PRODUCT INFORMATION

Köraform K 12

Condensation-curing two-component silicone mould-making and pad printing compound

- **Convincing reproductive precision and drawing sharpness of castings**
- **Very good elastic properties**
- **Excellent recovery**
- **Good flow characteristics**

TECHNICAL DATA

	Köraform K 12 Component A	**Köraform B 132** Component B		
Colour	white	yellowish		
Viscosity	9500	20	mPas	Brookfield HBTB[1]
Density	1,08	1,04	g/cm³	DIN 53479[1]
	Mixture			
Mixing ratio	100 : 3		by weight	
Viscosity	9500		mPas	Brookfield HBTB[1]
Pot life	140		min	[1]
Earliest de-moulding after	20		hours	[1]
	Vulcanized material			
Hardness Shore A	12			DIN 53 505 [2]
Tensile strength	2,4		N/mm²	DIN 53 504 S 3 A[2]
Elongation at break	380		%	DIN 53 504 S 3 A [2]
Tear resistance	10		N/mm	ASTM D 624 Form B [2]
Linear shrinkage	0,5		%	after 7 days [1]

[1] = measured in standard climate according to DIN 50 014 – 23/50-2
[2] = vulcanized material, measured after 14 days of storage in standard climate, DIN 50 014 – 23/50-2

PROCESSING

Preparation

Köraform K 12 should be well stirred up prior to processing in order to homogenize possibly settled fillers. Köraform B 132 is added to Köraform K 12 in the mixing ratio (K12 : B132) of 100 : 3 by weight and mixed by means of a spatula or a stirring device until the mixture is completely homogeneous. The pot life of 140 minutes in which Köraform K 12 is to be processed starts immediately with the mixing (casting resp. applying by brush). The removal from the mould can be done 20 hours later.

In order to obtain an absolutely bubble-free vulcanized material, the mixed silicone has to be degassed in the vacuum prior to casting (maximum 5 minutes at 10 – 20 mbar).

Köraform K 12 can be made thixotropic by the addition of 1 % Köraform TM to the final mix.

When casting critical substrates e. g. glass, the parting behaviour should always be checked by own tests. If necessary, a silicone-free mould release agent has to be employed.

KÖRAFORM K 12

CLEANING

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

SPECIAL NOTES

Storage

Köraform K 12 will retain its optimum processing characteristics for at least 9 months providing it is stored at 5°C to 30°C in the tightly closed original container.

Köraform B 132 will retain its optimum processing characteristics for at least 6 months providing it is stored at 5°C to 30°C in the 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 K 12: 22 kg containers and 220 kg drums
Köraform B 132: PE bottle 0,5 kg

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

ALPINA Technische Produkte GmbH

Distributor for The Benelux:
SCABRO Ideeën Krijgen Vorm

Scabro
Vliegveld Valkenburg
Wassenaarseweg 75-3265
NL - 2223 LA Katwijk

Tel: +31 (0) 71 4017246
Fax: +31 (0) 84 7402572
Email: info@scabro.com
Internet: www.scabro.com