

RECKLI[®] Si-Mould Paste HR-N

Silicone moulding material for the application on vertical or overhead areas

RECKLI Si-
Mould Paste HR-N
Product 03272
Edition 01/23

PROPERTIES

RECKLI Si-Mould Paste HR-N is a two-component silicone rubber with high tear resistance and elongation at break, cold curing by polycondensation and self-releasing. For the application on vertical or overhead areas the material is adjusted pasty with RECKLI Si-Thickener Liquid K (0,5 – 1,5 %).

APPLICATIONS

RECKLI Si-Mould Paste HR-N is used for making thin-walled elastic moulds for the manufacture of casts or copies out of gypsum, mortar, concrete, resins or resin formulations. It is tailored for a multilayer application on vertical or overhead areas.

Attention!

Moulds out of RECKLI two-component silicones are not fully suitable for casting polyester- or PMMA-resins. These applications strictly demand a preliminary test.

TECHNICAL DATA

property	value	method
hardener:	Si-Hardener Type N	
colour of base component:	white	
colour of hardener	colourless, clear	
odour	weak	
workable temperature:	+10 °C – +30 °C	
mixing ratio (base : hardener):	10 : 1	(according to weight)
dosage of REKLI Thickener Liquid K:	0,5 – 1,5 %	(according to weight)
pot life (at +21 °C):	15 – 25 min	
earliest demoulding (at +21 °C):	12 h	
specific weight:	1,10 g/cm ³	
hardness:	15 Shore A	DIN 53505
tensile strength:	2,5 N/mm ²	DIN 53504-S2
elongation at break:	420 %	DIN 53504-S2
tear resistance:	15 N/mm	ASTM D 624-B
heat resistance (dry heat):	approx. +160 °C	
linear shrinkage:	0,5 – 0,8 %	

These data are typical guide values. They are not destined for the generation of specifications.

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SURFACE PREPARATION

The model surface must be clean. Absorbing surfaces should preferably be sealed to avoid contamination by silicone oil and to ensure the easiness of the subsequent demoulding. For this, RECKLI PUR-Sealant can be used if the surface is solvent-resistant. Otherwise, especially if the surface has to be recovered in the original state, RECKLI Si-Stripping Lacquer can be applied and removed with water along with all residues after completing the moulding works. Before continuing, the sealant has to dry completely. Further measures are usually unnecessary due to the self-releasing effect. However, certain critical substrates, in particular glass, freshly milled metal or wood as well as silicone itself, must be covered with RECKLI Mould Wax.

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PROCESSING

Before processing, the base component has to be stirred up thoroughly. Add the hardener (B) to the base component (A) and mix them homogenously. Transfer the mixture into a second receptacle and stir it up again. Thereby the incorporation of larger amounts of air should be avoided.

After mixing the base component and the hardener, RECKLI Thickener Liquid K is added to adjust the required thixotropic consistency. The recommended dosage is 0,5 – 1,5 % (by weight). The maximum dosage is related to a layer thickness of 5 mm per application. Moulds with a higher wall thickness are preferably processed in several layers. Before any following layer can be applied, the preceding one must be sufficiently cured. For this the duration is influenced by several factors and cannot be given in general. Usually it takes about two hours. When completely cured, even after several days, proceeding is possible without later detachment of the silicone layers.

To facilitate the control of complete and adequate coverage, especially at edges and corners, add RECKLI Si-Colour Paste to every second layer.

Once mixed, the processing of the material must be completed within the pot life (15 – 25 minutes). The thickener accelerates the curing process. The shortest demoulding time is 24 hours.

METHOD OF PROCESSING

Painting or trowelling.

CLEANING OF EQUIPMENT

For the cleaning of the tools and the equipment, use dry, absorbing cloths, if necessary RECKLI EK-PU Thinner in addition. Immersion in solvents is not sufficient. When cured, the material can be removed from the tools due to the self-releasing effect.

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SPECIAL REMARKS

To ensure dimensional accuracy and maximum life period, moulds made of RECKLI Si-Mould Paste HR-N must be stored under admittance of air on non-absorbent or sealed material, best in their supporting mould. Each contact with other silicone products, either within the same or with other moulds as well, must strictly be avoided.

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PACKAGING SIZES

double drums: 5 kg | double cans: 1 kg.

RECKLI Si-Hardener Type N, RECKLI Si-Thickener Liquid K and RECKLI Si-Colour Paste are enclosed in the lid.

STORAGE

Store in a dry place at room temperature. RECKLI Si-Mould Paste HR-N is storable for 6 months from delivery when kept in the closed original packaging at about 18 °C. Opened drums must be closed airtight right after use.

GENERAL INFORMATION

For further information please also see:

“General advice for making moulds and models using RECKLI two-component silicones”.

SAFETY

Protect skin and eyes from material splashes. Please consult the relevant safety data sheet and attend to the indications on the label of the package regarding the Dangerous Goods Regulation. This pamphlet is intended solely as an application directive. It does not claim to be binding and valid for all modes of application. A preliminary test under operation conditions is highly recommended.

This pamphlet replaces all previously published pamphlets concerning RECKLI Si-Mould Paste HR-N, stating them as no longer being valid.

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