

Gypsum Solutions

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Plaster Mixing Instructions, Consistency and Setting Times

Mixing Instructions:

1. Weigh proper amount of room temperature water in a clean container. (Warmer water will accelerate the setting time.)*see chart below.*
2. Weigh proper amount of gypsum/plaster.
3. Sprinkle the gypsum/plaster into the water. (Never pour water into gypsum/plaster.) As you near completion, Small mounds of gypsum/plaster will peak above the surface of the water. When all the gypsum/plaster has been added, allow the mixture to sit undisturbed while the plaster soaks up the water. (Several minutes, *Approx. 2-3 mins.*)
4. MANUALLY: It is possible to get a good mix by using a spoon or wood dowel. Mix slowly and steadily from the bottom, using a side to side motion. Stirring in a circular motion will introduce undesirable air bubbles into the mix. The consistency of final mix should be that of heavy dairy cream. *Approx. 3-4 mins.* (The “old timers” are sometimes seen “elbow deep in plaster” literally mixing by hand. This is a very dangerous method since plaster becomes extremely hot when setting, potentially resulting in severe burns.)

ELECTRIC MIXER: You can achieve a consistently good mix by using an electric drill with a Jiffy Mixer attachment. “Stir” at 1750 RPM while holding the Jiffy Mixer at 15 degrees off vertical. This method is also quicker than the manual method discussed above. *Approx. 3-4 mins.*

5. Let mixture sit for 2 mins. before casting.

Storage:

Store gypsum/plaster in a warm, dry area, raise from the floor to avoid moisture absorption. The shelf life of all gypsum/plaster is limited but that life can be extended by storing in air-tight plastic containers.

CONSISTENCY AND SETTING TIMES

USG PRODUCT	RECOMMENDED CONSISTENCY (Parts of water by weight per 100 Parts of material)	APPROXIMATE SETTING TIME (Minutes)
GARDENCAST	12.5	25-35
HYDROCAL FGR 95	30	50-70
HYDROPERM	100	12-19
HYDROSTONE	32	17-20
NO.1 POTTERY	70	27-37
PURITAN	66	27-37

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