

**AMERISTONE™**

100% Acrylic-based finish with multi-coloured Quartz aggregates

**DSC142**

**Ameristone  
Spray Application Instructions**

**The following instructions apply to spray application equipment for Ameristone™ using a Hopper Gun.****A. Mock-up**

1. A minimum 2.4 m x 2.4 m (8 ft x 8 ft) area of actual project or mock-up wall must be sprayed with the Ameristone finish for the approval of the colour and texture by the owner/architect. Additionally, the mock-up serves to allow the applicators to familiarize themselves with the product and determine specific coverage rates for the job. The individual who will be spraying the project should be the one to make the mock-up. **The mock-up is a requirement and must be completed prior to ordering material for the job.**

**B. Material Preparation****1. Ameristone**

- a. Mix for approximately 1 minute with a "Twister" paddle or equivalent mixing blade powered by a 12.7 mm (1/2 in) drill at 450-500 RPM, just prior to application. Add water only to allow the material to flow. Mix all the pails the same length of time and make the same water-add to each pail for a particular batch. **DO NOT OVERMIX.**

**2. Color Prime™**

- a. Mix with a "Twister" paddle or equivalent mixing blade, powered by a 12.7 mm (1/2 in) drill at 450-500 RPM to a homogenous consistency.

**C. Surface Preparation**

1. It is essential that the Ameristone finish be applied to a clean, smooth, flat and level base coat or approved substrate. A spray finish will not hide surface imperfections. Sometimes it may be necessary to skim out the wall with the Dryvit Primus®, Genesis™, Primus® DM, Genesis™ DM or Genesis™ DMS mixtures to obtain a flat and level surface. Refer to appropriate Dryvit Product Data Sheet for mixing instructions and application.
2. Apply an even coat of the specified colour-coordinated Color Prime by brush, paint roller or spray equipment. Allow to dry at least four (4) hours or until completely dry.

**D. Application Conditions**

1. Air and surface temperatures for application of Ameristone must be **(10 °C) 50 °F or higher** and must remain so for a minimum of **48 hours**. Avoid spraying on windy days or airborne Ameristone material will mist unprotected areas. Also, on windy days there is a tendency to position the spray gun closer than 0.6 m (2 ft), which causes a milky, blotchy appearance. These areas will look different when compared to areas sprayed on calm days. Spray in the shade whenever possible. When spraying on areas exposed to direct sunlight, have someone shade the area being sprayed or work with the sun at a low angle.

**E. Hopper Guns Recommended**

1. All hopper guns are basically the same design and are gravity fed. Some have a dial orifice plate with various size openings, while others have individual plates with different size openings. Recommended brands are Goldblatt and Marshalltown.

**F. Compressor**

1. A compressor capable of maintaining 7 cubic feet per minute (CFM) above working pressure or a minimum tank pressure of 552 kPa (80 PSI) is needed for spraying with hopper guns. A four horsepower compressor is usually adequate.

**G. Air Pressure and Orifice Openings**

1. Different textures are achieved by regulating the air pressure. The higher the air pressure; the finer the texture. By decreasing the air pressure, the texture will be heavier. A working pressure range of 10 to 25 lbs. as determined by an air pressure gauge at the hopper gun is normally used. The applicator must find and maintain the pressure that produces the most desirable spray texture. The pressure should be noted so as to maintain it consistently throughout the job. An inline air regulator such as a Sears AirLine Regulator Model No. 282.160251 is recommended. Be sure to keep air pressure consistent throughout the project. The air compressor should maintain a constant air pressure without surging. Surging will cause texture variations.
2. The common orifice openings for Ameristone finish are 6.4 mm, 7.9 mm, or 9.5 mm (1/4 in, 5/16 in or 3/8 in). The larger the opening, the heavier the spray texture, and the smaller the opening, the finer the spray texture. Orifice openings smaller or larger than those listed above should not be used. The orifice plate should be inspected after spraying each panel and cleaned if needed. Excess material obstructing the orifice plate can change the texture delivered to the surface.

**H. Water Add**

1. Ameristone will usually flow well enough to be sprayed after being mixed **without the addition of water**. If the material will not spray easily after mixing, water can be added in small increments until a consistent material flow is obtained. The same amount of water must be added to all pails of a given batch. Do not exceed 6 ounces per pail. **A Dryvit Field Service Manager should be contacted if a given batch of Ameristone needs more than 6 ounces per pail of water to spray properly with a hopper gun.**

**I. Spray Techniques**

1. With the appropriate spray equipment, spray apply the Ameristone finish to the primed wall surface. Spray an initial pass left to right or up and down striving for a uniform coat covering the Color Prime. Small circular motions can be made with the spray unit while spraying. The spray unit must stay perpendicular to the wall

surface at all times and never be closer than 0.6 m (2 ft) to the wall surface. The individual spraying should focus their attention on the area of contact point of approximately 254 mm (10 in) in diameter where the material spray is highly concentrated. Follow this contact point closely when spraying. In doing so, the wall will be uniformly coated without a blotchy appearance. Spray a full panel or to a natural break or joint in the wall before doubling back with a second pass.

2. Double back with a lighter second pass perpendicular to the first. The second pass should be made while the material is still wet or tacky. Never allow the finish to be dry to the touch before spraying the second pass. On the second pass, hold the spray unit back from the wall a little farther, to 0.76 m to 0.91 m (2 1/2 to 3 ft). While spraying, look for the larger stones in the formulation to begin sticking consistently without bounce back. Once this begins to occur, the optimum thickness has been achieved. Strive for a uniform appearance, again focusing on the area of contact point as described above, and move on. Avoid spraying too thickly. All wall sections must be sprayed with the final pass in the same direction, either left to right or up and down. This is essential in panel plants as well. The panels must be sprayed in a vertical position and laid out in the same position as they would be installed on the building so the finish can be applied in the same direction.
3. Since no two applicators will have the identical spraying technique, the most uniform results will be obtained, if one applicator can spray the entire project or elevation. If this is not possible, ensure that each mechanic is using the same type of equipment, pressure level, orifice opening and spray distance(s) from the wall.

#### J. Achieving a Uniform Job

1. Whenever possible, utilize lift equipment that will allow a free range of motion for the sprayer and will eliminate the potential for scaffold lines. If scaffolding is used, it should be placed away from the wall so outriggers can be used to provide a free range of movement.
2. Enough material should be ordered to complete the entire project so it can be produced from the same production batch. Because of the natural aggregates used in the finish, slight colour variations can occur from batch to batch. When project size requires more than one production batch of Ameristone, be sure adjacent wall surfaces are sprayed with the same batch.
3. Do not spray Ameristone on surfaces that will receive caulk/sealant. These surfaces shall be coated with colour coordinated Color Prime.

#### K. Coverage

1. The optimum coverage for Ameristone is 5.6 m<sup>2</sup> (60 ft<sup>2</sup>) per pail, including over-spray waste. Determine the pails required to cover a particular section of wall as follows:

$$\text{Area of Wall (sq.ft.)} \div 60 = \text{Pails needed to cover}$$

Approximately 75% of the material should be used on the first pass and 25% on the second pass. Coverage rates can vary down to 5.1 m<sup>2</sup> (55 ft<sup>2</sup>) per pail depending upon the texture and if there are difficult objects such as aesthetic joints, bands, trims and ornate cornice to spray. Coverage should not exceed 6.0 m<sup>2</sup> (65 ft<sup>2</sup>) per pail. Greater coverage rates will result in background show through, mottling and inconsistent appearance.

**IMPORTANT: Ameristone must never be applied greater than 3.2 mm (1/8 in) thick including first and second passes. If applied greater than 3.2 mm (1/8 in), the Ameristone finish may form cracks or blisters resulting in localized delamination.**

#### L. Curing

1. The Ameristone finish must dry for a minimum of 48 hours under average drying conditions [21 °C (70 °F), 55% RH] in order to resist washoff, blistering or water whitening from rains. Cooler and/or more humid conditions will require a longer cure. Temperatures should remain above 10 °C (50 °F) during the cure period. Ameristone finish must be allowed to fully cure before being exposed to rain or freezing temperatures.

#### **DISCLAIMER**

Information contained in these application instructions conforms to standard detail and product recommendations for the installation of the Ameristone Finish as of the date of publication of this document and is presented in good faith. Dryvit Systems Canada assumes no liability, expressed or implied, as to the architecture, engineering or workmanship of any project. To insure that you are using the latest, most complete information, contact Dryvit Systems Canada.