

Köraform A 18



Addition-curing, silicone mouldmaking compound with low hardness Shore A and high tensile strength

- Very low viscosity for easy pouring
- Curing nearly without shrinkage
- Curing may be accelerated by heat
- High mechanical strength
- Certified for skin contact

Köraform A 18 is predestined for modeling with strong undercuts and negative forms for wax melting procedures and customary casting resins.

TECHNICAL DATA

	A-component Köraform A 18	B-component Köraform A 18	
Colour	translucent	translucent	
Density	1,08	1,08	g/cm ³ DIN 53 479 ¹⁾
	Mixture		
Mixing ratio	1 : 1		by weight ¹⁾
Viscosity	9000		mPas ¹⁾
Pot life	4-6		min ¹⁾
Earliest demould after	20		min ¹⁾
	Vulcanized material		
Hardness Shore A	18-20		DIN 53 505 ²⁾
Tensile Strength	3,5		N / mm ² DIN 53 504 S3A ²⁾
Elongation at Break	400		% DIN 53 504 S3A ²⁾
Tear Resistance	15		N / mm ASTM D 624 Form B ²⁾

Platin catalyst is in Comp. A

¹⁾ = Measured at standard climate according to DIN 50 014-23/50-2.

²⁾ = Vulcanized material, measured after 14 days of storage at standard climate, DIN 50 014-23/50-2

PROCESSING

Preparation

Köraform A 18 and one of the B-components should be well stirred up prior processing in order to homogenize possibly settled fillers. The components A and B are mixed at a ratio of 1 : 1 by weight. Stir thoroughly using a spatula or an agitator until the material has become homogeneous. The pot-life within Köraform A 18 has to be processed (casted or applied with a brush) starts with the mixing procedure. Demoulding can be carried out after 20 min. at the earliest.

Prior to casting, the mixing silicone has to be degased under vacuum pressure in order to achieve a completely bubble-free vulcanized material.

The viscosity can be increased until a pasty consistency by adding up to 0,2 weight-% of Köraform TM.

Curing problems (inhibiting)

Certain substances can inhibit or even prevent curing of addition cross-linking silicones. Typical symptoms are tacky surfaces of the silicones towards the contact surfaces.

The following substances have to be particularly inspected with utmost care:

- nitrogen-containing substances (amines, polyurethanes, epoxy resins, ...)
- sulphurous substances (polysulfides, polysulfones, natural and synthetic rubber (EPDM))
- Organometallic compounds (organotin compounds, vulcanized material and hardeners of condensation cross-linking silicones)

In case of casting to unknown substrates, a compatibility test has to be carried out.

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CLEANING

Use Körasolv GL in order to remove fresh material. It is advisable to let residues completely cure in the mixing or casting container and peel them off later.

SPECIAL NOTES

Storage

A-component Köraform A 18 and the B-components will retain their optimum processing characteristics for at least 12 months if stored at 5 – 30°C in tightly closed original container.

SAFETY

Please notice the indications on our EC-safety-data-sheets and the safety-indications on the labels of each product for the treatment of our products.

Especially the directions of the Dangerous Substance Regulation have to be respected.

Keep the EC-safety-data-sheet of the product you treat ready to hand. It gives you valuable indications for the safe usage, disposal and in case of accidents.

PACKAGING UNITS

A-Comp.: 5 kg, 25 kg or 200 kg

B-Comp.: 5 kg, 25 kg or 200 kg

For safety related data please refer to the safety data sheet !

Please note: All given data are based on careful examination in our laboratories and our past practical experience. These are non-binding indications. Given the high number of materials appearing on the market and the different methods of use which are beyond our influences and control, we naturally cannot accept any responsibility for the results of your work, also with regard to third party patent rights. We recommend that sufficiently thorough tests be carried out to ascertain whether the product described will meet the requirements of your particular case.

Please also note our Terms of Sale, Delivery and Payment. This Product information replaces all previous issues.