



Glass fiber reinforced hard gypsum for producing thin-walled moulds in the hobby field.

The powder mixed with water is used to manufacture reliefs, models and negative moulds.

Special advantages

- Simple processing
- No drying, no firing
- Reduced weight
- Hard surfaces
- Not hazardous to health

Charakteristics

Appearance	powder
Mixig ratio	
powder : water	4 kg : 1 l
= mixing volume	0,6 l
Working time	app. 45 min
Setting time	app. 55 min
Hardness	above 300 N/mm ²

Working instructions

To coat an area of 25 cm x 25 cm with a layer 8 - 10 mm thick, 1 kg powder and 250 ml water are required.

Strew GILUFORM 500 L in the given ratio into the water, allow to soak for a few minutes, then stir thoroughly.

Carefully apply a thin layer of GILUFORM 500 L onto the model or form taking care to prevent air bubbles, then build up to the required thickness. Flexible plastic or rubber forms are ideal for this purpose, in the case of other form materials a parting agent should be first applied.

When manufacturing large parts it is advisable to cover the surface in stages by mixing quantities not exceeding 4 kg of powder with 1 ltr. of water. In this case a mechanical mixer is recommended.

Attention

The whole part has to be completed within the working time of 45 min. Each layer of the mixture has to be applied before the preceding one has set: "working wet in wet", in order to achieve a good bond between the layers.

If an especially fine reproduction of details on the surface is desired, it is recommended to apply the first layer on the model to a thickness of approx. 0,5 - 1 mm by applying a diluted mixture. The next layers are continued in the above described manner.

A finished model thickness of 5 mm for small models and 10 mm for large ones is usually sufficient. Models and parts which have set can be bonded together using a white wood adhesive.

After final setting (approx. 70 min) remove the manufactured part from the model and place it onto wooden lathes to allow air circulation. Dry for 12 hours at room temperatur or 4 hours at max. 40° C. After this time the part may be painted or coated in the desired manner.

Packaging

Foil bag	5 kg
Paperbag with foil liner	25 kg

Shelf life

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

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.