

KÖRAFORM K 27 2 part casting compound

Description	Property	Test Method	Value
Liquid, condensation crosslinking silicone casting compound	Uncured Product		
Key Features	Color B		Colourless / yellowish
<ul style="list-style-type: none"> Very good flow behaviour Stands out for the draughting accuracy of the moulds Suited for block moulds Suited for moulding shoe soles 	Cure Type		Condensation
Application	De-mould Time / Full Cure at 23°C/73°F		3 hrs
Block moulds	Density A	DIN 53 479	1.24
Use and Cure Information	Density B	DIN 53 479	1.04
Stir up KÖRAFORM K 27 thoroughly prior to processing it to homogeneously distribute possibly deposited fillers. To KÖRAFORM K 27 KÖRAFORM B 132 is added at a mixing ratio of 100 : 3 according to weight and mixed with the spatula or stirring unit until the compound is homogeneous. With this mixing the potlife starts by which time KÖRAFORM K 27 is to be processed (by casting or painting with the brush). Demoulding can be effected after 3 hours. For an absolutely bubble-free vulcanizate the mixed silicone gel must be degassed using vacuum prior to the casting process (5 min at 10 – 20 mbar at the most).	Mix Ratio By Weight		100:3
	Pot Life mins at 23°C/73°F		30 mins
	Viscosity A	Brookfield HBTD	14000 cP
	Viscosity B	Brookfield HBTD	20 cP
	Viscosity Mixed	Brookfield HBTD	13000 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	260 %
	Hardness Shore A	DIN 53 505	28
	Linear Shrinkage (%)		0.5 %
	Tear Resistance (N/mm)	ASTM D 624, Die B	5.0 N/mm / 29 ppi
	Tensile Strength	DIN 53 504, S 3 A	3.0 N/mm² / 435 psi
	Storage		
	Max Storage Temperature		30 °C / 86 °F
	Min Storage Temperature		5 °C / 41 °F
	Shelf Life		9 mths
For adjusting the potlife and demoulding time to the processing terms further B components (hardeners) are available:			
B component: KÖRAFORM B 128			
Pot life: 50 minutes			
Demouldable after 5 hours			
If you mould critical substrates, e.g. glass, you ought to check the release behaviour by carrying out your own trials. You may have to use a silicone- free release 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 27 can be optimally processed for at least nine months if the product is stored at 5 °C to 30 °C in tightly closed original containers (stir up thoroughly prior to use).
KÖRAFORM B 128 and B 132 can be optimally processed for at least six months if the product is stored at 5 °C to 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 27: 22 kg hobbock
KÖRAFORM B 128: 0.5 kg PE bottle
KÖRAFORM B 132: 0.5 kg PE bottle

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