

TECHNICAL DATA SHEET

KÖRAFORM K 50 2 part casting compound

Description

Low viscosity, condensation crosslinking silicone casting compound

Key Features

- Low viscosity
- Hardness (Shore A 50)
- Convincing by reproduction and drawing exactness of the moulding
- Moulding of simple geometric parts

Use and Cure Information

Prior to processing stir well KÖRAFORM K 50 to distribute homogeneously the perhaps deposited fillers. To KÖRAFORM K 50 add KÖRAFORM B 132 at a mixing ratio of 100 : 3 according to weight and mix with a spatula or a mixer until the compound is homogeneous. With the mixing process the potlife during which KÖRAFORM K 50 is to be processed (casting or painting with a brush). The demoulding can be done after 12 hours.

For an absolutely bubble-free vulcanisate the mixed silicone has to be degassed using vacuum (max. 5 minutes at 10 - 20 mbar).

In case of moulding on difficult supports, e.g. glass the demoulding behaviour has to be checked in tests by yourself. A silicone free demoulding agent has to be applied in case of need.

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 K 50 can be processed for at least nine months (stir well before use). KÖRAFORM B 132 is processible for at least six months if stored at temperature between 5 °C and 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 50:

22 kg hobbock
10 kg pail

KÖRAFORM B 132:

0.5 kg PE bottle

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Revision No 1
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Property

Uncured Product

Colour A Part

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

**White
Colourless /
yellowish
Condensation**

12 hrs

DIN 53 479

1.20

DIN 53 479

1.04 g/cm³

100:3

100 mins

Brookfield
HBTD

8000 mPas

Brookfield
HBTD

20 mPas

Brookfield
HBTD

6000 mPas

Cured Product

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

Elongation at Break (%)

DIN 53 504, S
3 A

120 %

Hardness Shore A

DIN 53 505

50

Linear Shrinkage (%)

0.5 %

Tear Resistance (N/mm)

ASTM D 624,
Die B

3.0 N/mm / 17 ppi

Tensile Strength (N/mm²)

DIN 53 504, S
3 A

**2.3 N/mm² / 334
psi**

Storage

Max Storage
Temperature

30 °C / 86 °F

Min Storage Temperature

5 °C / 41 °F

Shelf Life (mths)

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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.

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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