

STA-SMOOTH® BRAND HI-STRENGTH (HS) JOINT COMPOUND



GENERAL INFORMATION

Sta-Smooth HS is a high-strength, quick-setting compound developed by National Gypsum specifically for the manufactured housing industry. Designed primarily for ceilings, Sta-Smooth HS minimizes the costly cracking that often occurs when ceiling panels are moved for assembly.

Unlike other compounds, Sta-Smooth HS develops its high strength within the first hour of application, minimizing the potential for cracks and fractures. Sta-Smooth's quick-setting formula also promotes quality and efficiency on the production floor. One coat of Sta-Smooth HS Compound is normally all that is required when the surface is to be spray-textured.

ProForm® BRAND spray textures can be sprayed on the treated joint the moment the compound is hard, but not dry. Spraying can begin from the time the compound is set.

For best results, Sta-Smooth HS must be used in combination with reinforcing tapes such as Sta-Smooth HS Tape or ProForm Paper Joint Tape. For unsprayed ceilings, Sta-Smooth Lite is recommended as a second coat prior to stomp/knockdown or smooth finish.

Spray textures on ceilings create a monolithic look while concealing minor surface imperfections and irregularities.

FEATURES/BENEFITS

- Sta-Smooth HS Joint Compound develops its high strength in less than one hour, minimizing the potential for cracking.
- Available in five working-set times to meet industry needs.
- Packaged in easy-to-carry 25-lb. (11.3 kg) bags.
- When a spray texture is specified for ceilings, the usual second coat of compound can be eliminated, saving time and labor.
- Noncombustible.

SPECIFICATIONS

Sta-Smooth HS is available in the following working and setting times: (It is difficult to regulate setting-times to the exact minute; time ranges are used when discussing setting-type joint compounds.)

Product	Working Time (Min.)	Setting Time (Min.)
HS 15	10-15	15-20
HS 20	10-20	20-25
HS 30	15-30	25-35
HS 45	25-35	35-55
HS 60	45-60	45-65

Coverage: 45-55 lbs/1,000 sq. ft. (22-27 kg/100m²)

Note: Compound hardens and chemically sets before it completely dries. Always close bags as airtight as possible. Do not mix with any other material.

GENERAL APPLICATION

When mixing the compound with water, use only clean, drinkable water. Use of dirty water or other materials could result in inconsistent set times and possibly no bond to the wallboard. Clean mixing equipment and tools thoroughly between batches. Material should not be overmixed; this will result in shortened working times.

Sta-Smooth HS should not be used over another product until the first coat is set hard to the touch.

Each coat of Sta-Smooth HS must be set hard to the touch before adding a second coat or a vapor barrier spray.

Apply Sta-Smooth HS Joint Compound at a heavy consistency, making sure to completely fill the wallboard joint through the tape. For optimum results, use Sta-Smooth HS Tape or ProForm Paper Joint Tape.

As soon as Sta-Smooth HS starts to harden, shave off all trowel, knife or joint marks or excess compound using a 6" finishing knife. Do not wait to smooth out marks and protrusions or the compound will be extremely difficult to sand.

If the surface will not be textured, apply a second, wider coat of Sta-Smooth Lite Joint Compound. Sta-Smooth Lite is a lightweight setting compound that produces a smooth, easy-to-sand finish.

Once a second coat has been applied, feather all edges and finish the surface smooth and level. The wet sponge sanding method offers excellent results, avoids creating dust and can be started as soon as the compound has hardened.

When ProForm spray textures will be applied, the second coat of compound can be eliminated. This saves valuable time and labor in assembly-line operations.

Sta-Smooth HS can be decorated with either a good-quality wall or ceiling paint or a spray texture. Apply paint after priming according to the recommendations of the paint manufacturer. ProForm spray texture products can be used as directed after priming with an alkyd flat paint or a vapor barrier seal.