

SHERAALPIN

INSTRUCTIONS FOR USE

1. Indication

Hard plaster type 3 (EN ISO 6873) for working, situation and opposing models, for all model in the acrylic technique, for investing model in duplicating flasks.

2. Processing instructions

Mixing ratio



Powder : demineralised water

100 g : 30 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.

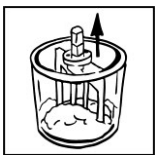
Mixing by hand



First pour stone/plaster powder into the mixing bowl, then add water and stir slowly by hand until powder and liquid are well mixed, then spatula for 45 seconds. Total hand mixing 60 seconds.

Our recommendation

Mixing under vacuum



First pour the plaster powder into the mixing bowl, then add water and mix speedily by hand until powder and liquid are well mixed.

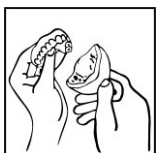
Mix for 45 seconds under vacuum at 80 % vacuum, 300 rpm. Do not switch on the stirring device until the vacuum is complete. Always leave unused mixing bowls filled with water.

Working time



Process the stone/plaster with water mixture within 3.5 - 4.0 minutes. Set the vibrator to the lowest setting. Place the tray flat, avoiding contact of the impression material with the vibrator. Allow stone/plaster to run in from one side only. Do not shake the impression once it has been filled. Afterwards, the stone/plaster should harden undisturbed for good crystallisation and setting to avoid splintering, flaking or breaking.

End of setting time



After approx. 20 minutes you can remove the model from the mould.

3. Technical data

(at mixing ratio 100 : 30 an mixing under vacuum)

Hardness after 2 hours (MPa; N/mm ²)	100
Hardness after 24 hours (MPa; N/mm ²)	110
Compressive strength after 1 hour (MPa; N/mm ²)	40
Setting expansion after 2 hours (%)	0.15
Working time (min)	3.5 - 4.0
End of setting time (min)	approx. 20

4. Tips and tricks

- Use only clean and dry tools.
- Use only demineralised/distilled water.
- Never mix stone/plaster with additives like trimming water or stone/plaster hardener.
- Dose stone/plaster and water exactly.
- Stir stone/plaster 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.
- Wet trimming no later than 2 hours after removal of the mould.
- Dry trimming, preferably 2 to 10 hours after removal of the mould.
- 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/plaster.
 - If there are large temperature differences between the articulating plaster and the model, the bond may loosen.

5. Shelf life

At least 24 months in closed containers in dry rooms.

6. Warranty

SHERA Werkstoff-Technologie GmbH is certified according to 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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