

TECHNICAL DATA SHEET

KÖRAFORM 97069 A 2 part casting compound

Description

Condensation crosslinking silicone casting compound for pad printing, Shore A 18

Key Features

- 100:3 mix ratio
- Low viscosity
- Suited printing pad manufacture
- Shore A 18

Application

PAD printing

Use and Cure Information

Prior to processing KÖRAFORM 97069 must be stirred thoroughly to distribute possibly settled filling agents homogeneously. To KÖRAFORM 97069 KÖRAFORM B 128 is added at a mixing ratio of 100 : 3 according to their weight shares and mixed with a spatula or stirring unit until the mass is homogeneous. With this mixing process the potlife of 60 min starts by which time KÖRAFORM 97069 has to be processed (poured or applied by a brush). Demoulding can be done after 24 hours. For an absolutely bubble-free vulcanizate the mixed silicone gel must be degassed using vacuum prior to the casting process (maximal 5 min at 10 - 20 mbar). By addition of up to 1 weight per cent KÖRAFORM TM C into the catalysed mass the viscosity can be increased up to stability. In case of moulding of critical substrates, e.g. glass, the mould release behaviour has to be verified in your own tests, and if need be, a silicone-free mould release agent has 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

Stored at temperatures between 5 °C and 30 °C in tightly closed original containers KÖRAFORM 97069 A can be used for at least six months.

Stored at temperatures between 5 °C and 30 °C in tightly closed original containers KÖRAFORM B 128 K can be used 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 units

KÖRAFORM 97069 A:

Hobcock of 22 kg

Bucket of 20 kg

Bucket of 5 kg

KÖRAFORM B 128 K:

PE-bottle of 0.5 kg

Revision Date 29 Apr 2021

Revision No 1

Download Date 12 May 2021

Property

Uncured Product

Colour A Part		yellow
Cure Type		Condensation
De-mould Time / Full Cure at 23°C/73°F		24 hrs
Density B	DIN 53 479	0.99 g/cm³
Mix Ratio By Weight		100:3
Pot Life at 23°C/73°F		90 mins
Viscosity A-Part mPas	Brookfield HBTD	16000 mPas
Viscosity B-Part mPas	Brookfield HBTD	14 mPas
Viscosity Mixed mPas	Brookfield HBTD	12000 mPas

Cured Product

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

Colour		Yellow
Elongation at Break (%)	DIN 53 504, S 3 A	300 %
Hardness Shore A	DIN 53 505	18
Linear Shrinkage (%)		0.5 %
Tear Resistance (N/mm)	ASTM D 624, Die B	15 N/mm / 86 ppi
Tensile Strength (N/mm ²)	DIN 53 504, S 3 A	2.00 N/mm² / 290 psi

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.

CHT Germany GmbH: Postfach 12 80, 72002 Tübingen, Bismarckstraße 102, 72072 Tübingen, Germany
Telephone: 07071/154-0, Fax: 07071/154-290, Email: info@cht.com, Homepage: www.cht.com / www.cht-silicones.com