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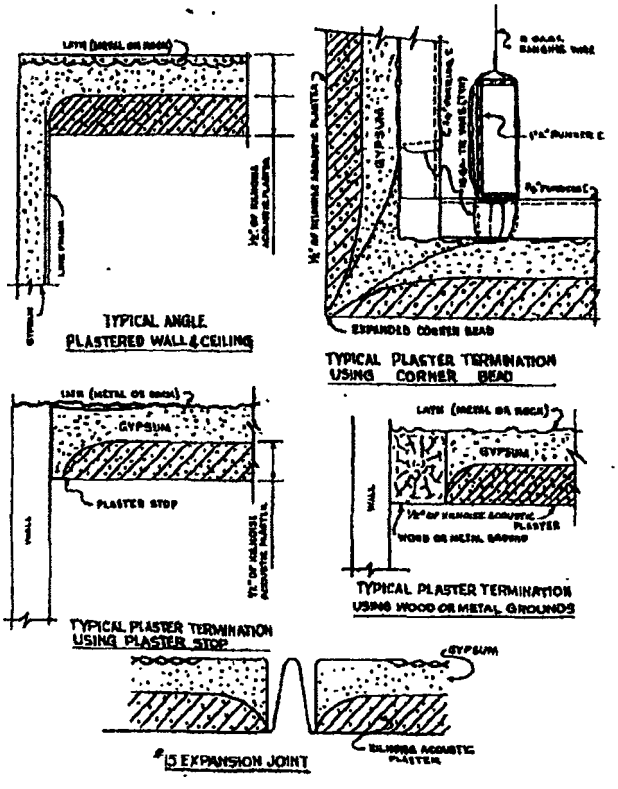
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technical data

PIONEERING IN PHYSICAL CHEMICALS

KILNOISE® ACOUSTIC PLASTER

SUGGESTED WAYS TO MINIMIZE SHRINKAGE OF KILNOISE® ACOUSTIC PLASTER AT POINTS OF TERMINATION.



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TR-148-5

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MINERALS, PIGMENTS & METALS DIVISION

Tiger, Gibsonburg and Blubag Products

specification.....
Gibsonburg Lime

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Kilnoise Acoustic Plaster was developed by Tiger Brands specifically for application on either dry brown coat or unset brown coat. With the Rourke method, Kilnoise is applied over a gypsum brown coat before the brown coat has set, thus saving equipment tie-up and job delay due to prolonged scaffolding. This method of application compares in cost with an application of smooth plaster plus two coats of paint. Kilnoise applied in this manner gives a coverage of 6 square yards, 1/2" thick per 50-lb. bag. Its N.R. Coefficient is .50 and it has a sound-absorption factor of .63 at 500 CPS.

With the dry set base coat method (Standard Application), Kilnoise, like standard acoustic plasters, is applied after the brown coat has set. It works perfectly over many types of base coats: gypsum scratch coat on metal lath; gypsum or portland cement scratch and brown coat on metal lath; 3/8" brown coat on gypsum lath, hollow tile or brick. Kilnoise applied in this manner gives a coverage of 4-1/2 square yards, 1/2" thick per 50-lb. bag. Kilnoise N.R. Coefficient is .60 and it has a sound-absorption factor of .59 at [redacted].

MIXING -- for hand or machine application -- of Kilnoise

Use a clean plaster mixing machine. (Lime stir mixer is NOT suitable for mixing Kilnoise.) For each 50-lb. bag of Kilnoise, use 2 full 5-gallon buckets of clean water. The mixer should run 12 to 15 minutes at 30-32 rpm. If higher rpm machine is used, reduce the mixing time proportionately.

When mixing for hand-type texture machine, use 12-1/2 to 12-1/2 gallons of clean water for each 50-lb. bag of Kilnoise. Mix 8 to 10 minutes.

APPLICATION, depending on your needs and on equipment available, can be any of the following:

1. Apply base coat and texture coat of acoustic plaster with high-volume type plastering machine.
2. Apply base coat with high-volume type plastering machine, then texture with small hand texturing machine.
3. Apply base coat with high-volume type plastering machine, then texture with brush.
4. Apply base coat with hawk and trowel, then texture with small hand texturing machine.
5. Apply base coat with hawk and trowel, then texture with brush.

NOTE: Base coat referred to here is minimum of 1/2" of Kilnoise Acoustic Plaster.

SAMPLE 16374

Sample PFZ0010

Application of Kilnoise to Unset Gypsum Base Coat, - Rourke Method

1. Application of gypsum scratch coat (over metal or gypsum lath)

This must be a 1-2 mix with either sand of lightweight aggregate and allowed to set.

This gypsum scratch coat is necessary over metal lath or a clip system (including nailable channels) of gypsum lath (perforated and non-perforated). It is unnecessary only over gypsum lath nailed to wood joists.

2. Application of gypsum brown coat.

Apply only after scratch coat is set and preferably before scratch coat is dry, with sufficient pressure to insure good mechanical bond. Gypsum brown coat must be a 1-2 mix with sand or lightweight aggregate and must be free of lumps and foreign matter.

NOTE: Sand or lightweight aggregate must meet A.S.T.M. Specification for plastering aggregates. Gypsum mortar consistency must conform with that [redacted] plastering practices.

3. Application [redacted]

Apply to a minimum thickness of 1/2 inch. If machine applied, spray on in one coat. If hand applied, use the 2-coat, double-up method. Apply Kilnoise before the brown mortar has set. The brown coat must be in a plastic state. Follow with straightedging, darbying and spotting to bring to a level surface ready for texturing.

Application by the Standard Method on Dry, Set Brown Coat

1. Application of gypsum scratch coat (over metal lath)

This must be a 1-2 mix with either sand or lightweight aggregate and allowed to set. Take after application to establish good mechanical key.

2. Application of gypsum brown coat.

Apply only after scratch coat is set and preferably before scratch coat is dry, with sufficient pressure to insure good mechanical bond. Gypsum brown coat must be a 1-2 mix with sand or lightweight aggregate and must be free of lumps and foreign matter.

NOTE: Sand or lightweight aggregate must meet A.S.T.M. Specifications for plastering aggregates. Gypsum mortar consistency must conform with that of good plastering practices.

3. Application of Kilnoise

Apply to a minimum thickness of 1/2 inch. If machine applied, spray on in one coat. If hawk and trowel are used, apply in 2 coats. The relative thickness of these two coats is dependent on three factors: the amount of suction; the type of aggregate in gypsum brown coat; the specific job conditions. Follow with all necessary straightedging, darbying and spotting to bring to a level surface ready for texturing.

SAMPLE 16375

Sample PFZ0011

Application of Kilnoise over Portland Cement Base Coat

1. Application of Portland Cement scratch coat.

This must be a mixture of one (1) sack Portland Cement, one (1) sack Tiger Pressure Hydrate Lime or Tiger Mortar-Mate Lime, 4 cu. ft. (24 - #2 shovels) of sand, 7 lbs. of hair or fiber. Apply with sufficient pressure to cling to metal lath. Before mortar is set, score with wire scratcher to establish good mechanical key.

2. Application of Portland Cement brown coat.

This must be a mixture of one (1) sack Portland Cement, 1/2 sack Tiger Pressure Hydrat lime or Tiger Mortar-Mate lime, 4-1/2 cu. ft. (27 - #2 shovels) of sand, 3-1/2 lbs. of hair or fiber. Before mortar is set, score with wire scratcher to establish good mechanical key.

3. Application of Kilnoise

Apply over dry base coat to a minimum thickness of 1/2 inch. If machine applied, spra on in one coat. If hawk and trowel are used, apply in 2 coats. Follow with straight-edging, darbyin[redacted] spotting to bring to a level surface ready for texturing.

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WHEN USING A HIGH-VOLUME PLASTER MACHINE: Be sure to remove the screen from hopper to permit easy flow of material through pump. Operate machine at approximately 20-lbs. p pressure. Use same nozzle as used to apply gypsum plaster. Spray Kilnoise to a unifo thickness of full 1/2 inch. Regulate speed of machine to keep pace with the mechanics Darby material to a level surface. If a brush texture is desired, texturing can be do immediately after darbying.

WHEN USING HAND TEXTURING MACHINE: Surface should be textured when it offers sufficie resistance (Usually 24 hours or more after application). Moisten hopper before filling with Kilnoise (see mixing instructions on page one). Operate machine at 12 to 15 lbs pressure. Use nozzle with 1/2 to 3/8-inch orifice. Regulate texture by changing orifi size, air pressure or material consistency, or any combination of these. Keep orifice free of foreign matter. Keep nozzle at slight angle, 12 to 18 inches from surface. Move gun constantly to insure uniform texture.

BRUSH TEXTURING: Brush surface uniformly to the desired texture. Surface can be brush textured immediately after darbying (or within a few hours). For best results, keep brush clean and free of material build-up at all times.

PERFORATING: Use nail perforator uniformly over entire surface after texturing, and only after a slight crust has formed on surface. For best results with Kilnoise applie to unset base coat, perforate 48 hours after application; for best result with Kilnoise applied to dry, set base coat, perforate 24 hours after application. Keep nail wet, clean and free of fibers. Flatten all hanging fibers with light pressure of clean, rust-free trowel.

SAMPLE 16376

Sample PFZ0012

REPAIRS: If damaged, Kilnoise can be repaired. First, cut out the damaged area. Mix Kilnoise to a fluffy consistency, so that it will be the same density as the surrounding material. Dampen the patch with clean water (to a width of 2 or 3 inches) completely around the joint. Apply two coats. Stipple and perforate the same as in the original application of Kilnoise. Caution: Avoid material build-up around edge of the patch.

CLEANING: Cleaning may be necessary occasionally, particularly in areas around thermostats. Use an ordinary vacuum cleaner with brush attachment, or a small whisk broom.

PAINTING: Make sure no fibrous hangings are showing (these can be removed with a vacuum or the edge of a trowel). Dampen the ceiling with clean water (this eliminates excessive paint suction into the Kilnoise). Do not wet too far ahead of painters; allow 48 ft. as maximum distance ahead in a room 30 ft. wide. Paint only with a water base (Non-Bridging) paint, using standard rollers or spray equipment.

SPECIAL TIPS

Ridges and depressions should be eliminated, providing a level surface for brush or machine texturing.

Whenever possi[redacted]plete work at points of termination, rather than leave joints overnight. Wi[redacted]plied to a set, dry base, when 24 hours or more elapses between coats,[redacted]urface of first coat lightly to establish good mechanical key.

Highlighting is necessary for a more pleasing and maintenance-free surface. For best results, highlight immediately after perforating. Always use a clean, rust-free trowel

Undermixing will fail to give full coverage.

Overmixing will prevent surface from attaining desired hardness and cause hand failure

SPECIAL TIPS.....for Kilnoise applied to unset brown coat only.

The binder tape on gypsum lath must be completely removed, otherwise give from tape may cause separation between brown coat and gypsum lath.

Over a clip system of gypsum lath (including metallic channels) allow scratch coat to set before applying brown coat. This is necessary to develop sufficient strength to prevent gypsum lath from "saddling".

GLITTER: This will add extra beauty to a ceiling. It should be of a non-tarnishing type, and applied in dry form either by a glitter gun or by a small hand-type texturing machine. When using Kilnoise applied over an unset base, spray the glitter in a uniform pattern, usually one day after application. When using Kilnoise applied over a dry, set base, spray glitter on immediately after brush texturing. The glitter should be highlighted very lightly to insure a permanent bond.

SAMPLE 16377

Sample PFZ0013

BONDING AGENTS: We do not recommend the use of Kilnoise over asphalt emulsions or similar bonding agents. Products such as 'Plaster-Weld', 'Link', and 'Durabond' are best suited for this purpose. When applied in strict accordance with these manufacturers' specifications, and used in full strength, such bonding agents will hold Kilnoise to any surface except those covered with water soluble paints. Always apply Kilnoise directly over the bonding agent -- never use a gypsum brown coat between them.

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SAMPLE 16378

Sample PFZ0014