

## KÖRAFORM K 50 2 part casting compound

### Description

Low viscosity, condensation crosslinking silicone casting compound

### Key Features

- Low viscosity
- Hardness (Shore A 50)
- Convincing by reproduction and drawing exactness of the moulding
- Moulding of simple geometric parts

### Use and Cure Information

Prior to processing stir well KÖRAFORM K 50 to distribute homogeneously the perhaps deposited fillers. To KÖRAFORM K 50 add KÖRAFORM B 132 at a mixing ratio of 100 : 3 according to weight and mix with a spatula or a mixer until the compound is homogeneous. With the mixing process the potlife during which KÖRAFORM K 50 is to be processed (casting or painting with a brush). The demoulding can be done after 12 hours.

For an absolutely bubble-free vulcanisate the mixed silicone has to be degassed using vacuum (max. 5 minutes at 10 - 20 mbar). In case of moulding on difficult supports, e.g. glass the demoulding behaviour has to be checked in tests by yourself. A silicone free demoulding agent has to be applied in case of need.

### 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 at temperatures between 5 °C and 30 °C in tightly closed original containers KÖRAFORM K 50 can be processed for at least nine months (stir well before use). KÖRAFORM B 132 is processible for at least six months if stored at temperature 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 50:

22 kg hobbock  
10 kg pail

KÖRAFORM B 132:

0.5 kg PE bottle

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Revision No 2

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### Property

#### Uncured Product

Color A

White

Color B

Colourless /  
yellowish  
Condensation

Cure Type

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

12 hrs

Density A

DIN 53 479

1.20

Density B

DIN 53 479

1.04

Mix Ratio By Weight

100:3

Pot Life mins at 23°C/73°F

100 mins

Viscosity A

Brookfield HBTD

8000 cP

Viscosity B

Brookfield HBTD

20 cP

Viscosity Mixed

Brookfield HBTD

6000 cP

#### Cured Product

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

Elongation at Break

DIN 53 504, S 3 A

120 %

Hardness Shore A

DIN 53 505

50

Linear Shrinkage (%)

0.5 %

Tear Resistance (N/mm)

ASTM D 624, Die  
B

3.0 N/mm / 17 ppi

Tensile Strength

DIN 53 504, S 3 A

2.3 N/mm<sup>2</sup> / 334 psi

#### Storage

Max Storage Temperature

30 °C / 86 °F

Min Storage Temperature

5 °C / 41 °F

Shelf Life

9 mths

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