

# Köraform K 40 + B 132



## Condensation – curing silicone mouldmaking compound

- Very good flowing characteristics
- Medium hardness Shore A
- Excellent recovery
- Pouring of simple block moulds
- Moulding of shoe soles

### TECHNICAL DATA

	Köraform K 40 Component A	Köraform B 132 Component B		
Colour	white	yellowish		
Viscosity	6000	20	mPas	<sup>1)</sup>
Density	1,16	1,04	g/cm <sup>3</sup>	DIN 53 479 <sup>1)</sup>
<b>Mixture</b>				
Mixing ratio	100 : 2		by weight	
Viscosity	5000		mPas	<sup>1)</sup>
Pot life	100		min	<sup>1)</sup>
Earliest demould after	12		h	<sup>1)</sup>
<b>Vulcanized material</b>				
Hardness Shore A	40			DIN 53 505 <sup>1)</sup>
Tensile Strength	2,4		N/mm <sup>2</sup>	DIN 53 504 S 3 A <sup>2)</sup>
Elongation at break	140		%	DIN 53 504 S 3 A <sup>2)</sup>
Tear Resistance	3		N/mm	ASTM D 624 Form B <sup>2)</sup>
Linear Shrinkage	0,5		%	after 7 days <sup>1)</sup>

<sup>1)</sup> = Measured at Standard Climate according to DIN 50 014-23/50-2

<sup>2)</sup> = Vulcanized Material, measured after 14 days of storage at Standard Climate, Din 50 014 – 23/50-2

### PROCESSING

#### Preparation

Köraform K 40 should be well stirred up prior processing in order to homogenize possibly settle fillers. Köraform B 132 is added to Köraform K 40 in the mixing ratio (K 40 : B 132) of 100 : 2 by weight and mixed by means of a spatula or a stirring device until the material is completely homogeneous. The 100 minutes pot-life during which Köraform K 40 must be processed (casted or applied with a brush) starts with the mixing procedure. Removal from the mould can be carried out after 8 hours at the earliest.

Prior to casting, the mixed silicone has to be degased under vacuum pressure in order to achieve a completely bubble-free vulcanized material (maximum 5 minutes at 10 to 20 mbar).

To adapt pot-life and demoulding to the processing conditions, an additional B-component (curing agent) can be selected:

B-component	Pot-life	demoulding after
B 128	50 min	18 h

On mouldings from critical bases, for example glass, the release reaction has to be checked with tests. If necessary, a silicone-free release agent has to be used.

**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 to peel them off then.

**SPECIAL NOTES****Storage**

Köraform K 40 will retain its optimum processing characteristics for at least 9 months when stored at 5 – 30°C in the tightly closed original container.

Köraform B 128 and B 132 will retain its optimum processing characteristics for at least 6 months when stored at 5 – 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 40 – 22 kg containers  
Köraform B 128 – 0,5 kg containers  
Köraform B 132 – 0,5 kg containers

**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.



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