

PRODUCT DATA SHEET

SikaWall®-640 Tuscan Stucco

Multi-Texture Acrylic Plaster Finish

PRODUCT DESCRIPTION

SikaWall®-640 Tuscan Stucco is a decorative, multi-effect, versatile, tintable and sandable acrylic finish. SikaWall®-640 Tuscan Stucco obtains finish levels ranging from textured to smooth, resembling the appearance of an Old World Plaster finish.

USES

Exterior or Interior finish coat over:

- EIFS
- Properly prepared masonry, stucco, and concrete surfaces
- Interior application over drywall, plaster, or properly prepared masonry or concrete

CHARACTERISTICS / ADVANTAGES

- Dual function use as a basecoat or finish
- Sandable
- Low VOC

PRODUCT INFORMATION

Packaging	60 lbs (27.2 kg) net weight in 5 gal. pails.
Shelf Life	15 months, properly stored in original containers.
Storage Conditions	<ul style="list-style-type: none">▪ Storage: Protect from direct sunlight and freezing at all times.▪ Do not stack pails more than 3 pails high
Volatile organic compound (VOC) content	7 grams per liter

APPLICATION INFORMATION

Coverage	Coverage will vary depending on surface conditions and thickness of
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application.

- Approximately 40-50 ft² per gallon

BASIS OF PRODUCT DATA

Results may differ based upon statistical variations depending upon mixing methods and equipment, temperature, application methods, test methods, actual site conditions and curing conditions.

LIMITATIONS

- Use only on surfaces that are sound, clean, dry, and free from any residue that might affect the ability of this product to bond to the surface.
- Ambient and surface temperature must be 40° F (4.4°C) or higher during application and drying time. Provide supplemental heat and protection from precipitation as needed.
- Application in direct sunlight in hot weather may adversely affect aesthetics.
- Do not allow to freeze until completely dry.
- Always wear proper safety equipment, including particle mask, eye protection and gloves when mixing and/or applying this product.
- In case of contact with eyes, flush with clean water and seek medical attention if irritation persists.
- Do not use harsh or abrasive cleaners. SikaWall®-640 Tuscan Stucco can be cleaned with a soap and water solution followed by a warm water rinse.
- For additional technical guidance, contact Technical Services at (800) 226-2424

ENVIRONMENTAL, HEALTH AND SAFETY

For further information and advice regarding transportation, handling, storage and disposal of chemical products, user should refer to the actual Safety Data Sheets containing physical, environmental, toxicological and other safety related data. User must read the current actual Safety Data Sheets before using any products. In case of an emergency, call CHEMTREC at 1-800-424-9300, International 703-527-3887.

APPLICATION INSTRUCTIONS

SUBSTRATE PREPARATION

- Surfaces must be clean, dry, structurally sound and free from efflorescence, grease, oil, form release agents and curing compounds. For previously painted surfaces, all loose and chalking paint must be removed, and glossy surfaces dulled.
- If used, base coats must be adequately cured before applying SikaWall®-640 Tuscan Stucco.
- Treat all joints, fasteners and accessories with the industry standard joint treatment system for attaining a Level 3 finish as outlined in Gypsum Association publication GA-214, "Recommended Levels of Gypsum Board Finish".

- Cure concrete at least 28 days before applying SikaWall®-640 Tuscan Stucco.
- Skim coat surfaces as necessary, using an appropriate base coat to produce a smooth, level surface and allow it to cure adequately before applying primer and SikaWall®-640 Tuscan Stucco.

MIXING

1. Use clean equipment for mixing and preparation.
2. Stir to obtain a homogeneous consistency using a heavy-duty 1/2-in. (13mm) drill with a rust free paddle at 400-500 rpm. Avoid air entrainment.
3. If specified: Add liquid color to the pail of finish. Make sure all of the color is added by rinsing out the color vial with water (1/3 of the vial's volume) into the pail.
4. Add the amount of water needed (up to a maximum of 16 oz. per pail) to achieve finish texture. To avoid color variations, add the same amount of water to each pail of finish.

APPLICATION

Clean tools frequently using clean water, prior to drying.

- Sika Facades recommends that the project owner or designer approve a job site mock-up of the application of this product. The mock-up should demonstrate the product's appearance under the conditions given by the project specification(s).
- Periodically, as the work progresses, evaluate it from a distance to ensure the desired effect is being produced across the entire surface.
- If installing in a wet environment, the Sika Facades High Humidity Wet Areas specification must be followed.
- Use stainless steel trowels, floats, brushes or rollers to produce intended results.
- The finished surface can be sanded using 220 grit or finer sand paper to remove high points, although sanding SikaWall®-640 Tuscan Stucco alone will not make the surface smooth or eliminate texture resulting from the application. After sanding, wipe the surface with a clean damp cloth and allow to dry completely prior to any further applications.
- Smooth finish - Trowel apply a thin even coat of SikaWall®-640 Tuscan Stucco to completely cover the substrate and allow to dry completely. Then sand the surface with 220 grit or finer sand paper to remove high points. Apply a second tight even coat to the smoothest level possible. After 20-30 minutes, lightly mist the immediate surface area with a small amount of water as necessary and trowel the surface in a random multidirectional pattern with a stainless steel or chrome trowel to achieve the desired level of smooth finish and allow to dry. Repeat this process as necessary allowing drying between each water-trowel process. Allow to dry completely prior to any further

Product Data Sheet

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BUILDING TRUST



applications.

- Textured finish - Trowel apply a hawk-full of SikaWall®-640 Tuscan Stucco in a thin, even coat to completely cover the substrate and immediately follow with a texture coat. While the finish is still wet, immediately follow with the staining process using SikaWall VariStain (optional). Set the spray bottle to a fine mist and spray directly onto the wall surface. Use a sponge float to tamp the SikaWall VariStain into the finish and remove any undesirable spots or drips.
- Two tone effect - Trowel apply a thin coat of SikaWall®-640 Tuscan Stucco to completely cover the substrate and allow to dry. Apply a second coat of SikaWall®-640 Tuscan Stucco over the entire surface and allow it to firm up. Then apply a second color of SikaWall®-640 Tuscan Stucco randomly, using skip trowel methods to achieve the desired level of finish and create highlights. After 20-30 minutes, lightly mist the immediate surface area with a small amount of water as necessary and trowel the surface in a random-multidirectional pattern with a stainless steel or chrome trowel to achieve the desired level of finish.
- Fine texture and burnishing can be achieved by dry troweling the material while still fresh. Special effect - Dilute material with 1 part water to 2 parts SikaWall®-640 Tuscan Stucco and apply the first coat with a 6" "weenie" roller with 1/2" nap and allow to dry 1-2 hours. Then trowel apply a second tight coat with a stainless steel or chrome trowel using methods to achieve the desired level of finish and allow to dry completely prior to any further applications. Apply SikaWall VariStain in the selected colors to achieve the special effect.
- The dry SikaWall®-640 Tuscan Stucco surface of all the finish levels can be sanded at any point to produce the desired results (before or after applying SikaWall VariStain) with each producing a different result.
- Custom finishes - Specific textures can be achieved by using different application techniques. Contact Technical Support regarding custom designs.

read and follow the warnings and instructions on the product's most current product label, Product Data Sheet and Safety Data Sheet which are available at usa.sika.com or by calling SIKA's Technical Service Department at 1-800-933-7452. Nothing contained in any SIKA literature or materials relieves the user of the obligation to read and follow the warnings and instructions for each SIKA product as set forth in the current product label, Product Data Sheet and Safety Data Sheet prior to use of the SIKA product.

SIKA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Product Data Sheet if used as directed within the product's shelf life. User determines suitability of product for intended use and assumes all risks. User's and/or buyer's sole remedy shall be limited to the purchase price or replacement of this product exclusive of any labor costs. **NO OTHER WARRANTIES EXPRESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS.**

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LEGAL DISCLAIMER

- KEEP CONTAINER TIGHTLY CLOSED
- KEEP OUT OF REACH OF CHILDREN
- NOT FOR INTERNAL CONSUMPTION
- FOR INDUSTRIAL USE ONLY
- FOR PROFESSIONAL USE ONLY

Prior to each use of any product of Sika Corporation, its subsidiaries or affiliates ("SIKA"), the user must always

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