

## KÖRAFORM K 65 2 part casting compound

### Description

Low viscosity, temperature stable, condensation crosslinking silicone casting compound

### Key Features

- Low viscosity
- High hardness (Shore A)
- Convincing by reproduction and detail exactness of the moulding
- Moulding of simple geometric parts

### Use and Cure Information

Prior to processing KÖRAFORM K 65 has to be stirred well so that perhaps deposited filling agents are homogeneously distributed. Add to KÖRAFORM K 65 KÖRAFORM B 132 in a mixing ratio of 100 : 2.5 according to weight and mix with a spatula or the mixer until the compound is homogeneous. With mixing the potlife starts in which KÖRAFORM K 65 is to be processed (casting or painting with a brush). The demoulding can start after 8 hours. For an absolutely bubble-free vulcanisate the mixed silicone must be degassed using vacuum prior to the casting process (maximal 5 minutes under 10 - 20 mbar). In case of moulding on difficult mouldings, 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. During curing alcohol is separated which has to escape completely out of the vulcanisate before the mould can be heated by temperatures > 70 °C. For accelerating the mould can be tempered at max. 70 °C in the air recirculating heating chamber. The mould has to be tempered per 1 cm thickness by storing in a ventilated heating chamber at approx. 60 - 70 °C.

### 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 in tightly closed original containers at temperatures between 5 °C and 30 °C KÖRAFORM K 65 is optimally processible for at least nine months (stir well before use). Stored in tightly close original containers at temperatures between 5 °C and 30 °C KÖRAFORM B 132 is optimally processible for at least six months.

### 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 unit

KÖRAFORM K 65: 5 kg pail  
KÖRAFORM B 132: 0.5 kg PE bottle

Revision Date 29 Apr 2021  
Revision No 1  
Download Date 12 May 2021

### 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

**Red**

**Colourless to yellowish  
Condensation**

**8 hrs**

DIN 53 479

**1.40**

DIN 53 479

**1.04 g/cm<sup>3</sup>**

**100 : 2.5**

**100 mins**

Brookfield  
HBTD

**12500 mPas**

Brookfield  
HBTD

**20 mPas**

Brookfield  
HBTD

**10000 mPas**

#### Cured Product

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

Colour

**Red**

Elongation at Break (%)

DIN 53 504, S  
3 A

**80 %**

Hardness Shore A

DIN 53 505

**60**

Linear Shrinkage (%)

**0.5 %**

Tear Resistance (N/mm)

ASTM D 624,  
Die B

**4.0 N/mm / 23 ppi**

Tensile Strength (N/mm<sup>2</sup>)

DIN 53 504, S  
3 A

**4.0 N/mm<sup>2</sup> / 580 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.

**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