

Processing

100 g powder : 23 ml distilled / demineralised water

The amount of water can be decreased by up to 1,5 ml. With less liquid the plaster will be harder and the working time will be shorter.

Please take care only to mix enough plaster that is required for 4 to 5 socles (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 under vacuum for 45 sec at 80 % vacuum, 300 U/min. Start the mixing action after a full vacuum has been established. Not needed mixing bowls always leaving filled with water. Pour out the base former without the vibrating apparatus to achieve homogenous results.

Tip

While using a plaster of the colour apple green for acrylic works, discolouration of the acrylic may occur. We recommend using a plaster of another colour for this kind of purpose.

For isolating the arch we recommend using our separating agents SHERASEPARAT or SHERASEPAL-U.

Technical data:	Brinell hardness after 2 hours (MPa; N/mm ²).....	230
(applies for a mixing ratio	Brinell hardness after 24 hours (MPa; N/mm ²).....	250
of 100 g : 23 ml and	Compressive strength after 1 hour (MPa; N/mm ²).....	49 (7,105 psi)
vacuum mixing)	Setting expansion (%).....	0,05
	Complete stability (min).....	35 - 45
	Working time (min).....	3,5 - 4,5

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 SHREA has no influence on the processing. Nevertheless possibly arising claims for damages relate to the value of the products only.

