

### PRODUCT DESCRIPTION

Alfapress is a formulated plaster designed for RAM press in tableware with good mechanical properties and controlled in expansion.

### APPLICATIONS

Tableware

### PRODUCT BENEFITS

- + Specifically designed for RAM Press
- + Good balance between permeability and mould life
- + Controlled expansion

### TECHNICAL INFORMATION

Chemical name	Calcium sulphate hemihydrate
Chemical composition	CaSO <sub>4</sub> ·½H <sub>2</sub> O
Minimum gypsum purity (%)	95
Plaster to water ratio (by weight)	3.00:1
Water to plaster ratio (by weight)	33%
Plaster to water mix ratio (by weight)	100/33
Colour	White
Vicat ring fluidity (cm)	20 ± 3
Initial setting time (minutes)	18 ± 4
Flexural strength (MPa)	12
Brinell hardness (MPa)	125
Dry compressive strength (Mpa)	36
Particle size (% weight retained)	≤ 1.00 % at 100 µm
Loose bulk density (kg/m <sup>3</sup> )	1075

The technical data outlined represents typical figures only. For further details, please contact Saint-Gobain Formula directly.

### KEY INFORMATION

Preparation of the matrix:

The preparation of the matrix is key. Air Network must be well fixed to the frame. The space between each air tubes should be constant (~ 2 cm between each). The air network should be place at ~ 2cm of the working surface of the mould.

Plaster Preparation:

The temperature of both the plaster and water should be as close as possible during processing, within the range 15 - 20°C, as plaster and water temperatures affect setting behaviour. Sprinkle evenly over the entire surface of the water and allow to soak for approx. 2 minutes.

Depending on the intensity of the mixer and the quantity, the recommended mixing time is 6 - 12 minutes. Mixing can start since the beginning of the soaking. To avoid air entrainment, it is advisable to mix under vacuum.

The temperature of the mix should be taken at the end of the mixing. The best is to control the pressure increase according the temperature increase.

After pouring, a thermometer is placed in the mould. Once the temperature has increased by 6 to 8°C, the purging process can be started.

The pressure should be increased by 0.5 bar from every half a minute to every minutes. After reaching 5 bar, purge until the mould is dry, for minium half an hour. The purging process can be stopped when dry areas can be seen on the surface (2 hours).

The mould should be allowed to harden for at least 12 hours.

## PACKAGING AND SHELF LIFE

	Packaging Available	Shelf Life (Month)
Sack	25kg	8

When stored under dry conditions and in its original packaging, the product will have a specified shelf life that commences from the date of manufacture that is displayed on each sack. Shelf life depends on the packaging type. For those products where a defined 'best before' date is applicable, BBE (Best Before End) followed by the date will be displayed on each sack.

## STORAGE

Plaster based products are not recommended for conditions where they are likely to be located externally or in any way subjected to weathering or excessive dampness.

Absorption of moisture can result to physical properties, including a reduction in the set strength of plasters and also a lengthening of setting time.

To help protect the product during use, open or part used bags should be carefully folded and closed. Each bag is date stamped and stocks should be rotated so that the oldest material is used first.

## DISCLAIMER

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## CONTACT

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