

Processing

100 g powder : 30 ml distilled / demineralised water.

The amount of water can be increased or decreased by up to 1,5 ml. With less liquid the expansion will increase, the stone will be harder and the working time will be shorter. More liquid has the reverse effect.

Please take care only to mix enough plaster that is required for three to four models (this is important for crystallization!).

Empty plaster into mixing beaker and then add water. Slowly stir by hand until powder and liquid are well mixed, then mix through with the spatula for 45 seconds.

Total manual mixing time 60 sec.

Technical data:	Brinell hardness after 2 hours (MPa; N/mm ²).....	100
(applies for a mixing ratio	Brinell hardness after 24 hours (MPa; N/mm ²).....	110
of 100 g : 30 ml)	Compressive strength after 1 hour (MPa; N/mm ²).....	44 (6,380 psi)
	Setting expansion (%).....	0,15
	Complete stability (min).....	15 - 20
	Working time (min).....	3,0 - 4,0

Shelf life

At least 24 months if stored tightly closed and under dry conditions.

Warranty

SHERA Werkstoff-Technologie GmbH & Co. KG is certified according to DIN EN ISO 13485 and guarantees for the products, due to a thorough quality control system, a flawless quality of its products. Our instructions for use are based on the results of our test laboratory. The technical data given can only be guaranteed if the processing is carried out as mentioned. The user is self-responsible for processing of the products. We are not liable for faulty results as SHERA has no influence on the processing. Nevertheless possibly arising claims for damages relate to the value of the products only.

