

KÖRAFORM K 40 / K 40 AZ 2 part casting compound

Description

Low viscosity, condensation crosslinking silicone casting compound

Key Features

- For casting simple geometric parts and for detailed reproductions
- Low viscosity
- Convincing by its excellent reproducibility and draft accuracy of the cast
- Medium hardness (shore A)

Application

keywords

Use and Cure Information

Application Fields

KÖRAFORM K 40 AZ has a somewhat higher viscous adjustment for building up thicker layers at the edges.

Processing

Preparation of work

Prior to processing, KÖRAFORM K 40 / K 40 AZ must be stirred up thoroughly, so that any deposited filling substances are homogeneously distributed. To KÖRAFORM K 40 / K 40 AZ, KÖRAFORM B 132 is added at a mixing ratio of 100 : 3 according to weight and mixed with a spatula or stirring unit until the mass is homogeneous. With this mixing process the potlife starts by which time KÖRAFORM K 40 / K 40 AZ is to be processed (by pouring or painting with the brush). Demoulding can be done after 12 hours. For an absolutely bubble-free vulcanisate the mixed silicone gel must be degassed using vacuum prior to the casting process (max. 5 min at 10 – 20 mbar). When casting critical undergrounds such as glass, the separation behaviour has to be checked in individual trials and perhaps a silicone-free separation agent must be added.

Property

Uncured Product

Color A

Color B

Cure Type

De-mould Time / Full Cure at 23°C/73°F

Density A

Density B

Mix Ratio By Weight

Pot Life mins at 23°C/73°F

Viscosity A

Viscosity B

Test Method

DIN 53 479

DIN 53 479

Brookfield HBTD

Brookfield HBTD

Value

White

Colourless / yellowish
Condensation

12 hrs

1.16

1.04

100:3

60 mins

5500 / 8000 cP

20 cP

Cured Product

Standard climate DIN 50 014 - 23/50-2. Vulcanizate tested after 7 days at room temperature

Color

Elongation at Break

Hardness Shore A

Linear Shrinkage (%)

Tear Resistance (N/mm)

Tensile Strength

White

140 %

40

0.5 %

3.0 N/mm / 17 ppi

ASTM D 624, Die B

2.40 N/mm² / 348 ppi

Storage

Max Storage Temperature

Min Storage Temperature

Shelf Life

30 °C / 86 °F

5 °C / 41 °F

9 mths

	KÖRAFORM K 40 / K 40 AZ Component A	KÖRAFORM B 132 Component B		
Colour	white	colourless/yellowish		
Viscosity	5,500 / 8,000	20	mPa·s	Brookfield HBTD ¹⁾
Density	1.16	1.04	g/cm ³	DIN 53 479 ¹⁾
	Mixture			
Mixing ratio	100 : 3		acc. to weight	
Potlife	60		min	¹⁾
Demouldable after	12		hours	¹⁾
	Vulcanisate			
Hardness Shore A	40			DIN 53 505 ²⁾
Tensile strength	2.4		N/mm ²	DIN 53 504 S 3 A ²⁾
Elongation at break	140		%	DIN 53 504 S 3 A ²⁾
Res. to further tearing	3		N/mm	ASTM D 624 Form B ²⁾
Linear shrinking	0.5		%	After 7 days ¹⁾
¹⁾ = Measured under standard climate DIN 50 014-23/50-2 ²⁾ = Vulcanisate, measured after 7 days of storage at room temperature				

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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

Stored in tightly closed original containers between +5 and 30 °C, KÖRAFORM K 40 / K 40 AZ can be processed at best for at least nine months (stir up well before use).

Stored in tightly closed original containers between +5 and 30 °C, KÖRAFORM B 132 can be processed at best for at least six months.

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
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