

MOULDING

KOMBI STUCCO

A coarse-grain moulding mortar for making drawn facade mouldings



MAIN ADVANTAGES

- Fast setting
- Hydrophobic
- Easy to apply and process
- Reinforced with microfibres 2 limited shrinkage and tensions during drying

AREAS OF APPLICATIONS

KOMBI STUCCO is a fast-setting mortar for making small size casts/moulds/mouldings. Fast-setting properties make it possible to remove casts from forms already after 1.5-2.0 hours. The mortar can be used both inside and outside buildings. **Note:** **KOMBI STUCCO** mortars should not be used to make parts featuring significant difference in thickness. The mortar is not suitable for use to moulding work on thermal insulation systems. In such applications EPS profiles should be used. Kombi Stucco does not contain components inducing chloride corrosion. **Note:** we recommend strengthening cross-section with reinforcing bars in case of making large-size castings or large changes in thickness.

TECHNICAL SPECIFICATION

Composition: mix of cements, mineral fillers and modifiers;

Temperature of application (air and substrate): from +5°C to +30°C;

Colour: white;

Grain size: up to 0.8 mm;

After adding water the product must be used within: approx. 10-15 minutes.

Setting time: ca. 1.5-2 hours (at an air temp. 20°C, RH 65%)

Note: Do not reuse dried mortar by adding water or mixing with fresh mortar.

Mixing ratio: ca. 8.0 l of water per 25 kg of dry mortar;

Gross dry density of hardened mortar: ca. 1 450 kg/ml;

Range of compressive strength: cat. CS IV;

Adhesion to substrate: ≥ 0.2 N/mm²;

Water absorption due to capillary action: cat. W₀;

Water vapour permeability coefficient: $\mu \leq 20$

Packaging: Disposable paper packaging containing 25 kg of the product

Storage: The product should be stored in its original sealed packaging in dry rooms, on pallets, at temperature ranging from +5°C to +25°C. Protect against moisture.

Shelf life: 6 months from the date of manufacture provided on the packaging.

APPLICATION METHOD

SUBSTRATE PREPARATION: Check the condition of substrate where the casts should be fixed -it should be sound, stable, even, dry and free from biological or chemical efflorescence. In case of algae and/or fungi growth apply ALGIZID agent. Old and/or dirty substrates should be washed off and degreased with water and **CLEANFORCE** cleaning agent. Any loose layers not bound to the substrate (i.e. dirt, dust, loose renders or flaked coatings) should be removed. If there is any large unevenness to the substrate, use a levelling compound. Absorbent substrates should be primed with **BUDOGRUNT ZG/WG** before applying the mortar. Typical setting time ca. 3 h under optimum conditions (at 20°, 55% RH).

MORTAR PREPARATION AND APPLICATION: Pour gradually the contents of the bag into a container with a measured amount of clean and cold water approx. 8.0 l per 25 kg of mortar and thoroughly mix (with a low-speed mixer fitted with a basket stirrer) until homogeneous mixture is obtained and immediately pour into the mould. **Note:** Both too long and too intensive mixing can lead to excessive aeration of the mortar and, consequently, a reduction in its strength parameters. Add water to such an amount of material to be used within 5-10 min. Remove immediately any material excess and dirt. It is recommended, if possible, to concentrate the mortar in the mould by vibrating it. By vibrating and slightly knocking the mould around, it is possible to remove any air bubbles from the mass. After about 1.5-2 hours, remove the cast from the mould to allow to dry it evenly. To allow for drying from all sides, the casts should be stored on wooden grates.

USEFUL HINTS: Do not speed up the drying process by exposing the casts to sunlight or wind. It is recommended to provide additional mechanical fixing of the profiles to the substrate. All tools should be cleaned with water immediately after finishing work. The manufacturer bears no responsibility for using the product without observing its intended application and instructions provided on the packaging. The cast requires seasoning before painting, taking one day to dry for every 1 mm of casting thickness (when drying at +20 °C and 65% relative humidity). The casts should be covered with highly diffusive paint coating, using **CALSILIT F**, **NOVALIT F** or **ARMASIL F** paints.