

**Suggested Specification  
For  
Tuff-Kote Flex 10,000—Kel-Prime System  
One-Coat Plaster  
ICC ESR Report #2099**

Section 9001: Quality Control

1. **Equipment:** Pumping and mixing equipment shall not be modified e.g. screen shall remain on pump hopper not attached to the mixer. Pumping equipment or hoses shall not have any water leaks.
2. **Climatic conditions:**
  - A. **Cold weather application:** No plaster shall be mixed or applied when the temperature is 32 degrees or below during initial hydration time of 2 ½ hours.
  - B. **Hot weather conditions:** Contractor shall take steps to keep the plaster application moist for the initial hydration period of 2 ½ hours.
  - C. Should a soft wall occur the contractor will apply one coat of Kel-Prime mixed 50/50 with water to plaster and let hydrate for 24 hours before the finish coat is applied.
  - D. **Certification:** Plaster contractor shall be trained and certified on the proper mixing, pumping and application of the Tuff-Kote/Flex 10,000—Kel-Prime one-coat plaster system.

Section 9002: Lathing and trim inspection

- A. General contractor and plasterer (sub-contractor) shall inspect all lathing and trims to confirm, and sign a joint statement that all lathing and trims have been properly installed in accordance with the manufacturer's specification, and the architect's plans and drawing.
- B. Lathing shall be properly attached so as to permit proper keying of the plaster, and a uniform thickness.

Section 9003: Materials

- A. Tuff-Kote/Flex 10,000 reinforced fiber mix design: 80-pound bags as manufactured by Incide Technologies or certified licensed sub-distributor/manufacturer.
- B. Kel-Prime bonding/sealing/curing/hardening agent by Kel-Crete Industries, Inc. or a certified licensed sub-distributor.

- C. Paint: acrylic water based paint that has been blocked with 8 ounces per gallon of Kel-Prime concentrate (no water added to Kel-Prime).
- D. Sand shall be clean washed plaster sand meeting ASTM requirements.
- E. Water: clean tap water only.

**Note: No fly ash shall be permitted in any plaster materials used for this project.**

#### Section 9004: Preparation

All windows, doors, electrical outlet areas, etc. that are not to receive plaster shall be protected by masking off or covering of such. Masking or covering materials shall be of a type that does not leave a residue on items to be protected.

#### Section 9005: Mixing for each 80-pound sack

- A. Water: Add a sufficient amount of water to the mixer to obtain a 2 ½” slump (See attached Exhibit “A”). The contractor shall consider the water content in the sand to determine the amount of water to be used.
- B. Sand: Add 3 ½ parts of sand (280 pounds) per 80-pound sack of Tuff-Kote/Flex 10,000 to the mixer.
- C. Tuff-Kote/Flex 10,000 to the mixer.
- D. Mixing time: Mix the total mix design 3 to 5 minutes (no more than 10 minutes) for a proper gelling of the mix design.
- E. Option: The contractor has the option to add **50%** of sand then add the Tuff-Kote/Flex 10,000, and then add the balance of the sand. This will allow faster gelling time of the mix design.

#### Section 9006: Application

- A. Plaster application shall be a full 3/8” thickness at all areas. **No exceptions.** The application shall be rodded, darbied, scraped or floated so as to leave the surface for the desired finish coat application in accordance with the architect’s specification.
- B. Finish coat application shall be 1/8” in thickness. The finish coat shall be of the same mix design as in “Section 9005” with possible change in the sand so as to obtain the desired texture of the architect’s specifications.
- C. Kel-Prime mixed 50/50 with clean tap water shall be applied to all plaster areas within 24 to 48 hours of the application.
- D. A ph reading shall be taken before “Item E” is applied. An acceptable ph reading is normally “48” obtained from the Kel-Prime application.
- E. Kel-Prime induced paint shall be applied to all plaster areas. Kel-Prime/paint shall be applied in accordance with ASTM standards.

Section 9007: Clean up

- A. Contractor shall remove all masking, coverings, etc. from the protected areas on the project.
- B. The contractor shall remove all waste materials from the project.
- C. The contractor shall remove all plaster equipment from the project.

Section 9008: Warranty

- A. Material suppliers and plaster contractor will provide a joint 10-year minimum warranty to remove and replace any plaster areas that are determined to be defective by the owners, general contractor and architect. The warranty covers any materials or labor that is considered not to be in accordance with the accepted ASTM standards or accepted practices.
- B. In the event that there is a conflict a third-party arbitrator (not connected) shall be obtained at the cost of all parties involved in the conflict.

Section 9009: Technical Service

Call Kel-Crete Industries, Inc. at 800-845-1833.

End of Suggested Specification

## **Exhibit “A”**

In the absence of a slump cone the following method may be used to obtain a 2 ½” to 3” slump for proper gelled mortar pumping:

1. Mix the mortar in accordance with Section 9005.
2. Dump the gelled mortar into the screen on the pump hopper.
3. Two-thirds of the mortar should pass through the screen by gravity.
4. One-third of the mortar should have to be shaken or vibrated through the screen.

### Summation:

The obtained results by following these instructions are:

1. Easier pumping.
2. Reduced fuel costs.
3. Reduced rebound.
4. Reduced equipment and repair costs.
5. Reduced labor costs.
6. Reduced material costs.
7. Increased psi values.
8. Greatly reduced shrinkage cracks.