

TECHNICAL INFORMATION



Marsclay Medium 8432M / 8432MC

Composition:	waxes, oil, fillers, pigments
Density:	approx. 1,5 g/cm ³ , de-aired
Color:	brown
Odor:	neutral
α (Linear Shrinkage Coefficient)	constant $2,1 \times 10^{-4} \text{ K}^{-1}$ (0 – 20°C / 32 – 68°F) \emptyset $2,3 \times 10^{-4} \text{ K}^{-1}$ (20 – 35°C / 68 – 95°F) constant $2,6 \times 10^{-4} \text{ K}^{-1}$ (35 – 60°C / 95 – 140°F)
Shelf life:	at least 24 months at temperatures from 0°C/32°F to 30°C/86°F maximum 14 days in the oven at 55°C/131°F - 60°C/140°F
Working temperature:	55°C/131°F - 60°C/140°F
Degree of hardness:	medium
Shore hardness A	62 (20°C/68°F)
STAEDTLER-hardness AH / g:	23°C/73,4°F: 4.500 40°C/104°F: 800 60°C/140°F: 250
Solubility:	insoluble in water, partially soluble in organic solvent
Toxicology:	Marsclay Medium is toxicologically harmless, certified by ACMI, USA.

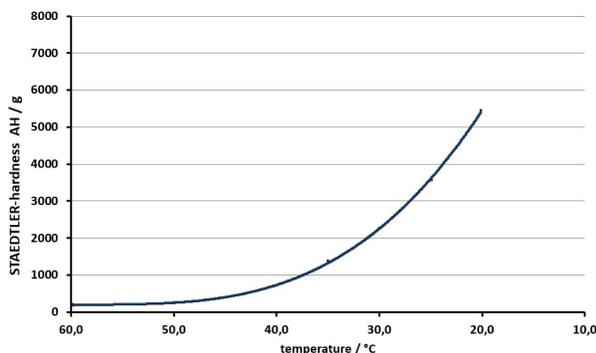


Sales information: 1 twin round bar = 2,30 kg/5,07 lbs; volume: approx. 1,55 l
 (2 bars each diameter approx. 6,0 cm; length of bar approx. 26 cm)
 9 pcs in carton; 216 pcs on pallet

The values given are typical test results which should be used as a guide only. They cannot be considered a specifications or guarantees

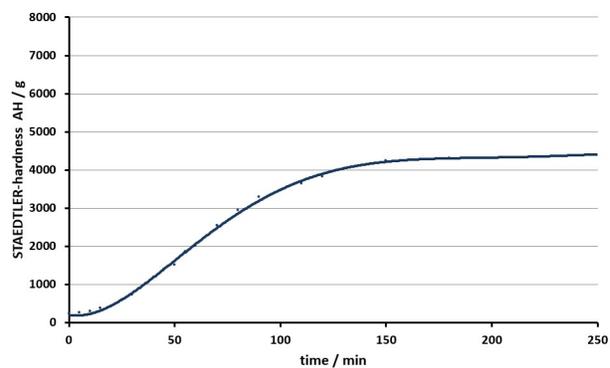
Cooling rate of Marsclay Medium
 Hardness-Temperature-Diagram

Cooling behaviour to 20°C/68°F



Cooling rate of Marsclay Medium
 Hardness-Time-Diagram

Cooling behaviour to 23°C/74°F



Safety instruction:

- Do not heat Marsclay Medium over the recommended temperature (60°C / 140°F).
- Hazards:
 - Burns to the skin from molten material
 - The material can be ignited at higher temperatures; the following instructions should therefore be followed:
 - Keep well away from ignition sources
 - Prevent contact with uncovered heating wires/heating coils
 - Keep well away from sparks/open flames
- Do not use any combustible materials when heating the material in the oven.
- Safety data sheets are obtainable on request.

Instruction of use:

- As a permanently malleable compound Marsclay Medium remains pliable and can be used again and again.
- When heated to 55°C/131°F - 60°C/140°F, the clay becomes soft and pliable.
- The heating period is about 5 hours (depending on type and loading of oven).
- At room-temperature up to 25°C/77°F the models keep their contours and edges.
- By hot conditions or direct solar radiation softening of the surface occurs.
- Wood, polystyrene and hard foams can be used as base materials.
- Base materials and the warm modelling clay bond without the need of adhesives.
- Grave quantities should be applied in layers.
- By applying of bigger masses, we commend to warm up the base layer for an optimum bond.
- Once the top surface has cooled down, the model can be shaped by hand or milling machines.
- Modifications can be made to the finished model simply and dust free.
- Due to the special bonding qualities small amounts of material can be applied.
- In case of serious changes, the roughening of the previous surface is recommended.
- Finishes with modelling film can be removed quickly and easily.
- When using a heat-gun do not exceed temperatures above 60°C/140°F.
- The clay-model can be casted with gypsum or silicone. As releasing agent shellac can be used.
- The clay can be lacquered with ClayPeel.
- Soiled surfaces can be cleaned with solvent cleaner.