

KÖRAFORM A 28 2 part casting compound

Description

This is a pourable 2-part addition cure silicone elastomer system. After mixing parts 'A' and 'B' in the correct proportions, the system will cure at ambient temperatures within 24 hours, but the rate of cure can be accelerated by heat. The cured rubber exhibits excellent physical and electrical properties.

Key Features

- Applicable in the ceramics industry and for reproducing master forms (stereolithographic parts)
- Self-crosslinking at temperatures as of 23 °C/77°F
- Simple processing
- Very good mechanical properties, in particular the resistance to tear propagation

Application

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Use and Cure Information

IMPORTANT:

The 'A' part of product contains the platinum catalyst; great care should be taken when using automatic dispensing equipment. Please ensure that it is not contaminated by residual hydride containing rubber in the dispensing equipment, as curing will result. If in doubt, it's advised to thoroughly purge the equipment with a suitable hydrocarbon solvent or silicone fluid.

Mixing

Both the 'A' and 'B' parts should be well stirred to ensure the material is uniform and any settlement of the fillers have been remixed. Place the required amount of 'A' and 'B' parts by weight at the mix ratio shown opposite, in a clean plastic or metal container of approximately 3 times their volume, and mix until the colour of the mixture is uniform. For best results, we recommend degassing.

Degas by intermittent evacuation, the larger volume of the mixing vessel helps prevent overflow during this operation. In case of automatic dispensing with static mixing head, the two components should be degassed before processing. Recommended vacuum conditions are 30-50 mbar intermittently over 5-10 minutes. Cast the mixture either by gravity or pressure injection.

Inhibition of Cure

Great care must be taken when handling and mixing all addition cured silicone elastomer systems, ensuring that all the mixing tools (vessels and spatulas) are clean and constructed in materials which do not interfere with the curing mechanism. The cure of the rubber can be inhibited by the presence of compounds of nitrogen, sulphur, phosphorus and arsenic; organotin catalysts and PVC stabilizers; epoxy resin catalysts and even contact with materials containing certain of these substances e.g. moulding clays, sulphur vulcanised rubbers, condensation cure silicone rubbers, onion and garlic.

Curing Conditions

The data offers a guide to the rate of cure at various temperatures, mixing of the components at temperatures between 15 and 25°C is recommended to ensure adequate pot life for degassing and handling. The pot life can be extended to several hours by chilling the components before mixing.

Health & Safety

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Safety Data Sheets available on request.

Packaging

CHT Moulding Rubbers are available in a variety packaging including bulk containers. Please contact our sales department for more information.

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Property	Test Method	Value
Uncured Product		
Appearance		Translucent
Colour A Part		Translucent
Cure Type		Addition
De-mould Time / Full Cure at 23°C/73°F		16 or 8 hrs
Density A	BS ISO 2781	1.08
Density B	BS ISO 2781	0.97 g/cm3
Mix Ratio By Weight		10:1
Pot Life at 23°C/73°F		90 or 30 mins
Viscosity A-Part mPas	Brookfield	29000 mPas
Viscosity B-Part mPas	Brookfield	1000 mPas
Viscosity Mixed mPas	Brookfield	21000 mPas
Cured Product		
Colour		Transparent
Density	BS ISO 2781	1.08 g/cm3
Elongation at Break (%)	ISO 37	400 %
Hardness Shore A	DIN 53 505	28
Linear Shrinkage (%)		< 0.1 %
Tear Resistance (N/mm)	BS ISO 34-1	22 N/mm / 127 ppi
Tensile Strength (N/mm ²)	ISO 37	5.6 N/mm² / 812 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