

Operation RockCast Patching Process

Set Up Procedure:

1. Identify color of unit to be patched and quantity. (fig. 1)
2. Request patch kit of pre-mixed sand (with appropriate color if applicable) and white cement, & RockCast bonding agent from Customer Service Rep.
3. Obtain a mixing container, measuring spoon or equivalent, trowel, a 3/4 x 3 x 8 piece of plywood or equivalent and a fine misting spray bottle. (fig. 2)
4. Do not attempt patching in direct hot sun or when temperatures are below freezing.

Patching Process:

1. Verify that sand is color requested, bag should be labeled.
 2. Using the measuring spoon, mix 5 (five) parts sand with 1 (one) part cement into container. (fig.3) Stir mixture with spoon prior to adding bonding agent. (fig. 4)
 3. Add only enough bonding agent to moisten the mix, maintaining a dry consistency. 5% is standard. (fig. 5)
 Note: Remove a handful of mix and squeeze together in your hand. The mixture should stay together in a ball but leave little residue on hand. (fig. 6)
 4. Apply fine mist of water to area being patched.
 5. Using the trowel, apply mixture to the area to be patched.
 Note: It is important to fill only the damaged area and not the surrounding areas.
 6. Using the trowel & wood, gently pack/trim the patch. (fig. 7 and 8)
 7. It is important to periodically (every 15 minutes for a 2 hour time frame) apply a fine mist of water. Do not saturate. (fig. 9)
 8. For normal use allow patch(es) to cure for a minimum of 24 hours. For higher traffic areas allow 48 hours cure time.
- Maximum placement for patching mix should not exceed 30 minutes. Higher air and surface temperatures will decrease working / placement time.
 - Material within patch area will have a slight variation in shade and texture. Allow adequate curing time, clean entire job according to recommended instructions.
 - Do not patch when ambient air or surface temperature is below 40 degrees or expected to fall below there within 48 hours.

Key Quality Checkpoints:

Description

1. Ensure correct sand color
2. Do not mix sand and cement prior to being ready to patch. Moisture within sand could begin hydration process.
3. Verify material and tool list is available
4. Do not add too much bonding agent to mix, moisten only.
5. Do not apply too much mix at one time to patch area.
6. Frequently mist completed patch

1. Area to patch



2. Required tools and materials



3. 5 parts aggregate, 1 part cement



4. Stir mixture



5. Add bonding agent



6. Mix hydrated with bonding agent



7. Tamp patch



8. Finish patch



9. Moisten patch



Approvals:

Division Manager

Date

Quality Representative

Date

Responsible E.C. Member

Date