

SHERAMAXIMUM

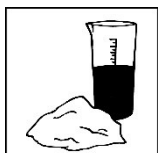
INSTRUCTIONS FOR USE

1. Indication

Super hard stone type 4 (DIN EN ISO 6873) for sectioned, master models and plastic basing systems.

2. Processing instructions

Mixing ratio



Powder : demineralised water

100 g : 20 ml

The amount of water can be increased or decreased by up to 1.5 ml.

Less liquid → stone/plaster will be harder, working time will be shorter and expansion will increase.

More liquid → stone/plaster will be softer, working time will be longer, expansion will decrease.

Pre-mixing by hand



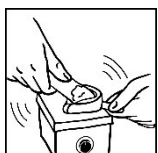
First fill in the stone powder into the mixing bowl, then add water and stir by hand for approx. 30 sec. Please only mix the quantity of stone which is necessary for three to four models (important for crystallization).

Mixing under vacuum



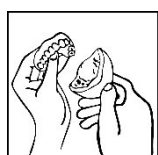
Mix for 45 seconds under vacuum at 80 % vacuum, 300 rpm. Switch on the stirring device only when the vacuum is complete. Always keep the not needed mixing bowls filled with water.

Working time



Process the stone within 6.0 – 7.0 minutes. Use the vibrator at the lowest level possible. Place the impression onto the vibrator thereby avoiding contact of the impression material with the vibrator. Fill in the stone from one side only. Do not go on vibrating once the impression is poured.

End of setting time



After approx. 30 minutes you can remove the model from the mould.

3. Technical data

(at mixing ratio 100 : 20 and mixing under vacuum)

Hardness after 2 hours (MPa; N/mm ²)	300
Hardness after 24 hours (MPa; N/mm ²)	320
Compressive strength after 1 hour (MPa; N/mm ²)	60
Setting expansion after 2 hours (%)	0.10
Working time (min)	6.0 – 7.0
End of setting time (min)	approx. 30

4. Tips and tricks

- Use only clean and dry tools.
- Use only demineralised/distilled water.
- Never mix stone with additives like trimming water or stone hardener.
- Dose stone and water exactly.
- Stir stone under vacuum and observe the recommended mixing speed and time.
- Keep the surface of the vibrator clean and smooth.
- Clean work place and tools immediately after use.
- Preferably avoid evaporation, if possible:
 - Distance of the nozzle should be at least 10 cm.
 - Work at intervals so as not to overheat the stone.
- Sawing: preferably after 2 hours.
- Pay attention to tool-specific speed.
- Saw cuts parallel to the pin.
- Wet trimming no later than 2 hours after removal of the mould.
- Dry trimming, preferably 2 to 10 hours after removal of the mould.

5. Shelf life

At least 24 months in closed containers in dry rooms.

6. Warranty

SHERA Werkstoff-Technologie GmbH 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 user recommendations are based on so-called guideline values determined in 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.



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