

## Portland Cement Plaster – 3 Coat Stucco (new or existing)

### New Installations

#### Framing

- x Underlying framing/sheathing assembly shall be designed to limit deflection to L/360 under Code specified loading conditions.
- x Stud spacing – maximum 16” o.c.

#### Scratch and Brown Coats

- x New Portland cement scratch and brown coats are to be reinforced with alkali resistant fibers and mixed using a minimum of 1 part liquid acrylic admix to 4 parts water.
- x Portland cement plaster shall be a minimum 3/4” thick (scratch and brown coat) over paper and metal lath per Code requirements. *Galvanized diamond mesh metal lath is strongly recommended.*
- x Outside corners shall be reinforced with metal corner reinforcement e.g. 3x3 Corner Rite.
- x Corners at door and window openings shall be reinforced with 6” x 12” sections of galvanized diamond mesh lath set on a 45 degree diagonal with the corner.

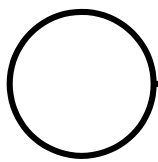
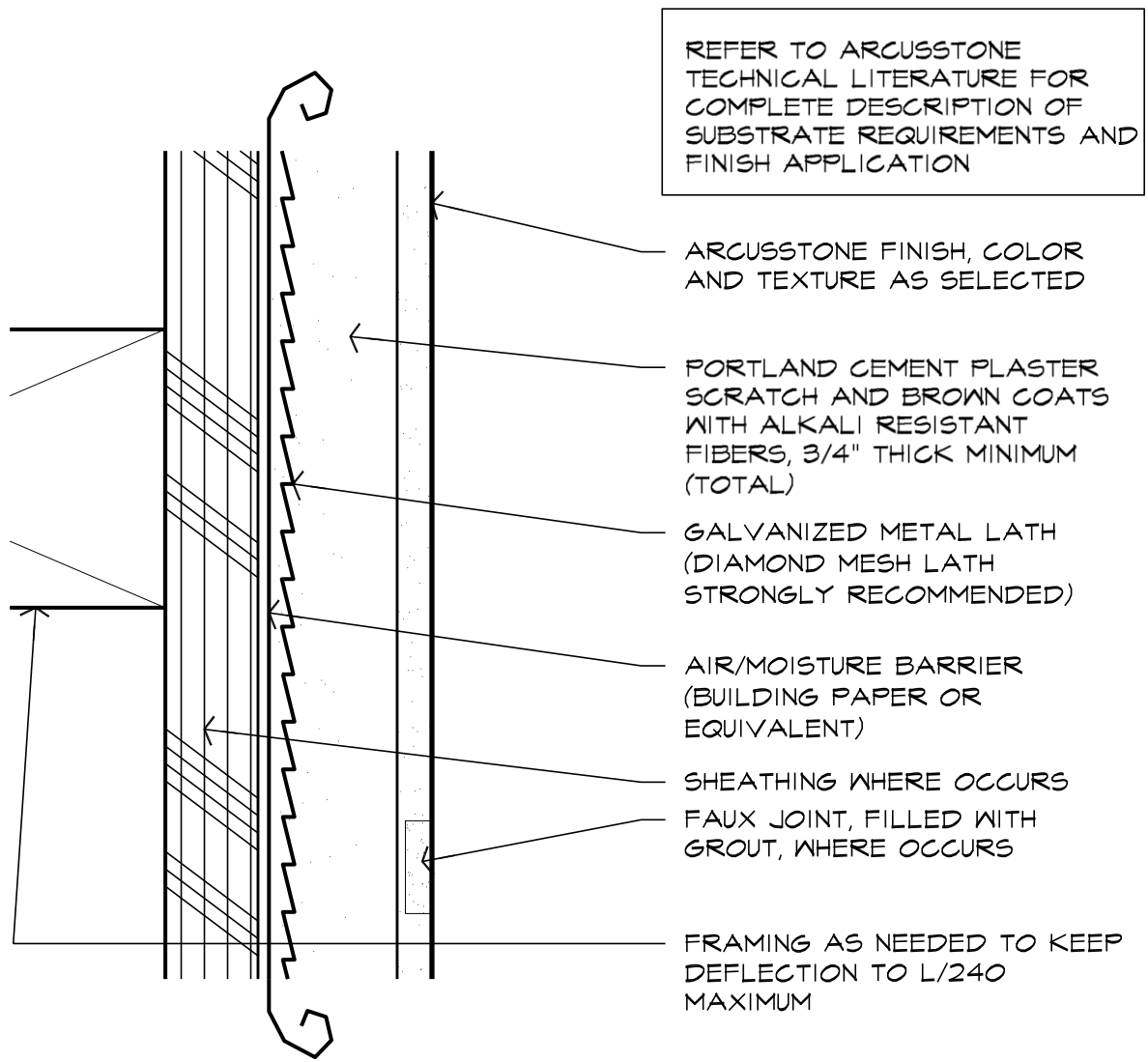
### New and Existing Installations

- x Finish frame / moldings for door, window, vent, and other openings are to be installed prior to the ArcusStone® material application.
- x Waterproofing, including required flashing and counter-flashing must be in place.
- x Metal, including lath, flashing, corner guards, and fasteners, are to be corrosion resistant (galvanized, stainless, etc.).
- x Dust and debris must be removed and the substrate cured properly as per the Code requirements for Portland cement plaster. Clean off all efflorescence or staining prior to any ArcusBond or ArcusStone material applications.
- x Check substrate surfaces for finishes to a tolerance of + 1/4” in 5’.
- x Cracks in the substrate are to be covered with Portland cement brown coat or EIFS basecoat with 4 ounce fiberglass mesh embedded the length of the crack and extended on all sides of the crack a minimum of 3 inches.
- x ArcusBond – Apply a generous and uniform coat of ArcusBond per manufacturer’s application instructions. Let dry before applying any ArcusStone finish.

New Installations – ArcusBond is NOT necessary for installation of ArcusStone materials over NEW stucco brown coats unless cracks have been treated (see above). It is recommended, however, to help: even out the suction; prevent “flashing” of the ArcusStone material due to rapid moisture loss; avoid unwanted color variations; and to aid in bonding the ArcusStone materials to the substrate.

Existing Installations – ArcusBond MUST be applied prior to any ArcusStone application.

*Note! Please review the Climatic / Environment Precautions Section for further details and information.*



## Portland Cement Plaster

### ArcusStone Substrate Preparation

Full Size

All substrates to be in compliance with local codes and regulations, substrate component manufacturer's requirements for installation, and ArcusStone Products' published guidelines.