

BASIC USE: STAMPCRETE Iron Oxide pigments are specifically designed to be used in cementitious materials to produce various colored, stamped concrete surfaces. Coloring of concrete surfaces dramatically changes their aesthetic value from a dull gray to pleasing environmentally acceptable surfaces. The proper selection and use of STAMPCRETE colors can add new and lasting dimension to your project.

COMPOSITION and

MATERIALS: STAMPCRETE Natural and Synthetic Iron Oxides are available in a broad range of colors and blends. The three basic color groups, yellow, reds, and black, are each produced by select manufacturing methods. With yellow, red or black combinations. Stampcrete International, Ltd. has expanded the color range by formulating laboratory controlled high tinting strength blends for accurate color control. Each of these colors is 99 percent minus 325-mesh particle size for easy dispersing and maximum coloring power. The STAMPCRETE iron oxides are permanent, inert, stable to atmospheric conditions, sunfast, limeproof, and free of deleterious fillers and extenders. All Stampcrete colors comply with the ASTM 979 for integrally colored concrete.

PACKAGING: STAMPCRETE iron oxides are available in dry powder. Standard packaging is 9 to 18 pound pails.

COLOR RANGE: STAMPCRETE Iron Oxides are available in many standard colors. By altering the percentage of color added to the cement, the potential color shades are virtually unlimited.

LIMITATION: A level of 10% color based on the weight of total cementitious material used is the color saturation point. *Color added in excess of 10% will not provide*

additional benefits and can significantly reduce the overall strength of the finished surface. Conversely, a level of color below 1% can cause irregular coloring and a general "washed out" appearance. The suggested "optimum" range is 2% to 7% pigment loading based on the total cementitious material weight.

ADMIXTURES: Stampcrete colors contain no admixture such as calcium chloride, water reducing agents, or air entrainments. The use of these admixtures can produce changes in the uniformity of non-colored gray cement, subsequently their use with Stampcrete colors must be controlled carefully. When admixtures are a part of the job's mix design, their use must be employed equally throughout the job to ensure consistent colors.

INTEGRALLY COLORED

CONCRETE SPECIFICATION: Depending upon the compressive strength required for the concrete, utilize the proper mix design to achieve 4,000 PSI. The proportion of normal weight concrete should be in accordance with ACI 301 standards. Mix Stampcrete color pigment number 5C-with designated mix design at the rate of 3 pounds per each 94 lb. Bag of portland cement. Color weight should not exceed 10% of the weight of cement.

INTEGRAL COLORING

METHOD:

The key to effective integral color in concrete surfaces is consistency. For best color results, use between 2lbs. and 7lbs. of pigment per 100lbs. of cement. Always add ingredients in the same order of each batch. Generally, color addition should be after the aggregate charge and before major water and cement addition. A water to cement ratio should not exceed .45 for best mixing results. However, a value less than .30 may not allow

enough water for proper cement hydration and workability. A minimum mix time of 15 minutes after color addition is recommended for best dispersion results. During each job ingredients such as sand, gravel, and cement should be consistent as to source or brand use.

FINISHING: The methods of finishing the colored concrete surfaces should be performed consistently to avoid discoloration in the finished job. Finishing should not begin until surface water has left the surface. Avoid sprinkling water or dusting cement on the surface when finishing. Customary finishes are possible depending on the texture desired, whether it be broom, rotary, textured, or pattern, final strokes should be in the same direction.

WARRANTY

Stampcrete International, Ltd. warrants that this product will be free from defects and will perform as represented in writing provided application of product is in accordance with manufacturer's recommendations and application instruction. Stampcrete International, Ltd. will refund the purchase price of any product proven defective, but shall in no way be liable for indirect, consequential, special or resultant damages, whether due to breach of warranty or negligence. Stampcrete International, Ltd. makes no guarantee or warranty, express or implied, including, without limitation, warranties of fitness or merchantability, with respect to this product.

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