MOLDA 3 BIS

Ceramics

PRODUCT DESCRIPTION

Molda 3 Bis is used to produce working moulds for sanitaryware, tableware or refractory where mould life is important. In particular with abrasive clays slurry such as coarse fire clay or pottery and when a long working time is needed to cast plaster moulds. This product can be also used in ceramics tableware for jiggering. As well in Art & Decoration in fibrous plasterwork and in the manufacture of decorative plasterwork or for sculpture and modelling.

PRODUCT BENEFITS

+ **Adapated for ceramics slip casting with abrasive clay**
+ **High mechanical properties**

OTHER MARKETS

Fibrous and Decorative Plaster

APPLICATIONS

Sanitaryware, Artistic, Tableware

TECHNICAL INFORMATION

Plaster to Water Ratio	
Plaster to Water Ratio (by weight)	1.75:1
Water to plaster ratio (by weight)	57%
Plaster to water mix ratio (by weight)	100/57
Chemical Properties	
Chemical Name	Calcium sulphate hemihydrate
Chemical Composition	$CaSO_4.1/2H_2O$
Minimum gypsum purity %	95
Colour	White
Setting Parameters	
Vicat Ring Fluidity (cm)	18
Initial setting time (minutes)	13
Mechanical Properties	
Flexural Strength (MPa)	8
Brinell Hardness (MPa)	50
Dry compressive strength (Mpa)	17
Physical Properties	
Particle Size (% weight retained)	≤ 6.00 % at 100 µm
Loose bulk density (kg/m³)	700

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

INSTRUCTIONS FOR USE

The recommended plaster to water ratio is between 1.55:1 and 1.80:1, with a mixing time of approx. 2 to 4 minutes, depending on batch size and plaster shop process. Mixing utensils should always be clean and free from set plaster. Use distilled water only. For consistent results, attention must be given to the correct proportioning and mixing of the plaster and water. Add the weighed quantity of plaster slowly into the measured volume of water and allow to soak. Do not mix fresh plaster with that which has been mixed for some time previouslyChanges to plaster to water ratio will influence product performance, particularly setting time and strength and absorption capability.The following graphs help illustrate how varying ratios will affect compressive strength and water absorption.

PACKAGING AND SHELF LIFE

	Packaging Available	Shelf Life (Month)
Bag	25 kg	10

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 in changes to physical properties, including a reduction in the set strength of plasters and also a lengthening of setting time.

Gypsum minerals can be affected by absorption of moisture and may change physical properties.

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.

CERTIFICATION

UK CA CE DoP n°CS001

ENVIRONMENT, HEALTH AND SAFETY

Material Safety Data Sheets of Saint-Gobain Formula plasters and gypsum minerals are available for all products and may be obtained directly on our website in the product and documentation sections. No liability is accepted by Saint-Gobain Formula for injury to any person or loss or damage to property by improper use of the product.

NOTIFICATION

The plaster to water ratios quoted are those used in Saint-Gobain Formula’s standard test methods and are not necessarily those used in practice.
The precise consistency to use will need to be adjusted to suit the individual application. Changes to plaster to water ratio will influence product performance, particularly setting time and strength.
Unless otherwise stated, Saint-Gobain Formula’s standard test methods apply. To obtain a copy of the test method, please contact Saint-Gobain Formula directly.
This literature cancels and replaces any previous document. All information given is provided in good faith and may be subject to change.
It’s advisable to contact Saint-Gobain Formula in case of any doubt arising from the content of such information.

CONTACT

For any information, please visit our website

www.saintgobainformula.com

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