

KÖRAFORM 97036 A 2 part casting compound

Description

Condensation crosslinking silicone casting compound for pad printing, shore A 12

Key Features

- 100:3 mix ratio
- Low viscosity
- Suited printing pad manufacture
- Shore A 12

Application

PAD printing

Use and Cure Information

Prior to processing thoroughly stir up KÖRAFORM 97036 A to distribute homogeneously possibly deposited fillers. To the KÖRAFORM 97036 A the component KÖRAFORM B 128 K is added at a mixing ratio of 100 : 3 according to weight and then mixed with a spatula or stirrer until the compound is homogeneous.

With this mixing the potlife of 60 min starts where KÖRAFORM 97036 A must be processed (casting or brushing). Demoulding can be effected after 24 hours. For an absolutely bubble-free vulcanizate the mixed silicone gel must be degassed using vacuum prior to the casting process (5 min at the most at 10 - 20 mbar). The viscosity can be increased up to strength by adding up to 1 weight per cent KÖRAFORM TM C to the catalyzed compound. When casting critical grounds, e.g. glass, check the release behaviour with your own trials. A silicone-free release agent may have to be applied.

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

KÖRAFORM 97036 A can be optimally processed for at least six months if being stored at 5 °C - 30 °C in tightly closed original containers.

KÖRAFORM B 128 K can be optimally processed for at least six months if being stored at 5 °C - 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.

Revision Date 29 Apr 2021
Revision No 1
Download Date 12 May 2021

Property

Uncured Product

Property	Test Method	Value
Colour A Part		white
Cure Type		Condensation
De-mould Time / Full Cure at 23°C/73°F		24 hrs
Density B	DIN 53 479	0.99 g/cm ³
Mix Ratio By Weight		100:3
Pot Life at 23°C/73°F		60 mins
Viscosity A-Part mPas	Brookfield HBTD	12000 mPas
Viscosity B-Part mPas	Brookfield HBTD	14 mPas

Cured Product

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

Property	Test Method	Value
Colour		White
Hardness Shore A	DIN 53 505	12
Linear Shrinkage (%)		0.5 %

Storage

Max Storage Temperature		30 °C / 86 °F
Min Storage Temperature		5 °C / 41 °F
Shelf Life (mths)		6

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The CHT technical service department is available to offer further information and advice and should it be needed to look at modifying current products or custom formulate a new one to meet your specific requirements. Please contact the technical service department.

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