

New Köraform A 28



Addition-curing two component silicone moulding compound with medium hardness Shore A

- Low viscosity for easy pouring
- High mechanical strength
- Excellent impact resistance
- Curing nearly without shrinkage
- Curing may be accelerated by heat
- Good Polyester and resin resistance

- Production of flexible moulds to be kept for long periods or where particularly accurate reproduction is required (ceramics, figurines, modelmakers, etc.)

TECHNICAL DATA

	Köraform A 28 A	Köraform A 28 B	Dimension	Conditions
Colour	transparent	transparent		
Viscosity	29.000	1000	mPas	Brookfield HBTD ¹
Density	1,1	1,0	g/cm ³	DIN 53 479 ¹
	Mixture			
Mixing ratio	10 : 1		by weight	
Viscosity	21.000		mPas	¹
Pot life	90		min	¹
Earliest demould after	16		h	¹
	Vulcanized material			
Hardness Shore A	28			DIN 53 505 ²
Tensile Strength	5,6		N / mm ²	DIN 53 504 S3A ²
Elongation at Break	500		%	DIN 53 504 S3A ²
Tear Resistance	22		N / mm	ASTM D 624 Form B ²
Linear Shrinkage	0,1		%	After 7 days ¹

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
The platincatalysator is in component B

KÖRAFORM A 28

PROCESSING

Preparation

Köraform A 28 A- and B-component should be well stirred up prior processing! The components A and B should be mixed at a ratio of 10 : 1 by weight. Stirr thoroughly using a spatula or an agitator until the material has become homogeneous. The 90 minutes pot-life within Köraform A 28 has to be processed (casted or applied with a brush) starts with the mixing procedure. Demoulding can be carried out after 16 hours at the earliest.

Prior to casting, the mixing silicone has to be degassed under vacuum pressure in order to achieve a completely bubble-free vulcanized material (ca. 5 – 10 min. at 10-20 mbar). The curing time can be accelerated with the help of heat.

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.

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

Köraform A 28 A- and B-components will retain their optimum processing characteristics for at least 6 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

Köraform A 28 A: 22 kg container
Köraform A 28 B: 2,2 kg container

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.