

Köraform K 65 red



High thermo resistant condensation – curing two component silicone mouldmaking compound

- Very good flowing characteristics
- High hardness Shore A
- Excellent recovery
- Pouring of simple block moulds
- Moulds for low melting-point alloys

TECHNICAL DATA

	Köraform K 65 red Component A	Köraform B 132 Component B		
Colour	red	yellowish		
Viscosity	12500	20	mPas	¹⁾ DIN 53 479 ¹⁾
Density	1.40	1.04	g/cm ³	
Mixture				
Mixing ratio	100 : 2.5			by weight
Viscosity	10 000			mPas ¹⁾
Pot life	80			min ¹⁾
Earliest demould after	8			h ¹⁾
Vulcanized material				
Hardness Shore A	60			DIN 53 505 ¹⁾
Tensile Strength	4			N/mm ² DIN 53 504 S 3 A ²⁾
Elongation at break	80			% DIN 53 504 S 3 A ²⁾
Tear Resistance	4			N/mm ASTM D 624 Form B ²⁾
Linear Shrinkage	0,5			% after 7 days ¹⁾

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

K 65 RED

PROCESSING

Preparation

Köraform K 65 red should be well stirred up prior processing in order to homogenize possibly settled fillers. Köraform B 132 is added to Köraform K 65 red in the mixing ratio (K 65 rot : B 132) of 100 : 2.5 by weight and mixed by means of a spatula or a stirring device until the material is completely homogeneous. The 80 minutes pot-life during which Köraform K 65 rot 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 degassed under vacuum pressure in order to achieve a completely bubble-free vulcanized material (maximum 5 minutes at 10 to 20 mbar). To adapt potlife and demoulding to the processing conditions, an additional B-component (curing agent) can be selected:

B-component	Pot-life	demoulding after
B 131	2 %	20 min

3 h

On mouldings from critical bases, for example glass, the release ability has to be checked with tests. If necessary, a silicone-free release agent has to be used. The vulcanizate has to be completely free of volatile alcohol before it's heated up to temperatures above 70°C. To accelerate the removing of the alcohol it is possible to store the vulcanizate at max. 70°C. For each 1 cm thickness of the vulcanizate you need approximately 1 hour storage in a ventilated heat oven at approx. 60 – 70°C.

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 65 red 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 131 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 65 red: Hobbock of 5 kg

Köraform B 132/B131: PE-bottle of 0,5 kg

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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