

## RECKLI<sup>®</sup> Si-Compound 6.25

### Properties

Pourable, condensation-cure two-component silicone rubber, cold-curing, self-detaching, reproduction of finest surface contours and textures, elastic, good tear resistances, shortened demoulding times. Thickening with Si-Thickener Liquid K nor AV is not possible.

### Application

Manufacture of elastic relief and profile moulds by pouring, from models made of gypsum plaster, cement mortar, concrete or plastics.

**Caution!** Silicone-moulding rubbers are only partly resistant against artificial-resin compounds, like polyesters or PMMA. 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

Pouring.

### 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.

### 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”.

### Technical data

Hardener:	Type N	
Colour of hardener:	transparent	
Colour of base component:	white	
Mixing ratio by weight:	10 parts base component 1 part hardener	
Viscosity of base component:	25000 mPa.s	(ISO 2555)
Mixing viscosity:	12000 mPa.s	(ISO 2555)
Working temperature:	+10° C to +30° C	
Potlife 200-g-mixture at +21° C:	40-60 mins	
Earliest stripping:	5 hrs	(at +21° C)
Shore-A hardness:	appr. 25	(DIN 53505)
Spec. weight:	1.16 g/cm <sup>3</sup>	(DIN 53505 - S2)
Linear shrinkage:	0.5-0.8 %	
Tensile strength:	2.5 N/mm <sup>2</sup>	(DIN 53504 - S2)
Elongation at break:	280 %	(DIN 53504 - S2)
Tear resistance:	6 N/mm	(ASTM D 624-B)
Heat resistance:	appr. +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

### Safety

Protect skin and eyes from material splashes. Please consult the relevant safety data sheet and attend to the indications on the lable 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 6.25 these no longer being valid.