

RECKLI® Supporting Mass EP-F Type VB

modified epoxy resin, glass fibre reinforced

RECKLI Supporting Mass
EP-F Type VB

Product 07542
Edition 01/23

PROPERTIES

RECKLI Supporting Mass EP-F Type VB is a glass fibre reinforced, solvent-free two-component epoxy resin with very low density. When cured, it shows high impact resistance and dimensional stability under heat.

APPLICATIONS

RECKLI Supporting Mass EP-F Type VB is suitable for manufacturing rigid, particularly light supporting moulds as used along with thin-walled elastic moulds out of polyurethane or silicone rubber when replicating ornaments, figures or monuments. It can also be used for making light and yet very stable backfillings of rigid moulds for construction-, ceramic- or porcelain-industry.

TECHNICAL DATA

property	value	method
mixing ratio (base : hardener):	7 : 1	(according to weight)
workable temperature:	+10 °C – +30 °C	
pot life (1000-g-mixture at +21 °C):	approx. 45 – 55 min	
earliest mechanical loading after:	7 – 10 h	
density:	0,6 g/cm ³	
dimensional stability under heat:	75 °C	DIN 53462
heat resistance (dry heat):	+100 °C	

early strength (after 24 h, 21 °C)

compressive strength	24,0 N/mm ²	DIN 1164
flexural strength	21,5 N/mm ²	DIN 1164

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.

To ensure good adhesion, backfillings out of RECKLI Supporting Mass EP-F Type VB must be applied if the primary layer is still wet but not displaceable any more.

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PROCESSING

Add the hardener (B) to the base component (A) and knead them homogenously. For mixing, a kneader is more suitable than an agitator, because the material tends to coil around the mixing rod. When kneading small quantities by hand, wear suitable protective gloves.

Subsequently the mass is applied and compacted with a trowel, a scraper or by hand. RECKLI Supporting Mass EP-F Type VB is most easily applied when the ready mixed material is rolled out between two foils to the required thickness. Right before placing, the first foil is removed, the second one after pressing the mass onto the substrate.

The recommended layer thickness is 5 – 30 mm per application. To increase the stiffness and the breaking strength of particularly large moulds, additional armouring or reinforcement out of steel or timber should be embedded. Likewise, provide supports ensuring the mould is standing level when turned. To achieve good adhesion, bare metal or coated wood must be roughened by grinding.

To protect against injuries, protruding glass fibres and sharp edges must be removed. When fresh, the material can be smoothed with RECKLI Epoxy OH. 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.

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

6 kg/m² per cm 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

drums / cans: 8 kg | 4 kg | 0,8 kg

The hardener is enclosed in the drum or can in a separate bottle.

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STORAGE

Store in a dry place at room temperature. RECKLI Supporting Mass EP-F Type VB 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.

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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. Wear suitable gloves for protection from resin-impregnated glass fibres. 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 Supporting Mass EP-F Type VB, stating them as no longer being valid.

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