

1. Indication

Super hard stone, class IV (DIN EN ISO 6873) for presentation models.

2. Processing instructions

Mixing ratio



Powder : demineralised water
100 g : 20 ml

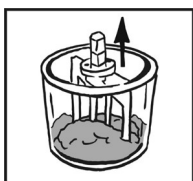
The amount of water can be increased or decreased by up to 1,5 ml
Less liquid → harder, shorter working time, higher expansion
More liquid → softer, longer working time, lower expansion

Premixing by hand



First fill 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



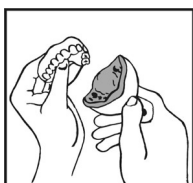
Mix for 45 seconds under vacuum at 80 % vacuum, 300 U/min. Start the stirring device not until the absolute vacuum has been established. Not needed mixing bowls should always be filled with water.

Working time



Work up the stone within 5 - 6 minutes. Use the vibrator at the lowest level possible. Lay down the impression onto the vibrator thereby avoiding contact of the impression material with the vibrator. Fill in the stone from one side only.

End of setting time



After approx. 45 minutes you can remove the model from the mould.

3. Technical data (at mixing ratio 100 : 20 and mixing under vacuum)

Brinell hardness after 2 hours (MPa; N/mm ²).....	240
Brinell hardness after 24 hours (MPa; N/mm ²).....	260
Compressive strength after 1 hour (MPa; N/mm ²).....	50
Compressive strength after 1 hour (psi).....	7.250
Setting expansion (%).....	0,10
Working time (min).....	5,0 - 6,0
End of setting time (min).....	ca. 45

4. Note:

Attention: Due to the strong pigmentation, this stone heavily stains.

5. Tips und tricks

- To achieve a continuous colour stability, we recommend to treat the surface with SHERASEPAL-U
- Only use clean and dry tools.
- Only use demineralized water.
- Never use additives like trimming water or stone hardener
- Exactly dose stone and water.
- 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 to ablate:
 - o The distance of the blast pipe should be at least 10 cm.
 - o In order not to overheat the stones, work at intervals.
- Sawing: preferably after 2 hours.
- Pay attention to the specific number of revolutions.
- Saw the cuts in parallel to the pin.
- Wet trim up to 2 hours after removal from the mould-at the latest!
- Preferably dry trim 2 to 10 hours after removal from the mould.
- Do not vibrate the filled impressions anymore.

6. Shelf life

At least 24 months in closed containers in dry rooms.

7. Warranty

SHERA Werkstoff-Technologie GmbH & Co. KG is certified according to DIN EN ISO13485 and guarantees a flawless quality of its products., due to a thorough quality control system. 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.



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