

REPLISIL 22 N  
 REPLISIL 22 S  
 REPLISIL 32 N



03/2008

## Information for use

**REPLISIL 22 + 32** are addition-curing 1:1 duplicating silicones with final hardness of Shore A 22 resp. A 32, low viscous with best mechanical characteristics and offer an extremely high accuracy in dimension and design of the duplicating form. **REPLISIL** is very flexible in the final consistency despite high ultimate tensile strength and therefore easy to deflask particularly in case of undercuts. It is from extraordinary productivity since it contains no additional fillers and requires no wetting agents. Due to a platinum catalyst in component A the hardening without any shrinkage is ensured.

**REPLISIL 22 + 32** are also suitable for casting without flasks and causes no limitation to the expansion value of the investment.

### Working instructions:

**REPLISIL** component A and B must be mixed at room temperature in proportion 1:1 approx. 1 min. until an uniform colour is reached. It should be poured from a height of approx. 30 cm constantly onto the dry plaster model in the flask until it's all round covered. If applicable in case of manual mixing removal from bubble formation should be indicated by a vibrator.

After a curing period of approx. 30 minutes in case of **REPLISIL 22 N + 32 N** or 10 minutes in case of **REPLISIL 22 S** at a room temperature of 23°C the model can be replaced and should be left another few minutes to release probably existing reproductions of undercuts.

### Technical data

#### uncured:

	<u><b>REPLISIL 22 N + 22 S</b></u>		<u><b>REPLISIL 32 N</b></u>	
	<u>Comp. A</u>	<u>Comp. B</u>	<u>Comp. A</u>	<u>Comp. B</u>
Viscosity:	2.500 mPa s	2.500 mPa s	3.420 mPa s	3.630 mPa s
Density (at 20°C, DIN 51 757):	1,069 g/cm <sup>3</sup>	1,081 g/cm <sup>3</sup>	1,069 g/cm <sup>3</sup>	1,081 g/cm <sup>3</sup>
Colour:	white	pink	transpa-white	blue

#### cured:

	<u><b>REPLISIL 22 N</b></u>	<u><b>REPLISIL 22 S</b></u>	<u><b>REPLISIL 32 N</b></u>
Processing time:	6 minutes	2 minutes	6 minutes
Setting time:	30 minutes	10 minutes	30 minutes
Shore A (DIN 53 505):	22	22	32

	<u><b>REPLISIL 22 N + 22 S</b></u>	<u><b>REPLISIL 32 N</b></u>
Tear resistance (DIN 53 504 S 1):	3,5 N/mm <sup>2</sup>	4,9 N/mm <sup>2</sup>
Elongation at tear (DIN 53 504 S 1):	400 %	432 %
Continuing tear resistance: (ASTM D 624 B)	4,5 N/mm	8,8 N/mm
Colour:	pink	blue
Linear change of measurement:	< 0,2 %	< 0,2 %

These data represent approximate values and are not intended to produce specifications.



**Shelf life:**

**REPLISIL** is storable in original locked containers at least 12 months at a temperature between 10°C and 25°C.

**Packaging:**

Item no. 241122701 **REPLISIL 22 N**, normal curing 2 x 1 Kg  
Item no. 241122806 **REPLISIL 22 N**, normal curing 2 x 6 Kg  
Item no. 241122825 **REPLISIL 22 N**, normal curing 2 x 25 Kg

Item no. 241132701 **REPLISIL 32 N**, normal curing 2 x 1 Kg  
Item no. 241132806 **REPLISIL 32 N**, normal curing 2 x 6 Kg  
Item no. 241132825 **REPLISIL 32 N**, normal curing 2 x 25 Kg

Item no. 241222701 **REPLISIL 22 S**, fast curing 2 x 1 Kg  
Item no. 241222806 **REPLISIL 22 S**, fast curing 2 x 6 Kg  
Item no. 241222825 **REPLISIL 22 S**, fast curing 2 x 25 Kg

Consider safety-related references of the safety data sheet!  
For further questions don't hesitate to contact us.

