

# Köraform A 60



## Addition-curing silicone mouldmaking compound with high hardness Shore A

- Low viscosity for easy pouring
- Good mechanical strength
- Curing practically without shrinkage at room temperature
- Curing may be heat accelerated
- Reproduction of master patterns (stereo lithography parts)
- Pouring of industrial parts such as damping elements, rubber elements, etc.
- Excellent cast resin stability

### TECHNICAL DATA

	Köraform A 60 A Component A	Köraform A 60 B Component B	
<b>Colour</b>	beige	transparent	
<b>Viscosity</b>	109.000	650	mPas <sup>1)</sup>
<b>Density</b>	1,35	0,97	DIN 53 479 <sup>1)</sup>
	<b>Mixture</b>		
<b>Viscosity</b>	50.000		mPas
<b>Mixing ratio</b>	10 : 1		by weight
<b>Pot Life</b>	30		min <sup>1)</sup>
<b>Earliest Demould after</b>	approx. 12		h <sup>1)</sup>
	<b>Vulcanized material</b>		
<b>Hardness Shore A</b>	60		DIN 53 505 <sup>1)</sup>
<b>Tensile Strength</b>	4,5	N/mm <sup>2</sup>	DIN 53 504 S 3 A <sup>2)</sup>
<b>Elongation at Break</b>	140	%	DIN 53 504 S 3 A <sup>2)</sup>
<b>Tear Resistance</b>	5,0	N/mm	ASTM D 624 Form B <sup>2)</sup>
<b>Linear Shrinkage</b>	0,1	%	after 7 days <sup>1)</sup>
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			

### PROCESSING

#### Preparation

Köraform A 60 A- and B-component should be well stirred up prior processing in order to homogenize possibly settled fillers. The components A and B are mixed at a ratio of 10 : 1 by weight. Stir thoroughly using a spatula or an agitator until the material has become homogeneous. The 60 minutes pot-life during which Köraform A 60 must be processed (casted or applied with a brush) starts with the mixing procedure. Demoulding can be carried out after 12 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 (approx. 5 to 10 minutes at 10 to 20 mbar).

## KÖRAFORM A 60

### Curing Problems (Inhibiting)

Certain substances can inhibit or even prevent curing of addition cross-linking silicones. Typical symptoms are tacky surfaces of the silicones towards the contact surfaces.

The following substances have to be particularly inspected with utmost care:

- nitrogen-containing substances (amines, polyurethanes, epoxy resins...)
- sulphurous substances (polysulfides, polysulfones, natural and synthetic rubber (EPDM))
- organometallic compounds (organotin compounds, vulcanized material and hardeners of condensation cross-linking silicones)

When casting to unknown substrates, a compatibility test must always be carried out.

### CLEANING

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

### SPECIAL NOTES

#### Storage

Köraform A 60 A and B components will retain their optimum processing characteristics for at least 6 months when 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

### **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.