

ITALIAN POLISHED PLASTER MATERIAL SYSTEMS – T651

Updated: January 11, 2010

Spatula Stuhhi® branded materials are manufactured in Italy in the time honored and tested tradition of producing the very best in Venetian plaster. Hundreds of years ago, Venetian plaster was created by mixing colored marble powders into local lime based stuccos, creating a wonderful, decorative wall finish for villas, palaces, and places of worship. The original formulas were gritty by today's standards, requiring significant amounts of skilled labor; often involving six to eight coats to achieve a polished finish.

Over the centuries, the primary ingredient in Venetian plaster (slaked lime) was further refined by removing the impurities and the coarser granules. The result is a superior material that is creamy in consistency. With improved product, came faster application speeds, resulting in reduced installation costs.

Today's materials are state of the art and consistent over time. The product is still installed by skilled installers, but in typically two or three coats, depending upon the desired final appearance. Installed prices in most US markets are generally well below \$10 a square foot for those projects over 1000 square feet and which may be accomplished with the installer standing on the ground (without the use of scaffolding). The color range, including both standard and custom colors, is virtually unlimited. Additional common creative effects include tinted waxes, metallic glazes, as well as highly original, complex creations. Triarch, the master US importer of Spatula Stuhhi, stocks material in four regional US warehouses, allowing for quick supply for any project. Shown below is a product summary.

GENERAL MATERIALS SYSTEM

Our plaster systems typically consist of the following four materials:

1. A primer = Gexxo™ Primer
2. A base plaster. What started off as a single product, *Spatula Stuhhi Venetian Plaster*, has expanded into multiple products within the finished plaster market. Not all should be referred to as *Venetian Plaster*, see below for details. Typical pail sizes are available in a 2, 8, or 24 kilo pail.
3. A special high performance, pH resistant pigment
4. A wax: = Cera Del Vecchio (1013), or Antiche Saponi (1017)

Our plaster bases are available in the following three options. Each provides a different final effect:

- Classico 1001, (typical 3 coats) CATALOG DESIGNATION (Sxxx). Generically referred to as *Polished Venetian Plaster* or Classic look.
- OPACO 1014, (typical 2 coats) CATALOG DESIGNATION (Exxx). Generically referred to as a *matte finish, non-glossy, or even a Marmorino finish*.

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- Spirito Libero 1060 (typical 2 coat) CATALOG DESIGNATION (either an Axxx = Spirito Libero w/Antiche Saponi, or Lxxx = with Cera del Vecchio). Generically referred to as *integrally color Italian burnished plaster*, similar to a Marmorino finish.

INTERIOR MATERIALS: Our current integral Italian plasters may be used for most interior installations only. Some limitations apply.

EXTERIOR MATERIALS: Our current product line of Italian Plasters should not be used for exterior projects or where direct exposure to weather is likely or anticipated.

APPROVED SUBSTRATES: most common interior wall assemblies, including drywall, cement board, and cement. Acceptable substrates should have at least a good **level 4 finish**. In some markets a level 5 finish may be needed.

System Components:

GEXXO PRIMER: water based acrylic latex, aggregate-filled primer. It is shipped in one and five gallon plastic pails in neutral white. GEXXO primer **is required** as part of the Spatula Stuhhi system. One good coat should be applied with a roller after substrate preparation and before any plaster. The application should be uniform and without “roller tracks”. Coverage rate is approximately 300 square feet per gallon.

SPATULA STUHHI, OPACO, MARMO, & Spirito Libero BASE MATERIAL: neutral white color, heavy paste that is manufactured with all-natural minerals in a slaked lime plaster base. It contains no resins, solvents, or other environmentally hazardous materials. It is completely non-combustible in either wet or cured state, with almost no VOC.

Our Italian Plasters are shipped wet in primarily plastic but sometimes metal pails and available in three sizes: 2 Kg (used for mock-ups), 8 Kg, and 24 Kg. Color or pigmentation may either be added at the job site or may arrive pre-mixed by the factory to customer requirements (a mixing fee will apply).

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EXAMPLE FROM CHART BELOW: (Classico) One 8 Kg pail of base material will complete 86-96 square feet of three coat finish. One 24 Kg pail of base material will complete 300+ square feet of three coat finish (assuming properly applied).

		<u>SQUARE FOOTAGE COVERAGE</u>		<u>TYPICAL COATS</u>		
		<u>2 kilo</u>	<u>8 kilo</u>	<u>24 kilo</u>		
1001	20-24		86-90	280-330	3	Classico
1014	18-20		80	230-250	2	OPACO 2
1060	18-20		75	230-250	2	Spirito Libero
		<u>SQUARE METER COVERAGE</u>		<u>TYPICAL COATS</u>		
		<u>2 kilo</u>	<u>8 kilo</u>	<u>24 kilo</u>		
1001	2.25		8-9	26-31	3	Classico
1014	< 2		6-7	21-23	2	OPACO 2
1060	< 2		6-7	21-23	2	Spirito Libero
1)	All coverage rates assume application to proper film thickness					
2)	Coverage rates are based upon a good level 4 or level 5 substrate					

PIGMENT SYSTEMS

Spatula Stuhhi branded products are the traditional, natural lime based materials. This traditional material approach produces the best quality finish and correct ambiance in the finished work. As mentioned under SAFETY PRECAUTIONS, the lime based plaster has a naturally occurring high pH. The high pH makes the product naturally resistant to any mold or mildew growth on the surface of the product. It also means that only pH resistant pigments may be used in the plaster bases, otherwise color fading could occur. Universal pigment systems should not be used.

StratoTone™ Pigment System: is a high performance pigment system that handles the high pH of lime based plasters. The StratoTone pigment line has zero VOCs and is APEO free, which is in keeping with sustainable construction practices. StratoTone pigments are used to create both standard and custom colors. All custom color mixing is done in Rhode Island. Consult Customer Service (or your price list) for the latest custom color charges; but as of 11/13/07 the charges are as follows:

	<u>Light to medium Colors</u>	<u>Dark Colors</u>
24 kilo	\$25	\$50
8 kilo	\$8.50	\$17.50
2 kilo	\$2.50	\$4.50

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Job site tinting using the StratoTone system may also be accomplished through the purchase of our Stuhhi Field Tinting Kit. See pictures below for the StratoTone Field Tinting Kit. See *Field Mixing Colors* below.



ADDITIVO (STANDARD COLORS): Additivo colorants are pre-packaged jars of high performance pigments that will reproduce all standard colors – those colors shown in the sales catalogs. The Additivos are packaged in either a 750 milliliter plastic cans or a 62 cc glass jar. Refer to the page in the color chart book called FORMULARIO for correct mixing proportions. The pigment quantity may or may not fill the container because each pigment is measured to an exact amount for the purpose of reproducing a particular color. Additivo colorant is added to the Spatula Stuhhi Base Material in various proportions to create the desired finish color. **Additivos are not always in stock. Please phone our customer service department to check on availability.**

COLOR DISCLAIMER NOTE: Actual material colors may vary from colors printed in sales literature. Colors may also vary from pail to pail due to natural variations in the limestone and marble aggregates used in polished plaster formulations. For assurance of color consistency on a wall or in a room requiring more than one pail, for colors mixed in the field, it is recommended that all pails be **cross boxed**.

Field Mixing Colors

GENERAL COLOR INFORMATION: Italian polished plasters may be installed in its natural off-white color (Bianco on the color chart) without pigment additive. Before adding any pigment, carefully determine the quantity of pigment to be used in the particular pail size you have opened as it is generally impossible to remove pigment after too much has been added.



COLOR PREPARATION: All pigments will settle over time and correct color mixing will not occur if some settled pigment remains in the pigment jar. Be sure to thoroughly shake the can of pigment before opening. In some cases one should stir the can of pigment prior to adding the pigment to the base plaster. If necessary stir using a spatula or other small mixing tool. Be sure to return any pigment that sticks to the spatula into the pigment jar before adding into the base plaster.

After the pigment is blended within the pigment jar, start by stirring the base plaster with a mixing paddle and electric drill.

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Note:

-  StratoTone pigments allow the artisan to add as little or much pigment as desired through the use of a measuring syringe, to achieve a particular color tone.
-  Additivo pigments are designed to be “open and pour” but always subject to general mixing instructions.

The best way to mix pigment into the base is achieved by forming a vortex in the base plaster and pouring the pigment directly into the vortex. This is easily accomplished by two people. If necessary, use a 1” putty knife to remove any pigment remaining in the pigment jar. Do not add water in an attempt to rinse pigment from the can. Stir plaster until completely uniform in color. Allow pigmented plaster to stand or “rest” for at least eight hours prior to application, but many artisans prefer a 24 hour resting period for the plaster to regain original viscosity. “Resting” allows the materials to settle into the required density or viscosity for proper application of first and second coats.

PIGMENT PROPORTIONING USING ADDITIVOS: (REFERRING TO THE PIGMENT MIXING DIAGRAM/CHART FOUND ON OUR WEBSITE. IT WILL ASSIST IN UNDERSTANDING PIGMENT RATIOS MORE QUICKLY) Each Italian Plaster standard color is achieved by adding a specific amount of ADDITIVO (pigment) (750 or 62) to a full pail (current plaster pails are packaged in 2,8 and 24 kilo quantities) of base material. The particular standard colors may require one or more jars of Additivo. Refer to the page in the color chart book of the correct product called FORMULARIO for correct mixing proportions.

If the color requires part of a can of Additivo, measure very, very carefully because a difference of a few drops of pigment can be seen by the eye. If the color requires a full can of Additivo, the correct amount is already measured in the can.

In the event a can of Additivo must be subdivided, follow this procedure:

1. After stirring the pigment can, using a large measuring cup, measure the total contents of the can. You cannot assume the can contains exactly 750 ml because different colors may have more or less pigment in a can.
2. Divide the measured quantity into the required proportions, as needed.
3. Pour the entire cup of pigment back into the original can and wash the cup clean with water.
4. Measure out the fractional part needed for each pail.
5. Stir per instructions and allow to rest at least eight hours before using.

WAXES

CERA del VECCHIO: (Wax of the Old Man) A liquefied, bees-wax base with very low solvent content and virtually no odor. The wax is applied in one or two coats and buffed to a high gloss. The wax is used on interior installations to provide soil rejection, ease of cleaning some abrasion resistance.

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ANTICHE SAPORI: A pigmented wax that “antiques” the surface of the Italian Plaster and imparts a reddish tint to the surface.



MATERIAL HANDLING, STORAGE, DISPOSAL

SAFETY PRECAUTIONS: Triarch’s Italian Polished Plasters (plaster base) contain no solvents, heavy metals, or other hazardous ingredients. They are made of slaked lime, marble dust, and other natural minerals. The plaster has a wet pH of approximately 11.5. It is recommended that eye protection be worn during installation. Application should be done by steel trowels. Consult MSDS for proper safety and handling. **DO NOT ALLOW TO FREEZE.**

ENVIRONMENTAL: All Spatula Stuhhi branded plasters are at or below 50 grams/liter VOC content, which meets or exceeds the USGBC LEED program requirements under section 4.2 for low emitting materials. The plaster is a mineral based product made from limestone (slaked lime) and is rated non-hazardous and noncombustible. It does not contain any glycols, heavy metals, or formaldehyde. StratoTone pigments have zero VOCs and are APEO free.

SHIPPING: Less than pallet quantities of plaster are shipped in pails which are placed in a corrugated paper box along with other product items such as colorant, Wax, etc. All products are shipped as non-hazardous.

DISPOSAL: Small quantities of Italian plaster materials do not require special disposal requirements. For larger quantities, consult local municipal requirements.

Spatula Stuhhi is a registered trademark of Giorgio Graesan & Friends.

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