



Sto Specification S 103 E

StoPowerwall™ NExT Stucco: Fiber Reinforced Portland Cement Stucco with Fluid Applied Waterproof Air Barrier for Concrete, Masonry and Frame Construction

Section 09 24 23 – Portland Cement Stucco

This document is intended for use by the design/construction professional and any user of Sto products to assist in developing project specifications for residential and commercial construction, and to provide guidance on the application of StoGuard® Waterproof Air Barrier and StoPowerwall Stucco to sound supporting construction. StoGuard is a fluid applied waterproof air barrier for wall sheathing and concrete/masonry surfaces. It functions in tandem with other air barrier components of the building envelope to create an air barrier system. An asphalt saturated felt or paper water-resistive barrier is required by code over StoGuard as a slip sheet for wood-based sheathing and is similarly recommended over gypsum sheathings. For complete technical information on StoGuard, including design considerations for air barriers in wall assemblies, consult the [StoGuard Waterproof Air Barrier Handbook found at www.stocorp.com](http://www.stocorp.com).

StoPowerwall Stucco is a portland cement plaster that serves as a base for Sto acrylic, silicone enhanced and elastomeric finish coatings. StoPowerwall Stucco functions as a decorative and protective exterior wall covering and may also be used on soffits, ceiling and interior walls. As with any exterior wall covering the proper integration of other components of construction, in particular, the use of flashing to direct water to the exterior, is essential. Efflorescence is a normal occurrence in portland cement based products and can affect final appearance of finish products installed over stucco. Some degree of cracking is normal in portland cement stucco and should be expected. Cracking is generally not caused by a material defect in the stucco and can be minimized by following sound construction practice such as the proper installation of lath, the use of properly graded sand, the proper incorporation of stress relief joints in the construction, moist curing of the stucco after it has been applied, and proper sequencing of construction to avoid stresses in the freshly placed stucco. Specific wall assemblies incorporating StoPowerwall Stucco are also listed in code compliance reports available on request from Sto Corp. or from ICC Evaluation Services, Inc. This specification provides a guideline for the use and specification of StoGuard Waterproof Air Barrier with StoPowerwall Stucco. Notes in Italics, such as this one, are explanatory and intended to guide the design professional/specifier and user in the proper selection and use of materials. This specification should be modified where necessary to accommodate individual project conditions.

PART 1 GENERAL

1.01 SECTION INCLUDES

- A. Materials and installation of waterproof air barrier and slip sheet over sheathing, concrete, and concrete masonry surfaces. Materials and installation of exterior stucco wall covering.

1.02 RELATED SECTIONS *(add/delete, depending on specific project requirements):*

- 1. Section 03300: Cast-In-Place concrete
- 2. Section 04200: Unit Masonry
- 3. Section 06115: Sheathing
- 4. Section 07190: Vapor Barriers
- 5. Section 07270: Air Barriers
- 6. Section 07500: Membrane Roofing

7. Section 07620: Sheet Metal Flashing and Trim
8. Section 07920: Sealants and Caulking
9. Section 08400: Exterior Entrance Doors
10. Section 08500: Exterior Windows
11. Section 09260: Gypsum Board Systems

1.03 REFERENCES

A. ASTM Standards:

1. A 641 Standard Specification for Zinc-Coated (Galvanized) Carbon Steel Wire
2. A 653 Specification for Sheet Steel Zinc coated (Galvanized) by the Hot-Dip Process, Commercial Quality
3. B 69 Specification for Rolled Zinc
4. C 578 Specification for Preformed, Cellular Polystyrene Thermal Insulation
5. C 847 Standard Specification for Metal Lath
6. C 897 Standard Specification for Aggregate for Job-Mixed Portland Cement-Based Plasters
7. C 1032 Standard Specification for Woven Wire Plaster Base
8. C 1063 Standard Specification for Installation of Lathing and Furring for Portland Cement Plaster
9. C 1177 Specification for Glass Mat Gypsum for Use as Sheathing
10. C 1278 Specification for Fiber-Reinforced Gypsum Panel
11. C 1396 Standard Specification for Gypsum Board
12. D 1784 Specification for Rigid Poly (Vinyl Chloride) (PVC) Compounds and Chlorinated Poly (Vinyl Chloride) (CPVC) Compounds
13. D2247 Practice for Testing Water Resistance of Coatings in 100% Relative Humidity
14. D4541 Test Method for Pull-Off Strength of Coatings Using Portable Adhesion Tester
15. E 84 Test Method for Surface Burning Characteristics of Building Materials
16. E 96 Test Methods for Water Vapor Transmission of Materials
17. E 119 Method for Fire Tests of Building Construction and Materials
18. E 136 Behavior of Materials in Vertical Tube Furnace at 750°C
19. E 283 Test Method for Determining the Rate of Air Leakage Through Exterior Windows, Curtain Walls, and Doors Under Specified Pressure Differences Across the Specimen
20. E 330 Test Method for Structural Performance of Windows, Curtain Walls, and Doors by Uniform Static air Pressure Difference
21. E 331 Test Method for Water Penetration of Exterior Windows, Curtain Walls, and Doors by Uniform Static Air Pressure Difference
22. E 2430 Standard Specification for Expanded Polystyrene (“EPS”) Thermal Insulation Boards For Use in Exterior Insulation and Finish Systems (“EIFS”).
23. G 155 Standard Practice for Operating Light-Exposure Apparatus (Xenon-Arc Type) With and Without Water for Exposure of Nonmetallic Materials

B. APA Engineered Wood Association

1. E 30 Residential and Commercial Construction Guide

C. EIMA (EIFS Industry Members Association)

1. EIMA Guideline Specification for Expanded Polystyrene (EPS) Insulation Board
- D. Gypsum Association
 1. GA-253 Application of Gypsum Sheathing
- E. ICBO ES (International Conference of Building Officials Evaluation Service)
 1. AC 11 Acceptance Criteria for Coatings Cementitious Exterior Wall
 2. AC 212 Acceptance Criteria for Water-resistive Coatings Used as Water-resistive Barriers over Exterior Sheathing
- F. Proprietary Publications
 1. Sto S422 StoGuard Waterproofing Air Barrier Handbook

1.04 DESIGN REQUIREMENTS

- A. Structural (wind and axial loads)
 1. Design for maximum allowable deflection, normal to the plane of the wall, of L/360
 2. Design for wind load in conformance with code requirements. Consult applicable code compliance report.
- B. Moisture Control
 1. Prevent the accumulation of water into or behind the stucco, either by condensation or leakage into the wall construction, in the design and detailing of the wall assembly.
 - a. Provide corrosion resistant flashing to direct water to the exterior where it is likely to penetrate components in the wall assembly, including, above window and door heads, beneath window and door sills, at roof/wall intersections, decks, abutments of lower walls with higher walls, above projecting features, and at the base of the wall.
 - b. Air Leakage Prevention—prevent excess air leakage in the design and detailing of the wall assembly. Provide continuity between air barrier components in the wall assembly. Refer to StoGuard™ Air Barrier and Moisture Control Handbook.
 - c. Vapor Diffusion and Condensation—perform a dew point analysis of the wall assembly to determine the potential for accumulation of moisture in the wall assembly as a result of water vapor diffusion and condensation. Adjust insulation thickness and/or other wall assembly components accordingly to minimize the risk of condensation. Avoid the use of vapor retarders on the interior side of the wall in warm, humid climates.
 - d. Provide StoGuard™ Waterproofing/Air Barrier over sheathing, concrete and masonry.
 - e. At expansion joints, back joints with barrier membrane. Refer to Sto details at www.stocorp.com.
- C. Grade Condition
 1. Do not specify the stucco for use below grade or on surfaces subject to continuous or intermittent water immersion or hydrostatic pressure. Provide minimum 4 inch (100 mm) clearance above earth grade, minimum 2 inch (51 mm) clearance above

finished grade (pavers/sidewalk). Provide increased clearance in freeze/thaw climate zones.

- D. Sloped surfaces, including Foam Trim and Projecting Architectural Features attached to stucco.
1. Avoid the use of stucco on build-outs or weather exposed sloped and horizontal surfaces (refer to 2 and 3 below).
 2. Build out trim and projecting architectural features from the stucco wall surface with code compliant EPS foam. All foam trim and projecting architectural features must have a minimum 1:2 [27°] slope along their top surface. All foam horizontal reveals must have a minimum 1:2 [27°] slope along their bottom surface. Increase slope for northern climates to prevent accumulation of ice/snow and water on surface. Where trim/feature or bottom surface of reveal projects more than 2 inches (51 mm) from the face of the wall plane, protect the top surface with waterproof base coat. Avoid the use of trim and features that exceed the maximum allowable thickness of EPS permitted by code (typically 4 inches [100 mm]) unless approved by the code official. Periodic inspections and increased maintenance may be required to maintain surface integrity of finishes on weather exposed sloped surfaces. Limit projecting features to easily accessible areas and limit total area to facilitate maintenance and minimize maintenance burden. Refer to Sto details at www.stocorp.com.
 3. Do not use EPS foam on weather exposed projecting ledges, sills, or other projecting features unless supported by framing or other structural support and protected with metal coping or flashing. Refer to Sto details at www.stocorp.com.
- E. Joints
1. Provide two piece expansion joints in the stucco system where building movement is anticipated: at joints in the substrate or supporting construction, where the system is to be installed over dissimilar construction or substrates, at changes in building height, at floor lines, at columns and cantilevered areas. Provide one piece expansion/control joints every 144 ft² (13 m²)*. Do not exceed length to width ratio of 2-1/2:1 in expansion joint layout and do not exceed more than 18 feet (5.5 m) in any direction without an expansion joint. Cut and wire tie lath to the expansion/control joint accessory so lath is discontinuous beneath the accessory. At expansion joints, back the joint with barrier membrane. Refer to Sto details at www.stocorp.com.
- *Note: the requirement for a one piece expansion/control joint every 144 ft² (13 m²) may be waived when two-piece expansion joints exist every 144 ft² (13 m²).*
2. Provide one piece expansion/control joints at through wall penetrations, for example, above and below doors or windows.
- Note: the requirement for one piece expansion/control joints at through wall penetrations may be waived in the following case: when another type of expansion joint is provided in lieu of the one piece expansion/control joint, for example, back-to-back casing beads.*
3. Provide minimum 3/8 inch (9 mm) wide joints where the system abuts windows, doors and other through wall penetrations.
 4. Provide appropriate accessories at stucco terminations and joints.
 5. Provide appropriate sealant at stucco terminations.
 6. Indicate location of joints, accessories and accessory type on architectural drawings.

F. Fire Protection

1. Do not use foam trim in excess of 4 inches (100 mm) thick unless approved by the code official.
2. Refer to the applicable code compliance report for other limitations and fire-resistive assemblies that may apply.

G. Stucco Thickness: General

1. Application to Metal Plaster Bases:
 - a. Woven wire fabric lath: stucco thickness shall be ½ inch (13 mm) applied in one or two coats
 - b. Galvanized diamond mesh metal lath:
 - i. Minimum 1.75 lb/yd² (1 kg/m²): stucco thickness shall be ½ inch (13 mm) applied in one or two coats.
 - ii. Minimum 2.5 lb/yd² (1.4 kg/m²): stucco thickness shall be ½ to ⅞ inch (13 to 22 mm). ½ inch (13 mm) thickness shall be applied in one or two coats. Thicknesses in excess of ½ inch up to ⅞ inch (13 up to 22 mm) shall be applied in two coats.
2. Thickness shall be uniform throughout the wall area.

H. Stucco Thickness: Specific

See ICC-ES Evaluation Report ESR-2323 for required thickness and construction of listed wind resistant and fire-resistive assemblies. See ICC-ES Evaluation Report ESR-1233 for listing of the Sto Guard moisture and air barrier construction.

1.05 PERFORMANCE REQUIREMENTS

A. StoGuard Waterproof Air Barrier

TEST	METHOD	CRITERIA	RESULTS
1. Aging/Water Penetration Resistance	AATCC 127 and ICC ES AC 212 (Water Column)	Resist 21.6 in (55 cm) water for 5 hours before and after aging	No water penetration before and after aging
2. Water Resistance Testing	ASTM D 2247	Absence of deleterious effects after 14 day exposure	No deleterious effects after 14 day exposure
3. Water Vapor Transmission	ASTM E 96 Method B (Water Method)	Measure	Sto Gold Fill®: 7.10 perms [408 ng/(Pa·s·m ²)] Sto EmeraldCoat®: 17.0 perms [976 ng/(Pa·s·m ²)]
4. Air Leakage: Sto Gold Fill	ASTM E 283 (CCMC Technical Guide Method)	<0.003 ft ³ /min·ft ² at 1.57 psf (<0.02 L/s·m ² at 75 Pa)	0.0002 ft ³ /min·ft ² (0.0014 L/s·m ²)

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5. Tensile Adhesion	ASTM D 4541	>15 psi (103 kPa)	Gypsum (ASTM C 79): 16.5 psi (114 kPa) Gypsum (ASTM C 1177): > 15.8 psi (109 kPa) Exposure 1 OSB: 62.6 psi (432 kPa) Exterior Plywood: 91.0 psi (627 kPa)
6. Surface Burning	ASTM E 84	Flame Spread: <25 Smoke Developed: <450	Flame Spread: <25 Smoke Developed: <450 NFPA or ICC Class A building material

B. StoPowerwall Stucco

TEST	METHOD	CRITERIA	RESULT
1. Accelerated Weathering	ASTM G 155	2000 hours	No chalking, cracking, checking, crazing, or erosion
2. Freeze-Thaw	ICBO AC 11	10 cycles	No cracking, checking or crazing
3. Surface Burning	ASTM E 84	Flame spread of less than 25, Smoke Developed of less than 450	Flame Spread: < 5 Smoke Developed: < 10 NFPA or ICC Class A building material
4. Fire Resistance	ASTM E 119	One hour fire resistive rating	Pass, refer to ICC-ES ESR 2323 for listed assemblies.
5. Combustibility	ASTM E 136	Noncombustible Material	Pass
6. Wind Loads	ASTM E 330	Allowable design pressure	Pass, refer to ICC-ES ESR 2323 for listed assemblies..

*Note: refer to the appropriate Sto Technical Bulletin for performance data on Sto finishes for use over StoPowerwall Stucco.

1.06 SUBMITTALS

- A. Manufacturer's specifications, details, installation instructions and product data.
- B. Manufacturer's code compliance reports.
- C. Manufacturer's standard warranty.
- D. Samples for approval as directed by architect or owner.
- E. EPS board manufacturer's certificate of compliance with ASTM E 2430-05, *Standard Specification for Expanded Polystyrene ("EPS") Thermal Insulation Boards For Use in Exterior Insulation and Finish Systems ("EIFS")*.
- F. Prepare and submit project-specific details (when required by contract documents).

1.07 QUALITY ASSURANCE

- A. Manufacturer requirements

1. Waterproof air barrier and stucco products manufacturer for a minimum of twenty (20) years.
 2. Waterproof Air barrier and stucco finish products manufactured under ISO 9001:2000 Certified Quality System and ISO 14001:2004 Environmental Management System.
- B. Contractor requirements
1. Insured and engaged in application of portland cement stucco for a minimum of three (3) years.
 2. Knowledgeable in the proper use and handling of Sto materials.
 3. Employ skilled mechanics who are experienced and knowledgeable in waterproofing/air barrier, lathing and furring, portland cement stucco application, and familiar with the requirements of the specified work.
 4. Successful completion of minimum of three (3) projects of similar size and complexity to the specified project.
 5. Provide the proper equipment, manpower and supervision on the job site to install the system in compliance with Sto's published instructions and details and the project plans and specifications.
- C. Insulation board manufacturer requirements
1. Recognized by Sto as capable of producing insulation board to meet system requirements, and hold a valid licensing agreement with Sto.
 2. Listed by an approved agency.
 3. Label insulation board with information required by Sto, the approved listing agency, and the applicable building code.
- D. Mock-up Testing (for projects of sufficient size or complexity)
1. Construct full-scale mock-up of typical stucco/window wall assembly with specified tools and materials and test air and water infiltration and structural performance in accordance with ASTM E 283, E 331 and E 330, respectively, through independent laboratory. Mock-up shall comply with requirements of project specifications. Where mock-up is tested at job site maintain approved mock-up at site as reference standard. If tested off-site accurately record construction detailing and sequencing of approved mock-up for replication during construction.
- E. Inspections
1. Provide independent third party inspection where required by code or contract documents.
 2. Conduct inspections in accordance with code requirements and contract documents.

1.08 DELIVERY, STORAGE AND HANDLING

- A. Deliver all materials in their original sealed containers bearing manufacturer's name and identification of product.
- B. Protect coatings (pail products) from freezing and temperatures in excess of 90°F (32° C). Store away from direct sunlight.

- C. Protect Portland cement based materials (bag products) from moisture and humidity. Store under cover off the ground in a cool, dry location.

1.09 PROJECT/SITE CONDITIONS

(Weather conditions affect application, drying time and curing requirements. Hot or dry conditions limit working time and accelerate drying and may require adjustments in application, scheduling and curing to achieve desired results; cool or damp conditions extend working time and retard drying and may require added measures of protection against wind, dust, dirt, rain and freezing.)

- A. Maintain ambient and surface temperatures above 40°F (4°C) during application and drying period of waterproofing/air barrier. Maintain ambient and surface temperatures above 40°F (4°C) during application and for 24 hours after set of stucco.
- B. Provide supplementary heat for installation in temperatures less than 40°F (4°C) such that temperatures are maintained as in 1.08A. Prevent concentration of heat on uncured stucco and vent fumes and other products of combustion to the outside to prevent contact with stucco.
- C. Prevent uneven or excessive evaporation of moisture from stucco during hot, dry or windy weather. For installation under any of these conditions provide special measures to properly moist cure the stucco.
- D. Provide protection of surrounding areas and adjacent surfaces from application of materials.
- E. Prevent excess interior humidity (for example, caused by the use of temporary interior propane heaters) during and after construction.

1.10 COORDINATION/SCHEDULING

(The work in this section requires close coordination with related sections and trades. Sequence work to provide protection of construction materials from weather deterioration)

- A. Protect sheathing from climatic conditions to prevent weather damage until the installation of the waterproof air barrier.
- B. Provide protection of the waterproofing/air barrier installation with stucco no later than 60 days after installation.
- C. Commence the stucco installation after completion of all floor, roof construction and other construction that imposes dead loads on the walls to prevent excessive deflection (and potential cracking) of the stucco.
- D. Sequence interior work such as drywall installation prior to stucco installation to prevent stud distortion (and potential cracking) of the stucco.
- E. Provide site grading such that the stucco terminates above earth grade minimum 4 inches (100 mm) and above finished grade (pavers/sidewalk) minimum 2 inches (51 mm). Provide increased clearance in freeze/thaw climate zones.
- F. Coordinate installation of foundation waterproofing, roofing membrane, windows, doors and other wall penetrations to provide a continuous air barrier. Provide protection of rough openings before installing windows, doors, and other penetrations through the wall and

provide sill flashing. Coordinate installation of waterproofing/air barrier components with window and door installation to provide weather proofing of the structure and to prevent moisture infiltration and excess air infiltration.

- G. Install window and door head flashing immediately after windows and doors are installed.
- H. Install diverter flashings wherever water can enter the wall assembly to direct water to the exterior.
- I. Install copings and sealant immediately after installation of the stucco and when finish coatings are dry.
- J. Attach penetrations through stucco to structural support and provide air tight and water tight seals at penetrations.

1.11 WARRANTY

- A. Provide manufacturer's standard warranty.

PART 2 PRODUCTS

2.01 MANUFACTURERS

- A. Sto Corp.
- B. Provide waterproof air barrier, stucco, primer and finish from single source manufacturer.

2.02 WATERPROOF AIR BARRIER

- A. StoGuard-- fluid applied waterproof air barrier for sheathing substrates consisting of three components: (Choose either Sto Emerald Coat, Sto Gold Fill and Sto Guard Mesh or Emerald Coat, StoGuard Fabric and StoGuard RediCorner)
 - 1. Sto Gold Fill -- ready mixed acrylic based flexible joint treatment for rough opening protection, joint treatment of wall sheathing, and connections with flashing
 - 2. Sto EmeraldCoat -- ready mixed flexible waterproof coating for wall sheathing
 - 3. StoGuard Mesh-- nominal 4.2 oz/yd² (142 g/m²), self-adhesive, flexible, symmetrical, interlaced glass fiber fabric, with alkaline resistant coating for compatibility with Sto materials (used with Sto Gold Fill to reinforce rough openings, inside and outside corners, sheathing joints, and connections with flashings)
 - 4. StoGuard Fabric—nonwoven cloth reinforcement used with Sto Emerald Coat to treat sheathing joints, inside and outside corners and rough openings
 - 5. StoGuard RediCorner—a preformed fabric piece used in the corners of the rough openings for quicker installation of the StoGuard system.

2.03 SLIP SHEET

(A slip sheet is required between StoGuard and lath unless the local code authority permits omission of the slip sheet)

- A. Slip Sheet – minimum No. 15 asphalt saturated felt complying with ASTM D 226, Type 1, or one layer of Grade D kraft building paper, or paperbacked stucco lath conforming to 2.04.

2.04 LATH (supplied by others; select one depending on type construction and refer to applicable code report for specific assemblies listed with woven wire fabric and 1.75 lb/yd² [1 kg/m²] metal lath.)

- A. Minimum No. 20 gauge 1 inch (25 mm) self-furred galvanized steel woven wire fabric in compliance with ASTM C 1032, or minimum 1.75 lb/yd² [1 kg/m²] galvanized steel diamond mesh metal lath in compliance with ASTM C 847 (recommended for residential [one and two family dwellings] and light commercial construction)
- B. Minimum 2.5 lb./yd² (1.4 kg/m²) self-furred galvanized steel diamond mesh metal lath in compliance with ASTM C 847 (recommended for residential and commercial construction)

(Note: metal lath is susceptible to corrosion in coastal environments. Provide weather protection to prevent moisture entry into wall construction as outlined in Design Requirements Section 1.04B)

2.05 MECHANICAL FASTENERS (supplied by others)

- A. Appropriate non-corroding fasteners, depending on the type framing
 - 1. Wood Framing—minimum 11 gauge, 7/16 inch (11 mm) diameter head galvanized roofing nails with minimum ¾ inch (19mm) penetration into studs or minimum #8 Type S wafer head fully threaded corrosion resistant screws with minimum ¾ inch (19 mm) penetration into studs.
 - 2. Steel Framing—minimum #8 Type S or S-12 wafer head fully threaded corrosion resistant screws with minimum ⅝ inch (10 mm) penetration into studs.
 - 3. Concrete or Masonry—minimum #8 wafer head fully threaded corrosion resistant screws for masonry with minimum 1 inch (25 mm) penetration into substrate.

Note: pull-out or withdrawal capacity of the selected fastener must be verified with respect to anticipated wind load, desired safety factor and building code requirements. Consult applicable code compliance report for specific assemblies and fastening schedules. Care must be taken when attaching metal lath or other wall assembly components so that fasteners go into (not between) framing supports. Powder actuated or other fastening devices that can damage the water-resistive barrier or sheathing should be avoided.

- B. Tie Wire—18 gauge galvanized and annealed low-carbon steel in compliance with ASTM A 641 with Class I coating.

2.06 ACCESSORIES (supplied by others, select one type)

- A. Weep screed, casing bead, corner bead, corner lath, expansion and control joint accessories. All accessories shall meet the requirements of ASTM C 1063 and its referenced documents:
 - 1. PVC plastic in compliance with ASTM D 1784, cell classification 13244C.
 - 2. Zinc in compliance with ASTM B 69.
 - 3. Galvanized metal in compliance with ASTM A 653 with G60 coating.
- B. All accessories shall have perforated or expanded flanges and shall be designed with grounds for the specified thickness of stucco.

(Note: metal accessories are susceptible to corrosion in coastal environments. Consider the use of zinc alloy or PVC accessories in these environments. Metal corner beads with solid metal noses are susceptible to corrosion in exposed exterior applications. Consider the use of several layers of woven-wire mesh in lieu of corner bead and completely encase the metal in stucco).

2.07 JOB MIXED INGREDIENTS

- A. Water—clean and potable.
- B. Clean, well graded sand free of deleterious materials in compliance with ASTM C 897 or ASTM C 144.
- C. Stucco Admixture
 - 1. Sto Bonding Agent—acrylic admixture for StoPowerwall Stucco.

2.08 STUCCO (*select one*)

- A. StoPowerwall Stucco — factory proportioned, fiber reinforced portland cement based stucco for trowel or pump application, field mixed with graded sand and water.
- B. StoPowerwall Stucco Polymer Modified — polymer modified, factory proportioned, fiber reinforced portland cement based stucco, field mixed with graded sand, water and Sto Bonding Agent and Admixture.

2.09 FOAM BUILD-OUTS

- A. Adhesive
 - 1. Sto BTS-Plus-one component, polymer modified, cement based high build adhesive.
- B. Insulation Board
 - 1. Sto EPS Insulation Board-nominal 1.0 lb/ft³ (16 kg/m³) Expanded Polystyrene (EPS) Insulation Board in compliance with ASTM C 578 Type I requirements, and ASTM E 2430-05, Standard Specification for Expanded Polystyrene (“EPS”) Thermal Insulation Boards For Use in Exterior Insulation and Finish Systems (“EIFS”).

(Note: minimum required thickness is 1 inch [25 mm] and maximum allowable thickness is typically 4 inches [100 mm] for noncombustible type construction unless thicker dimensions are approved by the code official).

- C. Reinforcing Mesh (*select one*):
 - 1. Sto Mesh-nominal 4.5 oz./yd² (153 g/m²), symmetrical, interlaced open-weave glass fiber fabric made with alkaline resistant coating for compatibility with Sto materials (achieves Standard Impact Classification).
 - 2. Sto Detail Mesh-nominal 4.2 oz./yd² (143 g/m²), flexible, symmetrical, interlaced glass fiber fabric, with alkaline resistant coating for compatibility with Sto materials (used for standard foam trim backwrapping and aesthetic detailing).
- D. Base Coats (*select one or both*):
 - 1. Sto BTS-Plus-one-component polymer modified cement based high build base coat with less than 33 percent Portland cement content by weight and capable of achieving minimum 1/16 inch (1.6 mm) thickness in one pass.

2. Sto Flexyl-fiber reinforced acrylic based waterproof base coat mixed with Portland cement (for use as a waterproof base coat to waterproof foundations, parapets, splash areas, trim and other projecting architectural features).

2.10 PRIMER (*select one*)

- A. Sto Primer Sand—acrylic based tinted primer.
- B. Sto Hot Prime—acrylic based primer/sealer for high pH surfaces.

(Note: priming is recommended to provide uniform substrate absorption and finish color, to improve adhesion and water resistance, and to retard efflorescence. Sto Hot Prime may be applied 48 hours after completing the brown coat). Sto Primer Sand requires 28 days curing of brown coat before application.

2.11 FINISH COAT (*select one from among the Sto textured wall finish products*)

- A. Sto elastomeric or silicone enhanced elastomeric textured wall finish
- B. Sto acrylic or silicone enhanced acrylic textured wall finish.

(Note: see appropriate Sto Product Bulletin for detailed information on finishes. Elastomeric textured wall finishes are recommended to provide best performance over cracks that may occur in stucco).

2.12 MIXING

- A. StoGuard
 1. Sto Gold Fill-- mix with a clean, rust-free electric drill and paddle to a uniform consistency. Do not thin, or dilute with water.
 2. Sto EmeraldCoat-- mix with a clean, rust-free electric drill and paddle to a uniform consistency. Do not thin, or dilute with water.
- B. StoPowerwall Stucco - mix 200 lbs. (90 kg) of sand to an 80 lb (36 kg) bag of StoPowerwall Stucco and approximately 4 gallons (15 L) of clean water in a paddle type mortar mixer. Add ½ to 2/3 of the required water, ½ of the sand, and one bag of StoPowerwall Stucco in a paddle type mortar mixer. Then add the rest of the sand and sufficient water to achieve a uniform mix of workable consistency. Mix for 3—5 minutes after all materials are in the mixer. Stucco material can be retempered once in the first hour after mixing. Avoid retempering after the first hour and discard material older than 1.5 hours. Keep mix ratio consistent from batch to batch and mix each batch separately. Use only the amount of water necessary for a workable mix. Use of excess water is detrimental to performance.
- C. StoPowerwall Stucco Polymer Modified – Dilute Sto Bonding Agent and Admixture with 3 parts water to one part Sto Bonding Agent and Admixture by volume by adding clean, potable water to a clean mixing pail and mixing with a high speed electric drill mixer. Follow normal mix ratio and procedures for mixing StoPowerwall Stucco (2.12B), except use diluted Sto Bonding Agent and Admixture in lieu of water.
- D. Adhesive and Base Coats for Foam Build-outs: (select either a or b)
 - a. Sto BTS Plus--mix ratio with water: 5-6.5 quarts (4.7-6.2 L) of water per 47 pound (21.3 kg) bag of Sto-BTS Plus. Mix ½ bag at a time by pouring 2.5-3.25 quarts (1.4-1.9L) of clean potable water into a clean mixing pail. Add approximately ½ bag of

Sto BTS-Plus, mix to a uniform consistency and allow to set for approximately 5 minutes. Adjust mix if necessary with additional Sto BTS-Plus or water and remix to a uniform trowel consistency. Avoid retempering. Keep mix ratio consistent. Do not exceed maximum amount of water in mix ratio.

- b. Sto Flexyl--mix ratio with Portland cement: 1:1 ratio by weight. Pour Sto Flexyl into a clean mixing pail. Add Portland cement, mix to a uniform consistency and allow to set for approximately five minutes. Adjust mix if necessary with additional Sto Flexyl and remix to a uniform trowel consistency. Avoid retempering. Keep mix ratio consistent.
- E. Primer--mix with a clean, rust-free high speed mixer to a uniform consistency.
- F. Finish--mix with a clean, rust-free high speed mixer to a uniform consistency. A small amount of water may be added to adjust workability. Limit addition of water to amount needed to achieve the finish texture.
- G. Mix only as much material as can readily be used.
- H. Do not use anti-freeze compounds or other additives.

PART 3 EXECUTION

3.01 ACCEPTABLE INSTALLERS

- A. Pre-qualify under Quality Assurance requirements of this specification (section 1.07B).

3.02 EXAMINATION

- A. Inspect sheathing application for compliance with applicable requirement:
 - 1. Exterior Gypsum Sheathing--GA-253
 - 2. Glass Mat Faced Gypsum Sheathing--refer to manufacturer's instructions.
 - 3. Exterior Grade and Exposure 1 wood based sheathing--APA Engineered Wood Association E 30.

Note: wood-based sheathing must be gapped 1/8 inch (3mm) at edge and end joints to prevent cracking in the stucco.

- B. Report deviations from the requirements of project specifications or other conditions that might adversely affect the stucco installation to the General Contractor.

3.03 SURFACE PREPARATION

- A. Remove surface contaminants and replace damaged sheathing.
- B. All sheathing must be handled and installed in compliance with applicable code and/or manufacturer requirements. Installed sheathing must be clean, dry and free from damage, frost, and all bond-inhibiting materials. Gap sheathing (if required) maximum 1/8 inch (3 mm) at joints. Should gaps exceed 1/8 inch (3 mm) up to 1/4 inch (25 mm) wide, apply low expanding urethane foam into joints and rasp or shave flush with sheathing surface in preparation for installation of StoGuard.

- C. Spot surface defects in sheathing with joint treatment (Sto Gold Fill or additional layer Sto EmeraldCoat).

3.04 WATERPROOF AIR BARRIER INSTALLATION

Important Note: the waterproof air barrier installation described below is one component of the air barrier system for the building envelope and the moisture protection of the wall construction. Installation of the waterproofing/air barrier must be integrated with other air and moisture barrier components in the construction. This requires coordination with other trades to ensure proper sequencing of work, to achieve air barrier continuity, and to direct rain water to the exterior, not into the wall assembly. Always protect rough openings in wall construction BEFORE installing windows, doors, louvers, etc. Where water is likely to penetrate the wall assembly, such as windows, flashing must be installed to direct water to the exterior at the leak source.

The following instructions are applicable to:

- Exterior or Exposure I Plywood in compliance with PS-1
- OSB (Oriented Strand Board) in compliance with PS-1 or PS-2
- Gypsum Sheathing in compliance with ASTM C 1396
- Glass Mat Faced Gypsum Sheathing in compliance with ASTM C 1177
- Fiber Reinforced Gypsum Sheathing in compliance with ASTM C 1278
- Concrete or Masonry surfaces

A. Reinforcement Options: (select one)

1. StoGuard Mesh: StoGuard Mesh is a “self-stick” glass fiber reinforcing mesh with adhesive on one side to facilitate placement of the mesh and installation of Sto Gold Fill over the mesh. Place minimum 4 inch (101 mm) wide mesh at sheathing joints and minimum 9 inch (152 mm) wide mesh at rough openings and inside and outside corners (refer to Sto details 5.09E and 5.23aE). Immediately apply Sto Gold Fill by spray or trowel over the mesh and trowel smooth. Protect from rain and freezing until dry.
2. Sto Guard Fabric: Liberally apply Sto EmeraldCoat (approximately 15 mils) over sheathing joint approximately 4 inches (101 mm) wide by spray, roller, or brush. Apply 4 inch (101 mm) StoGuard Fabric centered over the joint, then reapply a second coat of Sto EmeraldCoat to completely embed the fabric in Sto EmeraldCoat. Check for pinholes and thin spots. Correct with additional Sto EmeraldCoat. Follow same procedure for 6 inch (153 mm) StoGuard Fabric and StoGuard RediCorner used at rough openings. Refer to Sto detail 20.09E. Protect from rain and freezing until dry.

B. Surface Defects and Fasteners in Sheathing:

1. Spot surface defects such as knots and checks in plywood sheathing with Sto Gold Fill .
2. Spot fasteners with Sto EmeraldCoat or Sto Gold Fill. Protect from rain and freezing until dry.

C. Sheathing Surface Waterproofing:

1. Apply Sto EmeraldCoat by spray or roller over sheathing surface, including the dry joint treatment, to a uniform wet mil thickness of 10 mils in one coat. Use ½ inch (13

- mm) nap roller for plywood, gypsum sheathing, and fiber reinforced gypsum sheathing. Use ¾ inch (19 mm) nap roller for OSB and glass mat faced gypsum sheathing. Protect from rain and freezing until dry. Note: Back rolling is not required for spray applications over sheathing. OSB sheathing may require touch-up with a second coat of Sto EmeraldCoat where wood strands are raised from the surface. Inspect surface after initial application of Sto EmeraldCoat and touch-up as needed.
2. Coordinate installation of connecting waterproofing/air barrier components, for example at expansion joints, penetrations, openings, foundation, and roof, with other trades to provide a continuous air tight membrane and moisture protection.
 3. Coordinate installation of flashing and other moisture protection components with other trades to achieve complete moisture protection such that water is directed to the exterior, not into the wall assembly, and drained to the exterior at sources of leaks (windows, doors and similar penetrations through the wall assembly).
 4. Note that some flashing components such as window or door head flashing, roof sidewall step flashing, and weep screeds at the base of the wall, require a splice strip of reinforcing mesh, joint treatment and waterproofing. This creates a “shingle lap” and proper shedding of water onto the face of the flashing, not behind the flashing (refer to Sto details 5.09E and 5.23bE).

D. Concrete or Masonry Surface Waterproofing:

1. Repair cracks in masonry or concrete surfaces up to 1/8 inch (3 mm) with Sto Gold Fill. For cracks larger than 1/8 inch (3 mm), up to ¼ inch (6 mm), fill with a paintable latex caulk, tool flush and allow to dry. **DO NOT USE** Sto Gold Fill to fill moving cracks, consult the project engineer for repair methods.
2. Apply Sto EmeraldCoat by spray or roller over concrete or masonry surface to a uniform wet mil thickness of 10 to 30 mils in one coat depending on surface conditions. Apply second coat of 10 to 30 wet mil thickness to achieve a pin hole void free surface. If Sto EmeraldCoat is to be applied using spray equipment, backrolling of each coat will be necessary. Sto EmeraldCoat may also be applied using a paint roller with a nap thickness of ¾ inch (19 mm).
3. Coordinate installation of connecting waterproofing/air barrier components, for example at expansion joints, penetrations, openings, foundation, and roof, with other trades to provide a continuous air tight membrane and moisture protection.
4. Coordinate installation of flashing and other moisture protection components with other trades to achieve complete moisture protection such that water is directed to the exterior, not into the wall assembly, and drained to the exterior at sources of leaks (windows, doors and similar penetrations through the wall assembly).
5. Note that some flashing components such as window or door head flashing, roof sidewall step flashing, and weep screeds at the base of the wall, require a splice strip of reinforcing mesh, joint treatment and waterproofing. This creates a “shingle lap” and proper shedding of water onto the face of the flashing, not behind the flashing (refer to Sto details 5.09E and 5.23bE).

NOTE: DO NOT ALLOW WATERPROOFING/AIR BARRIER INSTALLATION TO REMAIN EXPOSED MORE THAN 60 DAYS. PROTECT WITH STUCCO WALL COVERING PROMPTLY AFTER INSTALLATION.

3.05 SLIP SHEET INSTALLATION

- A. Install in compliance with the applicable building code requirements for building paper. Lap paper over foundation weep screed attachment flange and window/door head flashings. Refer to Sto Details.

(Note: code requirements may vary. Always consult the applicable code and the manufacturer's code compliance report. Typically building paper in compliance with the code is attached directly to sheathing and lapped shingle style, upper courses over lower courses, by minimum 2 inches (51 mm), with vertical laps of minimum 6 inches (150 mm). Courses are staggered so that vertical joints do not align. Care must be taken to prevent tears in the paper and to limit penetrations to only those required for attachment. Flashing must be in place and properly integrated with the slip sheet at sills, above windows and doors, decks and at roof/wall intersections such that water is directed to the exterior)

3.06 STUCCO INSTALLATION

Apply the stucco in discrete panels without interruption to avoid cold joints and differences in appearance. Abut wet stucco to set stucco at natural or architectural breaks in the wall such as expansion joints, pilasters, terminations, or changes in plane. Hot or dry conditions accelerate drying and moisture loss from stucco which can affect strength and resistance to cracking. Adjustments in the application, scheduling and curing of stucco to prevent rapid loss of moisture are necessary to achieve a satisfactory stucco installation. Cold temperatures retard drying and strength gain and adjustments may have to be made in the application, scheduling and curing of stucco to prevent damage from frost and other trades. Do not install stucco during extremely hot, dry and/or windy conditions. Do not install stucco during freezing conditions or on frozen substrates. Do not install stucco onto grounds of accessories. Completely embed lath and flanges of accessories and completely cover attachments with stucco. Moist cure stucco minimum 48 hours for optimum strength gain and resistance to cracking. Allow final stucco application to completely dry before applying primer or finish. The finished installation must be true, plumb and square. Should stucco get into control or expansion joints, remove the stucco from within the joint before the stucco sets.

A. Weep Screed Installation

1. Install foundation weep screed at the base of the wall securely to framing with the appropriate fastener. Attach to sill plate at no more than 7 inches (178 mm) on center. Locate foundation weep screed so that it overlaps the joint between the foundation and framing by a minimum of 1 inch (25 mm). Locate the nosing of the foundation weep screed minimum 4 inches (100 mm) above earth grade, 2 inches (51 mm) above finished grade (paved surfaces, for example).
2. Apply waterproofing/air barrier over foundation weep screed attachment flange. Refer to Sto Detail 5.09E.

B. Casing Bead and Expansion Joint Installation

1. Install casing beads at stucco terminations—doors, windows and other through wall penetrations. Install two piece expansion joints (or back-to-back casing beads) at building expansion joints, where the stucco is to be installed over dissimilar construction or substrates, at changes in building height, at floor lines, columns, and cantilevered areas. Install full accessory pieces where possible and avoid small pieces. Seal adjoining pieces by embedding ends in sealant. Abut horizontal into vertical joint accessories. Attach at no more than 7 inches (178 mm) into framing with appropriate fasteners.

Note: refer to architectural drawings for joint locations and accessory type. Air barrier and moisture protection must be continuous behind joints and accessories. At expansion joints use barrier membrane behind the accessories for moisture protection and air barrier continuity. Refer to Sto details at www.stocorp.com.

C. Lath Installation (required for all substrates under StoPowerwall NExT Stucco)

1. Diamond Mesh Metal Lath
 - a. General--install metal lath with the long dimension at right angles to structural framing (horizontally on concrete or masonry substrates). Terminate lath at expansion joints. Do not install continuously across joints.
 - b. Seams/Overlaps--overlap side seams minimum ½ inch (13 mm) and end seams minimum 1 inch (25 mm). Stagger end seams. Overlap casing beads and two piece expansion joints minimum 1 inch (25 mm) over narrow wing accessories, minimum 2 inches (51 mm) over expanded flange accessories. Do not install lath continuously beneath expansion joints.
 - c. Attachment--fasten securely through sheathing into structural framing at 7 inches (178 mm) on center maximum vertically and 16 inches (406 mm) on center horizontally*. Wire tie at no more than 9 inches (225 mm) on center at side laps, accessory overlaps, and where end laps occur between supports.
2. Woven wire fabric lath--follow installation as for metal lath except overlap all seams by one mesh minimum.
3. Paper-backed lath--follow installation as for metal lath. Lap lath over lath, not paper to lath overlap. For horizontal overlaps the paper backing must lap shingle style behind the lath to lath overlap.

*(*Note: the type fastener selected, its layout and pullout or withdrawal value from the supporting construction must be verified and approved by the project engineer/architect with respect to design wind load and local building code requirements. Care must be taken when attaching metal lath or other wall assembly components so that fasteners go into [not between] framing supports. Powder actuated or other fastening devices that can damage the water-resistive barrier or sheathing should be avoided).*

D. One Piece Expansion/Control Joint Installation (installed after lath installation)

1. Cut lath in a straight line with shears at expansion/control joint location. Do not cut into or damage moisture barrier. Install one piece expansion/control joints over lath at through wall penetrations, for example, above and below doors or windows (unless another type of expansion joint is already provided at these locations). Install one piece expansion/control joints over lath every 144 ft² (13 m²). Wire tie one piece expansion/control joints to cut lath at no more than 7 inches (178 mm) on center. Make certain lath is discontinuous beneath joints. Do not exceed length to width ratio of 2 ½:1 in expansion/control joint layout and do not exceed more than 18 feet (5.5 m) in any direction without an expansion/control joint.

E. Inside and Outside Corners

1. Bend lath at inside corners and extend minimum 24 inches (610 mm) past corner. Attach through lath into framing at no more than 7 inches (178 mm) on center with appropriate fasteners. Alternatively, butt lath at corners and attach corner lath at no more than 7 inches (178 mm) on center into framing with appropriate fasteners. Install corner bead at outside corners over lath. Attach at no more than 7 inches (178 mm) on center into framing with appropriate fasteners.

F. Stucco Installation

1. Scratch Coat: apply stucco with sufficient pressure to key into and embed the metal lath. Apply sufficient material, 3/8 - 1/2 inch (9-13mm), to cover the metal lath and to permit scoring the surface. Score the stucco upon completion of each panel in preparation for a second coat. Score horizontally.

2. Brown Coat: as soon as the first coat is firm enough to receive the second coat without damage, apply the second coat. Alternatively, moist cure the first coat up to 48 hours and dampen the scratched surface with water immediately before applying the second coat. Apply the second coat with sufficient pressure to ensure intimate contact with the first coat and as needed to bring the stucco to a uniform thickness that matches the grounds of the accessories. Use a rod or straight edge to bring the surface to a true, even plane. Fill depressions in plane with stucco. Final thickness of stucco shall be minimum $\frac{1}{2}$ inch (13 mm), maximum $\frac{3}{8}$ inch (22 mm) as required by project conditions and specifications. Stucco shall be uniform in thickness throughout the wall area.
3. After the stucco has become slightly firm float the surface lightly with a darby or wood float to densify the surface and to provide a smooth, even surface.

(Note: The proper time to float is when the wood float no longer sticks to the surface of the stucco).

4. Moist cure after the stucco has set by lightly fogging for at least 48 hours. Fog as frequently as required during the 48 hour period to prevent loss of moisture from the stucco. Avoid eroding the stucco surface with excess moisture. If relative humidity exceeds 75% the frequency of moist curing can be diminished.

G. Foam Build-Outs (installed after 48 hours moist curing of stucco)

1. Where foam build-outs terminate at a dissimilar material such as a window, door or other non-stucco surface, backwrap the foam build-out by installing detail mesh onto the terminating edge of the stucco. Embed the mesh in the foam adhesive. Allow the mesh to dangle until the backwrapping procedure is completed (C4).
2. Install foam build-outs directly over hardened stucco with adhesive. Apply adhesive with the appropriate size notched trowel to the back of the insulation board and immediately place build-out in the proper location on the wall. Press firmly into place.
3. As soon as the foam build-outs are firmly attached rasp the entire surface smooth.
4. Complete the backwrapping procedure by applying the base coat to the exposed edges of the foam build-out and minimum 2- $\frac{1}{2}$ inches (64 mm) onto the face. Pull the backwrap mesh around the foam build-out and fully embed it into the base coat. Use a corner trowel for neat straight corners.
5. Apply the base coat to the foam build-out and approximately 3 inches (76 mm) onto the adjacent stucco surfaces to an approximate thickness of $\frac{1}{8}$ inch (3 mm). Immediately embed the reinforcing mesh in the wet base coat. Trowel from the center to the edges of the mesh to avoid wrinkles and remove excess base coat. Overlap mesh seams minimum 2- $\frac{1}{2}$ inches (64 mm). Overlap mesh onto adjacent stucco wall surfaces minimum 2- $\frac{1}{2}$ inches (64 mm) at terminations of the foam build-out and feather onto the stucco wall surface.

(Note: do not install foam build-outs over joints in the stucco wall assembly. Terminate foam build-outs and backwrap in accordance with instructions above).

H. Primer Installation

1. Sto Hot Prime—Moist cure stucco for a minimum of 48 hours. Apply primer evenly with brush, roller or proper spray equipment over the clean, dry stucco and foam build-outs, and allow to dry before applying finish.
2. Sto Primer Sand—Moist cure stucco for a minimum of 48 hours. Wait until stucco is 28 days old or the pH level of the surface is below 10 before applying primer and allow to dry before applying finish.

- I. Finish Installation
 1. Apply finish to primed stucco and foam build-outs when dry. Apply finish by spraying or troweling with a stainless steel trowel, depending on the finish specified. Follow these general rules for application of finish:
 - a. Avoid application in direct sunlight.
 - b. Apply finish in a continuous application, and work a wet edge towards the unfinished wall area. Work to an architectural break in the wall before stopping to avoid cold joints.
 - c. Weather conditions affect application and drying time. Hot or dry conditions limit working time and accelerate drying. Adjustments in the scheduling of work may be required to achieve desired results; cool or damp conditions extend working time and retard drying and may require added measures of protection against wind, dust, dirt, rain and freezing. Adjust work schedule and provide protection.
 - d. Float "R" (rilled texture) finishes with a plastic float to achieve their rilled texture.
 - e. Do not install separate batches of finish side-by-side.
 - f. Do not apply finish into or over joints or accessories. Apply finish to outside face of wall only.
 - g. Do not apply finish over irregular or unprepared surfaces, or surfaces not in compliance with the requirements of the project specifications.

3.07 PROTECTION

- A. Provide protection of installed materials from water infiltration into or behind them.
- B. Provide protection of installed stucco from dust, dirt, precipitation, and freezing.
- C. Provide protection of installed primer and finish from dust, dirt, precipitation, freezing and continuous high humidity until fully dry.

ATTENTION

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