

TECHNICAL PAMPHLET

RECKLI[®] Epoxy GF Filler

modified epoxy resin

PROPERTIES

RECKLI Epoxy GF Filler is a pasty, glass fibre reinforced, solvent-free two-component epoxy resin with high impact resistance as well as compressive- and flexural strength. It is almost shrinkage-free and insensitive to moisture, thus being applicable on slightly humid surfaces. The addition of further filling material is not recommended.

APPLICATIONS

RECKLI Epoxy GF Filler is primarily used for manufacturing rigid supporting moulds in combination with thin-walled elastic moulds out of polyurethane or silicone rubber when making moulds of ornaments, figures or monuments.

It can also be used in any other area of mould- and formwork manufacture. In this field of application it offers advantages compared with polyester resins due to its almost shrinkage-free and low-emission curing.

TECHNICAL DATA

property	value	method
mixing ratio (base : hardener):	8 : 1	(according to weight)
workable temperature:	+10 °C – +30 °C	
pot life (1000-g-mixture at +21 °C):	approx. 15 – 20 min	
earliest demoulding (at +21 °C):	7 – 8 h	
earliest mechanical loading after:	12 – 24 h	
density:	1,25 g/cm ³	
dimensional stability under heat:	60 °C	DIN 53462
heat resistance (dry heat):	+100 °C	
heat resistance (damp heat):	+80 °C	
colour:	grey	

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

SURFACE PREPARATION

On humid surfaces, such as gypsum or clay, a preceding treatment with RECKLI Si Stripping Lacquer is recommended. When making supporting moulds, at least two layers of RECKLI Mould Wax should be applied onto the entire mould surface ensuring an easy separation of the single parts.

When using RECKLI Epoxy GF Filler for levelling or repairing, the substrate must be stable, sound, dry, clean and free of oil, grease or wax; plastics or smooth surfaces must be roughened by grinding. In case of doubt, adhesion should be established in a preliminary test.

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. Once mixed, the processing of the material must be completed within the pot life (15 – 20 minutes). Mixing larger quantities decreases the processing time.

For making supporting moulds, RECKLI Epoxy GF Filler is applied with a trowel or a scraper up to 5 mm thickness. To increase the stiffness and the tear strength, additional glass fabric can be embedded in the application. To protect against injuries, protruding glass fibres and sharp edges must be removed. When fresh, the material can be smoothed by hand with the help of soap solution. To avoid skin contact, wear disposable gloves. When cured, the surface can be smoothed with a grinding machine. Avoid breathing grinding dust; if necessary, wear a dust mask.

Supports or reinforcements out of steel or timber can be glued to the plastic cap with RECKLI GF Filler as well. To achieve good adhesion, bare metal or coated wood must be roughened by grinding.

Depending on the mould's size and nature, the complete formwork can earliest be disassembled after 7 – 8 hours. Earliest mechanical loading is possible after 12 – 24 hours.

CONSUMPTION

1,25 kg/m² per mm thickness.

CLEANING OF EQUIPMENT

For the cleaning of the tools and the equipment, use dry, absorbing cloths, if necessary RECKLI Epoxy Cleanser in addition. Immersion in solvents is not sufficient.

PACKAGING SIZES

double drum: 4,5 kg | double can: 0,9 kg

The hardener is enclosed in the lid.

STORAGE

Store in a dry place at room temperature. RECKLI Epoxy GF Filler 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.

RECKLI Epoxy GF Filler
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SPECIAL REMARKS

Storage at low temperatures may cause partial crystallisation of the base component, even if only parts of the container are exposed to cold. In this case, the material can be melted in the closed container at 40 – 50 °C. When mixed up, it is usable again.

GENERAL INFORMATION

For further information please also see:

“General advice for the processing of RECKLI two-component resins“,

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

SAFETY

Protect skin and eyes from material splashes. Provide sufficient ventilation in the working place. 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 Epoxy GF Filler, stating them as no longer being valid.