Technical Information Sheet
Article No. 0588 - 0590

Casting Mortar

Ready to use, factory-mixed, dry mortar for moulding sculptures in a casting procedure.
Binder and aggregates on a pure mineral base

Range of use

Remmers Casting Mortar is outstanding for reproducing ornamental building elements, sculptures, balusters, etc. in a casting procedure that look very much like the original natural stone. Casting Mortar can also be used for the reconstruction of brick and terracotta sculptures. The different various colours of natural stone, brick and even concrete found in practice can be reproduced at the factory.
If a sample is sent in, colour and grain size can be matched at the factory without any mentionable deviation.
If the colours on the sample change, the desired colour on the sample should be clearly identified. As an alternative, the colour can also be selected from the Remmers Colour Collection or from other conventional shades.

Characteristic data of the product

Bulk density:	approx. 1.6 kg/l
Colours:	Art. No. 0588 grey
	Art. No. 0589 white
	Art. No. 0590 special colours
Tensile bending strength:	after 28 days approx. 5 N/mm²
Compressive strength:	after 28 days approx. 18 N/mm²
E-modulus in accordance with DIN 1048:	approx. 17,000 N/mm²
Shrinkage deformation DIN 52450:	after 28 days approx. 0.45 mm/m

Colours can be produced to match clearly marked samples or according to one of the shades in the Remmers® Colour Collection or some other colour (e.g. RAL).

Property profile

Remmers Casting Mortar is a ready to use, factory-mixed, dry mortar made of inorganic substances and strength promoting minerals. Its physical characteristics correspond to the requirement of being as durable as possible and have been especially coordinated to the least possible shrinkage and inherent stress when setting. Due to its excellent flow properties, Casting Mortar is very suitable for creating reproductions in a casting procedure. The "normal" grain size of the aggregates generally corresponds to those of fine sandstone (< 0.5 mm). To achieve a specific natural stone look, modifications in grain size distribution of the aggregates are available (if desired also in a "fine" < 0.2 mm and a "coarse" < 2.0 mm version) or the aggregate itself can be modified.

Working

Casting Mortar was designed especially for moulding in a casting procedure.
When moulding in a tamping procedure, Remmers Restoration Mortar, Art. No. 0750 should be used.

Casting Mortar is mixed with water in a ratio of approx. 4.5 l of water to 30 kg of mortar. The mixture must have good flowing capacity and be free of lumps so that it can run into the fine details of the

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mould as well. The liquid consistency of the restoration mortar plays a decisive role in a casting procedure; however, settling should never take place. To make sure that Casting Mortar does not settle in the mould, the mixed material should be allowed to rest in the mixing container for approx. 30 minutes first. During this time, the mortar should not settle. If the mortar is mixed with an electric mixer, a slow speed should be used to prevent excessive amounts of air from being brought into the mortar. The best way to avoid the inclusion of air in the mortar is to mix it with an agitator blade.
To avoid the entrance of air bubbles when pouring the mortar into the mould, Casting Mortar should be poured slowly down a suitable wood board or through a funnel with tube, allowing thin layers to run uniformly into the mould. The mortar should not fall in drops or fall free into the mould. Depending on size and shape of the mould, the mould can be removed in 3 to 7 days and the reproduction worked over, if necessary. It is recommended to wrap the mould tightly in plastic sheet while the mortar sets. The mould must also be absolutely water tight since seasoning in the mould during the setting process is not possible and dehydration should be strictly avoided.

Free-standing sculptures can be treated with Silicone Resin Scumble or Grout Scumble in a natural stone look or with a Funcosil® impregnation agent after the mould is removed to make them water repelling which considerably increases their service life outdoors. If the moulded reproduction stands in very shaded areas or areas with heavy moisture loads, treatment with Impregnation BFA is recommended prior to water repelling treatment to prevent infestation with micro-organisms (alga, lichen, fungus, etc.) or delay infestation as long as possible.

Safety, ecology, disposal

To produce moulds true to details, Remmers Silicone AFM, also with the addition of Remmers Thickening Agent AFM is particularly suitable.

Tools and cleaning

Mixing equipment, casting aids such as a wood board, funnel, etc. Clean tools with water while the mortar is still fresh.

Packaging, application rate, shelf-life

Packaging:
30 kg paper bags

Application rate:
approx. 1.8 kg for 1 litre cavity volume

Shelf-life:
at least 1 year stored dry in closed bags

Safety, ecology, disposal

Further information concerning safety during transport, storage and handling as well as for disposal is found in the latest Safety Data Sheet.

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