

KÖRAFORM K 31 2 part casting compound

Description	Property	Test Method	Value
Notch-resistant, condensation crosslinking silicone casting compound	Uncured Product		
Key Features	Cure Type		Condensation
• The mixture with CAT 9 is very well stable to polyester	De-mould Time / Full Cure at 23°C/73°F		20 - 22 hrs
Application	Density A	DIN 53 479	1.22
Properties vary depending on Part B used	Mix Ratio By Weight		100:3 or 100:5
Use and Cure Information	Pot Life mins at 23°C/73°F		60 or 25 mins
Stir up KÖRAFORM K 31 well before processing so that any deposited filling components are homogeneously distributed. KÖRAFORM B 128 is added to KÖRAFORM K 31 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 pot life of 60 minutes starts by which time KÖRAFORM K 31 has to be processed (casting or painting with the brush).	Viscosity A	Brookfield HBTD	25000 cP
Demoulding can be done after 20 hours. For an absolutely bubble-free vulcanisate, the mixed silicone has to be degassed using vacuum prior to the casting process (max. 5 min at 10 – 20 mbar). By adding up to 1 weight per cent of KÖRAFORM TM C to the catalysed mass, the viscosity can be increased up to stability. When moulding critical substrates such as glass, the release behaviour has to be verified by carrying out your own tests and perhaps by adding a silicone-free release agent.	Viscosity Mixed	Brookfield HBTD	24000 cP
	Cured Product		
	Standard climate DIN 50 014 - 23/50-2. Vulcanizate tested after 7 days at room temperature		
	Color		White or blue
	Hardness Shore A	DIN 53 505	21
	Linear Shrinkage (%)		0.5 %
	Storage		
	Max Storage Temperature		30 °C / 86 °F
	Min Storage Temperature		5 °C / 41 °F
	Shelf Life		6 mths

	KÖRAFORM K 31 Component A	KÖRAFORM B 128 Component B	CAT 9 Component B		
Colour	White	Colourless or blue	Colourless		
Viscosity	25,000	20	14	mPa·s	Brookfield HBTD ¹⁾
Density	1.22	1.04	0.99	g/cm ³	DIN 53 479 ¹⁾
Mixture					
Mixing ratio	100 : 3		100 : 5	according to weight	
Mixing viscosity	24,000		24,000		
Potlife	60		25	minutes	
Demouldable after	20		22	hours	
Vulcanisate					
Hardness Shore A	21		21		DIN 53 505 ²⁾
Tear strength	2.8		2.1	N/mm ²	DIN 53 504 S 3 A ²⁾
Elongation at break	380		290	%	DIN 53 504 S 3 A ²⁾
Tear propagation resistance	22		16.2	N/mm	ASTM D 624 Form B ²⁾
Linear shrinking	0.5		0.5	%	after 7 days
¹ = measured under standard climate DIN 50 014-23/50-2					
² = (vulcanisate, measured after 7 days at RT)					

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Solvents and Cleaning Agents

For removing fresh mass, KÖRASOLV GL has to be applied. Residues in the stirring or casting vessel are easily removed by letting them cure in order to scrape them off afterwards.

Storage

Stored at temperatures between 5 °C and 30 °C in tightly closed original containers, KÖRAFORM K 31 can be optimally processed for at least six months.

Stored at temperatures between 5 °C and 30 °C in tightly closed original containers, KÖRAFORM B 128 can be optimally processed for at

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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

Upon demand

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