

**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 under vacuum for 45 sec at 80 % vacuum, 300 U/min. Start the mixing action after a full vacuum has been established. When mixing by hand the mixing time is 60 seconds. Not needed mixing bowls always leaving filled with water.

**Tip**

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

<b>Technical data:</b>	Brinell hardness after 2 hours (MPa; N/mm <sup>2</sup> ).....	120
(applies for a mixing ratio of 100 g : 30 ml)	Brinell hardness after 24 hours (MPa; N/mm <sup>2</sup> ).....	140
	Compressive strength after 1 hour (MPa; N/mm <sup>2</sup> ).....	46 (6,670 psi)
	Setting expansion (%).....	0,15
	Complete stability (min).....	20 - 30
	Working time (min).....	4,0 - 5,0

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

