

# Technical data sheet.

## Kerapress - grün, blend and blau

### Product description

Kerapress grün, blend and blau are moulding plasters for all products which can be manufactured using RAM moulding presses. Thanks to their high hardness, ultimate and compression strength, these products are the ideal moulding plasters for various moulding shapes. Optimum processing properties ensure that the moulds are ready for use in a fast and reliable manner.

### > Technical data and specifications

Kerapress		grün	blend	blau
Water-gypsum factor	-	0.37	0.34	0.30
Gypsum / Water	kg/l	2.70	2.94	3.33
Initial setting time	min	21	21	21
Final setting time	min	28	28	28
Linear expansion	%	< 0.18	< 0.18	< 0.18
Ball indentation hardness	N/mm <sup>2</sup>	125	138	150

### > Logistics and safety notes

Commercial form	bag, big bag and bulk
Shelf Life	given dry storage, it can be stored for at least 6 months
Safety notes	see safety data sheet, no specific hazards arising from Kerapress

### Information

This technical data sheet is intended to give advice to the best of our knowledge; it replaces any previous technical data sheets. The contents of this technical data sheet are not legally binding.

### For further information

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### Processing and processing time

These gypsum-based plasters require special and exact handling and processing, starting from mould making via mould manufacturing through to the use of the moulds.

### Mould making

In order to achieve the required permeability for the material fluid and release air during subsequent use of the mould, a fabric hose system in the form of the product to be manufactured must be inserted in the equipment at a distance of 2 - 2.5 cm to the mould mirror.

Via this hose system, the mould is ventilated during the curing of the gypsum-based plaster, the material on the mould press is drained and the product is pressed from the mould by means of compressed air.

### Manufacturing the gypsum mould

The temperature of Kerapress green, blend and blue and the mixing water should be between 20 and 25 °C.

The gypsum must be added quickly to the water, however, it must not be poured. Automatic adding via an auger has proven itself. The addition period should be approx. 2 minutes.

The stirring time depends on the agitator and speed used. It should not be less than 8 minutes. A stirring speed of 600 – 1.200 U/min is recommended. Stirring under vacuum can only be advantageous.

Casting should be carried out as quickly as possible in order to avoid different curing stages of the gypsum in the mould.

Immediately after the casting has been completed, the temperature must be measured. When the stiff-plastic consistency has been reached, the gypsum-based plaster must be screeded flush with the edge. If it takes longer than 5 minutes to screed the gypsum-based plaster after casting, the stirring time must be extended accordingly.

After a temperature difference of 7 - 8 °C (measured in the gypsum-based plaster) has been reached, ventilation must be started.

This is carried out by means of the hose system. The ventilation pressure must continuously be increased by 0.5 bar per 30 seconds. After 2.5 bars have been reached, the mould must be lifted off smoothly from the equipment without canting. During this process, ventilation must not be interrupted. The mould must be positioned in such a way that the escaping water can drain off.

The final ventilation pressure is approx. 5 - 6 bar. This pressure must be maintained until no more water escapes; i.e. for a period of not less than 30 - 60 minutes and not more than 120 minutes. Then, the mould has been finished.

In order to avoid mould cracks, the bottom side of the mould must be checked for absolute evenness and processed if necessary.

For storage, a level surface is recommended. Bottom and top mould should be assembled.

Before the mould is used on the moulding press, it must be watered adequately. Do not cant the mould when mounting it.