

### Technical Data

#### COVERAGE

1 bag = .8 cubic feet, or  
approximately 20 sq. ft.  
@ 1/2" Thickness

#### TECHNICAL DATA

- Compressive Strength (C170) 2,000 PSI
- Tensile & Flexural Strength (C880) 650 pounds
- Material Density 75 lbs. / Cubic Feet

#### CURING

Although curing is accomplished through chemical reaction, weather conditions impart a measure of variability that must be considered. Hot, dry, and/or windy weather speeds up the reaction. Conversely, cold, damp weather will slow down the reaction. These variables may dramatically affect the progress of the cure. Common sense should dictate appropriate adjustments in timing the project..

#### DESCRIPTION

CarpenterStone TruCast Lightweight is a triple component lightweight bag mix that creates cast pieces that replace the heavy, bulky precast concrete architectural elements on and within construction. This new cementitious composite material has dynamic strength to weight ratios previously unachievable in the concrete industry. CarpenterStone Lightweight greatly reduces the materials and labor required to construct products such as traditional architectural detailing and panels. It has superlative readability of its mold that enables the finished product to look like stone, tile, rock, wood, or any imaginable shape or design. With a wide range of color selection design considerations are nearly limitless. CarpenterStone Lightweight provides a resolutely durable precast element for a pleasing architectural detail.

#### MIXING

TruCast Lightweight is packaged bag kit to be mixed in a mortar or concrete mixer. Mix times are affected in a large way by the mixer style selected. Among the most effective mixers for CarpenterStone Lightweight is the mortar or plaster mixer with a horizontal helix shaft.

Total mix time can take > 20 minutes. Note that mix will appear unreasonably dry. Do NOT add more liquid, wait for the chemical reaction to occur. The mix will only appear fluid near the end of the above process.

Total Mix Elements:	Mix Directions:
1 bag of dry mix	Add 2 gallons of water + 1 gallon of modifier
2 ½ gallons of water	Add color pack (if desired)
1 gallon of modifier	Start mixer, mix color for a couple of minutes
6 ounces of additive	Add 1 bag of dry mix into mixer
	Mix approximately 5 – 10 minutes
	Add 1 quart of water and 6 oz. additive
	Mix approximately 2 – 8 minutes
	<b>If needed</b> , add up to 1 additional quart of water
	Mix until consistency is that of oatmeal or grits

#### APPLICATION

Pour mixed material into form. While vibration is not absolutely required, it will help material to fill the form level, enhance readability, and reduce pin holes that may have been created by air. Any conventional molds will work for CarpenterStone Lightweight mix design. Appropriate form release is customarily necessary for good "pulls" from the molds. Material may be pulled in approximately 8 hours. However, thin pieces especially need extra care when pulling and handling. CarpenterStone Lightweight should cure for approximately 7 days before handling and a minimum of 14 days before installing.

After product is removed from the mold it may be stained or painted, but note that adding a liquid to product will slow the cure. Although not required, CarpenterStone Lightweight may be sealed with any clear sealers.

#### LIMITATIONS

Do not allow the Lightweight Modifier to freeze. Cast product in temperatures between 40° and 90° F. Competent contractors experienced in the placement of this product should apply this product.