

# ProForm<sup>®</sup> BRAND Sta-Smooth<sup>®</sup> Setting Compounds

ProForm<sup>®</sup> BRAND Sta-Smooth<sup>®</sup> Setting Compounds are quick setting (hardening) type compounds that are not affected by humidity once they have set and dried. They were developed for use in the ProForm Sta-Smooth System to reduce joint deformities such as ridging and beading and provide shortened joint finishing time. ProForm Sta-Smooth Compounds firmly bond the tape to the board and the ProForm Sta-Smooth board edges to each other. ProForm Sta-Smooth Compounds are suitable for filling voids left in above-grade interior concrete. Required for finishing joints on exterior soffit board.

## ProForm<sup>®</sup> Sta-Smooth<sup>®</sup> Joint Compound



### Description

Quick setting/hardening compound that is not affected by humidity once it has set and dried. Available in 20, 45, 90 and 210 minute set times.

### Applications

- Use in poor drying conditions
- Heavy fills, beads and trims
- Can recoat as soon as previous coat sets
- Allows same-day joint finishing

### Features/Benefits

- Unaffected by humidity once set/dried
- Low shrinkage
- Greater scheduling flexibility
- Resists ridging and beading

### Packaging

Packaged in:  
25 lb. (11.3 kg) bags  
West Coast only:  
44.1 lb. (20.0 kg) bags  
**Approx. Coverage:**  
45-55 lbs./1000 sq. ft.  
(22-29 kg/100 sq. m)  
**Mixing:**  
Mix 13-14 pts.  
(6.2-6.6 L) clean  
drinkable water  
per bag.

## ProForm<sup>®</sup> Sta-Smooth<sup>®</sup> Lite Joint Compound



### Description

A lightweight setting compound offering the advantages of a setting type compound that is also sandable. Available in 5, 20, 45, 90 and 210 minute set times.

### Applications

- Use in poor drying conditions
- Heavy fills, beads and trims
- Can recoat as soon as previous coat sets
- Allows same-day joint finishing

### Features/Benefits

- 30% lighter than regular Sta-Smooth
- Easier sanding
- Unaffected by humidity once set/dried
- Low shrinkage
- Greater scheduling flexibility
- Resists ridging and beading

### Packaging

Packaged in:  
18 lb. (8.2 kg) bags  
West Coast only:  
44.1 lb. (20.0 kg) bags  
**Approx. Coverage:**  
45-55 lbs./1000 sq. ft.  
(22-27 kg/100 sq. m)  
**Mixing:**  
Mix 11-12 pts.  
(5.2-5.7 L) clean  
drinkable water  
per bag.

## ProForm<sup>®</sup> Sta-Smooth<sup>®</sup> FS 90 Joint Compound



### Description

A setting type compound designed to provide protection in fire-stopping penetrations through fire-rated partitions or assemblies in both new and retrofit construction. Sta-Smooth FS 90 seals out smoke, toxic gas and water, plus it provides a seal to stop sound and dust infiltration.

### Applications

- Seals out smoke, toxic gas and water
- Provides seal to stop sound and dust infiltration

### Features/Benefits

- Tinted reddish/pink to distinguish from other joint treatment products
- Comes in powder form so that only amount needed can be mixed (less waste)

### Packaging

Packaged in:  
25 lb. (11.3 kg) bags  
**Approx. Coverage:**  
25 lb. bag/850 cu. in.  
**Mixing:**  
Mix 12-13 pts.  
(5.7-6.2 L) clean  
drinkable water  
per bag. If less than a  
full bag will be needed,  
then plan on a ratio of  
2 parts dry powder to  
1 part water.

## Mixing

Mix no more compound than can be applied in the designated set time. Place the amount of water recommended on the compound packaging in a clean 5-gallon pail. A plastic container is recommended because of its ease in cleaning between batches. Add the compound gradually to room temperature clean, drinkable water. Mix the compound until it is smooth and free of lumps. Allow to stand (soak) for one minute, then remix until consistency is smooth and uniform. If a thinner or thicker mix is desired, add water or powder sparingly. When power mixing is used, the motor speed should not exceed 600 RPM since high speed and prolonged mixing will shorten the working time of the product.

## Estimated Working Times

One of the most crucial things for selecting the proper ProForm Sta-Smooth Joint Compound is matching its working time and setting time ranges to the project.

It should be noted that working time and setting time are not the same.

**Working Time** refers to the period during which the ProForm Sta-Smooth is usable for application. At the end of this time, the material begins to stiffen and can no longer be spread easily. Working time should correspond to the required time for actual application.

**Setting Time** refers to the time after which the applied ProForm Sta-Smooth Compound will become adequately hardened so that another layer can be applied. For manufactured or modular builders, the setting time should match your timetable for moving a floor along the line.

### APPROXIMATE WORKING TIME VS. SET/HARDENING TIME

Sta-Smooth/ Sta-Smooth Lite Product Grade	Working Time (Minutes)	Set/Hardening Time (Minutes)
5	3	10–20
20	15	20–35
45	30	45–60
90	70	90–120
210	150	210–250

## Limitations

- Not to be applied over moist surfaces or surfaces subject to direct moisture.
- Do not mix with any other material. Use only clean, drinkable water.
- Mixing equipment and tools must be thoroughly cleaned between batches.
- Each fresh batch of compound must be kept free of previous batches; otherwise the working time will be shortened.
- High-speed mixing or excessive mixing will shorten the working time of the ProForm Sta-Smooth Compounds.
- Do not add water or remix after compound begins to thicken and harden.
- Cleanup difficulties with automatic taping tools may occur when using a setting-type compound.
- Close opened bag as tight as possible for storage or setting time may be affected.
- Storage life in high humidity area is 6 months; other areas up to 12 months maximum.
- In cold weather, temperatures within the building should be maintained at a minimum 50°F (10°C), both day and night, during joint finishing. Adequate ventilation should be provided to eliminate excess moisture.

## Frequently Asked Questions

### 1) Why is the product lumpy after mixing?

- Water was added to the ProForm Sta-Smooth, rather than the compound being added to the water.
- ProForm Sta-Smooth was not allowed to soak (for approximately one minute) after initial mix before remixing was initiated.

### 2) Why is the product setting much faster than the advertised range?

- Dirty mixing water and/or application tools.
- Excessive mixing of the compound.
- Foreign material (accidentally or deliberately) added to the mixture.
- Mixing water too hot.

### 3) Why is the product setting much slower than the advertised range?

- Too much water was used.
- Impure water source (dissolved organics in the water generally retard the set time).
- Foreign material (accidentally or deliberately) added to the mixture.
- Water too cold.

### 4) Why does the product display weak strength?

- Too much water was used.
- Foreign material (accidentally or deliberately) added to the mixture.