

KÖRAFORM K 27 2 part casting compound

Description

Liquid, condensation crosslinking silicone casting compound

Key Features

- Very good flow behaviour
- Stands out for the draughting accuracy of the moulds
- Suited for block moulds
- Suited for moulding shoe soles

Application

Block moulds

Use and Cure Information

Stir up KÖRAFORM K 27 thoroughly prior to processing it to homogeneously distribute possibly deposited fillers. To KÖRAFORM K 27 KÖRAFORM B 132 is added at a mixing ratio of 100 : 3 according to weight and mixed with the spatula or stirring unit until the compound is homogeneous. With this mixing the potlife starts by which time KÖRAFORM K 27 is to be processed (by casting or painting with the brush). Demoulding can be effected after 3 hours. For an absolutely bubble-free vulcanizate the mixed silicone gel must be degassed using vacuum prior to the casting process (5 min at 10 – 20 mbar at the most).

For adjusting the potlife and demoulding time to the processing terms further B components (hardeners) are available:

B component: KÖRAFORM B 128

Pot life: 50 minutes

Demouldable after 5 hours

If you mould critical substrates, e.g. glass, you ought to check the release behaviour by carrying out your own trials. You may have to use a silicone- free release 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 27 can be optimally processed for at least nine months if the product is stored at 5 °C to 30 °C in tightly closed original containers (stir up thoroughly prior to use).

KÖRAFORM B 128 and B 132 can be optimally processed for at least six months if the product is stored at 5 °C to 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.

Delivery Units

KÖRAFORM K 27: 22 kg hobbock

KÖRAFORM B 128: 0.5 kg PE bottle

KÖRAFORM B 132: 0.5 kg PE bottle

Revision Date 29 Apr 2021

Revision No 1

Property

Uncured Product

Colour B Part

Cure Type

De-mould Time / Full Cure at 23°C/73°F

Density A

Density B

Mix Ratio By Weight

Pot Life at 23°C/73°F

Viscosity A-Part mPas

Viscosity B-Part mPas

Viscosity Mixed mPas

Test Method Value

**Colourless / yellowish
Condensation**

3 hrs

DIN 53 479

1.24

DIN 53 479

1.04 g/cm³

100:3

30 mins

Brookfield
HBTD

14000 mPas

Brookfield
HBTD

20 mPas

Brookfield
HBTD

13000 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

260 %

Hardness Shore A

DIN 53 505

28

Linear Shrinkage (%)

0.5 %

Tear Resistance (N/mm)

ASTM D 624,
Die B

5.0 N/mm / 29 ppi

Tensile Strength (N/mm²)

DIN 53 504, S
3 A

3.0 N/mm² / 435 psi

Storage

Max Storage Temperature

30 °C / 86 °F

Min Storage Temperature

5 °C / 41 °F

Shelf Life (mths)

9

The content set out in the technical data sheet does not contain information upon which you should rely. It is provided for general information purposes only and does not constitute a product specification. You must obtain professional or specialist advice before taking any action based on the information provided in the technical data sheet.

CHT make reasonable efforts to ensure that information set out in the technical data sheet is complete, accurate, and up-to-date. CHT do not, however, make any representations, warranties or guarantees (whether express or implied) that information set out in the technical data sheet is complete, accurate, or up-to-date or that the product will be suitable for your requirements. You should carry out your own testing to determine the applicability of such information and whether the product will be suitable. CHT reserve the right to modify the technical data sheet at any time.

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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