



Formliners

Mould making Technique

**Resins for Mould and Pattern making
Concrete Surface**

DESIGN YOUR CONCRETE



**12-1 Cold cure resins
for moulding, modelling
and pattern making**



Product	Application Characteristics	Mixing ratio by weight	Specific gravity g/cm ³	Shore A hardness	Linear shrinkage %	Tear resistance N/mm	Elongation at break %	Viscosity mPa.s	Pot life min 21 °C 200-g-mixture	Earliest stripping h 21 °C	Heat resistance °C	Colour
Polyurethane Elastomers · Unfilled pourable resins												
RECK-o-lan 75 type N	two-component pourable resin for making high wear resistant moulds and mould parts in machinery, tool making, mould and model making, especially suitable for making blockouts or recesses in concrete industry	2:1	1.10	76	0.1-0.25	28	470	Base 2300	6	24	60	black
RECK-o-lan 85 type N	similar to RECK-o-lan 75, but Shore A 85	2:1	1.12	86	0.1-0.25	32	400	Base 2000	5	24	60	grey
RECK-o-lan 95 type N	similar to RECK-o-lan 75, but Shore A 95	2:1	1.12	94	0.1-0.25	47	300	Base 1800	4	24	60	red-brown
RECKLI PUR Compound A 85	similar to RECK-o-lan 85, but shorter potlife, highly resistant against abrasion	3:1	1.06	85	0.1-0.2	38	500	Base 2700	2.5-3	3	60	yellow-brown

Polyurethane Elastomers · Filled pourable resins												
RECKLI PUR Elastomer A 40	pourable elastic two-component compound for making formliners, moulds and mould parts, block outs or recesses, nearly shrinkage-free curing, isometric reproduction of finest pattern details, long lasting functional life, highly elastic	8:1	1.40	40	nearly free of shrinkage	6-7	300	2000-4000	15-20	>24	60	grey
RECKLI PUR Elastomer A 55	exists also as type K: special type for closed gypsum moulds in ceramics industry	8:1	1.40	55	nearly free of shrinkage	8-9	280	3000-5000	15-20	>24	60	grey
RECKLI PUR Elastomer A 70	similar to RECKLI PUR Elastomer A 40, but Shore A 70	8:1	1.40	70	nearly free of shrinkage	22-24	600	4000-6000	20-30	>24	60	grey
RECKLI PUR Elastomer SR 50	similar to RECKLI PUR Elastomer A 55, but Shore A 50, exceptionally tear resistant, lower spec. gravity	8:1	1.28	52	nearly free of shrinkage	18-20	900	8000-11000	15	>24	60	grey

Polyurethane Elastomers · Putty resins												
RECKLI PUR Elastomer Thix	two-component compound, thixotropic, paste-like, especially suitable for moulding on vertical surfaces	8:1	1.40	55	nearly free of shrinkage	8-9	280	pasty	8-10	3-5	60	grey
RECKLI PUR Elastomer Thix black	similar to RECKLI PUR ElastomerThix but stiffer and shorter potlife	8:1	1.40	55	nearly free of shrinkage	8-9	250	pasty	6-8	3-5	60	black
RECKLI Elasto Filler	two-component putty, elastic, suitable for repairing moulds, mould-parts or formliners made of RECKLI PUR Elastomers	8:1	1.40	55	nearly free of shrinkage	8-9	280	pasty	10-15	2-3	60	grey

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Silicone Rubber Compositions · Curing by condensation, pourable												
RECKLI SI Compound 6.25	two-component silicone rubber for moulding of voluminous models with less complicated undercuts, shortened demoulding times	10:1	1.16	25	0.5-0.8	6	280	12000	40-60	5	160	white
RECKLI SI Compound 10.15	very creepable two-component silicone rubber with high tear resistance, specially suitable for coat castings of gypsum mouldings	10:1	1.10	15	0.5-0.8	15	420	12000	60-90	24	160	white
RECKLI SI Compound 20	high tear-resistant universal type, suitable for nearly all moulding works and complicated replicas	10:1	1.24	20	0.5-0.8	19	500	18000	60-90	30	160	beige
RECKLI SI Compound 20 translucent	similar to RECKLI SI Compound 20 but translucent	10:1	1.10	20	0.5-0.8	19	500	20000	60-90	24	200	translucent
RECKLI SI Compound 35	two-component silicone rubber, especially applicable for mouldings for the restoration of historical constructions, moulds for gypsum and concrete replicas and several resins	10:1	1.00	35	0.5	3	200	24000	45-60	24	80	white
RECKLI SI Compound 35 "rapid"	similar to RECKLI SI Compound 35, but shorter potlife, therefore quicker curing and earlier demoulding	10:1	1.00	35	0.5	3	200	30000	10-15	5	80	white
RECKLI Eco Sil 25	two-component silicone rubber, moulding material only for 1 use, application in shoe industry and bronze foundries, still possible to fill	10:1	1.30	23	0.5-0.8	1.5	200	10000	15-25	2	150	white

Silicone Rubber Compositions · Curing by condensation, paste filler												
RECKLI SI Mould Paste HR-N	two-component silicone rubber paste for vertical or overhead moulding works, enclosed thickener for an individual consistency of the paste, high elongation at break and short potlife	10:1	1.10	15	0.5-0.8	15	420	pasty	15-25	12	160	white

Silicone Rubber Compositions · Curing by addition, pourable												
RECKLI SI Compound 21 AV	two-component silicone rubber, nearly shrinkage-free curing, high tear resistance, for true to measure mouldings and long lasting mouldstorage	10:1	1.30	21	0.1-0.2	13	300	6000	90-120	24	160	white
RECKLI SI Compound 26 AV	similar to RECKLI SI Compound 21 AV but Shore A 26 and still higher tear resistance and tensile strength	10:1	1.10	26	0.1-0.2	20	430	14000	60-90	24	160	translucent
RECKLI SI Compound 31 AV	similar to RECKLI SI Compound 21 AV but Shore A 31	10:1	1.35	31	0.1-0.2	12	200	10000	90-120	24	160	white

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Silicone Rubber Compositions · Supplementary products												
RECKLI SI Stripping Lacquer	water-soluble release lacquer on absorbent surfaces for avoiding of bonding and discolourations of the original model when using RECKLI silicones; approx. 200-250 g/m ²	–	1.02	–	–	–	–	150	–	–	–	translucent
RECKLI SI Colour Paste	for the pigmentation of RECKLI SI Compounds, colour green; consumption depending on the grade of colour intensity a few grams per kg	–	1.20	–	–	–	–	pasty	–	–	–	green
RECKLI SI Thickener Liquid K	liquid thixotropic agent for making pourable RECKLI SI Compounds brushable or applicable as paste, suitable for the types SI 10.15, SI 20 and SI 20 translucent; 0.5-1.5%	–	1.00	–	–	–	–	200-300	–	–	–	translucent
RECKLI SI Thickener Liquid AV	liquid thixotropic agent for making RECKLI SI Compounds types AV brushable and applicable as paste; consumption 0.1-1.0%	–	1.00	–	–	–	–	450-550	–	–	–	translucent

Product	Application Characteristics	Consumption
Extenders · Thickeners		
RECKLI Filler L	lightweight filler, blown, inorganic, for solvent-free two component resin compositions, especially for the reduction of material and weight for large sized moulds or mould parts	strongly depending on the basic viscosity of the resin, dry weight approx. 0.6-0.8 kg/l
RECKLI Filler C	bright, inorganic filler on a base of calciumcarbonate for two component resin compositions, high filling grades possible, easy to stir in lump free	strongly depending on the basic viscosity of the resin, dry weight approx. 1.4 kg/l
RECKLI Thickener 100	cream-white powder, light, suitable for making liquid resins pasty	1-20 % depending on the viscosity of the resin and required stability
RECKLI Thickener 720	very light powder, opak-white, for making liquid resins pasty	0.5-5 % depending on the viscosity of the resin and required stability

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Product	Application Characteristics	Mixing ratio by weight	Specific gravity g/cm ³	Viscosity mPa.s	Pot life min 21 °C 200-g-mixture	Hardness given by the dynamic indentation test after 14 days N/mm ²	Dimensional stability under heat according to Martens °C	Temperature resistance 7 days, 100 °C recirculated air	Earliest loading h
Epoxies · Unfilled casting resins									
RECKLI Construction Resin EP	universally suitable colourless two-component resin for nearly all applications in the building or concrete industry e.g. for coatings, as adhesive, bond course or binder for resin-based concrete, mortar or screed and compounds	2:1	1.10	1000-1200	40-50	70-75	40	resistant	24-48
RECKLI Construction Resin EP "rapid"	similar to RECKLI-Construction Resin EP, but shorter potlife and quicker curing time, especially suitable in cold seasons	2:1	1.10	1000-1200	15-20	70-75	40	resistant	24-48
RECKLI Construction Resin Epoxy K	modified colourless two component resin, high resistance to chemicals, high compressive strength and abrasion resistance, especially suitable for bonding course and sticking and as binder for resin-based concrete, mortar and screed	4:1	1.10	600-700	60-70	2-4	28	resistant	24-48
RECKLI Flooring Resin EP	colourless two component resin of low viscosity, especially suitable as binder for resin-based mortars and screeds tight to liquids and as a good penetrating primer for cement-based surfaces	3:1	1.10	350	40-50	50-55	40	resistant	24-48
RECKLI Flooring Resin EP Thix	similar to RECKLI Flooring Resin EP but more thixotropic therefore better suitable for rough-grained screeds	3:1	1.10	slightly thixotropic	40-50	50-55	40	resistant	24-48
RECKLI Injection Resin EP	two component resin, transparent, low-viscosity, good wetting, long pot-life, especially suitable for injections and sealings of hairline cracks in cement-based surfaces, also applicable as primer for sprinkling coat systems	3:1	1.10	300	80-90	45-50	38	resistant	24-48
RECKLI Epoxy WST	two component resin, transparent, high abrasion resistance and impact toughness, high resistance to thermal deformation, exactly reproduction of pattern details, easy to cut, drill, mill or shape, nearly shrinkage-free and low-stressed curing, specially suitable for glassfiber reinforced laminates and binder for backfillings and supporting mortars by using RECKLI Filler L in mould making technique	3:1	1.10	1600	15-20	125	60	resistant	12-24
RECKLI Epoxy GC	special two component laminate resin for fibre reinforced plastics, hand-application or spray technique, for model and mould making filled with RECKLI Filler L for e.g. reliefs or raised works	100:30	1.10	650-750	10	110-120	60	resistant	12-24
RECKLI Epoxy PB	two component resin, transparent, very high resistance to thermal deformation, low-viscosity, high filling grades possible, also suitable as binder for polymer concrete	4:1	1.10	230	35	140	88-90	resistant	24-48
RECKLI Polymer Resin EP	similar to RECKLI Epoxy PB, longer potlife but lower resistance to thermal deformation	4:1	1.08	250	80	120	*50*	resistant	24-48
RECKLI Epoxy LB Clear	cycloaliphatic two component resin, light-transparent, low-viscosity, excellent light fastness and yellowing resistance, specially suitable as top coat for bright stone-carpets	4:1	1.10	500	25-30	50-55	35	resistant	24-48

* up to 75 °C by additional curing time of 24 hrs at 40 °C in an oven or heater

Product	Application Characteristics	Mixing ratio by weight	Specific gravity g/cm ³	Viscosity mPa.s	Pot life min 21 °C 200-g-mixture	Hardness given by the dynamic indentation test after 14 days N/mm ²	Dimensional stability under heat according to Martens °C	Temperature resistance 7 days, 100 °C recirculated air	Earliest loading h
Epoxies · Unfilled casting resins									
RECKLI Epoxy LB	similar to RECKLI Epoxi LB Clear but opaque-transparent and slightly thixotropic, therefore a better filling of rough-grained stone-carpets	4:1	1.10	slightly thixotropic	25-30	50-55	35	resistant	24-48
RECKLI Electro Resin EP	two component resin, transparent, very long potlife, slow-stressed curing, insulating compound also for solid electrical and electronic components and circuitries	100:35	1.13	500	4 h (1000 g)	110-120	70	resistant	24-48

Epoxies · Pourable filled compounds									
RECKLI Epoxy Compound 61/20	two component compound for making models, reliefs, ornaments, frames and decorations, low shrinkage, easy to tool, colour cream-white	6:1	1.50	3000-5000	20	140-145	60-62	resistant	24-48
RECKLI Epoxy Compound 71/30	similar to RECKLI Epoxy Compound 61/20, but longer potlife, colour cream-white	7:1	1.53	3000-5000	30	130-135	62-64	resistant	24-48
RECKLI Epoxy Compound 51/30	similar to RECKLI Epoxy Compound 71/30 but lower viscosity and more flexible, colour cream-white	5:1	1.45	2500-3500	30	65	38-40	resistant	24-48
RECKLI Epoxy BB	two component resin, high resistance to chemicals, abrasion resistance and compressive strength, especially for self-levelling thick film coatings, bond courses, stickings or groutings, colour grey	5:1	1.40	3000-5000	50 (1000 g)	30	30	resistant	24-30
RECKLI Epoxy BT	two component epoxy coating, pigmented, thixotropic, suitable also for vertical surfaces, colour grey	4:1	1.32	thixotropic	55-60 (1000 g)	120	50	resistant	24-30

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Epoxies · Paste fillers								
RECKLI Epoxy OH	two component surface-modified coating resin, thixotropic, for model and mould making, good resistance to plastic deformation, impact toughness and abrasion resistance, exact reproduction of mould pattern details, colour white	7:1	1.50	20-30	120	60	resistant	24
RECKLI Epoxy OH blue	similar to RECKLI Epoxy OH but blue coloured therefore better examination of coat thickness on bright surfaces	7:1	1.50	20-30	120	60	resistant	24
RECKLI Epoxy OH Scratch Proof	similar to RECKLI Epoxy OH but especially scratch resistant by Nano-Technology, colour white	8:1	1.50	15-20	130	60	resistant	24
RECKLI Epoxy OH / D50	similar to RECKLI Epoxy OH but more flexible, especially suitable for mould making in the ceramic industry, colour yellow	8:1	1.40	25	15 Shore D 50	–	resistant	24

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Epoxies · Paste fillers								
RECKLI Adhesive Paste EP	two component adhesive resin, slightly thixotropic, sticking of wood, card board, nature or artificial stone, several metals and several plastics, colour cream-white	4:1	0.80	60-70	25	40	resistant	24
RECKLI Epoxy Flex Filler	two component filler paste, nearly shrinkage-free and quick curing, for the repair and levelling of holes, cracks, dimples, unevennesses and joints on wood, steel or cement-based surfaces which shall be coated with RECKLI Epoxy materials, colour: dark grey	1:1	1.85	4-5	65	35	resistant	3-4

Epoxies · Paste fillers, glass fibre strengthened								
RECKLI Epoxy GF Filler	nearly shrinkage-free glass-fibre reinforced two component filler for making supporting moulds for elastic moulds or liners made of RECKLI PUR Elastomers or RECKLI Silicones, replaces heavy supporting moulds made of gypsum or concrete, colour grey	8:1	1.25	15-20 (1000 g)	–	60	resistant	12-24
RECKLI Supporting Mass EP-F Type L	glass-fibre reinforced two component tamp composition, high resistance to thermal deformation, for layer of 5-10 mm, colour grey	7:1	0.95	30-40 (1000 g)	–	85	resistant	12-24
RECKLI Supporting Mass EP-F Type VB	similar to type L but lower specific gravity, colour grey	7:1	0.60	45-55 (1000 g)	–	75	resistant	12-24

Product	Application Characteristics	Mixing ratio by weight	Specific gravity g/cm ³	Pot life min 21 °C 200-g-mixture	Compressive strength N/mm ²	Tensile strength N/mm ²	Dimensional stability under heat according to Martens °C	Temperature resistance 7 days, 100 °C recirculated air	Earliest loading h
Epoxies · Fillers · Mortars									
RECKLI Epoxy GS	two component priming, adhesive and levelling filler for cement-based surfaces, wood, ceramics, steel or polystyrene, especially for following thick coating with RECKLI Epoxy BB or BT	5:1	1.25	25-30 (1000 g)	35-39	30-34	35	resistant	24-48
RECKLI Rapid Epoxy Type LS	two component epoxy filler, stable, for repairing and sticking of cement-based or steel surfaces, levelling of unevennesses and dints on horizontal and vertical surfaces, special application: sticking of large format concrete, colour grey	9:1	1.55	15-20 (1000 g)	55-60	35-40	40	resistant	24-48
RECKLI Epoxy Fine Concrete	two component repair or levelling mortar for cement-based surfaces, stable, also in thick layers	25:1	2.00	25-35 (1000 g)	60	35	40	resistant	24-48

Product	Application Characteristics	Consumption
Release Agents for moulding and modelling		
RECKLI Mould Wax	solvent containing precious hard wax for the safe separation when making formliners, moulds or stopp-offs with RECKLI PUR Elastomers or RECKLI Epoxy Resins	approx. 50-100cm ³ /m ²
RECKLI Polishing Wax	solvent containing liquid wax for getting polished surfaces, specially suitable forgypsum surfaces	approx. 100-200cm ³ /m ²
RECKLI SI Stripping Lacquer	water-soluble release lacquer for absorbent surfaces and for avoiding discolourations of the original model when using RECKLI Silicones for moulding	approx. 200-250cm ³ /m ²

Release and Stripping Agents for casts on moulds and formworks		
RECKLI Stripping Wax TL	solvent containing precious release agent for a safe stripping of RECKLI Formliners, offers a high quality of exposed concrete surfaces, also best suitable for non-absorbent formworks like steel, sealed plywood, plastic-coated plates etc.	approx. 100-150cm ³ /m ² spray in fine coats remove surplus from pattern bottom
RECKLI Stripping Wax TL-SO	similar to RECKLI Stripping Wax TL but with additional chemical active substance, specially suitable for in-situ concrete or longer lasting stripping time	approx. 100-150cm ³ /m ² spray in fine coats remove surplus from pattern bottom
RECKLI Stripping Wax TL-W	aqueous non-polluting ready-for-use wax-based release agent, suitable for RECKLI Formliners and other non-absorbent formworks like sealed plywood or plastic-coated plates	approx. 80-100cm ³ /m ² spray in fine coats remove surplus from pattern bottom
RECKLI Gypsum Release Agent GTM	aqueous, non-polluting release agent for moulding gypsum from plastics like RECKLI-PUR Elastomers, - Silicones, -Epoxyes, polyethylene or polyesters	approx. 50 g/m ² on smooth surfaces, spray in fine coats, remove surplus from dips or cavities and pattern bottom
RECKLI Mould Wax	solvent containing precious hard wax for the safe separation when making casts of liquid resins on formliners or moulds made of RECKLI PUR Elastomers or RECKLI Epoxyes	approx. 50-100cm ³ /m ²