

### Technical Data

#### COVERAGE

1 bag = 12 sq. ft.  
@ 1/2" Thickness

#### TECHNICAL DATA

- Compressive Strength (C170) 6,000 PSI
- Flexural Strength (C880) 1,200 PSI
- Abrasion Resistance (C1353-96) 20.00
- Bond Strength (C482) 80 PSI
- Material Density 135 lbs./cu. ft.
- Water Permeability (Not ASTM) 3 days/no leak

#### 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 countertop cure. Common sense should dictate appropriate adjustments in timing the project. Customarily countertops are cast in a controlled environment.

#### DESCRIPTION

**CarpenterStone TruCast** is a dual component bag mix that greatly reduces the materials and labor required to produce dense, strong cast products with superior aesthetic design. With the wide range of color selection and aggregate loading, design considerations are nearly limitless. CarpenterStone Cast Mix provides a high-end resolutely durable surface.

#### USES

TruCast can be used to cast virtually any horizontal or vertical product application. The product may be used for both pre-cast and cast-in-place application. Examples of uses include residential, commercial, or industrial countertops, cash wraps, serving surfaces, wall or floor tiles, fireplace hearths, reception areas, etc. It may also be used to fashion extreme design furniture and produce any manner of durable architectural panels.

#### CHEMICAL DESIGN

CarpenterStone TruCast combines the most advanced chemical technology with modern fiber advancements, to create an unparalleled cast mix design. This technology binds the raw materials of cement and sand with other ingredients into a stronger, denser cementitious composite than ever before possible, while providing enhanced user-friendly attributes to maximize design production techniques.

#### APPLICATION

Mix one gallon of the **CarpenterStone TruCast Modifier** into one 50-lb. bag of dry ingredients; and, add one color pack to integrally tint, if desired. (Add the color pack to the modifier and mix prior to introduction to the dry mix to ensure a thorough, homogenous mix of the color throughout the mix.) Mechanically mix for at least five minutes after all of the ingredients are combined to produce a lump-free consistency.

Pour the mixed material into the selected form or mold. While vibration is not required, it will help the material to fill the form level, enhance readability, and reduce pin holes that may have been created by trapped air. However, if so, do not vibrate vigorously as this may lead to segregation of the fibers.

Virtually any material may be used as a mold. (For example, rubber, foam, wood, metal, etc.) And, the end result will be directly related to the type of mold used. For example, if there is no requirement for a sophisticated intricate design or read, a foam mold is acceptable. However, if you wish to achieve a finely detailed wood grain look, a rubber mold will better provide that capability. To obtain a smooth, glossy surface, it is best to cast on a hard slick surface such as melamine or glass. Regardless, whatever type surface the material is cast upon, that is the look that you are going to receive.

Textures can also be achieved through the use of baking soda and other surface additives. Further, decorative aggregates may be loaded throughout the mix through adjustments to the mix design, if so desired. Alternatively, aggregate or other decorative elements may be added or seeded into the base of the form prior to placing the mix.

After approximately four hours, the piece may be pulled from the form. If desired, after approximately eight hours, the piece may be polished with diamond pads. Any pinholes may be filled with a slurry mix. Secondary coloring may also be applied, if desired.

Final sealing selection is dependent upon the desired finish, ranging from the simplicity of Butcher's Wax to the high build and gloss look, or a simpler, more natural concrete-look.