

# Köraform K 18



**High tear strength, condensation – curing two component silicone mouldmaking compound especially for the pouring of polyester resins**

- Very good flowing characteristics
- Low hardness Shore A
- Excellent elastic properties
- High resistance against polyester resins
- Mouldmaking compound in the manufacture of block and skin moulds with strong undercuts
- Manufacture of printing pads

## TECHNICAL DATA

	Köraform K 18 Component A	Köraform B 161 Component B	
<b>Colour</b>	white	colorless	
<b>Viscosity</b>	19000	14	mPas 1)
<b>Density</b>	1,09	0,98	g/cm <sup>3</sup>
<b>Mixing ratio</b>	<b>Mixture</b> 100 : 2		by weight
<b>Viscosity</b>	20 000		mPas <sup>1)</sup>
<b>Pot life</b>	100		min <sup>1)</sup>
<b>Earliest demould after</b>	18		h <sup>1)</sup>
	<b>Vulcanized material</b>		
<b>Hardness Shore A</b>	18		DIN 53 505 <sup>1)</sup>
<b>Tensile strength</b>	3,5		N/mm <sup>2</sup> DIN 53 504 S 3 A <sup>2)</sup>
<b>Elongation at break</b>	350		% DIN 53 504 S 3 A <sup>2)</sup>
<b>Tear resistance</b>	17		N/mm ASTM D 624 Form B <sup>2)</sup>
<b>Linear shrinkage</b>	0,5		% after 7 days
<sup>1)</sup> = Measured at Standard Climat 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 18 should be well stirred up prior processing in order to homogenize possibly settle fillers. Köraform B 161 is added to Köraform K 18 in the mixing ratio (K 18 : B 161) of 100 : 2 by weight and mixed by means of a spatula or a stirring device until the material is completely homogeneous. Th 60 minutes pot-life during which Köraform K 18 must be processed (casted or applied with a brush) starts with the mixing procedure. Demoulding can be carried out after 18 hours at the earliest.

Prior to casting, the mixed silicone has to be degassed under vacuum pressure in order to chieve a completely bubble-free vulcanized material (maximum 5 minutes at 10 to 20 mbar). Köraform K 18 can be made thixotropic by the addition of 1 % Köraform TM to the final mixture.

**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 K 18 will retain its optimum processing characteristics for at least 9 months when stored at 5°C to 30°C in the tightly closed original container.

Köraform B 161 will retain its 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**

Köraform K 18: 22 kg containers  
Köraform B 161: 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.