

FACADESXi

Xi-SURFACEWELD

DESCRIPTION AND USAGE

Xi-SurfaceWeld is an Ethylene Vinyl Acetate Copolymer re-emulsifying bonding agent to improve adhesion of new cementitious products over numerous porous substrates. SurfaceWeld is recommended as a primer over older porous surfaces and as a polymer modifier for cementitious mortar.

PACKAGING / COVERAGE

1 Gallon (3.785 L) 5-gallon (18.92 L) Pails

Approximate Coverage:

200 to 300 ft² (18 m² - 28 m²) / gallon

Coverages are approximate and will vary depending on application methods and environmental/surface conditions. Porous substrates will have a lower coverage rate

FEATURES / BENEFITS

- Sandable for smooth coatings
- Ready to Use
- Low VOC

BONDING AGENT FOR ADHERING

- Concrete
- Plaster
- Hardboard
- Plywood
- Tile
- Brick
- Interior and exterior surfaces.
- Gypsum board
- Concrete block
- Wood
- Lath
- Stone

SURFACE PREPARATION / JOB CONDITION

Temperature must be 50°F (10°C), at time of installation and for 72 hours after installation. Substrates must be above 40°F (4°C), unpainted and clear of dirt, dust, chalk, mildew, algae, foreign materials, etc. that may prohibit the bond of the material

Painted/loose/damaged substrates must have the loose paint removed and damage repaired.

Glossy paint should be dulled with an abrasive before adhesion, and adhesion should be verified before application of the entire wall.

Smooth surfaces must be mechanically scarified (water blasting, sanding or sand blasting) to open surface pores to allow for a good bond.

SHELF LIFE

12 months – in an unopened container that is stored in a cool dry place away from sunlight



FACADESXi Xi-SURFACEWELD

MIXING

Stir Xi-SurfaceWeld thoroughly before use. Do not dilute.

TECHNICAL INFORMATION

Solids Content (by weight): $38 \pm 2\%$

Specific Gravity: 8.85 ± 0.2 lbs/gal

VOC Content: < 5 g/l

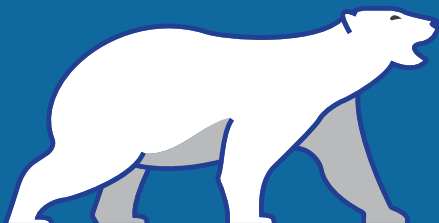
Viscosity: @ 77F: - 200 – 300 cps

Meets ASTM C1059 Type 1 specifications

CAUTIONS / LIMITATIONS

Do not use Xi-SurfaceWeld under hydrostatic pressure.

- Store at temperatures between 50°F to 90°F (10°C to 32°C).
- Do not apply to frozen or frost filled surfaces.
- Do not apply if temperature is below 50°F (10°C).



CONTACT FACADESXi TECHNICAL FOR SPECIFIC INSTRUCTIONS.

APPLICATION

1. All surfaces must be clean from soil, dust, loose particles and oil. The moisture content on the surface should be below 16% for all substrates prior to application.
2. Surface preparation should be performed using a mechanical abrasion. Pressure washing with water and detergent is recommended to remove oily surfaces and allow it to dry.
3. Apply Xi-SurfaceWeld using a brush, roller or low pressure sprayer at a rate of approximately 200-300 ft² per gallon. Porous surfaces may require additional material.

SPRAYING:

For best results and for larger areas, use an airless sprayer with 0.015 inch to 0.02 inch spray tips and hold the sprayer 12-18 inches from the substrate. Apply in a cross hatching method or a horizontal and then a vertical pass of material.

4. Xi-SurfaceWeld will surface dry in approximately 1-2 hour depending on ambient temperature.
5. Once Xi-SurfaceWeld is surface dried, the Cementitious products may be applied. Product may be applied up to 7 days later, however adhesion should be checked after this time.
6. If using in a patching, the patching materials should be applied while the Xi-SurfaceWeld is tacky. If it dries, it may be re-emulsified using a clean fine spray or water.

CLEAN UP

Clean tools and equipment with water immediately after use. Dried material can only be removed mechanically. Clean tools and equipment with detergent and water immediately following use. Clean drips and over-spray with water while still wet. Dried Xi-SurfaceWeld may require mechanical abrasion for removal

