

RECKLI[®] Si-Compound 20

Properties

Pourable condensation-cure two-component silicone rubber, cold-cure, self-releasing, identical reproduction of even the finest surface details, highly elastic, very high tensile strength. By adding RECKLI Si-Thickener Liquid K (0.5-1.5%) you reach a paintable and brushable consistency.

Application

The manufacture of highly elastic particular tear-resistant moulds for the reproduction of models or copies made of plaster, cement mortar, concrete, plastic resins and plastic resin combinations.

Caution! RECKLI Si-Compound 20 is not absolutely resistant to polyester and PMMA resins. A preliminary test is essential.

Surface

See separate pamphlet "General Surface Pretreatment Advices when using One- or Two-Component RECKLI Resins".

Processing

See separate pamphlet "General Processing Advices for RECKLI-Two-Component Resins".

Method of processing

Pour, paint or brush on.

Special advice

For proper reaction RECKLI Si-Materials contain moisture. For this reason it is very important that the drums of material remain tight closed when not in use, and closed immediately after use. If you experience problems, such as longer reaction times and sticky surface on the model face, you can stir in water to the base component at the rate of 1-2 g per kg before mixing only. Then the drum must be sealed again and kept in storage for 24 h.

If the outer side of the rubber remains sticky, it is an indication for insufficient humidity in the surrounding area. In this case it is necessary to get the sufficient percentage of humidity by suitable measures (sprayer, vapourizer, etc.). 50% relative humidity is the optimum. The addition of water by mixing in the basic material is not recommended in this case.

Cleaning of equipment

Before material has cured, clean equipment thoroughly with RECKLI EK-PU-Thinner, simply placing equipment in thinner is not sufficient. When hardened, the material can be removed from tools due to the self-detaching effect.

Technical data

Hardener	Typ 20	
Colour of hardener:	transparent	
Colour of base component:	beige	
Mixing ratio by weight:	10 parts base component 1 part hardener	
Viscosity of base component:	35000 mPa.s	(ISO 2550)
Viscosity of mixture:	18000 mPa.s	(ISO 2550)
Working temperature:	+10° C to +30° C	
Potlife:	60-90 mins.	
Earliest stripping:	30 hrs (at +21° C)	
Shore-A-hardness (approx.)	20	(DIN 53505)
Specific weight:	1.24 g/cm ³	
Linear shrinkage:	0.5-0.8 %	
Tensile strength:	2.6 N/mm ²	(DIN53504-S2)
Elongation at break:	appr. 500%	(DIN53504-S2)
Tear resistance:	19 N/mm	(ASTM D 624-B)
Heat resistance:	+160° C	
Odour:	neutral	

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

Drum sizes

Double drums, hardener in drum lid;
5-kg; 1-kg

Storage

Unopened drums may be kept in closed stores at +18° C for 6 month from date of delivery. Also see "General Processing Advices for RECKLI-Two-Component Resins".

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 drum regarding Dangerous Goods Regulations.

This pamphlet is intended solely as an application directive. It does not claim to be binding and valid for all modes of application. We recommend the carrying out of a preliminary test application relevant to full scale application every time.

This pamphlet replaces all hitherto published pamphlets concerning RECKLI Si-Compound 20 these no longer being valid.