TECHNICAL DATA SHEET

KÖRAFORM K 18
2 part casting compound

Description

Notch-resistant, condensation crosslinking silicone filling compound particularly for casting polyester resin

Key Features

- Good flowing behaviour
- Very good elastic properties
- Outstanding stability to polyester resins
- Suitable for block moulds and skin moulds with strong undercuts

Use and Cure Information

Stir up components A and B well before processing!

KÖRAFORM B 132 is added to KÖRAFORM K 18 at a mixing ratio of 3 : 100 according to weight and mixed with the spatula or stirring unit until the mass is homogeneous. With this mixing process, the potlife starts by which time KÖRAFORM K 18 has to be processed (casting or painting with the brush). Demoulding can be done after 18 hours. For an absolutely bubble-free vulcanisate the mixed silicone must be degassed using vacuum prior to the casting process (max. 5 minutes at 10 - 20 mbar). When moulding difficult substrates such as glass, the separation behaviour has to be verified in own tests and perhaps by adding a silicone-free separation agent.

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 K 18 can be optimally processed for at least nine months if stored between 5 °C and 30 °C in tightly closed original containers.
KÖRAFORM B 132 can be optimally processed for at least six months if stored between 5 °C and 30 °C in tightly closed original containers.

Property	Test Method	Value
Uncured Product		
Colour A Part		**White**
Colour B Part		**Colourless / yellowish**
Cure Type		**Condensation**
De-mould Time / Full Cure at 23°C/73°F		**18 hrs**
Density A	DIN 53 479	**1.09**
Density B	DIN 53 479	**1.04 g/cm3**
Mix Ratio By Weight		**100:3**
Pot Life at 23°C/73°F		**100 mins**
Viscosity A-Part mPas	Brookfield HBTD	**25000 mPas**
Viscosity B-Part mPas	Brookfield HBTD	**20 mPas**
Viscosity Mixed mPas	Brookfield HBTD	**24000 mPas**
Cured Product		
Standard climate DIN 50 014 - 23/50-2. Vulcanizate tested after 7 days at room temperature		
Colour		**White/yellowish**
Elongation at Break (%)	DIN 53 504, S 3 A	**350 %**
Hardness Shore A	DIN 53 505	**18**
Linear Shrinkage (%)		**0.5 %**
Tear Resistance (N/mm)	ASTM D 624, Die B	**17 N/mm / 98 ppi**
Tensile Strength (N/mm2)	DIN 53 504, S 3 A	**3.5 N/mm2 / 508 psi**
Storage		
Max Storage Temperature		**30 °C / 86 °F**
Min Storage Temperature		**5 °C / 41 °F**
Shelf Life (mths)		**9**

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 18: 22 kg hobbocks
KÖRAFORM B 132: 0.5 kg PET bottles

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