

SHERAPOWDER-ARTI

INSTRUCTIONS FOR USE

1. Indication

Hard plaster type 3 (EN ISO 6873) for articulating models, also for milling bases and over bites.

2. Processing instructions

Mixing ratio



Powder : demineralised water

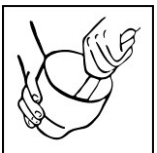
100 g : 28 ml

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 the plaster powder into the mixing bowl, then add water and mix quickly by hand until the powder and liquid are well mixed. Hand mixing total approx. 45 seconds.

Working time



Process the stone within 2.0 – 2.5 minutes.

Subsequent processing time

After approx. 15 minutes you can start the next working steps.

3. Technical data

(at mixing ratio 100 : 28)

Hardness after 2 hours (MPa; N/mm ²)	100
Hardness after 24 hours (MPa; N/mm ²)	120
Compressive strength after 1 hour (MPa; N/mm ²)	30
Setting expansion after 2 hours (%)	< 0.04
Working time (min)	2.0 – 2.5
End of setting time (min)	approx. 15

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.
- 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/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.

