

Köraform K 31 „new“



High tear strength, condensation-curing two-component silicone mould-making compound

- Compound in the manufacture of block and skin moulds with strong undercut
- Convincing reproductive precision and drawing sharpness of castings
- Very good elastic properties
- Excellent recovery
- Good flow characteristics

TECHNICAL DATA

	Köraform K 31 Component A	Köraform B 128 Component B		
Colour	white	colorless and blue		
Viscosity	25 000	14	mPas	Brookfield HBTB ¹
Density	1,22	0,99	g/cm ³	DIN 53479 ¹
	Mixture			
Mixing ratio	100 : 2		by weight	
Viscosity	24.000		mPas	Brookfield HBTB ¹
Pot life	60		min	¹
Earliest de-moulding after	20		hours	¹
	Vulcanized material			
Hardness Shore A	23			DIN 53 505 ²
Tensile strength	2,8		N/mm ²	DIN 53 504 S 3 A ²
Elongation at break	380		%	DIN 53 504 S 3 A ²
Tear resistance	22		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 31 “new” should be well stirred up prior to processing in order to homogenize possibly settled fillers. Köraform B 128 is added to Köraform K 31 “new” in the mixing ratio (K31 : B 128) of 100 : 2 by weight and mixed by means of a spatula or a stirring device until the mixture is completely homogeneous. The pot life of 60 minutes in which Köraform K 31 “new” 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 31 “new” can be made thixotropic by the addition of 1 % Köraform TM C 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.

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 31 "new" 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 128 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 31 "new": 5 kg, 22 kg containers and 220 kg drums
Köraform B 128: PE-bottle 0,5 kg and 20 kg canister

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.