



## CONCRETE CASTING

# XS FACE

## SPRAYABLE FACE COAT FOR GFRC



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# XtremeSeries

## XS FACE

### DESCRIPTION

**XS Face™** is a dual component cement based bag mix that perfectly reads the mold or casting surface upon which it is placed, providing a near flawless precast piece. It is not a “stand alone” mix, but is designed to be used in concert with **XS Precast** or **XS Backer**. **XS Face** greatly reduces the materials and labor required to construct traditional precast concrete. Reinforcement steel is eliminated, thinner precast pieces are routine, quicker production times are accomplished, and no “B” mold is required. A stronger, denser and more flexible cementitious composite is created by combining cutting-edge technology with modern fiber advancements. With a wide range of coloring and texture selections along with the manipulation of water demand and placement, design considerations are nearly limitless. **XS Face** produces concrete countertops, fireplace mantles and facades, shower surrounds, wall panels, furniture and many other architectural elements. **XS Face** is the perfect medium for residential, commercial, and industrial applications.

### TEMPERATURE/DRY/CURE

Fabrication of **XS Face** should be inside a shop. Casting should take place when shop temperature and all materials are maintained between 50°F (10°C) and 90°F (32°C) throughout all fabrication and curing. Product will dry and cure slower at cool temperatures and conversely, faster at warm temperatures. Full cure is reached at approximately 30 days, like concrete. Although rare, at high altitudes and dry climates, some pieces may require covering with plastic to slow the cure and avoid curling.

### MIXING

1. Utilize a handheld concrete mixer with a helical (spiral) mixer blade, such as an Eibenstock model #EHR 20R or similar.
2. Thoroughly mix **XS Precast Modifier**.
3. Add 1 gallon (3.8 liter) **XS Precast Modifier** to a clean 5 gal (18.9 L) pail or similar mixing vessel
4. Add **XS TruColor (color pack)** to **XS Precast Modifier** (if desired) and mix. Some design elements require the addition of and mixing up to 8 volumetric oz. (0.5 L) of **XS Packing**. For specific directions on **XS Packing** refer to its TDS
5. While mixing add approximately  $\frac{3}{4}$  of the **XS Face** bag.
6. Continue mixing until a loose, flowable consistency is achieved.
7. Scrape sides of pail with margin trowel to prevent dry pockets from forming.
8. Add remaining **XS Face** and continue to mix for 2 – 3 minutes.
9. Up to an additional 16 oz. (0.5 L) water may be added for a more fluid mix.

### APPLICATION

The most common method utilizes a traditional compressed air supplied hopper gun, such as Marshalltown Sharpshooter. Spray gun orifice should be approximately  $\frac{1}{4}$ " (6.3 mm) or a little larger. Air compressor should be set to approximately 40 PSI (276 kPa) with capacity of the delivery approximately 8 ft<sup>3</sup> (0.23m<sup>3</sup>) per minute. Other methods of application include by trowel or placed by hand.



### PACKAGING

50 lb (22.7 kg) bag

### MIXING RATIO

1 gal (3.8 L) **XS Precast Modifier** to 1 – 50 lb (22.7 kg) bag of **XS Face**  
+ up to 16 oz. (0.5 L) water

### COVERAGE

1 - 50 lb (22.7 kg) bag of **XS Face** =  
approx. 20 - 25 ft<sup>2</sup> @  $\frac{1}{4}$ " (1.9 – 2.3 m<sup>2</sup> @ 6.35 mm)  
OR 0.43 ft<sup>3</sup> (.01 m<sup>3</sup>)

### DENSITY

n/a

### COMPRESSIVE STRENGTH ASTM C-109-08

3 day - 9,340 PSI (64,397 kPa)  
7 day - 10,120 PSI (69,775 kPa)  
28 day - 10,120 PSI (69,775 kPa)

### FLEXURAL STRENGTH ASTM C-348-08

3 day - 820 PSI (5,654 kPa)  
7 day - 835 PSI (5,757 kPa)  
28 day - 660 PSI (4,551 kPa)

### TENSILE STRENGTH ASTM C190-85

3 day - 405 PSI (2,792 kPa)  
7 day - 490 PSI (3,378 kPa)  
28 day - 505 PSI (3,482 kPa)

### SHELF LIFE

Under normal conditions: **XS Face** bag mix and **XS Precast Modifier** when the container and packaging are kept dry and moisture free, out of direct sunlight, the shelf life of an unopened product is (12) months from the date of purchase. Additionally **XS Precast Modifier** should be protected from freezing. Storage for both products must be under roof and off the floor. Rotate inventory to maintain product that is within limits.

### DEMOLD

In warm weather 4-6 hours may be appropriate to de-mold. Cool temperature or pieces with extreme texture will require overnight drying. **XS Face** should not be left in the mold past a 24 hour period, as curling of the piece is likely. A freshly de-molded sample should be handled similar to granite or natural stone, and should be well supported above the work surface to allow the free flow of air around the piece.

### CLEANING

All **XS Face** samples require cleaning, except those that are to be polished. **SCR** diluted with water 3:1 (3 parts water to 1 part **SCR**) is recommended.

For specific directions on **SCR** refer to its TDS.

## SLURRY

**XS Slurry** fills pin holes and voids to create a smooth surface. For specific directions on **XS Slurry** refer to its TDS.

## POLISH

**XS Face** may be polished if desired.

1. Polish sample as soon as practical. Allow a minimum of 8 hours cure time.
2. Begin with wet grind with 100 grit diamond pad.
3. **LD1800** may be utilized with wet 100 grit grind to densify and fill pinholes with resultant color match slurry. For specific directions on **LD1800** refer to its TDS.
4. Allow **LD1800** and slurry to dry. Proceed with 200 grit and if any pinholes are still present add more **LD1800** and continue grinding.
5. Remove any excess dried slurry with the 200 grit.
6. Proceed through 400 grit polish. If stain and / or sealer is to be used do not polish past 400 grit, as a measure of profile must be maintained for stain penetration and sealer adhesion.
7. If desired and sealer is not used, one can continue polishing through 800 grit and beyond, however such a piece with no sealer is subject to staining.

## STAINING

**XS Face** accepts most concrete stains. **Eco-Stain** adds a desirable design element to any **XS Face** piece and is eco-friendly and UV stable. Staining customarily follows slurry. For specific directions on **Eco-Stain** refer to its TDS.

## SEALING

**XS Face** pieces are completed by sealing. Two distinct sealers have been created for **XS Face**:

- **XS-327** - hybrid water based polyurethane available in matte and gloss finish.
- **XS-PC12** - hybrid solvent based polyurea, color enhancing, high gloss mirror finish.

For specific directions on sealing refer to the appropriate TDS.

## SEAMING/ADHESION

100% silicone caulk provides an excellent seaming and adhesive fastening material, as it allows for movement of the precast piece. **XS Face** like any other concrete will undergo slight dimensional variations based upon its environment (e.g. shrinkage or expansion). Do not use caulking or adhesive that could "bleed" through the finished surface, such as petroleum based products. Large pieces and undermount sinks will require mechanical fastening.

## SUITABILITY SAMPLE

Always prepare an adequate number of test samples for suitability for products' intended use.

## CLEAN-UP

Before **XS Face** dries; spills and tools can be cleaned up with water.

## DISPOSAL

Contact your local government household hazardous waste coordinator for information on disposal of unused product.

## LIMITATIONS

For use by trained professionals that have read the complete TDS and SDS.

## WARRANTY

Warranty of this product, when used according to the directions, is limited to refund of purchase price, or replacement of product (if defective), at manufactures/seller's option. **SureCrete Design Products** shall not be liable for cost of labor or direct and/or incidental consequential damages.

## CAUTIONS

**KEEP OUT OF REACH OF CHILDREN. Inhalation:** Avoid prolonged breathing of airborne dust, particularly present during mixing. Use NIOSH approved respirator for nuisance if threshold limit values are unsafe. **Skin Contact:** Skin contact may cause irritation. Remove contaminated clothing and wash affected skin with soap and water. Launder clothing before reuse. If symptoms persist, seek medical attention. **Eyes:** Wear safety eye protection when applying. Contact with eyes may cause irritation. Flush eyes with water for 15 minutes. If symptoms persist, seek medical attention.

## SAFETY DATA SHEETS

The following are links to all available safety data sheets related to this product:

- [xtreme-series-xs-face-sds.pdf](#)
- [xtreme-series-xs-modifier-sds.pdf](#)