

USG HYDRO-STONE® SUPER X GYPSUM CEMENT

DESCRIPTION

USG Hydro-Stone® Super X Gypsum Cement is an excellent product for manufacturing solid cast architectural, art novelty and statuary products. It is an extremely hard gypsum cement with high compressive strength and high water absorption resistance, while providing very fine detail duplication. If information for a specific use is needed, please contact your local USG Sales Representative for further assistance.

TYPICAL PHYSICAL PROPERTIES

Normal Consistency	22 lbs. water/100 lbs. product (9.9 kg/45.5 kg)
Hand Mix Vicat Set, Target	15 - 25 minutes
Compressive Strength, One Hour After Set	6,500 psi (4.8 MPa)
Compressive Strength, Dry	13,000 psi (89.6 MPa)
Density, Wet	127.0 lbs./cu. ft. (2034 kg/m ³)
Density, Dry	125.0 lbs./cu. ft. (2002 kg/m ³)
% Maximum Expansion	0.20%

NOTE The *Typical Physical Properties* in the above table were achieved under controlled laboratory conditions with freshly produced material, results may vary. Other set times may be available; call your USG Sales Representative for more information.

MIXING INSTRUCTIONS

MIX PREPARATION

Use potable water at temperatures between 70 °F (21 °C) and 100 °F (38 °C). Because variations in slurry (USG Hydro-Stone Super X Gypsum Cement and water mixture) temperature produce variations in set time, it is important to keep both the USG Hydro-Stone Super X Gypsum Cement and water in a stable temperature environment prior to use. The higher the temperature of the slurry, the shorter the set time. Conversely, the lower the temperature of the slurry, the longer the set time.

Weigh both the USG Hydro-Stone Super X Gypsum Cement and the water prior to use for each mix. The water-to-USG Hydro-Stone Super X Gypsum Cement ratio is critical because it governs the strength and the density of the final cast.

SOAKING

Sift or strew USG Hydro-Stone Super X Gypsum Cement into the water slowly and evenly. Do not drop large amounts of USG Hydro-Stone Super X Gypsum Cement directly into the water as proper soaking of the USG Hydro-Stone Super X Gypsum Cement may not occur. USG Hydro-Stone Super X Gypsum Cement should be fully dispersed in the water prior to mixing. Small batches require less soaking time than large batches. See USG IG503 *Plaster Mixing Procedures* for specific soaking instructions.

MIXING

Mixing USG Hydro-Stone Super X Gypsum Cement slurry is one of the most important steps in producing USG Hydro-Stone Super X Gypsum Cement casts with optimal strength, absorption, hardness and other important properties.

Mechanically mixed slurries develop uniform casts with optimal strengths. USG Hydro-Stone Super X Gypsum Cement can be mechanically mixed through both batch and continuous processes. Proper blade and bucket dimensions are important for obtaining the best batch mix (see USG IG503 *Plaster Mixing Procedures* for details).

Longer mixing times result in higher mold strength and shorter set times.

POURING

To prevent air entrainment and provide a uniform, smooth surface, careful pouring of USG Hydro-Stone Super X Gypsum Cement slurry is necessary. Agitation/vibration of the filled mold is a further step used to prevent air at or near the mold surface. Whenever possible, USG Hydro-Stone Super X Gypsum Cement slurry should be poured carefully in the deepest area so that the slurry flows evenly across the surface of the case mold.

Pouring a large amount of slurry directly on the face of the case mold may result in slight densification of the USG Hydro-Stone Super X Gypsum Cement mold at the point where it strikes the surface of the case. This produces a hard spot, giving uneven absorption.

DRYING

All casts should be dried as quickly as is safely possible after manufacture so that maximum physical properties can develop. Dry to a constant weight.

The best drying rooms or ovens provide 1) uniform and rapid circulation (minimum of 15-30 fps (4.6-9.1 mps)) of air with no "dead spots" having little or no air movement, 2) equal temperatures throughout the entire area, and 3) provisions for exhausting a portion of the air while replacing it with fresh air. High humidity surrounding the drying room or oven inhibits drying efficiency because the air pulled into the room is incapable of picking up much moisture from the molds.

The optimal temperature range at which USG Hydro-Stone Super X Gypsum Cement molds are safe from calcination is between 110 °F (43 °C) and 120 °F (49 °C). With substantial free water in the mold, a higher drying temperature can be used initially without difficulty. As drying progresses, the temperature must be reduced to prevent calcination. Before removing molds from the dryer, the temperature should approach that of the area around the dryer to prevent thermal shock. See IG502 *Drying Plaster Casts* for additional information.

STORAGE AND USE

PRODUCT INFORMATION

See usg.com for the most up-to-date product information.

DANGER

Causes skin irritation. Causes serious eye damage. May cause cancer by inhalation of respirable crystalline silica. Do not handle until all safety precautions have been read and understood. Avoid breathing dust. Use only in a well-ventilated area, wear a NIOSH/MSHA-approved respirator. Wear protective gloves/protective clothing/eye protection. If swallowed, inhaled, or skin irritation occurs get medical attention. When mixed with water, this material hardens and becomes very hot sometimes quickly. DO NOT attempt to make a cast enclosing any part of the body using this material. If on skin: Wash with plenty of water. If in eyes: Rinse cautiously with water for several minutes. Remove contact lenses and continue rinsing. Wash contaminated clothing before reuse. Dispose of in accordance with local, state, and federal regulations. For more information call Product Safety: 800-507-8899 or see the SDS at usg.com
KEEP OUT OF REACH OF CHILDREN.

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SAFETY FIRST!

Follow good safety/industrial hygiene practices during installation. Wear appropriate personal protective equipment. Read applicable SDSs and literature before specification and installation.

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