

KÖRAFORM K 50 2 part casting compound

Description	Property	Test Method	Value
Low viscosity, condensation crosslinking silicone casting compound	Uncured Product		
Key Features	Color A		White
<ul style="list-style-type: none"> Low viscosity Hardness (Shore A 50) Convincing by reproduction and drawing exactness of the moulding Moulding of simple geometric parts 	Color B		Colourless / yellowish
Use and Cure Information	Cure Type		Condensation
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.	De-mould Time / Full Cure at 23°C/73°F		12 hrs
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.	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 ² / 334 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			
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			
Revision Date	29 Apr 2021		
Revision No	1		
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