...Why Reckli?

- **Reliability**...German quality.
- **Experience**...We've been making moulds since 1968.
- **Care**...We are focused on the best visual result.
- **Know how**...We've been involved in Thousands of projects worldwide.
- **Local office**...Supported by an international network with offices in over 56 countries.
- **Integrity**...Be assured that we will work ethically and professionally.
History of Reckli Group Australia

Reckli in Australia was formed in 2004 by John Joveski, who since 1989 was involved with reinforcing steel supply to the Precast & Insitu-Cast Concrete Wall industry in Victoria.

Having identified a lack of local availability of mould suppliers to the Precastors & Insitu-Cast Wall manufacturers, he discovered Reckli, and being a world leader in this field, who had no representation in Australia.

The first office Reckli in Australia was set up in North Laverton, Victoria in 2004.

Here we displayed the different standard sample profiles where orders were arranged and sent to Germany, where they were manufactured and delivered via Seafreight or Airfreight to Australia.

As demand for form-liners grew, the tight construction time constraints also put pressure on safe and quick supply of our form-liners from Germany, thus in late 2009, we moved to Derrimut and again in September 2012 we moved to our current larger location 84 Hunter Road Derrimut, Victoria, 3030 Australia.

We can now make all form-liners here and supply standard form-liners in 2 weeks (Ex-Melbourne).

As Reckli-AU has earned the confidence & respect of Designers, we have also invested in the ability to make unique/custom moulds (project specific) at our current facility.

Along with the support of Reckli-International’s other 56 offices, we have our own in-house Industrial Designers, Interior Designer, CNC Programmers, 4no. state of the art 3-d CNC Milling Machines and 7 Laser cutting/engraving machines, waterjet and various other specific machines.

What does this mean ... we can make form-liners to almost any profile, FAST and of HIGH QUALITY, here in Australia.

Disclaimer:
All form-liner dimensions are nominal. Actual dimensions may vary slightly depending upon design. Despite our carefully controlled production processes, dimensional tolerances are unavoidable. Due to the high elasticity of our form-liners, they can also stretch and be compressed during packing and transport, which may add to dimensional variations.
Methods of concrete panel manufacture vary between all manufacturers and also at different times of the year, we recommend you adopt our suggestions outlined in our “Application Guideline for Reckli Form-Liners” (refer to pages 80-93).

Limited Warranty:
Reckli warrants their form-liners to be of uniform quality within manufacturing specifications and will perform as represented, provided that the concrete construction practices used are in accordance with our guidelines and installation instructions.
Reckli assumes no responsibility for any damage to form-liners due to the improper use or application of a non-Reckli form release agent.
Our obligation under this warranty shall be limited to refunding the purchase price or replacing that portion of the material proven to be defective.
Reckli make no other warranty expressed or implied, including, without limitation, warranties of fitness or merchantability, with respect to its products. For more information refer to page 80 – 93

World of Reckli

Partner and Agents in 56 Countries
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All patterns on this page are available within 2 weeks Ex-Melbourne (Made in Melbourne)
Broken Rib Patterns

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Manufacturers of Form-Liners & Rubber Moulds for
Patterns on Concrete Panels & other Concrete Elements

Broken Rib Patterns

2/87 B-Ohio

Named after a river in Ohio USA

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Broken Rib Patterns

1/21 B-Malta
Named after the island

1/41 B-Ibiza
Named after an island of Spain

1/45 B-Sicilia
Named after an island in Italy

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Broken Rib Patterns

1/347 B-Forte de France

1/29 Krete

1/37 B-Rippe J

1/21 B-Malta

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Broken Rib Patterns

Manufacturers of Form-Liners & Rubber Moulds for Patterns on Concrete Panels & other Concrete Elements

1/124 B-Taro

1/126 B-Larnaka

1/09 B-Norderney

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Broken Rib Patterns

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1/124 B-Taro (See specs on page 8)

1/126 B-Larnaka (See specs on page 8)

1/126 B-Larnaka (See specs on page 8)

1/09 B-Norderney (See specs on page 8)

1/09 B-Norderney (See specs on page 8)
Rough Cast and Textured Patterns

2/69 Marne (See specs on page 12)

2/69 Marne (See specs on page 12)
Rough Cast and Textured Patterns

Manufacturers of Form-Liners & Rubber Moulds for Patterns on Concrete Panels & other Concrete Elements

2/62 Tevere  Named after a river in Italy

2/102 Parana  Named after a river in South America

2/103 Lena  Named after a river in Russia

2/93 Red River  Named after a river in Northern U.K

2/133 Toscana

2/92 Rio Bravo  Named after a city in California

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Rough Cast and Textured Patterns

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Wood Patterns

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2/82 Colorado (See specs on page 16)
Wood Patterns

Manufacturers of Form-Liners & Rubber Moulds for Patterns on Concrete Panels & other Concrete Elements

Wood Patterns

2/20 Ahr
Named after a river in Germany

2/23 Alster
Named after a River in Northern Germany

2/22 Altmuhl
Named after a river in Germany

2/73 Tisa
Named after a river in Central Europe

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Wood Patterns

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Wood Patterns

Manufacturers of Form-Liners & Rubber Moulds for Patterns on Concrete Panels & other Concrete Elements

2/51 Spree
Named after a river in Germany

2/26 Elbe
Named after a river in Central Europe

2/97 Kongo
Named after a Geographical area in Africa

2/83 Tejo
Named after a river in Brazil

2/25 Eder
Named after a river in Germany

2/144 Spessart
Named after a region in Southwest Germany

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Wood Patterns

2/84 Missouri
Named after a river in USA

2/167 Trent
Named after a river in Canada

2/96 Niger
Named after a river in Western Africa

1/18 Bornholm
Named after an island in Denmark

1/10 Pellworm
Named after an island in Northern Germany

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Wood Patterns

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1/03 Fehmarn

1/04 Fohr

1/07 Langeoog

1/08 Mainau

1/11 Reichenau

Named after an Island in Germany

More photo references on page 21
Wood Patterns

1/24 Gotland

1/28 Lolland

1/27 Seeland

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Wood Patterns

1/317 Rustic

1/317 Rustic

2/28 Emscher (See specs on Page 22)

1/317 Rustic

1/27 Seeland (See specs on Page 20)

2/26 Elbe (See specs on Page 17)

1/04 Fohr (See specs on Page 19)

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Wood Patterns

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Wood Patterns

1/17 Wollin

2/152 Martinique

2/153 Martinique invers

2/711 Ventanique

2/712 Ventanique Inverse

2/707 Basket Weave

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Abstract Patterns

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2/98 Vltava (See spec on page 25)

2/44 Neckar (See spec on page 26)

1/06 Juist (See spec on page 27)

1/20 Kerkyra (See spec on page 30)
Abstract Patterns

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2/61 Thames
Named after a river in South England

2/98 Vltava
Named after a river in Czech Republic

1/25 Baltrum
Named after an Island in Northwest Germany

2/42 Naab
Named after a river in Germany

Form Liner

Manufacturers of Form-Liners & Rubber Moulds for Patterns on Concrete Panels & other Concrete Elements

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Abstract Patterns

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Abstract Patterns

1/43 Corse

Named after an Island in Southeast France

1/44 B-Sardegna

Named after an Island in West Coast of Italy

1/14 Sylt

Named after an Island in Northern Germany

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Abstract Patterns

2/49 Saale
Named after a river in Germany

2/45 Oder
Named after a river in Central Europe

2/57 Loire
Named after a river in France

2/168 Somme
Named after a region in France

1/01 Amrum
Named after an Island in Northern Germany

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Abstract Patterns

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Abstract Patterns

Manufacturers of Form-Liners & Rubber Moulds for Patterns on Concrete Panels & other Concrete Elements

2/151 Gironde
Named after a river in France

2/125 Dordogne
Named after a river in France

2/174 Breisgau
Named after a region in Southwest Germany

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Manufacturers of Form-Liners & Rubber Moulds for Patterns on Concrete Panels & other Concrete Elements

Brick and Masonry Patterns

2/65 Drau
Named after a river in Central Europe

2/99 Salzach
Named after a river in Austria

2/40 Mohne
Named after a lake in Northern Germany

2/70 Po
Named after a river in Italy

2/39 Main
Named after a river in Germany

2/718 Stack-Bond Ausbrick
Named after an Australian Brick Pattern

2/719 Stretcher-Bond Ausbrick
Named after an Australian Brick Pattern

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Brick and Masonry Patterns

1/165 Reno

Named after a river in Northern Italy

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2/177 Westfalia

Named after a region in Germany

2/71 Don

Named after a river in Russia

2/141 Dachstein

Named after a mountain in Austria

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Manufacturers of Form-Liners & Rubber Moulds for Patterns on Concrete Panels & other Concrete Elements

Brick and Masonry Patterns

2/140 Camargue
Named after a region in France

2/89 Duero
Named after a river in Portugal

2/88 Trave
Named after a river in Germany

2/72 Ob
Named after a river in Russia

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Brick and Masonry Patterns

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Brick and Masonry Patterns

2/312 Engadin
Named after a Valley in the Swiss Alps

1/127 Shannon
Named after a river in Ireland

2/139 Auvergne
Named after a region in France

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Brick and Masonry Patterns

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2/149 Tirol

Named after a region in Austria

2/147 Allgau

Named after a region in South Germany

2/311 Zyklop

Named after a type of German wall pattern

2/135 Provence

Named after a region in Southeast France

2/374 La Reunion

Named after an island of France

2/137 Bourgogne

Named after a region in France

2/137 Bourgogne

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Manufacturers of Form-Liners & Rubber Moulds for Patterns on Concrete Panels & other Concrete Elements

Brick and Masonry Patterns

.named after a region in Spain

.named after a region in Belgium

.named after an old Roman roadway

.named after a river in France

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Brick and Masonry Patterns

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Named after a mountain range in France

1/354 Durance

1/354 Durance

2/161 Esterel

2/161 Esterel

2/196 Wallonie

2/196 Wallonie

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All patterns on this page are available within 2 weeks Ex-Melbourne (Made in Melbourne)
Stone and Rock Patterns

2/121 Cheyenne (See specs on page 44)

2/157 Fichtelberg (See specs on page 42)
Stone and Rock Patterns

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Stone and Rock Patterns

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Stone and Rock Patterns

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Stone and Rock Patterns

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Stone and Rock Patterns

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Rib and Wave Patterns

Manufacturers of Form-Liners & Rubber Moulds for Patterns on Concrete Panels & other Concrete Elements

Concrete Actual Finish

2/95 Amazonas

Named after a region in Peru

2/95 Amazonas

Rib and Wave Patterns

2/94 Orinoco

Named after a river in South America

2/94 Orinoco

1/134 Riviera

Named after a region in Italy

1/134 Riviera

1/171 Sinus 18/76

Latin for "Wave"

1/171 Sinus 18/76

1/172 Sinus 27/100

Latin for "Wave"

1/172 Sinus 27/100

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Manufacturers of Form-Liners & Rubber Moulds for Patterns on Concrete Panels & other Concrete Elements

Rib and Wave Patterns

1/42 Madeira
Named after a region in Portugal

2/29 Fulda
Named after a river in Germany

2/750 Sahara
Named after a desert in Northern Africa

2/63 Wisla
Named after a town in Poland

2/175 Friesland
Named after a region in Northern Netherlands

1/198 Traun
Named after a region in Austria

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All patterns on this page are available within 2 weeks Ex-Melbourne (Made in Melbourne)
Rib and Wave Patterns

2/75 Kocher

Named after a river in Germany

2/77 Tigris

Named after a river in Turkey

1/35 Rippe Type G

1/34 Rippe Type F

1/30 Rippe Type A

1/32 Rippe Type D

1/33 Rippe Type E

1/39 Rippe Type L

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Rib and Wave Patterns

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Rib and Wave Patterns

Manufacturers of Form-Liners & Rubber Moulds for Patterns on Concrete Panels & other Concrete Elements

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Geometric Patterns

2/112 Oriental 12 (See specs on page 55)
Manufacturers of Form-Liners & Rubber Moulds for Patterns on Concrete Panels & other Concrete Elements

Geometric Patterns

2/327 Aurillac
Named after a region in France

2/340 Miribel
Named after a region in Eastern France

1/138 Alsace
Named after a region in France

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Oriental and Eastern Patterns

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**Oriental and Eastern Patterns**

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Anti Slip Patterns

Manufacturers of Form-Liners & Rubber Moulds for Patterns on Concrete Panels & other Concrete Elements

2/178 Antislip

2/115 Pastillen

2/120 Rhombus

2/119 Pikes

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All patterns on this page are available within 2 weeks Ex-Melbourne (Made in Melbourne)
Ante Slip Patterns

Manufacturers of Form-Liners & Rubber Moulds for Patterns on Concrete Panels & other Concrete Elements

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All patterns on this page are available within 2 weeks Ex-Melbourne (Made in Melbourne)
Digital Form-liners (Made To Order)

DESIGN YOUR CONCRETE

A Digital concrete surface? RECKLI makes it happen! This is an innovative new design method onto concrete surfaces. New technologies allow photos, pictures and drawings, that can be imaged in the third dimension.

The Idea
The use of elastic RECKLI® Formliners for texturing the exposed face of concrete surfaces has attained a high degree of acceptance in terms of quality, ease of use and economic efficiency. Many millions of square metres of this type of finished concrete are the proof of this. The elasticity of our formliners removes the risk of damage to the hardened concrete allowing intricate detail to be used.

This system has given architects, planners and designers the freedom to realize unlimited ideas in their designs.

The new generation of Digital Formliners expands these possibilities in a previously unknown way.

It is unique in its application, based on geometrical representation of contours. Through different ups and downs it achieves third dimension effects. This is especially significant for indoor areas previously unknown to this application, since the visual effects are virtually impartial by the effects of light.

The Technique
The process is a computer based method for transferring image data onto sheet materials by means of milling technology.

At first a specially developed software converts pictures into a three dimensional milling file. The structure with its different levels, can then be transmitted by a computer controlled milling machine onto a plate material.

The milled model is used as a master for casting the elastic RECKLI® Formliners. Their elasticity, quality and reusability contribute to the aesthetics and the economic efficiency of the whole process and make it possible to recreate the image onto the concrete surface.

The templates are scalable, which allows the production of Digital formliners in any size. The size of the formliners is limited by the maximum dimensions (3m x 2m). Indeed it is possible to put more plates together to one common picture or to several parts of one picture. But please note that junctions will unavoidable lead to barely visible joint lines. Therefore we ask you to contact us for a clarification of this question in advance.

The applications are almost unlimited because almost any image in standard graphic formats can be used.

The result is a Digital texture of the concrete surface.
Manufacturers of Form-Liners & Rubber Moulds for Patterns on Concrete Panels & other Concrete Elements

Graphic Form-liners (Made To Order)

2/601 Charente
Named after a region in France

2/602 Saône
Named after a river in Eastern France

2/603 Vienne
Named after a region in France

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All patterns on this page are available within 2 weeks Ex-Melbourne (Made in Melbourne)

Non Standard Examples Of Graphic Designed Form-liners
(Made To Order)
Photo Engraved Form-liners (Made To Order)
Photo Engraved Form-liners (Made To Order)

61

Calistermon Pattern at Nambour Hospital, Northern Brisbane

Running Man Pattern at Victoria University (Footscray)

Changing the face of concrete

Photo Engraved Form-liners (Made To Order)
Photo Engraved Form-liners (Made To Order)

Riverstone Crossing Estate at Upper Coomera (North of Gold Coast, Queensland)

Photo Engraved Form-liners (Made To Order)
Photo Engraved Form-liners (Made To Order)
Manufacturers of Form-Liners & Rubber Moulds for Patterns on Concrete Panels & other Concrete Elements

Trends Patterns

2/186 Dolarna
Named after a region in Sweden

2/183 Gelderland
Named after a region in Netherlands

2/180 Steiermark
Named after a region in Austria

2/186 Dalarna

2/180 Steiermark

2/191 Burgenland
Named after a region in Austria

2/181 Burgenland

2/187 Abruzzo
Named after a region in Italy

Unavoidable production tolerances of +/- 2mm apply to heights/thickness of all profiles on this page.

All patterns on this page are available within 2 weeks Ex-Melbourne (Made in Melbourne)
Manufacturers of Form-Liners & Rubber Moulds for Patterns on Concrete Panels & other Concrete Elements

Trends Patterns

Unavoidable production tolerances of ±2mm apply to heights/thickness of all profiles on this page.

All patterns on this page are available within 2 weeks Ex-Melbourne (Made in Melbourne)
Custom Patterns (Made To Order)

Sand-dune at Peppermint Grove Library, South Perth

‘The Knot’ at North Richmond Community Health Centre, Melbourne

‘Circuit-board’ at Edith Cowan University, Joondalup, North Perth
Custom Patterns (Made To Order)

Dimples at Melbourne Convention and Exhibition Centre

Waves at Burinja Cultural Centre, Upwey (S.E Melbourne)

Sunburst at Sunshine Hospital, West of Melbourne
Custom Patterns (Made To Order)

Floral at Coment Bay College, South of Perth

Dragon Scales at Harbour 1, Docklands of Melbourne

Woolworths Shopping Centre, Phillip Island (S.E of Melbourne)
Custom Patterns (Made To Order)

Tyre Tracks, Noise Wall at Kings Rd and Calder FWY Interchange, Northwest of Melbourne

Sloping Pattern at Novotel Hotel, Brisbane Airport

Water Swirl at Victorian Desal, Wonthaggi, South East of Melbourne
Manufacturers of Form-Liners & Rubber Moulds for Patterns on Concrete Panels & other Concrete Elements

Custom Patterns (Made To Order)

National Centre 84 Hunter Road Derrimut, Victoria, 3030 Australia  M 0418 176 044  F 03 8361 7186  E australia@reckli.com.au  W www.reckli.com.au

Hex Noise Wall at Penninsula Link (S.E Melbourne)

Bluestone Stack Bond Fence at Garden House Apartments Carlton (North of Melbourne)

Hex Shapes on Noise Wall, Great Eastern HWY, Perth
Pre Cast Being Made With Reckli Form-Liners
Manufacturers of Form-Liners & Rubber Moulds for Patterns on Concrete Panels & other Concrete Elements

Pre Cast Being Made With Reckli Form-Liners
In-Situ Cast Preparations With Reckli Form-Liners

Man-Making of Form-Liners & Rubber Moulds for Patterns on Concrete Panels & other Concrete Elements

National Centre 84 Hunter Road Derrimut, Victoria, 3030 Australia  M 0418 176 044  F 03 8361 7186  E australia@reckli.com.au  W www.reckli.com.au
In-Situ Cast Preparations With Reckli Form-Liners

Manufacturers of Form-Liners & Rubber Moulds for Patterns on Concrete Panels & other Concrete Elements

National Centre 84 Hunter Road Derrimut, Victoria, 3030 Australia  M 0418 176 044  F 03 8361 7186  E australia@reckli.com.au  W www.reckli.com.au
Site Cast Preparations With Reckli Form-Liners
Site Cast Preparations With Reckli Form-Liners

National Centre 84 Hunter Road Derrimut, Victoria, 3030 Australia  M 0418 176 044  F 03 8361 7186  E australia@reckli.com.au  W www.reckli.com.au
CNC (Machine in Action) Making Master Moulds

National Centre 84 Hunter Road Derrimut, Victoria, 3030 Australia  M 0418 176 044  F 03 8361 7186  E australia@reckli.com.au  W www.reckli.com.au
Disclaimer:
All form-liner dimensions are nominal. Actual dimensions may vary slightly depending upon design. Despite our carefully controlled production processes, dimensional tolerances are unavoidable. Due to the high elasticity of our form-liners, they can also stretch and be compressed during packing and transport, which may add to dimensional variations.

All methods of concrete panel manufacture vary between all manufacturers and also at different times of the year, we recommend you adopt our suggestions outlined in our “Application Guideline for Reckli Form-Liners”.

Limited Warranty:
Reckli warrants their form-liners to be of uniform quality within manufacturing specifications and will perform as represented, provided that the concrete construction practices used are in accordance with our guidelines and installation instructions.

Reckli assumes no responsibility for any damage to form-liners due to the improper use or application of a non-Reckli form release agent. Our obligation under this warranty shall be limited to refunding the purchase price or replacing that portion of the material proven to be defective.

Reckli make no other warranty expressed or implied, including, without limitation, warranties of fitness or merchantability, with respect to its products.
Application Guideline for RECKLI Form-liners

1. Classification
We distinguish our formliners with the prefix numbers 1/.. and 2/.. The most important distinguishing features are listed in Table 1. There is also available another type of formliner with the prefix number 3/.. These formliners are for one use only. This working guide applies only to the formliners with the prefixes 1/.. and 2/.. For the OneTimer Formliners prefix number 3/.. there is a separate catalogue with the relevant guide.

2. Material
The formliners consist of rubber-like Polyurethane Elastomers. The high flexibility and elasticity allow a damage-free release of the concrete and exact reproduction of the pattern and allowing for undercuts and shallow grooves.

3. Delivery
For the formliners with the index 1/.. we deliver them flat on pallets or in chipboard boxes. The formliners 2/.. are rolled up on heavy duty cardboard rolls for transport and storage and wrapped in heavy brown kraft paper and/or polyethylene for extra protection against dirt. Depending on the size and weight they are additionally strapped to non-returnable pallets. (Picture 1)

4. Delivery Check
Upon delivery please check your consignment immediately for any damage sustained in transport. If you note any damage to your consignment you must describe it in detail on the delivery note and get the driver to countersign your comments. Before using the formliners first check the required dimensions as detailed on the package especially to the longitudinal direction (Id) of the pattern if here is one.

5. Storage
Before fixing all formliners must be stored dry and level to avoid deformation of the pattern. If using the 2/.. formliners loosely (not adhered) they can be rolled up tightly again onto the cardboard rolls after use. Make sure the formliners rolls do not have any heavy or sharp objects stored on top of them as this would lead to permanent deformation.

6. Transport
6.1 Boxes and pallets
The boxes and pallets with the formliners 1/.. can usually be transported and moved by fork-lift or crane. The pallets with the formliner rolls can also be transported and moved by fork-lifts or cranes.

6.2 Single formliner rolls
Up to a length of approx. 1.50 m the cardboard rolls can be lifted by placing the fork or forks of the fork-lift into the cardboard tube. For rolls of formliner in excess of 1.5 m it is necessary to use extension forks or a carpet ‘spike’ as otherwise the forks would pierce the cardboard roll and probably the liner as well. If using a crane for lifting make sure you use wide nylon lifting straps evenly distributed along the length of the roll. Do not use wires ropes or chains. For large size formliners it can be useful to place a steel tube through the cardboard roll, make sure you use separate lifting straps from each pole end to crane hook to ensure even lifting. (Picture 3)

7. Heat Resistance
The formliners can used in temperatures up to +65° C. Temperatures which exceed this value will damage the material. Should you expect a concrete temperature on the interface to the formliner of more than +65° C due to the concrete mass or other circumstances the mix design or other suitable actions should be adjusted to allow for the safe use of the formliner within its temperature constraints.

Table 1

<table>
<thead>
<tr>
<th></th>
<th>Formliners 1 /..</th>
<th>Formliners 2 /..</th>
</tr>
</thead>
<tbody>
<tr>
<td>Depth of structure*</td>
<td>&gt; 25 mm</td>
<td>1 - 25 mm</td>
</tr>
<tr>
<td>Maximum size*</td>
<td>approx. 1.00 m x 5.00 m</td>
<td>approx. 4.00 m x 10.00 m</td>
</tr>
<tr>
<td>Type of elastomer</td>
<td>normal γ = 1,4</td>
<td>normal γ = 1,4</td>
</tr>
<tr>
<td>Re-uses</td>
<td>50 times</td>
<td>100 times</td>
</tr>
<tr>
<td>Kind of delivery</td>
<td>Packed flat</td>
<td>Rolls</td>
</tr>
</tbody>
</table>

* The exact sizes you find in our catalogue under the photos of the pattern.
8. Pattern Design
There is no intended repeatability (with the exception of any of the rib type patterns) in the formliner patterns within the maximum mould size as compared to wallpapers. A number of patterns are designed in a way that they can be placed together side by side continuously. With a little care the joints in the patterns can be made almost invisible. (Picture 4+5)

For the building of our master moulds we use a combination of natural and man made materials of commercial grade quality which are formed using current standard working practices. Unavoidable tolerances, discrepancies and imperfections caused by the use of these materials can and will be reflected in the patterns of the formliners. The measurements shown in the sectional drawings under and beside the pattern photos in our pattern book are average values and nominal dimensions which have the stated tolerances. In using these sizes for the calculation of your requirements you should not expect that there is an equal repetition of measurements within the same formliner. The same criteria will apply whether you place two full sizes sheet formliners together or two or more ‘made to measure’ (smaller) formliners. Therefore it may be necessary to grind the formliners edges to even and level them or to thicken the seam area with RECKLI-Formliner Adhesive SO or RECKLIElasto Filler when required to place them horizontally next to another formliner. (see 20.2)

9. Cutting
9.1 Oversize and tolerances
Due to their high elasticity the formliners will be stretched or compressed during packing and transport which can lead to dimensional tolerances. Therefore, to protect the liner edges against damage we always supply the formliners oversized. They must be cut to their final dimension on site. It is always advisable to cut formliners a couple of millimetres longer than required for a tight fit against the formwork guide battens. (see 10.1)

The formliners should be cut to their final size directly before adhering to avoid size changes by stretching or shrinking due to temperature differences.

As with all highly elastic rubber-like materials the formliners are subjected to stretching after a long period of use. Therefore it may be necessary to re-cut the formliners to their original dimension from time to time. This of course will only apply if the formliners are not fixed by gluing.

Despite the most carefully controlled production process, dimensional tolerances of some mm in the rear wall thickness of the formliners is unavoidable. This is due to material and production factors which we are unable to negate. These dimensional differences are unavoidable whether you have a formliner produced in its maximum size or a smaller ‘made to measure’ formliner within the maximum size of the same formliner. Therefore it may be necessary to grind the formliners edges to even and level them or to thicken the seam area with RECKLI-Formliner Adhesive SO or RECKLIElasto Filler when required to place them horizontally next to another formliner. (see 20.2)

9.2 Formliners with prefix number 1/..
These formliners are normally supplied in fixed widths whereas the length/height (ld) is variable. If you have to put 2 or more formliners together (side by side) to reach a total area for the shutter or mould, cutting will probably be necessary. To make perfect cuts lay the formliners onto a flat, clean even surface and cut them using a suitable hand panel or circular power saw. (Picture 6) If using a power saw it is most important to allow the saw blade to rotate freely into the cut and during the cut. Keep the sawn material (waste part) pulled away from the blade to avoid it flapping against the rotating saw blade, otherwise heat will be generated and the formliner can burn. On long cuts it is a good idea to pull the power saw away from the cut and let the saw spin under power to dissipate any build-up of heat.

9.3 Formliners with prefix number 2/..
Roll out these formliners onto a flat, clean even surface and cut them with the...
Application Guideline for RECKLI Form-liners

10. Application in Pre-cast Concrete

10.1 Fitting the formliner to the formwork or mould

After cutting the liner lay it loose into the formwork/mould frame. The formliners with prefix number 1/.. should be cut with an over-size of 1-2 mm.

So that you can compress them into the dimension frame for getting a tight compressive fit all round.

The liners with prefix number 2/.. should also be cut to an oversize of 1-2 mm. It is easy to compress them so that they will be a tight fit around the edges of the formwork/mould.

RECKLI Formliner Knife. For a straight cut line please use a metal or timber straight edge. (Picture 7)

When cutting thicker pattern formliners do not try and make the cut ‘in one’ place the knife in the first cut and draw through the formliner gently as many times as required, do not use excessive force as this will lead to crooked cuts. We do not advise cutting these formliners with a circular power saw.

Note: It is very difficult to make mitred, bevel cuts with a knife to an unfixed formliner.

10.2 Fixing by adhering

Loose formliners have to be refitted into the mould after every cast. To avoid this you can glue the formliner on to the ‘tilt-up’ or vibrating tables (see 12.) This is always an advantage when you have to produce a series of elements of the same size. Loose formliners will also be more prone to stretching from their constant handling.

10.3 Setting & Placing the formwork/mould edges

You can of course place your form – work/ mould dimension frame directly on to the formliners which have shallow patterns or textures of approx. 1-2 mm. Patterns with a depth of up to 5 mm can be sealed sufficiently by a compression band.

For deeper patterns we suggest you make ‘pattern stop-offs’ (see 19.2) or in symmetrical patterns (ribs or waves) you can use the same formliner piece inverted. (Picture 10)

Please Note: If the frame is pressed too firmly on to the formliner for too long, there will be a permanent depression in the formliner giving a noticeable difference to the pattern if and when the frame has to be moved to a different part of the formliner.

10.4 Vibration

It is possible that the frequencies of an external vibrator can make the formliner ‘flutter’ and draw air under the formliner. This can result in air ‘cushions’ or ‘bubbles’ in the formliner which can lead to indentations in the concrete surface. Therefore the vibrator and its vibration frequency must be checked and adjusted correctly.

10.5 Stripping/Striking

Formliners that are laid loose in the mould are generally removed from the concrete elements and replaced back into the moulds ready for reuse. Care should be taken during the stripping/striking process that the formliner will not fall off the concrete element when the tilting table is in the vertical. The formliner would almost certainly be damaged. (Picture 11-13) To avoid this happening you can glue the liners onto the formwork/tilting table. (see 12.)
11. Application for In-situ Concrete

11.1 Fixing by adhering
When used for in-situ concrete the form-liners must be glued down. (see 12.)

11.2 Fixing by nails
For minimum use or the immediate change of shutter sizes after the first pour, the formliners with prefix number 1/.. can be nailed onto the formwork. The nail centres should be approx. 20-25 cm. Use ‘lost heads’ or ‘ovals’ nails so that it is possible to pull the nail heads through the formliner during stripping/striking. Depending on the pattern or texture always nail through the high points of the pattern. This will ensure that nail holes are in the negative part of the concrete and not so easily noticed.

The formliners with prefix number 2/.. should not be nailed to the formwork. Due to the weight of the formliners there would be too much weight placed on the nails when lifted into the vertical position and this can result in the formliner tearing.

12. Adhering

Please Note: It can be to your advantage to glue the formliners onto plywood sheets and use these sheets as auxiliary/‘slave’ formwork which you can then fix onto your load bearing formwork or casting table. The plywood can be fixed from the rear using wooden screws. The plywood can easily be removed from the load bearing formwork after use. It will also be easier to store and dispose of the formliners when they are glued to plywood.

12.1 Principles of fixing
RECKLI-Formliners must adhere completely. The easiest surface to glue on to is the horizontal surface. Other shutter/mould applications which you might encounter might be inclined, (Picture 17) half or quarter columns etc. On vertical or rounded surfaces the adhesive would flow down to the lowest point leaving insufficient adhesive for a complete fixing. In these applications the Formliner Adhesive should be thickened with our RECKLI-Standardiser 100 to make it more ‘pasty’. Please ask for our special advice.

12.2 Adhesive
RECKLI-Formliner Adhesive SO is not a contact adhesive. It is a 2-component adhesive. The mixing ratio is 4:1 by weight. For mixing the adhesive a slow speed electric drill with the correct mixing paddle should be used. (Picture 14) The base solution must be mixed first. The hardener is then added to the base solution and mixed thoroughly. To avoid any ‘soft spots’ or uncured material the adhesive must be placed into another empty, clean container and mixed again. (Picture 15+16)

You should use only as much adhesive as you can work with within the pot-life. The pot-life depends on the ambient temperature but as a rough guide you will have approximately 30-40 minutes at 18-20° C.

Adhesive consumption is approx. 750-1000 g/m2. After 24 hours the adhesive is cured. You should give a longer curing time during winter periods with lower temperatures. The formwork, mould or the tilting table can no longer be used.

12.3 Surface / Formliner rear
All surfaces that you wish to adhere to must be even, clean and dry. Any grease, oil or mud should be sanded off the shutter not washed off. A superior bonding of the formliner to the shutter will be achieved if you sand the rear of the formliners. (Picture 18) A light sanding which will roughen the rear will be sufficient. (12.4.1.1 or 12.4.2.1)
12.3.1 Timber
The most suitable foundation for RECKLI Formliners are new clean untreated plywood sheets designated as suitable for shuttering. (Picture 19) Resin coated plywood plates must be ground off to the rough timber surface.

12.3.2 Steel
Steel must be rust free and the work will benefit from a light sand-blast. If this is not possible the minimum should be the use of an angle grinder to the surface. When using RECKLI Formliner Adhesive SO no primer is required.

12.4 Adhering
12.4.1 Formliners with prefix number 1/..
12.4.1.1 Roughening of the formliner rear
Lay the formliners onto their patterned surface for roughening the rear by using a grinding machine. Circular grinding machines or belt sanders are better suitable for this work than vibratory grinders. The grinding dust must be removed completely by sweeping or rubbing off or by blowing off with compressed air.

12.4.1.2 Checking dimensions with a ‘Dry run’
Lay the liners loosely onto the surface to be adhered, adjust them and check against your measurements. Lay out a temporary right angle on to your shutter/mould and lay the liners against this frame. Remove and stack the formliners onto a clean surface.

12.4.1.3 Adhering/Gluing
After mixing the RECKLI-Formliner Adhesive SO (see 12.2) pour it onto the surface to be glued and spread the adhesive evenly over the surface using the supplied serrated trowel. (Picture 19+20) Take care that you spread the adhesive equally. Spread only so much adhesive over the formwork surface as you need for the gluing of one formliner or that you can work with within the adhesive’s pot life. Make sure that the edges of the formliner have sufficient adhesive as this is the most critical area of stress when stripping and concrete will always try to enter at the edge of the glue line and get behind the formliners. Lay the formliner onto the fresh adhesive along the temporary right angle. (Picture 21) Please take care that there are no air bubbles under the liner. The best way to avoid this is by sliding the formliner backwards and forwards on the adhesive. Then apply the adhesive for the next liner. Press the liner against the first one making sure you coat the vertical surface of the first formliner with adhesive to give a grout free join. (Picture 22) Any surplus that has been squeezed out can be wiped off after fixing or left to dry and sanded down.

Carry on in this order until you reach your total shutter requirement. When fixing the formliner onto the shutter check that the formliners will reach the required point on the shutter/mould. Use rips of plywood / wood and pin down edges of liner to prevent them from lifting. You need gentle pressure on the edges for 24 hrs. minimum. Nail through the liner into the plywood. Note: Do not drive the nails home, excessive pressure will raise the edge of the formliner and take it out of contact with the shutter. If using steel shutters use weight on the timber/ply rips.

12.4.1.4 Gluing onto vaulted or curved surfaces
The formliners 1/.. are flexible and can be deformed to various degrees to accommodate shutter and mould shapes but because they are flexible and have a ‘spring’ value you will have to support/contain the formliners to the shutter/mould profile until the adhesive cures. To reduce the ‘spring’ in the formliner you can cut kerfs in the rear of the formliner which makes curving the formliner easier, on extreme curves you can cut V’s in the back of the liner. The depth of these cuts will depend on the thickness of the formliner. Cut only into the rear thickness of the formliner do not cut near the pattern thickness. (Picture 23+24)
12.4.2 Formliners with prefix number 2/..
12.4.2.1 Roughening of the formliner rear
Before gluing/adhering the rear of the formliner must be roughened. Lay the formliners onto their patterned surface for roughening the rear by using a grinding machine. Circular grinding machines or belt sanders are better suitable for this work than vibratory grinders. The grinding dust must be removed completely by sweeping or rubbing off or blowing off with compressed air. Then turn the formliner back onto its rear side and roll it up again on to the ‘transport jacket’ (cardboard roll) making sure that formliner is in the right position to be rolled out onto the Formliner Adhesive and shutter. The use of the stripping jackets will make it easier to move the formliners around the working area.

12.4.2.2 Checking dimensions with a ‘Dry run’
Roll the liner loosely onto the surface to be adhered, adjust and check against your measurements. If necessary mark reference points on the shutter/mould. Lay out a temporary right angle on to your shutter/mould and lay the liner against this frame. Roll the liner loose onto the surface to be adhered and straight and fit it exactly. Take note of any pattern that has parallel ribs or grid details.

12.4.2.3 Adhering/Gluing
Mix the adhesive (see 12.2) pour it onto the shutter/mould surface, spread the adhesive with a serrated trowel. Lifting the formliner by its stripping jacket, place it next to the start of the vertical part of the right angle ‘setting out’ frame roll the liner slowly onto the fresh adhesive.
Make sure that the edges of the formliner have sufficient adhesive as this is the most critical area of stress when stripping and concrete will always try to enter at the edge of the glue line and get behind the formliners. Please take care that there are no air bubbles under the formliner.
For the fixing of large formliners or when there is a shortage of manpower an alternative method of fixing you might employ could be this.
After the ‘Dry-run’ roll up the formliner again with the cardboard roll until in the middle of the shutter. Then mix the formliner adhesive (see 12.2) and pour it in front of the rolled up half of the formliner and spread it equally over a strip of approx. 75-100 cm along the length of the liner. (Picture 25+26)

An even and uniform thickness of the adhesive is most important. Check against excess adhesive which can lay in pools.
In moving the adhesive with the serrated trowel you should look for the distinctive ‘tram-line’ effect on the adhesive the shutter/mould surface should be clearly visible.
Now roll the liner onto the fresh adhesive and repeat the pouring, spreading and rolling the liner along the shutter/mould strip by strip until you reach the end of the first liner half. Make sure that there are no air bubbles under the formliner. Press out the air to the front and the sides. During fixing check that you are reaching your datum/pattern points on the formliner or the parallel running of ribs or joints if there are any in the patterns.
Now roll up the second half of the liner to its middle until you reach where you have started spreading the adhesive for the first half and repeat the first half procedure until you reach the end of the second formliner half.

12.5 Removal of glued formliners
When the formliner adhesive has been mixed and applied correctly the fixing should be considered permanent.
The removal of glued formliners should be considered a major task and would be very difficult to remove them from the shutter/mould without damage to the formliner.
Therefore it can be an advantage not to glue the formliner directly onto the structural formwork but onto separate plywood sheets as ‘slave’ formwork and then to fix these to the structural formwork.
If it is absolutely necessary to remove formliners from the shutter/mould you can use the peel-off method. Cut in at the glue line on one corner pulling the formliner up and cutting away at the glue line carry on until you have a large enough piece of formliner to attach a clamp to which can be attached to a crane, fork lift etc. to apply more force while cutting away at the glue line. Any residue can be sanded off the shutter and formliner with a belt sander.
13. Release Agents

13.1 Choice of release agent
The choice and application of the correct release agent is most important to obtain an efficient release and high quality concrete finish. We supply three different release agents depending on the application.

RECKLI-Stripping Wax TL contains solvents.
RECKLI-Stripping Wax TL-W is water-based.
These two release agents are more suited to pre-cast concrete. RECKLI-Stripping Wax TL-SO also contains solvents and is especially designed for in-situ concrete. (Table 2)

13.2 Application
The stripping wax must be brushed or sprayed on a minimum two times. (Picture 27) The release agent should be applied laterally and longitudinally. It is most important that in any rib patterns the vertical part of the ribs should be sprayed at 45° from both sides of the formliner to ensure correct coverage. Surplus wax must be removed by a brush or clean cloth. You can also blow it off with compressed air.

13.3 Protection of the wax film against weathering
After evaporation of the solvents in Stripping Wax TL and TL-SO or the drying of the water-based Wax TL-W you can use the formliner/mould. To avoid any damage by rain and weather to the wax film you should protect the liners with polyethylene or any light plastic covers. (Picture 28) If the wax film has been reduced or damaged it should be reapplied.

Note: You will find that a ‘fan’ spray will give the best and most even application of the Stripping Wax’s TL and TL-SO. Make sure that your sprayer has solvent resistant gaskets.

14. Bar spacers
Bar spacers that offer the largest contact areas should be used. Chair type spacers give a point loading and will press into the formliner (Picture 29) and will therefore show through the concrete. The minimum concrete covering over the reinforcement is always measured from the deepest point in the concrete surface. Therefore the bar spacers must be set onto the highest points of the formliner pattern. It is of great advantage to hang up the reinforcement for avoiding a loading of the liners. (Picture 30)

15. Concrete Casting
RECKLI Form-liners allow the use of all types of cement based concrete. When using external vibrators you should note that some of the vibration frequencies will be absorbed by the elasticity of the formliner. This can be compensated for by a longer vibration time.

Table 2

<table>
<thead>
<tr>
<th>Application</th>
<th>Type</th>
<th>Consumption per coat</th>
</tr>
</thead>
<tbody>
<tr>
<td>Pre-cast concrete</td>
<td>RECKLI-Stripping Wax TL contains solvents</td>
<td>50 - 100 g/m² ² 2 coats required</td>
</tr>
<tr>
<td>Pre-cast concrete</td>
<td>RECKLI-Stripping Wax TL-W water-based</td>
<td>50 - 100 g/m² ² 2 coats required</td>
</tr>
<tr>
<td>In-situ concrete</td>
<td>RECKLI-Stripping Wax TL-SO contains solvents</td>
<td>50 - 100 g/m² ² 2 coats required</td>
</tr>
</tbody>
</table>
16. Striking / Stripping

16.1 Striking / Stripping timing
It is easier to release RECKLI-Formliners within 24 hrs of casting. Specification and striking times for your particular application should overrule RECKLI’s suggestion.

16.2 Unfixed formliners
Formliners that are laid loosely in the mould will peel off of the concrete during stripping due to their weight. (Picture 11-13) If this should not happen due to the depth of pattern, peel off the liners carefully starting from a corner. Do not tear at the formliner, doing so could exceed its stretching capacity.

16.3 Adhered formliners
Release the pre-cast concrete elements from their moulds or the shutter from the concrete.

If, for any reason it becomes necessary to clean the formliner, take a dry, clean rag and soak it with the relevant Stripping Wax and clean off any cement splashes or dirt on the formliner.

17. Cleaning

17.1 Formliner surfaces
When the formliners are provided with the correct amount of Stripping Wax the formliner will be clean and ready for reuse after striking/stripping. Reapply more Stripping Wax ready for the next cast.

17.2 Tools and equipment
For cleaning tools and equipment after use, use RECKLI-EK-PU Thinner. Clean thoroughly while the formliner adhesive is fresh. Use a brush, it is not sufficient to lay the tools in the thinner. You will not be able to remove the cured 2-component material once it has hardened.
18. Joints / Corners / Edges
18.1. Use of profiled fillets
Profiled fillets for shaping corners, edges and joints should be considered. You must calculate the thickness of the profile as to what part of the pattern it is required to be aligned to i.e., top, middle or bottom. The thickness of the formliner back must also be considered. (see sketch 1-5) (Picture 36-39)
18.2 Formliner joints

When placing formliners with coarse or rank patterns side by side care must be taken to see that the joints from this operation are sealed correctly. RECKLI-Formliner Adhesive can be used after you have glued the formliner down. You can also use standard building One Component Silicone applied to the formliner when the adhesive has cured. We do not advise butting or mitring formliners together for 90° corners for such kind of patterns. They will never look good. Make a feature at the corners by introducing a plain band to the pattern, the corner will look sharper and straighter. The formliner will also have a straight line to finish to. (see sketch 6-9)

Of course for patterns with straight lines like ribs and waves it is of advantage to cut the liners mitred for 90° corners. (Picture 40+41)
19. Stop-offs / Counter impressions

19.1 Cuts out
Pattern stop-offs for i.e. windows, doors or lighting can be formed by cutting out the shapes in the formliners and inserting a frame. This is suitable if the same openings are to be used in the same position for every use of the formliner. (Picture 42)

19.2 Pattern stop-offs using RECKLI-Mould Paste PU
If they are to be used once or twice or the formliner needs to be used in a different position then RECKLI-Mould Paste PU should be used. (Picture 43+44)
Select the area for the pattern stop-off and paint on RECKLI-Mould Wax exceeding the area by at least 100 mm all round. On textures, shallow patterns deep ribs place a frame larger than the required stop-off. Use clay or Plastercine to fill in the space between the bottom of the frame and the pattern detail.
On deep rib patterns, to save material block off with timber pieces. Paint the frame, clay, Plastercine with a coat of Mould Wax. Mix and pour the Mould Paste PU inside the frame forcing the material into the pattern detail with a spatula. You can mix and pour wet on wet material to reach the required level which should be approx. 6mm higher than the highest part of the pattern. Place a clean dry board onto the fresh Mould Paste PU making sure it is level. Leave to harden.
When hardened remove from formliner and trim off surplus material for sharp square or cut bevelled edges.

19.2.1 Properties of RECKLI-Mould Paste PU
RECKLI-Mould Paste PU is a pasty elastic 2-component material. The mixing ration is 1:0.1 by weight. If using only part quantities from a drum the amounts of base solution and hardener must be weighed out, never mix by volume. For mixing use a slow speed electric drill with the correct mixing agitator.
Mix only so much paste as you can work with within the pot-life. The pot-life is approx. 10-15 minutes depending on temperature. The curing time is approx. 1 hour. The consumption depends on the type of pattern.
The specific weight is approx. 1.4 g/cm³.

19.2.2 Removing of mould wax residues
To avoid different colours in the finished concrete, the area treated with RECKLI-Mould Wax must be removed and cleaned by using RECKLI-Stripping Wax. Soak a clean cloth with RECKLI-Stripping Wax TL, TL-SO or TL/W and wash and clean off the areas where the Mould Wax remains.
If this procedure is not carried out carefully, colour differences in the finished concrete surface should be expected.

19.3 Inverted formliners
For symmetrical patterns (ribs or waves) you can use the same formliner pieces inverted for stop-offs. (Picture 10)

20. Repairing / Patching & Equalizing of Formliners

20.1 Repair
With RECKLI-Elasto Filler you can patch and repair damaged or torn formliners. To get a correct bonding of the Elasto Filler to the formliner the damaged area holes or tears must be clean, dry, dust, oil, wax and grease free. The area to be repaired or filled must be roughened by sand paper.
The filler must be applied quickly and within the pot life time. Surplus material must be removed while the material is still fresh. The area to be repaired or filled must be roughened by sand paper.
Under the tear lay a piece of polyethylene to avoid unwanted bonding of the paste. Apply RECKLI-Elasto Filler to the sides of the tear and press the tear together.
Surplus filler can be removed with cloth or spatula and is best removed while fresh. Cured filler you can only remove by sanding or cutting. After curing turn the liner on to its front side. Grind out 3-5 cm left and to the right of the tear line and approx. 3 mm deep. Fill this recess with the Elasto Filler and smooth it. After 2-3 hours hardening it can be ground level. Turn the formliner back onto its rear and apply RECKLI-Stripping Wax to the repaired area.

Note: We must categorically point out that a repaired seam cannot possibly give the same result as an undamaged formliner. There is always the possibility of the repaired formliner tear showing through in the patterned surface even when the repair has been carried out extremely careful.
20.1.2 Properties of RECKLI-Elasto Filler
RECKLI-Elasto Filler is composed of 2 liquid components. The mixing ratio is 8:1 by weight. After mixing the hardener with the base component a thixotropic action will take effect after about 2-3 minutes. The thixotropic effect increases until the end of the materials workable time. In this time RECKLI-Elasto Filler can be used as a pourable material and as a filler. The pot-life takes approx. 10 minutes at +18°C. The layer thickness can be up to 10 mm in one application. Consumption depends on the area to be repaired. The specific weight is approx. 1.4 g/cm³.

Note: To extend the workable time of Elasto Filler spread the mixed filler onto a board as a thin coat.

20.2 Equalizing of formliner rears
As already mentioned (see 9.) dimensional tolerances of some mm in the rear wall thickness of the formliners is unavoidable. Therefore, sometimes it is necessary to adjust the thickness of the formliner rear. This you can do by grinding down the thicker one or by increasing the thickness of the thinner one. Turn the liners on to their pattern sides put them together and grind or sand down the thicker parts along the edges in a flat strip until you have reached the thickness of the thinner formliner. (Picture 46)

Be sure to ‘feather’ away the grinding or sanding to the centre of the formliner so that you do not leave a step. When the difference of the rear thickness is too big, it could be easier not to grind the formliner down but to increase the thickness of the thinner one. Turn the liners on to their pattern side. Clean the area to be levelled by grinding or sanding this also acts as preparing the foundation.

Place a piece of timber along the edge to be levelled to the required height. Paint the board with RECKLI-Mould Wax allow to dry and fix along the formliner edge which you wish to fill level. Mix the RECKLI-Formliner Adhesive SO (see 12.2) and pour it onto the roughened rear part of the formliner. (Picture 47)

Being a liquid it should find its own level. Take RECKLI-Elasto Filler (see 20.1.2) for the levelling material when the area to be levelled is not too large. (Picture 48)

After the Formliner Adhesive or the Elasto Filler has cured remove the board along the formliner edge. If necessary grade the repair into the formliner by grinding or sanding which will also remove any high spots. The formliner is now ready for use. (Picture 49)

21. Waste disposal
RECKLI-Formliners are made from Polyurethane Elastomers.
The code of the European Waste Register is 12 01 05.
Application Guideline for RECKLI Form-liners

22. Product & Consumption Table

22.1 Material - Please refer to the relevant technical pamphlets, too.

<table>
<thead>
<tr>
<th>Material</th>
<th>Application</th>
<th>Consumption</th>
</tr>
</thead>
<tbody>
<tr>
<td>RECKLI-EK-PU Thinner</td>
<td>Cleaning of tools and equipment</td>
<td>Depending on the degree of contamination</td>
</tr>
<tr>
<td>RECKLI-Elasto Filler</td>
<td>Repair of damaged formliners and equalizing of formliner rears</td>
<td>Depending on the volume of damage or filling, $\gamma = 1.4$</td>
</tr>
<tr>
<td>RECKLI-Formliner Adhesive SO</td>
<td>Adhesive for full entire surfaces on steel or timber and equalizing of formliner rears</td>
<td>Approx. 750-1000 g/m$^2$</td>
</tr>
<tr>
<td>RECKLI-Mould Paste PU</td>
<td>For making pattern stop-offs</td>
<td>Depending on the pattern, $\gamma = 1.4$</td>
</tr>
<tr>
<td>RECKLI-Mould Wax</td>
<td>Release agent for RECKLI-Mould Paste PU and for steel or timber gauges while equalizing of formliner rears</td>
<td>Approx. 150-200 g/m$^2$</td>
</tr>
<tr>
<td>RECKLI-Standardiser 100</td>
<td>Thickener for Formliner Adhesive for gluing on vaulted or curved surfaces</td>
<td>1-5 %</td>
</tr>
<tr>
<td>RECKLI-Stripping Wax TL</td>
<td>Release agent for pre-cast concrete, contains solvent</td>
<td>Approx. 100-150 g/m$^2$ depending on the pattern</td>
</tr>
<tr>
<td>RECKLI-Stripping Wax TL-SO</td>
<td>Release agent for in-situ concrete, contains solvent</td>
<td>Approx. 100-150 g/m$^2$ depending on the pattern</td>
</tr>
<tr>
<td>RECKLI-Stripping Wax TL-W</td>
<td>Release agent for pre-cast concrete, water-based</td>
<td>Approx. 100-200 g/m$^2$ depending on the pattern</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Tool / Equipment</th>
<th>Application / Use</th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>Boards / rips / laths</td>
<td>Restraining of formliner during and after adhering, boards for pressing into Mould Paste PU for stop-offs</td>
<td></td>
</tr>
<tr>
<td>Brush</td>
<td>Cleaning tools</td>
<td></td>
</tr>
<tr>
<td>Buckets</td>
<td>To decant after mixing 2-component material in original container</td>
<td></td>
</tr>
<tr>
<td>Circular grinder / belt grinder</td>
<td>Removing residue of adhesive film / grinding rear of formliner for better bonding / grinding of recesses for strengthening of repaired tears / equalizing of formliner rear</td>
<td></td>
</tr>
<tr>
<td>Cloth / rags</td>
<td>Removing of Mould Wax residues while using Mould Paste PU / soaking up of surplus of Stripping Wax</td>
<td></td>
</tr>
<tr>
<td>Gauging/pointing trowel</td>
<td>Scraping material from pails or drums</td>
<td></td>
</tr>
<tr>
<td>Hand circular saw</td>
<td>Cutting of formliners index 1/.. and pattern stop-offs</td>
<td></td>
</tr>
<tr>
<td>Marker-pencil</td>
<td>Marking of stop-off lines</td>
<td></td>
</tr>
<tr>
<td>Metal / wood straight edges</td>
<td>Straight edges for cutting liner index 2/..</td>
<td></td>
</tr>
<tr>
<td>Mixing paddle</td>
<td>For electric hand drilling machine for mixing 2-component material</td>
<td></td>
</tr>
<tr>
<td>Polyethylene</td>
<td>Protection of formliners and Stripping Wax application against weathering</td>
<td></td>
</tr>
<tr>
<td>RECKLI-Formliner Knife / hand panel saws</td>
<td>Cutting of formliner index 2/..</td>
<td></td>
</tr>
<tr>
<td>Sandpaper</td>
<td>Cleaning and sanding of formliners / removal of surplus Elasto Filler and levelling of repaired areas</td>
<td></td>
</tr>
<tr>
<td>Screw clamps</td>
<td>To apply pressure to boards while Formliner Adhesive cures / clamp preparation for peeling off of glued formliners</td>
<td></td>
</tr>
<tr>
<td>Serrated trowel</td>
<td>Spreading of Formliner Adhesive</td>
<td></td>
</tr>
<tr>
<td>Slow speed electric hand drill</td>
<td>Mixing of 2-component material</td>
<td></td>
</tr>
<tr>
<td>Spatula</td>
<td>Mixing and application of Elasto Filler, cleaning and pointing joint lines and smaller quantities of Formliner Adhesive</td>
<td></td>
</tr>
<tr>
<td>Spray</td>
<td>Application of Stripping Wax</td>
<td></td>
</tr>
<tr>
<td>Stanley or RECKLI-Formliner Knife</td>
<td>Peel off of adhered liners from form-work</td>
<td></td>
</tr>
<tr>
<td>Tape measure</td>
<td>Checking of formliner measurements</td>
<td></td>
</tr>
<tr>
<td>Weighing scales</td>
<td>Weighing out of smaller quantities of 2-component materials</td>
<td></td>
</tr>
</tbody>
</table>
For the production of premium exposed aggregate concrete, available in different washing depths

**RECKLI CR Type N**

is a solvent-based concrete surface deactivating agent used to produce fine to coarse exposed aggregate concrete using the negative or positive process. RECKLI CR Type N is available in 3 different washing depths. (Light / Medium / Heavy)

**Benefits:**
- Homogeneous washing pattern
- Quick and easy washing
- Low consumption
- Very short drying time
- Easy formwork cleaning

**Areas of Application:**
- Architectural façade elements
- Precast concrete elements
- Cast-in-place concrete elements
- Roughening of separating joints
- Cast stone and general concrete products

Please follow the instructions of the corresponding technical data sheet when applying the product.

<table>
<thead>
<tr>
<th>RECKLI CR Type N</th>
<th>Colour</th>
<th>Aggregate size</th>
<th>Washing depth</th>
</tr>
</thead>
<tbody>
<tr>
<td>Light</td>
<td>brown</td>
<td>2-4/8 mm</td>
<td>Approx. 1.0 mm</td>
</tr>
<tr>
<td>Medium</td>
<td>grey</td>
<td>8-12 mm</td>
<td>Approx. 3.0 mm</td>
</tr>
<tr>
<td>Heavy</td>
<td>red-violet</td>
<td>16-22 mm</td>
<td>Approx. 6.0 mm</td>
</tr>
</tbody>
</table>

Washing depths are approximate only. They depend on the cement grade, w/c ratio, aggregate mix and powder ratio. We will be pleased to assist you with the selection of the most appropriate type.
of the Customer to more particularly describe the security interest conferred by this clause.

3.7 Where in the period between acceptance of an offer and delivery of the relevant Goods, Reckli incurs an increased in the cost of recovering or remediating the Goods or the Customer incurs an increased cost to increase the offered price of these Goods at any time prior to delivery (a “price escalation”), provided that the Customer may, if it does not agree to the price escalation, terminate or part of all the contract within 7 days after receiving notice of the price escalation.

2.8 These Conditions of Trade apply to the exclusion of any terms and conditions of trade of the Customer whether or not any inconsistency arises, and bind the Customer both personally and as trustee of any trusts of which the Customer is a trustee.

3.0 Specifications and Working Documentation

3.1 If the Customer’s order refers to a Specification or Working Documentation:

(a) the Customer represents and warrants to Reckli that any such Specification or Working Documentation does not and any Goods produced by Reckli pursuant to such Specification or Working Documentation will not breach or infringe any图文摘取的限制，包括但不限于专利、版权、设计、版权或其它知识产权权利和 Reckli 生效的其它限制。

(b) the Customer delivers Reckli from and waives any rights or causes of action it may have had or against any loss, damage, liability or cost suffered or incurred by Reckli arising out of or by the Customer’s failure to comply with, or out of the terms of the Specification or Working Documentation provided by the Customer to Reckli; and

(c) the Customer indemnifies Reckli and must hold Reckli harmless from and against any loss, damage, liability or cost suffered or incurred by Reckli arising out of or by the Customer’s failure to comply with, or out of the terms of the Specification or Working Documentation provided by the Customer to Reckli; and

8.1.1 An CCA or any other legislation implies a condition or warranty into these Conditions in respect of goods supplied to the Customer for the sale or supply of Goods or Services or both and, without limitation, withhold any deliveries of the Goods or Services until the Goods or Services are supplied to the Customer.

9.4 If the CCA or any other legislation implies a condition or warranty into these Conditions in respect of goods supplied to the Customer for the sale or supply of Goods or Services or both and, without limitation, withhold any deliveries of the Goods or Services until the Goods or Services are supplied to the Customer.

9.1 These Conditions set out the entire agreement between the parties in relation to their subject matter. The Customer’s advice is reasonable and the Customer has not used the Goods, replace the Goods immediately upon delivery of new Goods;

9.2 Reckli may, at any time, without cause, vary, suspend, limit or withdraw any credit granted to the Customer.

11.5 The Customer must not disclose Reckli’s Confidential Information unless the Customer receives the prior written consent of Reckli.

11.4 The Customer is liable and must hold Reckli harmless from and against all costs and expenses, including solicitors fees on an indemnity basis) incurred by Reckli in connection with these Conditions, the exercise or attempted enforcement of these Conditions or Reckli’s rights and remedies hereunder, any claims, actions, suits or proceedings, whether tortious, statutory or otherwise, brought by Reckli or its customers or suppliers, or Reckli’s indemnities to the Customer and all its Related Corporations;

11.3 The Customer must not sell, assign, charge or otherwise encumber, any of the Goods or any part or parcel of them (including any of the provisions specified in clause 8.2).

12.0 Jurisdiction

12.6 The Customer must not disclose Reckli’s trade标记 or the name of any person or firm in connection with these Conditions. The parties irrevocably submit to the nonexclusive jurisdiction of the courts of Victoria.

1.0 Definitions & Interpretation

1.1 Accession means any Goods which are installed in or affixed to other goods; ACL means the Australian Consumer Law in Schedule 2 to the Competition and Consumer Act 2010 (Cth); 1.2 Reckli provides the Customer with a bill of lading or similar document at the Customer’s request or where it is customary in the trade and in the form used by the Customer;

(b) must store the Goods and such part of the Processed Goods separate from its own goods and those of any other third party such in a safe place as to clearly indicate at all times that the Goods and such part of the Processed Goods are owned by Reckli;

(c) in the case of a supply of Goods, Reckli doing any one or more of the following (at its election):

1.1.2 Customer means the party to the contract who is not a Related Corporation of Reckli or a Related Corporation of the Customer and the Customer (including the Customer’s Related Corporations) as the case may be;

1.3.1 Goods means anything tangible which is to be supplied by Reckli to the Customer under this contract and includes any Good or part or parcel of a Good;

1.3.2 Goods delivered by Reckli shall be supplied by Reckli after the terms in regard to quantity, weight, dimension and chemical-composition as specified in the relevant order or, if not specified, as consistent with usual industry practice. Where the total mass or length of any item supplied includes a fraction of a tonne, the Customer must pay for that fraction on a pro-rata basis.

1.0 Definitions & Interpretation

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2.0 Offers, Orders & Requests

2.1 A written offer issued by Reckli to the Customer is an invitation to the Customer to purchase. A written offer extends on the date of issue and shall be valid for 21 days from the date of issue.

2.2 Reckli may revoke, modify or vary a written offer at any time prior to the Customer submitting and Reckli accepting an offer only by way of another offer in response to the invitation to purchase comprised by Reckli’s written offer.

2.3 A contract for the supply of Goods is made when Reckli communicates in writing its acceptance of the Customer’s offer.

2.4 An order from the Customer on terms which are inconsistent with the terms of a written quotation is an offer to the Customer to buy Goods from Reckli. In those circumstances, a contract for the supply of Goods is made if:

(a) Reckli communicates that it is prepared to supply the ordered Goods only on the terms of these Conditions and;

(b) the Customer accepts delivery of the ordered Goods in which case the contract is deemed to have been made as at the date of the Customer’s order.

2.5 A contract is made pursuant to section 2.1 or 2.4 is wholly documented by any specific terms agreed by Reckli and the Customer in writing including, without limitation, in a quotation and these Conditions.

2.6 To the extent that any inconsistency arises between the terms of an offer and any clause of these Conditions, the terms of this contract shall prevail to the extent of the inconsistency.

2.7 Where in the period between acceptance of an offer and delivery of the relevant Goods, Reckli incurs an increased cost of recovering or remediating the Goods or the Customer incurs an increased cost to increase the offered price of these Goods at any time prior to delivery (a “price escalation”), provided that the Customer may, if it does not agree to the price escalation, terminate or part of all the contract within 7 days after receiving notice of the price escalation.

6.3 The amount of any cost recovery or compensation for costs under or in connection with these Conditions, the exercise or attempted enforcement of these Conditions or Reckli’s rights and remedies hereunder, any claims, actions, suits or proceedings, whether tortious, statutory or otherwise, brought by Reckli or its customers or suppliers, or Reckli’s indemnities to the Customer and all its Related Corporations;
To unlock the full potential of this document, you may need to consider: 
- The context and purpose of the document.
- The relationships between the different sections.
- The implications of the terms and conditions for stakeholders, such as customers and suppliers.
- The legal and regulatory framework governing the document.

This approach will help you better understand the document's content and its implications.
...Why Reckli?
- **Reliability** ... German quality.
- **Experience** ... We've been making moulds since 1968.
- **Care** ... We are focused on the best visual result.
- **Know how** ... We've been involved in Thousands of projects worldwide.
- **Local office** ... Supported by an international network with offices in over 56 countries.
- **Integrity** ... Be assured that we will work ethically and professionally.