

## PRODUCT INFORMATION

# Köraform A 40 *dry*



two component, silicone elastomer that vulcanises at room temperature and for which curing can be accelerated by heating.

- Extra hard version with high torsion stability.
- Outstanding transparency.
- Exceptional mechanical properties.
- Accurate reproduction of details.
- Fast mixing and easy processing due to the low viscosity

Köraform A 40 is a fluid moulding silicone designed for casting polyurethane, epoxy and polyester resins as well as wax and polyurethane foams.

## TECHNICAL DATA

	Köraform A 40 Component A	Köraform A 40 Component B	
<b>Appearance</b>	viscous liquid	viscous liquid	
<b>Colour</b>	Transparent	Transparent	
<b>Viscosity appx at 23°C</b>	40.000	40.000	mPas <sup>1)</sup>
<b>Density appx. at 23°C</b>	1,08	1,08	DIN 53 479 <sup>1)</sup>
<b>Mixing ratio</b>	<b>Mixture</b> 100:100		by weight
<b>Viscosity</b>	approx. 40.000		mPas <sup>1)</sup>
<b>Pot Life</b>	90		Minutes <sup>1)</sup>
<b>Earliest Demould after</b>	< 8-9		Hours <sup>1)</sup>
<b>Hardness Shore A</b>	<b>Vulcanized material after curing for 24h</b> approx. 40		DIN 53 505
<b>Tensile Strength</b>	> 6,0		N/mm <sup>2</sup> DIN 53 504 S 3 A
<b>Tear Strength</b>	> 25,0		ASTM D 624 Form B
<b>Elongation at Break</b>	approx. 350		N/mm DIN 53 504 S 3 A
<b>Linear shrinkage</b>	< 0,1%		%
1) = Measured at Standard Climate according to DIN 50 014-23/50-2			
<b>Platinum catalyst is in Component A</b>			

# KÖRAFORM A 40 DRY

## PROCESSING

### 1. Mixing the two components

Köraform A 40 component A + B are mixed by weight in a fixed ratio given above.

The two components may be thoroughly mixed either by hand or using a low-speed electric or pneumatic mixer to minimise the introduction of air and to avoid any temperature increase.

It is also possible to use a special mixing and dispensing machine for the two silicone components.

Further information is available upon request.

### 2. Moulding

The mixture should be degassed preferably at 30 to 50 mbar to eliminate any entrapped air. If a dispensing machine is used, the two components are degassed separately prior to mixing.

The silicone mixture expands to 3 to 4 times of its initial volume and bubbles rise to the surface. The bubbles progressively disappear and the mixture returns to its initial volume after 5 to 10 minutes. Wait a few minutes to complete the degassing and then flash the vacuum. The silicone is ready for pouring, either by gravity or under low pressure.

Flashing the vacuum once or twice accelerates the degassing. It is recommended to use a container with a high diameter / height ratio (3 to 4 times of the initial volume)

### 3. Polymerisation

The RTV-system, as indicated in the technical data, polymerises at 23 ° C. The curing may be slowed down at lower temperature and contrary accelerated by applying heat.

In general contact with certain materials can inhibit the crosslinking of RTV. See list below:

- natural rubbers vulcanised with sulphur
- RTV elastomers catalysed with metal salts, e.g. tin-compounds
- PVC stabilised with tin salts and additives
- epoxy catalysed with amines
- certain organic solvents, e.g. ketones, alcohols, ether etc.

In case of doubts, it is recommended to test the substrate by applying a small quantity of the mixed silicone on a restricted area.

## SPECIAL NOTES

### Storage

The Köraform A 40 must be used within 12 months with respect to the manufacturing date.

Beyond this date, ALPINA Technische Produkte GmbH no longer guarantees the conformity of the product with the sales specifications.

In order to preserve best properties it is recommended to follow strictly the following guidelines:

- store the original packaging tightly sealed and at a temperature below 30 ° C
- use the product as soon as the packaging has been opened

## SAFETY

The usual safety precautions have to be taken into consideration in case of contacts with Köraform A 40.

Detailed information is given in the Material Safety Data Sheet.

### Warning to users:

The information contained in this document is given in good faith based on our current knowledge. It is only an indication and is in no way binding, particularly as regards infringement of or prejudice to third party rights through the use of our products.

ALPINA Technische Produkte GmbH guarantees that its products comply with its sales specifications.

This information must on no account be used as a substitute for necessary prior tests which alone can ensure that a product is suitable for a given use. Users are responsible for ensuring compliance with local legislation and for obtaining the necessary certifications and authorisations.

Users are requested to check that they are in possession of the latest version of this document and ALPINA Technische Produkte GmbH is at their disposal to supply any additional information.

## PACKAGING UNITS

- 2 x 1 Kg can
- 2 x 5 Kg drum
- 2 x 25 Kg Canister
- 2 x 25 Kg Cansister with oil formula

If needed special containers are available on request.

## **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.