



Form cement for the manufacture of prototypes in the automobile industry

A modified synthetic hard plaster where by controlling the crystalic structure the rate of expansion can be predetermined. Very high expansion from approximately 1.2 %.

In the manufacture of press tools it is suitable for patterns taken from an original. The expansion of the plaster compensates for the contraction of the metal alloys to be cast in it.

LUDUR 1.2 offers special advantages through

- omission of oversize models
- smooth surfaces free from imperfections
- high stability and
- good tooling workability

Characteristics

Appearance	light brown powder
mixing ratio	100 kg plaster : 39 l water
= mixed volume	75 Liter
processing time	app. 12 min
solidification point	app. 25 min
compressive strength, damp	over 7 N/mm ²
linear setting expansion after 24 h	app. 1.2 %

Mixing

Strew LUDUR 1.2 into the measured amount of water and mix thoroughly with an electric whisk for one min., then pour at once into the form. In order to attain accuracy in length and breadth it is recommended to cover the form with an insulation blanket during the first six hours.

Useful hints

LUDUR 1.2 and the water to be mixed shall have a temp. of 20 °C (68 °F). Plaster which has been stored at extreme temps. should be acclimatised for several hours before use.

The mixing machine must be clean.

Small changes in the amount of expansion can be achieved by altering the mixing ratio. With a ratio of 100 kg plaster: 40 l water the expansion decreases by about 0.05 %. Vice versa with a ratio of 100 kg plaster: 38 l water the expansion increases slightly.

By an order of at least 2 tons the form plaster can also be delivered with a lower expansion.

Packing

Paper bag with foil liner 50 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.

