

ACRABOND

Polymer-Based Leveling & Base Coat

Technical Data & Application Instructions

GLOBAL COATINGS
April, 2001

PRODUCT DESCRIPTION

ACRABOND is an acrylic polymer which, when mixed at the job site with Portland cement and a small amount of water, forms a high performance, water-repellent base coat for use in conjunction with the CARRARA flexible marble stucco system.

BASIC USES

ACRABOND was specifically developed for use as a base coat and leveling material over expanded polystyrene (EPS), concrete, masonry and approved exterior wallboard products. **ACRABOND** is also used to embed CARRARA Field Fabric, a woven fiberglass mesh, which provides impact and crack resistance, as well as additional reinforcement at seams and joints. It trowels easily, filling and leveling irregular surfaces, to yield a durable, water-resistant base, over which the CARRARA finish is applied.

TYPICAL PROPERTIES

1) Weight per Gallon (Density).....	12.8 lbs (+/- 2) [ASTM D 1475]
2) Tensile Strength.....	500 psi (+/- 50) [ASTM C 190]
3) Flexural Strength.....	1,300 psi (+/- 100) [ASTM D 790]
4) Sheer bond Adhesion.....	150 psi (+/- 50) [R & H Method]
5) Compressive Strength.....	5,700 psi (+/- 100) [ASTM C 109]
6) Flash Point.....	205°F (96°C) [ASTM D 56]
7) V.O.C.	0.02 lb/gal. [EPA RM-24]
8) Pot Life.....	~2hrs. @ 75°F (24°C), 50% R.H.
9) Shelf Life.....	One (1) year from date of shipment

PACKAGING & MIXING

ACRABOND is packaged in 5-gal plastic pails containing 60 lbs. of acrylic polymer. To use, pour ½ of the contents (30 lbs.) into a second, clean 5-gal container. To each of these containers, add approximately 1/3 bag (31 lbs.) of Type I or Type II Portland cement, mixing constantly. Once blended, allow mixture to stand for five (5) minutes to allow viscosity to stabilize. Mix once again, and then slowly add water to achieve desired consistency. **Do not add more than ¾ gallon of water**, as excess water will decrease the strength and vertical hold of the **ACRABOND**. Likewise, don't add more than 33 lbs. of cement to the acrylic polymer, as additional cement will decrease water resistance and flexibility properties, while decreasing the working time of the mix.



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www.carrara-stucco.com

Our data and suggestions are based on information from laboratory and field testing which we believe to be reliable. Because methods of application vary with each situation, we cannot guarantee or accept any liability resulting from the use of our products. Avoid contact with eyes and skin. For additional information on **ACRACREAM** safety requirements, refer to OSHA guidelines and Material Data Safety Sheet.

APPLICATION

All surfaces must be clean and dry, and free of dirt, dust, oil, efflorescence, form or release agents, and other contaminants, which may interfere with optimum adhesion. Apply **ACRABOND** using a stainless steel trowel or the *Carrara Texture Sprayer*, to a thickness of 1/16 inch, or approximately 1-½ times the thickness of the **Field Fabric**. Coverage rate will be approximately 170-sq. ft. of surface area per 5-gal pail of blended material (60 lbs. of **ACRA-BOND** mixed with 61 lbs. of Portland cement). Coverage rate will vary with surface profile and thickness of application.

If **Field Fabric** is utilized, embed it into the **ACRABOND** immediately after troweling it out to the desired thickness, overlapping it a minimum of 2 inches at each edge. Trowel over the top of the **Field Fabric** until it is completely encapsulated by the **ACRABOND**. Any ridges or rough areas on the surface can be removed with a rasp or heavy grit sandpaper after the **ACRABOND** has dried.

Workable pot life of the **ACRABOND** is approximately 2 hours, depending upon ambient conditions. Dry time will also vary with temperature and humidity. Under normal conditions, **ACRABOND** should be protected from rain or other adverse weather conditions for a period of 24 hours or until thoroughly dry. Complete cure will require approximately 28 days.

CLEAN-UP

For ease of clean up, clean tools and any adjacent areas to which the **ACRABOND** is inadvertently applied, with water before the material dries.

LIMITATIONS & PRECAUTIONS

ACRABOND will freeze and become unusable at temperatures below 32° F (0° C). Do not ship or store without protection from freezing temperatures. Do not apply at ambient temperatures below 50° F (10° C) or surface temperatures below 40° F (4.4° C) or if rain is expected. Cool temperatures and high humidity will retard drying time. Close container after each use.

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