



# DURACAST FACE MIX

Face Mix for Duracast GFRC System™

## PRODUCT DESCRIPTION

Deco-Crete (DC) DuraCast Face Mix is a cementitious blend of materials that, when mixed with DuraCast Modifier, forms a thin layer of concrete that picks up every detail in the mold. It is designed to be cast upside down & used in conjunction with DuraCast Modifier & DuraCast Backer Mix to result in an extremely lightweight, high strength, & long-lasting concrete surface. DC DuraCast Face Mix gives you the ultimate freedom for application method & can be spray applied or troweled & brushed to handle both horizontal & vertical applications. The DuraCast GFRC System™ includes 30 integral color options.



## TECHNICAL INFO

- + Working Time \_\_\_\_\_ 15–20 min.
- + Coverage \_\_\_\_\_ 20–30 sq. ft. per bag
- + Color \_\_\_\_\_ Gray or White
- + Packaging \_\_\_\_\_ 40lb. Bag
- + Clean-Up \_\_\_\_\_ Water

## RECOMMENDED APPLICATIONS

- + Concrete Countertops
- + Tables
- + Furniture
- + Wall Panels
- + Fireplace Surrounds

## QUICK FACTS

- + Demold in as little as 24 hrs.
- + Stronger & denser than traditional concrete at half the weight
- + Reduced Cracking & Spider Cracking
- + 30 Integral Colors Available with Mini Yard Pack System™
- + Unlimited Design Possibilities
- + Picks up EVERY detail in the mold
- + MADE IN THE USA



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## INSTRUCTIONS FOR USE

### MIXING

Start by adding 3½ qt. of DuraCast Modifier to a mixing container. Add a 40lb. bag of DuraCast Face mix & mix for 2 minutes, stopping once to scrape side walls. Wait 5-7 minutes for material to take a false set then remix for 1 more minute. If desired consistency is not achieved, add up to an additional ½ qt. of DuraCast Modifier to reach desired consistency for application.

### APPLICATION

Casting GFRC is done in two stages: a face coat without fiber, followed a by backer coat containing ARC Glass Fibers. No ARC Glass Fibers are used in the face coat so no fibers show through to the finished surface. Good bonding between layers is a crucial part to the GFRC process & **TIMING IS CRUCIAL!** Backer mix must be applied before face coat has completely dried out, but has set enough that the backer coat won't push through the surface & show fibers in the finish product.

Use a release such as Pol-Ease 2300 Release Agent on mold to ensure a clean separation when demolding.

**SPRAY TECHNIQUE:** The consistency of the sprayable face should be flowable enough to move through a hopper gun, but not so fluid that it runs off vertical formwork. Pour the mixture into a drywall hopper gun. Using 40 PSI as a starting point check the spray on a piece of cardboard. It should come out like wet splatter. The face coat creates the surface finish & should be around 1/8" thick. With a chip brush, angling the brush near flat to the surface, smooth the face coat in the mold to eliminate air pockets & bug holes.

**TROWEL TECHNIQUE:** The consistency should be similar to a thick latex paint. Using a bucket scoop, pour face coat into mold & spread with a magic trowel or steel pool trowel. The face coat creates the surface finish & should be around 1/8" thick. With a chip brush, angling the brush near flat to the surface, smooth the face coat in the mold to eliminate air pockets & bug holes.

### PRO TIPS

In most cases by the time the face coat tools are cleaned & the backer coat is mixed, that is a sufficient amount of time for the face coat to firm up. To check it use a gloved finger to touch the face coat. A face coat ready for backer mix will have the consistency of puddy but not leave residue on the glove. If face coat has firmed beyond that point, quickly use a spray bottle to prime the entire surface with DuraCast Modifier to gain adhesion.

It is always recommended to test the product in a small, inconspicuous area for desired results prior to application. Coverage rates may vary for all coatings & substrates depending on porosity, density, texture, etc.

## STORAGE

+ Store in a dry, covered area. Avoid moisture and direct sun.



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