Very good flowing behaviour Is convincing through the accurate reproducibility of the moulding Very good elastic properties Low hardness Shore A 	Color B		Colourless / yellowish
Use and Cure Information	Cure Type		Condensation
Stir up KÖRAFORM K 12 well before processing so that any deposited filling substances are homogeneously distributed. KÖRAFORM B 132 is added to KÖRAFORM K 12 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 12 has to be processed (casting or painting with the brush). Demoulding can be done after 20 hours. For an absolutely bubble-free vulcanisate the mixed silicone gel must be degassed using vacuum prior to the casting process (max. 5 minutes at 10 - 20 mbar). By adding up to 1 weight percent of KÖRAFORM TM C to the catalysed mass, the viscosity can be increased up to stability. 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.	De-mould Time / Full Cure at 23°C/73°F		20 hrs
	Density A	DIN 53 479	1.08
	Density B	DIN 53 479	1.04
	Mix Ratio By Weight		100:3
	Pot Life mins at 23°C/73°F		90 mins
	Viscosity A	Brookfield HBTD	14000 cP
	Viscosity B	Brookfield HBTD	20 cP
	Viscosity Mixed	Brookfield HBTD	13500 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	380 %
	Hardness Shore A	DIN 53 505	12
	Linear Shrinkage (%)		0.5 %
	Tear Resistance (N/mm)	ASTM D 624, Die B	380 N/mm / 2189 psi
	Tensile Strength	DIN 53 504, S 3 A	2.40 N/mm² / 348 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.			
Storage			
KÖRAFORM K 12 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 12: 22 kg hobbocks or 220 kg drums KÖRAFORM B 132: 0.5 kg PET bottles			

Revision Date 29 Apr 2021
Revision No 1
Download Date 16 May 2022