PRODUCT INFORMATION

Köraform A 30151

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

- **Very low viscosity for easy pouring**
- **Two B-components with different pot-life and curing times**
- **Curing nearly without shrinkage**
- **Curing may be accelerated by heat**
- **High mechanical strength**

Köraform A 30151 is predestined for modeling with strong undercuts and negative forms for wax melting procedures and customary casting resins.

TECHNICAL DATA

	A-component Köraform A 30151	B-component Köraform 34125	B-component Köraform 34144		
Colour	white	grey	blue		
Density	1,12	1,12	1,12	g/cm³	DIN 53 479 [1)]
	Mixture				
Mixing ratio		1 : 1	1 : 1	by weight	[1)]
Viscosity		7000	7000	mPas	[1)]
Pot life		4,5	50-60	min	[1)]
Earliest demould after		25	300-360	min	[1)]
	Vulcanized material				
Hardness Shore A		22			DIN 53 505 [2)]
Tensile Strength		3,5		N / mm²	DIN 53 504 S3A [2)]
Elongation at Break		400		%	DIN 53 504 S3A [2)]
Tear Resistance		20		N / mm	ASTM D 624 Form B [2)]

[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 30151 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. Stirr thorouhly using a spatula or an agitator until the material has become homogeneous. The pot-life within Köraform A 30151 has to be processed (casted or applied with a brush) starts with the mixing procedure. Demoulding can be carried out after 25 min (Köraform 34125) or 5-6 h (Köraform 34144) 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 symtoms 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 (organtin 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.

KÖRAFORM A 30151

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 30151 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

Köraform A 30151: 5 kg container
Köraform B 34125: 5 kg container
Köraform B 34144: 5 kg container

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

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