

## KÖRAFORM K 31 2 part casting compound

### Description

Notch-resistant, condensation crosslinking silicone casting compound

### Key Features

- The mixture with CAT 9 is very well stable to polyester

### Application

Properties vary depending on Part B used

### Use and Cure Information

Stir up KÖRAFORM K 31 well before processing so that any deposited filling components are homogeneously distributed. KÖRAFORM B 128 is added to KÖRAFORM K 31 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 pot life of 60 minutes starts by which time KÖRAFORM K 31 has to be processed (casting or painting with the brush).  
Demoulding can be done after 20 hours. For an absolutely bubble-free vulcanisate, the mixed silicone has to be degassed using vacuum prior to the casting process (max. 5 min at 10 – 20 mbar). By adding up to 1 weight per cent of KÖRAFORM TM C to the catalysed mass, the viscosity can be increased up to stability. When moulding critical substrates such as glass, the release behaviour has to be verified by carrying out your own tests and perhaps by adding a silicone-free release agent.

### Property

#### Uncured Product

Property	Test Method	Value
Cure Type		Condensation
De-mould Time / Full Cure at 23°C/73°F		20 - 22 hrs
Density A	DIN 53 479	1.22
Mix Ratio By Weight		100:3 or 100:5
Pot Life mins at 23°C/73°F		60 or 25 mins
Viscosity A	Brookfield HBTD	25000 cP
Viscosity Mixed	Brookfield HBTD	24000 cP

#### Cured Product

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

Property	Test Method	Value
Color		White or blue
Hardness Shore A	DIN 53 505	21
Linear Shrinkage (%)		0.5 %

#### Storage

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

	KÖRAFORM K 31 Component A	KÖRAFORM B 128 Component B	CAT 9 Component B		
Colour	White	Colourless or blue	Colourless		
Viscosity	25,000	20	14	mPa·s	Brookfield HBTD <sup>1)</sup>
Density	1.22	1.04	0.99	g/cm³	DIN 53 479 <sup>1)</sup>
	Mixture				
Mixing ratio	100 : 3		100 : 5	according to weight	
Mixing viscosity	24,000		24,000		
Potlife	60		25	minutes	
Demouldable after	20		22	hours	
	Vulcanisate				
Hardness Shore A	21		21		DIN 53 505 <sup>2)</sup>
Tear strength	2.8		2.1	N/mm²	DIN 53 504 S 3 A <sup>2)</sup>
Elongation at break	380		290	%	DIN 53 504 S 3 A <sup>2)</sup>
Tear propagation resistance	22		16.2	N/mm	ASTM D 624 Form B <sup>2)</sup>
Linear shrinking	0.5		0.5	%	after 7 days

<sup>1</sup> = measured under standard climate DIN 50 014-23/50-2  
<sup>2</sup> = (vulcanisate, measured after 7 days at RT)

<sup>1)</sup> = measured under standard climate DIN 50 014-23/50-2

<sup>2)</sup> = (vulcanisate, measured after 7 days at RT)

The mixture with CAT 9 is very well stable to polyester.

### Solvents and Cleaning Agents

For removing fresh mass, KÖRASOLV GL has to be applied. Residues in the stirring or casting vessel are 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 K 31 can be optimally processed for at least six months.

Stored at temperatures between 5 °C and 30 °C in tightly closed original containers, KÖRAFORM B 128 can be optimally processed for at

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least six months.

Stored at temperatures between 5 °C and 30 °C in tightly closed original containers, CAT 9 can be optimally processed for at least six months.

## **Health & Safety**

### **Safety**

Please observe our EC 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 EC 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**

Upon demand

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