



## Relief Casting compound

**Gilufom SP 16** is a white powder easy to mix with water. It forms a free flowing mass for the manufacture of reliefs, models and castings.

### Special advantages

- Simple processing
- Quick solidification without additives
- Porcelain-like structure of the cast material
- No drying, no firing
- Accurate reproduction of finest details.
- Surface-treatment with all commercial colors.
- Not harmful to skin or injurious to health.

### Characteristics

Appearance	white powder
Mixing ratio by weight powder : water = mixed volume	1 kg : 0,27 – 0,291 0,62 l
Working time	app. 10 min
Setting time	app. 18 min
Surface hardness	above 250 N/mm <sup>2</sup>

### Working instructions

The casting form, for example a flexible plastic mould, is to be set up in a level position.

### Mixing and filling the moulds:

Strew the plaster in the above mentioned ratio into the water, allow soaking, stirring for approx. 1 min., taking care not to cause air bubbles. In order to mix larger quantities it is advisable to use a mixing machine.

Pour the easy flowing mix in a thin stream into the middle of the form until the surface of the form is covered with a bubble free layer. The rest of the mix can be poured more rapidly.

### Demoulding:

The set model can be removed from the mould approximately 40 minutes after casting. Advantageously it is to be stored ventilated by air from all sides, e.g. on wooden lathes.

### Colouring the surface:

Water based colours may be applied 2 - 8 hours after demoulding. If using enamel paints or impermeable coatings, final setting reaction and drying must be completed in advance. At temperatures of 20-25 °C drying of the castings requires at least 2 days; it may be reduced to 24 hours if they are stored at temperatures of max. 40°C.

### Useful hints

It is important to use only pure water and clean receptacles and stirrers.

Do not exceed the working time.



## Availability

The standard quality is a white, non-colored powder.  
Other colors are available for orders of min. 2 tons.

The above recommendations are given to the best of our knowledge. We grant the quality of our products according to our specification. Any further liability cannot be accepted since the proper application of our products is outside of our control.

## Packing

Paper bag with foil liner	25 kg
Foil bag	5 kg

## Shelf life

At least 12 months in closed, vapour-proof packages.