

KÖRAFORM K 65 2 part casting compound

Description	Property	Test Method	Value
Low viscosity, temperature stable, condensation crosslinking silicone casting compound	Uncured Product		
Key Features	Color A		Red
<ul style="list-style-type: none"> Low viscosity High hardness (Shore A) Convincing by reproduction and detail exactness of the moulding Moulding of simple geometric parts 	Color B		Colourless to yellowish
Use and Cure Information	Cure Type		Condensation
Prior to processing KÖRAFORM K 65 has to be stirred well so that perhaps deposited filling agents are homogeneously distributed. Add to KÖRAFORM K 65 KÖRAFORM B 132 in a mixing ratio of 100 : 2.5 according to weight and mix with a spatula or the mixer until the compound is homogeneous. With mixing the potlife starts in which KÖRAFORM K 65 is to be processed (casting or painting with a brush). The demoulding can start after 8 hours. For an absolutely bubble-free vulcanisate the mixed silicone must be degassed using vacuum prior to the casting process (maximal 5 minutes under 10 - 20 mbar). In case of moulding on difficult mouldings, 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. During curing alcohol is separated which has to escape completely out of the vulcanisate before the mould can be heated by temperatures > 70 °C. For accelerating the mould can be tempered at max. 70 °C in the air recirculating heating chamber. The mould has to be tempered per 1 cm thickness by storing in a ventilated heating chamber at approx. 60 – 70 °C.	De-mould Time / Full Cure at 23°C/73°F		8 hrs
	Density A	DIN 53 479	1.40
	Density B	DIN 53 479	1.04
	Mix Ratio By Weight		100 : 2.5
	Pot Life mins at 23°C/73°F		100 mins
	Viscosity A	Brookfield HBTD	12500 cP
	Viscosity B	Brookfield HBTD	20 cP
	Viscosity Mixed	Brookfield HBTD	10000 cP
	Cured Product		
	Standard climate DIN 50 014 - 23/50-2. Vulcanizate tested after 7 days at room temperature		
	Color		Red
	Elongation at Break	DIN 53 504, S 3 A	80 %
	Hardness Shore A	DIN 53 505	60
	Linear Shrinkage (%)		0.5 %
	Tear Resistance (N/mm)	ASTM D 624, Die B	4.0 N/mm / 23 ppi
	Tensile Strength	DIN 53 504, S 3 A	4.0 N/mm² / 580 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 in tightly closed original containers at temperatures between 5 °C and 30 °C KÖRAFORM K 65 is optimally processible for at least nine months (stir well before use). Stored in tightly close original containers at temperatures between 5 °C and 30 °C KÖRAFORM B 132 is optimally processible for at least six months.			
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 unit			
KÖRAFORM K 65: 5 kg pail			
KÖRAFORM B 132: 0.5 kg PE bottle			
Revision Date	29 Apr 2021		
Revision No	1		
Download Date	16 May 2022		

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