



## Moulding plaster for ceramic press forms

### Advantages

- High absorption capacity
- Outstanding surface hardness
- Minimal expansion
- Consistent quality

### Characteristics

|                          |                                 |
|--------------------------|---------------------------------|
| Appearance               | white powder                    |
| Mixing ratio             |                                 |
| powder : water           | 3,0 - 3,3 kg : 1 ltr.           |
| Strewing and mixing time | 10 min                          |
| Working time             | app. 15 min                     |
| Final setting time       | app. 25 min                     |
| Surface hardness         | more than 250 N/mm <sup>2</sup> |

### Important

- AS-DUR K and the water to be mixed shall have a temperature of approx. 20° C. Plaster which has been stored at extreme temperatures should be acclimatised for several hours before use.
- The mixing equipment must be clean. Any contamination will affect the quality properties of the form.

### Working instructions

The mixing ratio can be varied in the above mentioned range according to the clay body. The higher plaster ratio to water results in optimal hardness and less absorption capacity - with the reduced plaster to water ratio less hardness and more absorption capacity is reached.

### a) Mixing

Strew AS-DUR K in the given ratio into the water. Use a mixer equipped with a propeller blade which run at approx. 300 rpm. We recommend mixing under vacuum to avoid air bubbles.

After the working time of 15 min. the mix is not allowed to be agitated any longer because disturbance of the crystallization process may result in considerable solidity loss which may cause fissuring of the plaster mould. To make press forms of good quality it is necessary to pay attention to the following timetable:

### Timetable for the processing of AS-DUR K

1. Strewing of plaster into the water app. 1 - 2 min
2. Soaking time app. 1 min
3. Mixing time with mechanical mixer 7 - 8 min
4. Total working time app. 15 min
5. Final setting time app. 25 min
6. Purging with compressed air:  
Volume and size of the pores are dependent on the beginning of purging. There for it should begin when the temperature in the plaster mould has increased by about 7 - 10°C; according to our experience this will take place approximately 2 min. after final setting time.



## Example

If the temperature of plaster mix amounts e. g. to 22° C, purging should begin at 29 - 32° C.

- Begin purging with a pressure of 0.5 bars
- Increase the pressure every minute by 0.5 bars
- to a maximum pressure of 5.0 bars

## Packaging

Paper bag with foil liner 25 kg

## Shelf life

At least 12 months in closed, vapour-proof packages. Long-term storing at temperatures above 30° C shortens the shelf life.

The above recommendations are given to the best of our knowledge. We grant the quality of our products according to our specification. Any further liability cannot be accepted since the proper application of our products is outside of our control.