



Building with conscience.

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**Sto Guide Specification 6600
StoPowerwall®
for Metal Plaster Base on Concrete, Concrete Masonry (CMU),
and Frame Wall Construction**

**Section 09 24 23
Portland Cement Stucco**

This guide specification is intended for use by the design/construction professional and any user of Sto products to assist in developing project specifications for a stucco wall assembly applied to code compliant concrete, concrete masonry, and frame wall construction. The stucco assembly incorporates a fluid applied air and water-resistive barrier, code compliant paper or felt water-resistive barrier (WRB), code compliant metal plaster base and portland cement stucco, and Sto primers and finishes. The assembly complies with the IBC and IRC building code requirements for use on all Types (I-V) of construction. It has been evaluated against NFPA 285 criteria and meets requirements for use on noncombustible construction. Notes in Italics, such as this one, are explanatory and intended to guide the design/construction professional and user in the proper selection and use of materials.

Local building codes or specifications may require a drainage space or cavity behind stucco. Refer to information on StoPowerwall Drainscreen (Sto Guide Specification 6400) for these situations.

StoGuard, the air and water-resistive barrier, functions in tandem with other compatible air barrier and flashing components of the building envelope to resist air and water infiltration. A code compliant asphalt saturated felt or paper WRB is applied over StoGuard in wood or steel frame wall construction and similarly functions in tandem with flashing to resist water infiltration. StoPowerwall and Sto listed stuccos are ASTM C 926 compliant portland cement stuccos that are applied to code compliant metal plaster base. Sto exterior primers and finishes complete the exterior stucco wall assembly and are applied over the properly cured stucco.

Like all building materials, portland cement stucco has limitations. For example, 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 design and construction practice such as: proper installation of lath, proper incorporation of stress relief joints in the construction, properly graded sand for field mixed stucco, proper proportioning of stucco mix ingredients, use of the minimum amount of water in the stucco mix for placement and avoiding the use of excess water, moist curing of the stucco after it has been applied, and proper sequencing of construction to avoid stresses in the freshly placed stucco. Surface alkalinity (pH) is an important consideration for stucco surfaces that will receive acrylic or acrylic elastomeric finishes and should be checked to verify pH less than 10 before primer or finish is applied. StoPrime Hot is the preferred primer for use on stucco surfaces to "mask" surface alkalinity. Refer to Sto Tech Hotline No. 1202-CF, Alkaline Substrates and Polymeric Finishes.

StoPowerwall, as with any exterior wall assembly, requires proper design detailing and integration with other components, in particular flashing and air barrier transition materials, to provide a wall assembly that resists air and water infiltration. The weather protection afforded by StoPowerwall should be evaluated by the design/construction professional in relation to building design, height, orientation, climate zone, and any other factors that affect the severity of exposure to rain and water infiltration. Refer to Sto Tech Hotline Nos. 0403-BSc, Critical Detail Checklist for Wall Assemblies, and 0603-BSc, Moisture Control Principles for Design and Construction of Wall Assemblies. Modifications should be made to this specification as deemed necessary by the design/construction professional to ensure a watertight building envelope without water entry or accumulation anywhere within the wall assembly, an airtight building envelope, and

control of condensation from water vapor diffusion. For complete technical information on Sto components and other reference materials, refer to product bulletins, guide details, and other technical information available at www.stocorp.com.

Notes in italics, such as this one, are explanatory and intended to guide the design/construction professional and user in the proper selection and use of materials. This specification should be modified where necessary to accommodate individual project conditions.

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PART 1 GENERAL

1.1 SUMMARY

- A. This section includes materials and installation of exterior stucco wall covering backed with air and water-resistive barrier.

1.2 RELATED SECTIONS

(add/delete, depending on specific project requirements)

- | | | |
|----|------------------|---|
| A. | Section 03 30 00 | Cast-In-Place Concrete |
| B. | Section 04 20 00 | Unit Masonry |
| C. | Section 06 16 00 | Sheathing |
| D. | Section 07 26 00 | Vapor Retarders |
| E. | Section 07 27 00 | Air Barriers |
| F. | Section 07 50 00 | Membrane Roofing |
| G. | Section 07 62 00 | Sheet Metal Flashing and Trim |
| H. | Section 07 92 00 | Joint Sealants |
| I. | Section 08 40 00 | Entrances, Storefronts, and Curtain Walls |
| J. | Section 08 50 00 | Windows |

1.3 REFERENCED DOCUMENTS

(add/delete depending on specific project requirements)

- | | | |
|----|-----------------|---|
| A. | ASTM Standards: | |
| | A 641 | Standard Specification for Zinc-Coated (Galvanized) Carbon Steel Wire |
| | A 653 | Specification for Sheet Steel Zinc coated (Galvanized) by the Hot-Dip Process, Commercial Quality |
| | B 69 | Specification for Rolled Zinc |
| | C 144 | Specification for Aggregate for Masonry Mortar |
| | C 297 | Standard Test Method for Flatwise Tensile Strength of Sandwich Constructions |
| | C 578 | Specification for Preformed, Cellular Polystyrene Thermal Insulation |
| | C 847 | Standard Specification for Metal Lath |
| | C 897 | Standard Specification for Aggregate for Job-Mixed Portland Cement-Based Plasters |
| | C920 | Standard Specification for Elastomeric Joint Sealants |
| | C 926 | Standard Specification for Application of Portland Cement-Based Plaster |
| | C 1063 | Standard Specification for Installation of Lathing and Furring for Portland Cement Plaster |
| | C 1177 | Specification for Glass Mat Gypsum for Use as Sheathing |
| | C 1513 | Standard Specification for Steel Tapping Screws for Cold-Formed Steel Framing Connections |

- D 226 Standard Specification for Asphalt-Saturated Organic Felt Used in Roofing and Waterproofing
 - D 1784 Specification for Rigid Poly (Vinyl Chloride) (PVC) Compounds and Chlorinated Poly (Vinyl Chloride) (CPVC) Compounds
 - D 4541 Test Method for Pull-Off Strength of Coatings Using Portable Adhesion Testers
 - E 84 Test Method for Surface Burning Characteristics of Building Materials
 - E 96 Standard Test Methods for Water Vapor Transmission of Materials
 - E 283 Test Method for Determining Rate of Air Leakage Through Exterior Windows, Curtain Walls, and Doors Under Specified Pressure Differences Across the Specimen
 - E 330 Test Method for Structural Performance of Windows, Curtain Walls, and Doors by Uniform Static Air Pressure Difference
 - E 331 Test Method for Water Penetration of Exterior Windows, Skylights, Doors, and Curtain Walls by Uniform Static Air Pressure Difference
 - E 783 Standard Test Method for Field Measurement of Air Leakage Through Installed Exterior Windows and Doors
 - E 2178 Standard Test Method for Air Permeance of Building Materials
 - E 2357 Standard Test Method for Determining Air Leakage of Air Barrier Assemblies
 - E 2430 Standard Specification for Expanded Polystyrene (“EPS”) Thermal Insulation Boards For Use in Exterior Insulation and Finish Systems (“EIFS”)
 - G 154 Recommended Practice for Operating Light-and Water-Exposure Apparatus (Fluorescent UV-Condensation Type) for Exposure of Nonmetallic Materials
- B. AISI (American Iron and Steel Institute)
- AISI S200-2007 North American Standard for Cold-Formed Steel Framing-General Provisions
- C. APA Engineered Wood Association
- PS 1 Voluntary Product Standard, Structural Plywood
 - PS 2 Performance Standard for Wood-Based Structural-Use Panels
 - E 30 APA Engineered Wood Construction Guide
- D. ICC (International Code Council)
- IBC 2015 and 2018 IBC (International Building Code)
- E. ICC ES (International Code Council Evaluation Service)
- AC 11 Acceptance Criteria for Cementitious Exterior Wall Coatings
 - AC 212 Acceptance Criteria for Water-resistant Coatings used as Water-resistant Barriers over Exterior Sheathing
 - ICC ESR 1233 StoGuard with Gold Coat, StoGuard with Gold Coat, and StoGuard VaporSeal Water-Resistive Barriers, and StoEnergy Guard
 - ICC ESR 2323 StoPowerwall and StoPowerwall NExT Stucco Systems
- F. IAPMO (International Association of Plumbing and Mechanical Officials)
- IAPMO ER 2017 Structalath No. 17 SFCR Twin Track 2.5
 - IAPMO ER 382 Western 1-Kote Exterior Stucco System
- G. National Fire Protection Association (NFPA) Standards
- NFPA 285 Standard Method of Test for the Evaluation of Flammability Characteristics of Exterior Non-Load-Bearing Wall Assemblies containing Combustible Components Using the Intermediate-Scale, Multistory Test Apparatus
- H. South Coast Air Quality Management District (SCAQMD)

- Rule 1113 (2007) Architectural Coatings
- I. Sto Corp. Addendum to Sto Stucco Specifications
- J. US EPA (United States Environmental Protection Agency)
40 CFR Part 59 (Code of Federal Regulations Title 40 Part 59 – National Volatile Organic Compound Emission Standards for Consumer and Commercial Products)

1.4 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 building code requirements.
 - 3. Refer to applicable ICC ESR for wind load limitations that may apply.
- 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 protect exposed elements and to direct water to the exterior, including, above window and door heads, beneath window and door sills, at floor lines, 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.
 - c. Vapor Diffusion and Condensation – perform a dew point analysis and/or dynamic hygrothermal modeling 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 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 Air and water-resistive barrier over sheathing, concrete and masonry.
 - e. At through wall expansion joints and at joints formed with back-to-back casing beads, back joints with appropriate StoGuard Detail Component. Refer to Sto Guide Details at www.stocorp.com.
 - f. Seal stucco terminations and accessory butt joints with appropriate sealant. Seal all penetrations through the stucco wall assembly with appropriate sealant, or backer rod and sealant, as dictated by joint type.
- C. Grade Condition
 - 1. Do not specify 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. Limit foam thickness to a maximum of 4 inches (102 mm). 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 to minimize maintenance burden. Refer to Sto Guide 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 Guide Details at www.stocorp.com
- E. Joints and Accessories
1. Provide two piece expansion joints in the stucco assembly 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.
 2. Provide one piece expansion joints every 144 ft² (13 m²). Cut and wire tie lath to the expansion joint accessory so lath is discontinuous at or beneath the accessory. 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. Where casing bead is used back-to-back as the expansion joint, back the joint with StoGuard Transition Membrane.
 3. Provide one piece expansion joints at through wall penetrations, for example, above and below doors or windows.
 4. Provide minimum 3/8 inch (9 mm) wide joints where the system abuts windows, doors and other through wall penetrations.
 5. Provide appropriate accessories at stucco terminations and joints.
 6. Avoid the use of channel reveal accessories which can interfere with proper drainage and proper stress relief.
 7. Provide appropriate sealant at stucco terminations and at stucco accessory butt joints.
 8. Indicate location of joints, accessories and accessory type on architectural drawings.
- F. Fire Protection
1. Noncombustible Type Construction: provide full width firestops at floor lines, typically 4 pcf (64 kg/m³) semi-rigid mineral wool, where metal framing runs continuously past floor line and provide minimum 3/4 inch (19 mm) uniform stucco thickness.
- G. Solid Substrates (concrete and CMU)
1. Provide surface plane tolerance not to exceed 1/4 inch in 10 feet (6 mm in 3.0 m).
 2. Concrete Masonry – provide open texture concrete masonry units with flush joints.
 3. Do not install air and water-resistive barrier materials over efflorescence, weak surface conditions, painted, coated, non-absorbent, salt-contaminated, or any concrete or CMU substrate where adhesion is in question. Proof test adhesion to prepared poured-in-place or pre-cast concrete surfaces and impose a regimen of quality control tests to verify adhesion throughout the project.

- H. Stucco Thickness (does not include primer or textured finish coat)
 - 1. Application to Metal Plaster Bases: stucco thickness shall be uniform $\frac{3}{4}$ inch or $\frac{7}{8}$ inch (19 or 22 mm). Stucco thickness shall not exceed $\frac{7}{8}$ inch (22 mm).
 - 2. Stucco shall be applied in 2 coats, scratch and brown coat, to achieve the prescribed thickness.
 - 3. Thickness shall be uniform throughout the wall area.

1.5 PERFORMANCE REQUIREMENTS

- A. Air and Water-Resistive Barrier
 - 1. Compliant with ICC ES Acceptance Criteria AC 212 (ICC ESR 1233)
 - 2. Material Air Leakage Resistance, ASTM E 2178: less than $0.02 \text{ L/s}\cdot\text{m}^2$ at 75 Pa (0.004 cfm/ft^2 at 1.57 psf)
 - 3. Assembly Air Leakage Resistance, ASTM E 2357: less than $0.2 \text{ L/s}\cdot\text{m}^2$ (0.04 cfm/ft^2 at 1.57 psf)
 - 4. Vapor Permeable, Water Vapor Permeance, ASTM E 96, Method B: greater than 10 perms [$573 \text{ ng}/(\text{Pa}\cdot\text{s}\cdot\text{m}^2)$]
 - 5. Vapor Impermeable, Water Vapor Permeance, ASTM E 96, Method B: less than 0.1 perms [$5.73 \text{ ng}/(\text{Pa}\cdot\text{s}\cdot\text{m}^2)$]
 - 6. Surface Burning, ASTM E 84: Flame Spread less than 25, Smoke Developed less than 450, Class A Building Material
 - 7. Tensile Adhesion, ASTM C 297: greater than or equal to 15 psi (103 kPa)
 - 8. VOC, calculation:
 - a. Less than 50 g/L
 - b. Compliant with US EPA 40 CFR 59 for waterproofing/sealer
 - c. Compliant with South Coast AQMD Rule 1113 for Building Envelope Coating
- B. Stucco Base (*select one*)
 - 1. Stucco scratch and brown coat material in compliance with ASTM C926 and manufactured or listed by Sto Corp. (see Addendum)
 - 2. One coat stucco material in compliance with ICC AC 11, listed by ICC ES, as manufactured or listed by Sto Corp. (see Addendum)
- C. Primers (*select one*)
 - 1. Acrylic-based primer for 28 day old stucco surfaces or pH less than 10
 - a. Surface Burning, ASTM E 84: Flame Spread less than 25, Smoke Developed less than 450, Class A building material
 - b. VOC: less than 50 g/L, compliant with South Coast AQMD Rule 1113 for architectural coatings - primers and sealers
 - 2. Alkaline resistant primer for freshly placed (minimum 4 day old) stucco surfaces:
 - a. Resistant to alkaline surfaces with pH of 13 or less
 - b. Surface Burning, ASTM E 84: Flame Spread less than 25, Smoke Developed less than 450, Class A building material

- c. VOC: less than 50 g/L, compliant with South Coast AQMD Rule 1113 for architectural coatings - primers and sealers
- D. Finishes *(select one)*
- 1. Lotus-Effect Technology Finish (Stolit Lotusan)
 - a. Super-hydrophobic textured finish with Lotus-Effect Technology
 - b. Accelerated Weathering, ASTM G 154: 2500 hours, no blistering, checking cracking, crazing, or other deleterious effects
 - c. Water Vapor Permeability, ASTM E96, Method B: > 30 perms [(1172 ng/(Pa·s·m²))]
 - d. Surface Burning, ASTM E84: Flame Spread less than 25, Smoke Developed less than 450, Class A building material
 - e. VOC: less than 50 g/L, compliant with South Coast AQMD Rule 1113 for architectural coatings
 - 2. Hydrophobic Finish (Stolit HDP™)
 - a. Accelerated Weathering, ASTM G 155: 2000 hours, no blistering, checking cracking, crazing, or other deleterious effects
 - b. Water Vapor Permeability, ASTM E96, Method B: > 40 perms [(2288 ng/(Pa·s·m²))]
 - c. Surface Burning, ASTM E 84: Flame Spread less than 25, Smoke Developed less than 450, Class A building material
 - d. VOC: less than 50 g/L, compliant with South Coast AQMD Rule 1113 for architectural coatings
 - 3. Silicone Enhanced Elastomeric Finish (Sto Powerflex Silco)
 - a. Accelerated Weathering, ASTM G 154: 2000 hours, no blistering, checking cracking, crazing, or other deleterious effects
 - b. Water Vapor Permeability, ASTM E96, Method B: > 10 perms [(574 ng/(Pa·s·m²))]
 - c. Surface Burning, ASTM E84: Flame Spread less than 25, Smoke Developed less than 450, Class A building material
 - d. VOC: less than 50 g/L, compliant with South Coast AQMD Rule 1113 for architectural coatings
 - 4. Elastomeric Finish (Sto Powerflex)
 - a. Accelerated Weathering, ASTM G 154: 2000 hours, no blistering, checking cracking, crazing, or other deleterious effects
 - b. Water Vapor Permeability, ASTM E96, Method B: > 5 perms [(287 ng/(Pa·s·m²))]
 - c. Surface Burning, ASTM E84: Flame Spread less than 25, Smoke Developed less than 450, Class A building material
 - d. VOC: less than 50 g/L, compliant with South Coast AQMD Rule 1113 for architectural coatings
 - 5. Flexible Acrylic Finish (Sto Powerwall)
 - a. Accelerated Weathering, ASTM G 154: 2000 hours, no blistering, checking cracking, crazing, or other deleterious effects
 - b. Water Vapor Permeability, ASTM E96, Method B: > 15 perms [(861 ng/(Pa·s·m²))]
 - c. Surface Burning, ASTM E84: Flame Spread less than 25, Smoke Developed less than 450, Class A building material

- d. VOC: less than 50 g/L, compliant with South Coast AQMD Rule 1113 for architectural coatings
- 6. Acrylic Finish (Stolit, Stolit X, Sto Essence DPR)
 - a. Accelerated Weathering, ASTM G154 or G 155: 2000 hours, no blistering, checking cracking, crazing, or other deleterious effects
 - b. Water Vapor Permeability, ASTM E96, Method B: > 10 perms [572 ng/(Pa·s·m²)]
 - c. Surface Burning, ASTM E84: Flame Spread less than 25, Smoke Developed less than 450, Class A building material
 - d. VOC: less than 50 g/L, compliant with South Coast AQMD Rule 1113 for architectural coatings

1.6 SUBMITTALS

- A. Manufacturer's specifications, details, installation instructions and product data
- B. Manufacturer's code compliance report for air barrier and water-resistive barrier
- C. Manufacturer's code compliance report for stucco where ICC listed one coat stucco is used
- D. EPS board manufacturer's certificate of compliance with ASTM E 2430-05
- E. Manufacturer's NFPA 285 assembly report or ICC ESR indicating compliance of air and water-resistive barrier with requirements of NFPA 285 for use on Types I, II, III, and IV construction
- F. Manufacturer's standard warranty
- G. Samples for approval as directed by architect or owner
- H. Fastener manufacturer's pull-out or withdrawal capacity testing for frame and solid substrates
- I. Prepare and submit project-specific details (when required by contract documents)

1.7 QUALITY ASSURANCE

- A. Manufacturer requirements
 - 1. Stucco and air barrier products manufacturer for a minimum of twenty (20) years.
 - 2. Stucco finish products and air barrier products manufactured under ISO 9001 Quality System and 14001 Environmental Management System.
- B. Contractor requirements
 - 1. Licensed, 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 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 specifications and details and the project plans and specifications.

- C. EPS foam trim board requirements
 - 1. Listed by an approved agency. Label foam trim board with information required by the applicable building code.
- D. Testing
 - 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 E283, ASTM E331 and ASTM E330, 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.
 - 2. Conduct air barrier adhesion testing in accordance with ASTM D4541.
 - 3. Conduct air barrier assembly testing in accordance with ASTM E783.
 - 4. Conduct pull-out or withdrawal capacity testing of proposed fasteners for lath attachment into concrete or masonry and verify adequacy with respect to negative design wind pressure. Conduct sufficient tests such that reliable and predictable pull-out values are obtained. Verify adequacy of pull-out or withdrawal capacity of fasteners used for frame construction with manufacturer in relation to negative design wind pressures.
 - 5. Conduct pH testing to check stucco surface alkalinity before application of primer or finish materials. Where alkaline resistant primer is used pH testing may be waived.
 - 6. Conduct wet sealant adhesion testing in accordance with sealant manufacturer's field quality control test procedure.
 - 7. Notify design professional minimum 7 days prior to testing.
- 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.

1.8 DELIVERY, STORAGE AND HANDLING

- A. Deliver all materials in their original sealed containers bearing manufacturer's name and identification of product.
- B. Protect EPS foam trim from prolonged UV exposure, keep away from sources of heat, sparks, flame, flammable or volatile materials. Store on a clean, flat surface, off the ground in a dry area.
- C. Protect coatings (pail products) from freezing and temperatures in excess of 90°F (32° C). Store away from direct sunlight.
- D. Protect portland cement-based materials (bag products) from moisture and humidity. Store under cover off the ground in a dry location.
- E. Handle all products as directed on labeling.

1.9 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 for 24 hours after set of stucco, and after application of air and water-resistive barrier and finish materials.
- B. Provide supplementary heat for installation in temperatures less than 40°F (4°C) such that material temperatures are maintained as in 1.09A. 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. Do not install stucco if ambient temperatures are expected to rise above 100°F (38°C) within a 24-hour period.
- D. Provide protection of surrounding areas and adjacent surfaces from application of materials.

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 and from damage from trades)

- A. Protect sheathing from climatic conditions to prevent weather damage until the installation of the air and water-resistive barrier.
- B. Install diverter flashings wherever water can enter the wall assembly to direct water to the exterior.
- C. Coordinate installation of foundation waterproofing, roofing membrane, windows, doors and other wall penetrations to provide a continuous air barrier and continuous moisture protection. Provide protection of rough openings before installing windows, doors, and other penetrations through the wall and provide sill flashing. Coordinate installation of air and water-resistive barrier components with window and door installation to provide weather proofing of the structure and to prevent moisture infiltration and excess air infiltration.
- D. Install window and door head flashing immediately after windows and doors are installed.
- E. Protect air and water-resistive barrier barrier with stucco cladding within 180 days of installation.
- F. Protect paper or felt water-resistive barrier with stucco cladding within 30 days of installation.
- G. 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.
- H. Sequence interior work such as drywall installation prior to stucco installation to prevent stud distortion (and potential cracking) of the stucco.
- I. 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.
- J. Install copings and sealant immediately after installation of the stucco and when finish coatings are dry.
- K. 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

2.1 MANUFACTURERS

- A. Air and water-resistive barrier, Portland Cement Stucco, Stucco Primers, Stucco Finishes, Joint Sealant
1. Sto Corp., 3800 Camp Creek Parkway, Building 1400, Suite 120. Atlanta, GA 30331

2.2 AIR AND WATER-RESISTIVE BARRIER

- A. StoGuard -- fluid applied air and water-resistive barrier for sheathing, concrete, and concrete masonry substrates consisting of multiple compatible components:
1. Sto Gold Fill -- ready mixed acrylic based flexible joint treatment for rough opening protection, joint treatment of wall sheathing, CMU crack repair, and detail component for shiplap connections with flashing, weep screed, and similar ship lap details.
 2. Sto Gold Coat® – ready mixed vapor permeable air and water-resistive barrier coating
 3. Sto AirSeal® - ready mixed vapor permeable high elongation air and water-resistive barrier coating
 4. StoGuard® VaporSeal® -- ready mixed vapor impermeable high elongation air and water-resistive barrier coating
 5. StoGuard Mesh-- nominal 4.2 oz/yd² (142 g/m²), self-adhesive, flexible, symmetrical, interlaced glass fiber mesh, 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 detail component for shiplap connections with flashing, weep screed, and similar shingle lap details
 6. StoGuard Fabric – nonwoven cloth reinforcement used with Sto air and water-resistive barrier coatings for rough opening protection, joint treatment of wall sheathing, and detail component for shiplap connections with flashing, weep screed, and similar shingle lap details
 7. StoGuard RediCorner – a preformed fabric piece used in the corners of rough openings in tandem with StoGuard Fabric for quicker installation
 8. StoGuard Tape – self adhering rubberized asphalt tape for rough opening protection in wood or metal frame construction
 9. StoGuard Primer – primer for use with StoGuard Tape
 10. StoGuard Conformable Membrane – self-adhered membrane flashing for use over prepared vertical above-grade concrete, concrete masonry, brick masonry, wood sheathing, glass mat gypsum sheathing, and cementitious sheathing used to:
 - Seal joints and seams in wall sheathing
 - Seal static joints between dissimilar materials
 - Flash exterior wall openings and protect rough openings
 - Seal between window flange and wall sheathing
 - Connect to above grade foundation waterproofing
 - Connect to roof membrane
 - Seal around wall penetrations such as pipes, scuppers, vents
 - Back masonry wall ties

- Seal dynamic joints in wall construction

11. Sto RapidGuard® - one component STPE rapid drying gun-applied treatment for sheathing joints, rough openings, seams, cracks, penetrations and other static transitions in above grade wall construction such as: shingle lap over flashing, wall to balcony floor slab or ceiling, and through wall penetrations – pipes, electrical boxes, and scupper penetrations

Choose one coating and select application by substrate (B1a, B2a, or B3), Medium-Build (B1b, B2b, or B3), or High-Build (B1c, B2c, or B3) as indicated

B. Air & Water-Resistive Barrier Coating

1. Sto Gold Coat: ready mixed vapor permeable air and water-resistive barrier coating applied,
 - a. By substrate as follows:
 - Glass Mat Gypsum: apply one coat at minimum 10 mils WFT
 - Plywood: apply one coat at minimum 10 mils WFT
 - Cement Board: apply one coat at minimum 10 mils WFT
 - OSB: apply one or two coats at minimum 20 mils WFT. If applied by roller, apply two coats. Touch up any bare spots and raised OSB strands.
 - CMU: apply two or three coats at minimum 20-60 mils WFT.
 - Concrete: apply one coat at minimum 10 mils WFT
 - b. To a Medium-Build in one or two coats to achieve minimum 20 mils WFT (if applied by roller apply two coats to achieve minimum 20 mils WFT. For CMU substrates apply two or three coats to achieve 20-60 mils WFT).
 - c. To a High-Build in two or three coats to achieve 40 mils WFT (if applied by roller apply three or more coats as needed. For CMU substrates apply multiple coats to achieve 40-60 mils WFT).
2. Sto AirSeal: ready mixed vapor permeable air and water-resistive barrier coating applied,
 - a. By substrate as follows:
 - Glass Mat Gypsum: apply one coat at minimum 20 mils WFT
 - Plywood: apply one coat at minimum 20 mils WFT
 - Cement Board: apply one coat at minimum 20 mils WFT
 - OSB: apply one or two coats at minimum 20 mils WFT. If applied by roller, apply two coats. Touch up any bare spots and raised OSB strands.
 - CMU: apply two or three coats at minimum 20-65 mils WFT.
 - Concrete: apply one coat at minimum 20 mils WFT
 - b. To a Medium-Build in one or two coats to achieve minimum 40 mils WFT (if applied by roller apply two coats to achieve minimum 40 mils WFT. For CMU substrates apply two or three coats to achieve 40-65 mils WFT).
 - c. To a High-Build in one, two or three coats to achieve minimum 65 mils WFT (if applied by roller apply minimum three coats to achieve minimum 65 mils WFT).
3. StoGuard VaporSeal: Class 1 vapor retarder coating for use over prepared vertical above-grade concrete, concrete masonry, brick masonry, wood sheathing, cementitious sheathing, and glass mat gypsum sheathing, applied by airless spray in one or two coats to achieve minimum 80 mils total WFT

2.3 SHEET WATER-RESISTIVE BARRIER

(supplied by others)

- A. Minimum No. 15 asphalt saturated felt complying with ASTM D226, Type 1, or one layer of Grade D kraft building paper, or paper-backed stucco lath conforming to 2.4.

2.4 LATH

(supplied by others)

- A. Structalath SFCR Twin Track 2.5 self-furring welded wire lath. See IAPMO ER 2017
- B. Minimum 2.5 lb./yd² (1.4 kg/m²) self-furred galvanized steel diamond mesh metal lath in compliance with ASTM C847

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 1.4B. Consider the use of stainless steel lath for coastal environments. Exercise care when attaching metal lath and accessories through the water-resistive barrier so that fasteners go into [not between] framing supports. Do not use power, powder-actuated or other fastening tools/methods that can damage the air barrier, water-resistive barrier, or substrate.

2.5 MECHANICAL FASTENERS

(supplied by others)

- A. Non-corroding fasteners in compliance with AISI S200 – 2007 and ASTM C1513
 - 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 3/8 inch (10 mm) and three thread 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 or conduct project specific testing to verify compliance with design wind pressure requirements.

- B. Tie Wire – 18 gauge galvanized and annealed low-carbon steel in compliance with ASTM A641 with Class I coating.

2.6 ACCESSORIES

(metal accessories supplied by others)

- A. Weep screed, casing bead, corner bead, corner lath, expansion and control joint accessories. All accessories shall meet the requirements of ASTM C1063 and its referenced documents
 - 1. PVC plastic in compliance with ASTM D1784, cell classification 13244C.
 - 2. Zinc in compliance with ASTM B69.
 - 3. Galvanized metal in compliance with ASTM A653 with G60 coating.
- B. All accessories shall have perforated or expanded flanges and shall be designed with grounds for the specified thickness of stucco.
- C. StoSeal STPE joint sealant in conformance with ASTM D920: Type S, Grade NS, Use NT, A, M, Class 100/50

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 or other corner accessories in lieu of corner bead and completely encase the metal in stucco. 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. CAUTION: AVOID THE USE OF CHANNEL REVEAL ACCESSORIES THAT INTERFERE WITH PROPER DRAINAGE AND STRESS RELIEF.

2.7 JOB MIXED INGREDIENTS

(supplied by others)

- A. Water: clean and potable.
- B. Sand: in compliance with ASTM C897 or ASTM C144, for use with one coat and ASTM C926 stucco concentrates

2.8 STUCCO

(refer to Addendum for other stucco products that may apply)

- A. 102 StoPowerwall Stucco Pre-Blended: fiber reinforced one coat portland cement stucco pre-blended with graded sand, and in compliance with ICC AC 11. See ICC ESR 2323.
- B. 103 StoPowerwall Stucco: fiber reinforced one coat portland cement stucco concentrate in compliance with ICC AC 11. See ICC ESR 2323.
- C. 108 Powerwall Scratch and Brown: portland cement-based stucco concentrate in compliance with ASTM C926.
- D. Other code compliant portland cement stucco as listed by Sto Corp. (refer to Addendum)

2.9 FOAM TRIM AND BUILD-OUTS

- A. Adhesive and Base Coat *(select one)*
 - 1. Sto BTS Xtra – light weight one component polymer modified cement-based extra high build base coat material
 - 2. Sto BTS Plus – one component polymer modified cement-based high build base coat material
 - 3. Sto Primer/Adhesive-B – one component polymer modified cement-based base coat material

4. Sto Primer/Adhesive – two component acrylic based base coat material field mixed with portland cement
 5. Sto RFP – ready mixed non-cementitious fiber reinforced base coat material
 6. Sto Flexyl – two component fiber reinforced acrylic based waterproof base coat material field mixed with portland cement (for use as a waterproof base coat to waterproof foundations, parapets, splash areas, trim and other projecting architectural features).
- B. Foam Insulation Board for Trim
1. Sto EPS Insulation Board--nominal 1.0 lb/ft³ (16 kg/m³) Expanded Polystyrene (EPS) Insulation Board in compliance with ASTM C578 Type I requirements, and ASTM E2430 *(Note: minimum required thickness is 1 inch [25 mm] and maximum allowable thickness is typically 4 inches [102 mm] for noncombustible type construction and fire-resistance rated wall construction unless thicker dimensions are approved by the code official).*
- C. Reinforcing Mesh
1. Sto Mesh--nominal 4.5 oz./yd² (153 g/m²), symmetrical, interlaced open-weave glass fiber mesh treated with alkaline resistant coating for compatibility with Sto materials (achieves Standard Impact Classification over foam insulation board).
 2. Sto Detail Mesh--nominal 4.2 oz./yd² (143 g/m²), flexible, symmetrical, interlaced open-weave glass fiber fabric treated with alkaline resistant coating for compatibility with Sto materials *(used for standard foam backwrapping and aesthetic detailing).*

2.10 CRACK DEFENSE

(optional components for added crack resistance)

- A. Base Coat *(select one)*
1. Sto BTS Xtra – light weight one component polymer modified cement-based extra high build base coat material
 2. Sto BTS Plus – one component polymer modified cement-based high build base coat material
 3. Sto Primer/Adhesive-B – one component polymer modified cement-based base coat material
 4. Sto Primer/Adhesive – two component acrylic based base coat material field mixed with portland cement
 5. Sto RFP – ready mixed non-cementitious fiber reinforced base coat material
 6. Sto Flexyl – two component fiber reinforced acrylic based waterproof base coat material field mixed with portland cement (for use as a waterproof base coat to waterproof foundations, parapets, splash areas, trim and other projecting architectural features).
- B. Reinforcing Mesh
1. Sto Mesh – nominal 4.5 oz./yd² (153 g/m²), symmetrical, interlaced open-weave glass fiber mesh made with alkaline resistant coating for compatibility with Sto materials

2.11 PRIMER

(select one)

- A. StoPrime Hot – acrylic based primer/sealer for freshly placed (minimum 4 day old) and high pH stucco surfaces.

- B. StoPrime Sand – acrylic based tinted, sanded primer for fully cured (minimum 28 day old or pH less than 10) stucco surfaces.
- C. StoPrime -- acrylic based tinted primer for fully cured (minimum 28 day old or pH less than 10) stucco surfaces

NOTE: Priming is recommended to provide uniform substrate absorption and finish color, to improve adhesion and water resistance. StoPrime Hot may be applied 48 hours after moist curing the brown coat. Other Sto primers require 28 days curing of brown coat or pH less than 10 before application.

2.12 FINISH

(select one)

- A. Stolit Lotusan Finish – integrally colored, factory blended textured Lotus-Effect Technology wall finish with graded marble aggregate
- B. Stolit HDP Finish – integrally colored, factory blended textured hydrophobic wall finish with graded marble aggregate
- C. Sto Powerflex Silco Finish – integrally colored, factory blended, silicone enhanced elastomeric textured wall finish with graded marble aggregate
- D. Sto Powerflex Finish – integrally colored, factory blended, elastomeric textured wall finish with graded marble aggregate
- E. StoPowerwall Finish – integrally colored, factory blended, flexible acrylic textured wall finish with graded marble aggregate.
- F. Stolit Finish – integrally colored, factory blended, acrylic textured wall finish with graded marble aggregate
- G. Stolit X Finish – acrylic based textured wall finish with graded marble aggregate and enhanced polymer technology for easy spread and float application
- H. Sto Essence DPR Finish – integrally colored, factory blended, acrylic textured wall finish with graded marble aggregate
- I. StoSignature Finishes – Stolit acrylic based textured wall finish applied over Sto Crack Defense with specialized techniques to achieve unique textures, impressions or effects. Refer to www.stocorp.com for StoSignature Finishes Brochure and Installation Guides.
- J. Sto Specialty Finishes – acrylic based textured wall finishes with colored aggregates that create unique aesthetic effects
- K. StoCast Finishes – factory cast decorative and protective finishes applied with specified Sto adhesives.
 - 1. StoCast Wood
 - 2. StoCast Brick

2.13 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 AirSeal -- mix with a clean, rust-free electric drill and paddle to a uniform consistency. Do not thin or dilute with water.
 3. Sto Gold Coat – mix with a clean, rust-free electric drill and paddle to a uniform consistency. Do not thin or dilute with water.
 4. StoGuard VaporSeal -- mix with a clean, rust-free electric drill and paddle to a uniform consistency. Do not thin or dilute with water.
- B. StoPowerwall Stucco
1. Refer to mix instructions on packaging. USE ONLY THE AMOUNT OF WATER NECESSARY FOR A WORKABLE MIX. Use of excess water is detrimental to performance.
- C. Adhesive and Base Coats for Sto Crack Defense and EPS Foam Build-outs:
1. Refer to applicable Sto [Product Bulletin](#) for selected adhesive/base coat material(s).
- D. Primer--mix with a clean, rust-free high speed mixer to a uniform consistency.
- E. Finish--mix with a clean, rust-free high speed mixer to a uniform consistency. A small amount of water (up to 12 ounces [0.4 L]) may be added to adjust workability. Limit addition of water to amount needed to achieve the finish texture.
- F. Mix only as much material as can readily be used.
- G. Do not add lime, anti-freeze compounds, or other additives to any of the materials.

PART 3 EXECUTION

3.1 ACCEPTABLE INSTALLERS

- A. Pre-qualify under Quality Assurance requirements of this specification (section 1.7.B).

3.2 EXAMINATION

- A. Inspect surfaces for:
- B. Contamination – algae, chalkiness, dirt, dust, efflorescence, form oil, fungus, grease, laitance, mildew or other foreign substances.
 - C. Surface absorption and chalkiness.
 - D. Crack – measure crack width and record location of cracks.
 - E. Damage and deterioration.
 - F. Moisture damage – record any areas of moisture damage.
 - G. Inspect sheathing application for compliance with applicable requirement:

- H. Glass Mat Faced Gypsum Sheathing in compliance with ASTM C1177 – refer to manufacturer’s instructions and/or ICC evaluation report
- I. Exterior Grade and Exposure 1 wood based sheathing – APA Engineered Wood Association E 30.

NOTE: Sheathing attachment can determine ultimate wind load resistance. Verify attachment in conformance with design wind pressure requirements as determined by building code requirements and/or project specific testing. Wood-based sheathing must be gapped 1/8 inch (3mm) at edge and end joints to prevent cracking in the stucco.

- J. Report deviations from the requirements of project specifications or other conditions that might adversely affect the air and water-resistive barrier or stucco installation to the General Contractor. Do not proceed with air and water-resistive barrier or stucco installation until deviations are corrected.

3.3 SURFACE PREPARATION

- A. Concrete and Concrete Masonry (CMU)
 - 1. Remove surface contamination such as oil, grease, dust, dirt, algae, mildew, salts, paint or coatings. Correct weak surface conditions such as laitance. Use chemical cleaners such as TSP (trisodium phosphate) detergent to remove oil and grease and rinse with potable water. Use chemical cleaners to remove efflorescence or other surface contamination in accordance with manufacturer’s written instructions. Use mechanical methods such as waterblasting, sandblasting, and wire brushing to remove weak surface conditions.
 - 2. Repair cracks up to 1/8 inch (3 mm) wide by raking with a sharp tool to remove loose, friable material and blow clean with oil-free compressed air. Apply joint treatment material over crack, embed reinforcement (where applicable), and smooth joint treatment material with a trowel, drywall or putty knife to cover the reinforcement.
 - 3. Remove projecting fins, ridges, and mortar by mechanical means.
 - 4. Fill honeycombs, aggregate pockets, holes and other voids with Sto patching material.
 - 5. Where the surface is excessively “rough” or out of plane, skim coat the wall surface with Sto base coat material to provide a smooth, level surface.
- B. Sheathing
 - 1. Remove surface contaminants and replace damaged sheathing.
 - 2. All sheathing must be handled and installed in compliance with applicable building code and/or manufacturer requirements. Installed sheathing must be clean, dry and free from damage, frost, and all bond-inhibiting materials. Abut gypsum sheathing joints. Gap wood sheathing 1/8 inch (3 mm) at joints. Should gaps exceed 1/8 inch (3 mm) up to 1/2 inch (13 mm) wide, use Sto RapidGuard to fill joints, or apply low expanding urethane foam into joints and rasp or shave flush with sheathing surface in preparation for installation of StoGuard joint treatment.
 - 3. Spot surface defects in sheathing with joint treatment (Sto Gold Fill, Sto RapidGuard, or Sto Gold Coat).

3.4 AIR AND WATER-RESISTIVE BARRIER INSTALLATION

(refer to Sto Guide Details as needed)

NOTE: The air and water-resistive barrier installation described below is one component of the air barrier assembly for the building envelope and the moisture protection of the wall construction. Installation of the air

and water-resistive barrier must be integrated with other air and water-resistive 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.

- A. The following instructions are applicable to:
1. Exterior or Exposure I Plywood in compliance with PS-1
 2. OSB (Oriented Strand Board) in compliance with PS-1 or PS-2
 3. Glass Mat Faced Gypsum Sheathing in compliance with ASTM C1177
 4. Concrete and Concrete Masonry surfaces
- B. Transition Detailing
1. Detail transition areas with Sto RapidGuard (static joints and seams) or StoGuard Conformable Membrane (dynamic joints and seams) to achieve air barrier continuity. For illustrations of installation, refer to Sto Guide Details, Sto RapidGuard Installation Guide, and StoGuard Conformable Membrane Installation Guide (www.stocorp.com).
- C. Rough Opening Protection (*select 1, 2, 3, or 4 for frame construction; for concrete or concrete masonry rough openings with wood bucks and similar openings with complex 3-dimensional geometry, select no. 3, Sto RapidGuard*):
1. Sto Gold Fill with StoGuard Mesh: apply 9 inch (229 mm) wide StoGuard Mesh at rough openings. Immediately apply Sto Gold Fill by spray or trowel over the mesh and spread with a trowel to create a smooth surface that completely covers the mesh (refer to Sto Detail 20.20M).
 2. Sto Gold Coat, Sto AirSeal, or StoGuard VaporSeal with StoGuard Fabric: apply coating liberally by spray or roller to corners of openings, immediately place StoGuard RediCorners in the wet coating, and apply additional coating over the RediCorners to completely embed them. After all corners have been completed apply coating liberally to the entire rough opening, immediately place StoGuard Fabric in the wet coating, smooth any wrinkles with a brush or roller, and apply additional coating over the fabric to completely embed it. Overlap all seams minimum 2 inches (51 mm). Once completed top coat with additional coating as needed to completely seal the surface. Allow to dry and inspect for pinholes or voids. If pinholes or voids are present, seal with additional coating or Sto RapidGuard.
 3. Sto RapidGuard: apply a fillet bead of material with a caulking gun at interior corners inside the opening to seal jamb/sill and jamb/head seams. Apply material in a zig-zag pattern along sill, jambs, and head to form a generous bead of material along the surface to be covered. Use a 6 inch (152 mm) wide plastic drywall knife to spread the material to a uniform thickness of 12-20 mils (0.3-0.5 mm) before the material skins. Treat the entire rough opening surface in this manner and overlap onto the face of the sheathing 2 inches (51 mm) minimum all the way around
 4. StoGuard Conformable Membrane – install the membrane in conformance with manufacturer’s written installation instructions.
- D. Sheathing Joint Treatment (*select one*)
1. Sto Gold Fill with StoGuard Mesh: place 4 inch (102 mm) wide mesh centered along sheathing joints and minimum 9 inch (229 mm) wide mesh centered and folded at inside and outside corners. Immediately apply

Sto Gold Fill by spray or trowel and spread with a trowel to create a smooth surface that completely covers the mesh.

2. Sto AirSeal, Sto Gold Coat, or StoGuard VaporSeal with StoGuard Fabric: apply coating liberally by spray or roller along sheathing joints and immediately place 4 inch (102 mm) wide fabric centered over the joints into the wet coating, and 6 inch (152 mm) wide fabric centered and folded at inside and outside corners into the wet coating. Smooth any wrinkles with a brush or roller and apply additional coating to completely embed the fabric. Overlap seams minimum 2 inches (51 mm).
 3. Sto RapidGuard: apply to properly installed sheathing - joints butted for gypsum sheathing, and joints gapped for plywood and OSB sheathings (wood-based sheathing typically requires 1/8 inch [3 mm] spacing at edge and end joints). Apply a thick bead of Sto RapidGuard with a caulking gun along sheathing joints, or apply in a zig-zag pattern across and down the joints. Spread to a uniform thickness of 20-30 mils (0.5-0.6 mm) before the material skins. Spread 1 inch (25 mm) beyond the sheathing joint on each side. Follow the same procedure for inside and outside corners.
 4. StoGuard Conformable Membrane – install the membrane in conformance with manufacturer’s written installation instructions.
- E. Air and Water-Resistive Barrier Coating Installation
1. Install the specified coating to the required wet film thickness as specified by Substrate, Medium-Build, or Hig-Build (Refer to Section 2.2B).
- F. Air and Water-Resistive Barrier Connections and Shingle Laps
1. Coordinate installation of connecting air barrier components with other trades to provide a continuous air tight membrane.
 2. 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).
 3. Splice-in head flashings above windows, doors, floor lines, roof/sidewall step flashing, and similar locations with StoGuard detail component to achieve shingle lap of the air and water-resistive barrier such that water is directed to the exterior.

NOTE: Windows and doors are typically installed immediately following installation of the air and water-resistive barrier and work should be sequenced accordingly. Consult with window manufacturer for installation requirements to maintain air barrier continuity and for head, jamb, sill flashing and perimeter sealant requirements needed to prevent leaks into the wall assembly.

NOTE: DO NOT ALLOW AIR AND WATER-RESISTIVE BARRIER INSTALLATION TO REMAIN EXPOSED MORE THAN 180 DAYS for Sto Gold Coat and Sto AirSeal, 90 DAYS for StoGuard VaporSeal. PROTECT WITH STUCCO WALL COVERING PROMPTLY AFTER INSTALLATION.

3.5 SHEET WATER-RESISTIVE BARRIER INSTALLATION

(for frame construction with wood or gypsum-based sheathing, not required for concrete or CMU construction)

- A. Install in compliance with the applicable building code requirements for building paper. Lap paper over foundation weep screed attachment flange, floor line flashing, and window/door head flashings. Refer to Sto Guide Details at www.stocorp.com

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 sheet WRB at sills, above windows and doors, at floor lines, decks and at roof/wall intersections such that water is directed to the exterior.

3.6 STUCCO INSTALLATION

(refer to Sto Guide Details as needed)

General Information: 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 diminish strength and resistance to cracking. Under these conditions, 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 fastener attachments with stucco. Moist cure stucco minimum 48 hours for optimum strength gain and resistance to cracking. Allow final stucco application to completely dry (28 days) before applying primer or finish (except in the case of StoPrime Hot which can be applied 48 hours after completing moist cure of stucco). 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.

After satisfactory inspection of surfaces and correction of any deviations from specification requirements commence the stucco installation as described below:

A. Installation over StoGuard

1. Weep Screed Installation *(may also be done in conjunction with flashing and air and water-resistive barrier installation to facilitate shingle lapping of components at base of wall)*
 - a. Install foundation weep screed at the base of the wall securely to solid substrate or framing with the appropriate fastener. 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 foundation weep screed nosing minimum 4 inches (100 mm) above earth grade, 2 inches (51 mm) above finished grade (paved surfaces, for example). Lap air and water-resistive barrier, sheet water-resistive barrier, over the weep screed attachment flange.
2. Casing Bead and Two Piece Expansion Joint Installation
 - a. 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, thru-wall joints in concrete or CMU, 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 (except where horizontal movement joints exist that prevent continuous vertical runs of accessories). Attach at no more than 7 inches (178 mm) into solid substrate/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 – refer to Sto Guide Details.

3. Lath Installation
 - a. Refer to Structa Wire Corp. TwinTrac Installation Guide and IAPMO ER 2017
 - b. Diamond Mesh Metal Lath – conform to ASTM C1063
 - i. General – install metal lath with the long dimension at right angles to structural framing (horizontally on solid substrates). Terminate lath at expansion joints. Do not install continuously at joints.
 - ii. Seams/Overlaps--overlap side seams minimum 1/2 inch (13 mm) and end seams minimum 1 inch (25 mm). Stagger end seams. Overlap casing beads and 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.
 - iii. Attachment--fasten securely into solid substrates or 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.
 - iv. Paper-backed lath – follow installation as for diamond mesh 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 of 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. Exercise care when attaching metal lath and accessories through the water-resistive barrier so that fasteners go into [not between] framing supports. Do not use power, powder-actuated or other fastening tools/methods that can damage the air barrier, water-resistive barrier or substrate.*

4. One Piece Expansion Joint Installation
 - a. Install one piece expansion joints at through wall penetrations, for example, above and below doors and windows. Install one piece expansion joints at every 144 ft² (13 m²). Wire tie one piece expansion joints to lath at no more than 7 inches (178 mm) on center. Seal adjoining pieces by embedding ends in sealant. Make certain lath is DISCONTINUOUS at or beneath joints.
5. Inside and Outside Corners
 - a. Install corner lath at inside corners and corner bead at outside corners over lath. Attach through lath into solid substrate or framing at no more than 7 inches (178 mm) on center with appropriate fasteners.
6. Stucco Installation
 - a. Scratch Coat: apply stucco with sufficient pressure to key into and embed the metal lath. Apply sufficient material, 3/8 or 1/2 inch (9 or 12 mm), 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.
 - b. 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 uniform throughout the wall area and shall be either 3/4 inch or 7/8 inch (19 or 22 mm), as required by construction documents, and shall not exceed 7/8 inch (22 mm).

- c. 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. The proper time to float is when the wood float no longer sticks to the surface of the stucco.
- d. 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.

B. EPS Foam Trim and Build-Outs

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 (B4).
2. Install foam build-outs directly over hardened stucco with foam trim 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 and trim or tool excess adhesive from ends and edges of foam trim for a smooth void-free connection to the stucco substrate.
3. After the adhesive has cured sufficiently to hold the build-out firmly in place, rasp the entire foam surface smooth.
4. Complete the backwrapping procedure by applying the foam trim base coat to the exposed edges of the foam build-out and minimum 2-1/2 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 cementitious base coat to the foam build-out and approximately 3 inches (76 mm) onto the adjacent stucco surfaces to an approximate thickness of 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 2-1/2 inches (64 mm). Overlap mesh onto adjacent stucco wall surfaces minimum 2-1/2 inches (64 mm) at terminations of the foam build-out and feather onto the stucco wall surface. Alternatively, If Sto Crack Defense is used apply Sto Crack Defense with its reinforcing mesh continuously from the stucco wall surface over foam build-outs (refer to 3.07 C).

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.

C. Crack Defense

NOTE: Crack Defense is optional. It provides additional crack resistance to the stucco wall surface.

1. Apply base coat over the moist cured stucco (and foam build-outs if not already reinforced with mesh) with appropriate spray equipment or a stainless steel trowel to a uniform thickness of approximately 1/8 inch (3 mm). Work horizontally or vertically in strips of 40 inches (1016mm), and immediately embed the mesh into the wet base coat by troweling from the center to the edge of the mesh. Overlap mesh not less than 2-1/2 inches (64 mm) at mesh seams and at overlaps of detail mesh. Feather seams and edges. Avoid wrinkles in the mesh. The mesh must be fully embedded so that no mesh color shows through the base coat when it is

dry. Re-skim with additional base coat if mesh color is visible. Do not install base coat or mesh over joints or accessories in the stucco wall assembly.

D. Primer Installation

1. StoPrime Hot – Moist cure stucco for a minimum of 48 hours. Allow stucco to dry an additional 48 hours, then apply primer evenly with brush, roller or proper spray equipment over the clean, dry stucco and foam build-outs, and allow to dry. Final age of primed stucco application must be minimum 7 days before application of finish.
2. StoPrime 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. Final age of primed stucco application must be minimum 28 days before application of finish or pH must be below 10.
3. StoPrime – 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. Final age of primed stucco application must be minimum 28 days before application of finish or pH must be below 10.

E. Textured Finish Installation

1. Apply finish to minimum 28-day old stucco or primed stucco and foam build-outs, or apply when pH of stucco surface is less than 10. If StoPrime Hot is used as the primer the primed stucco/foam build-out surfaces need only be minimum 7 days old. 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 or swirl 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 sealant joints. 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.
 - h. Do not install finish over high pH (≥ 10) stucco surfaces or surfaces that have not been fully cured.
2. Sto Signature or Specialty Finish Installation
 - a. Refer to applicable Installation Guide and/or Product Bulletin for selected finish.
3. StoCast Finish Installation
 - a. Refer to applicable Application Guide and/or Product Bulletin for selected finish.

3.7 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.
- D. Provide sealant and backer material at stucco terminations and at fixture penetrations through the stucco to protect against air, water and insect infiltration. Provide weeps at floor lines, window and door heads, and other areas to conduct water to the exterior.

3.8 CLEANING, REPAIR AND MAINTENANCE

- A. Clean and maintain the stucco finish for a fresh appearance and to prevent water entry into and behind the stucco. Repair cracks, impact damage, spalls or delamination promptly.
- B. Maintain adjacent components of construction such as sealants, windows, doors, and flashing, to prevent water entry into the wall assembly.
- C. Refer to Sto reStore Repair and Maintenance Guide ([reStore Program](#)) for detailed information on stucco restoration – cleaning, repairs, recoating, resurfacing and refinishing, or re-cladding.

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