

**Veneer plaster over DuRock cement board** IMPERIAL veneer finish provides superior abrasion resistance and excellent indentation and impact resistance when used as the finish plaster over DUROCK cement board in commercial and institutional applications such as schools and high-traffic retail locations. Prior to application of IMPERIAL veneer finish, the DUROCK cement board must be treated with USG plaster bonder and the joints treated with SHEETROCK joint tape and DURABOND setting-type joint compound or EASY SAND lightweight setting-type joint compound. Then DIAMOND veneer basecoat is applied as a basecoat. With the basecoat set and partially dry, apply the finish plaster using a scratch and double-back technique. Complete the finishing when the material is firm. Leave the finished surface smooth and dense for decorating. Note that only two-coat veneer plaster may be used over DUROCK cement board.

**Veneer plaster over sanded STRUCTO-BASE gypsum plaster** Extraordinary levels of indentation and impact resistance combined with superior abrasion resistance are achieved with IMPERIAL Veneer Finish used as the finish coat in this system. Leave the surface rough and open for the proper bond of finish coat. Allow the basecoat to set to provide proper suction for the finish coat. IMPERIAL veneer finish is applied as indicated above for a one-coat system.

**Decorating**

It is recommended that all plaster finishes be painted (decorated) unless the finish is considered acceptable undecorated. Unsealed IMPERIAL veneer finish may be painted the day after application, with a breather-type paint. No matter what paint or decoration is used, it is essential that the plaster be completely dry. Typically, veneer plasters may be dry in as little as 24 hours. Use a high-quality, undiluted acrylic latex, vinyl copolymer or alkali-resistant alkyd paint. All applied finishes, such as epoxy-based finish systems, must be properly sealed before finishing. Quick-drying vinyl-acrylic latex or alkali-resistant alkyd primer-sealers are recommended. Polyvinyl acetate (PVA) -based primers should not be used. The PVA film is subject to rewetting and will almost certainly cause bond loss and subsequent paint delamination.

**Product Data**

**Coverage:** IMPERIAL veneer finish covers approximately 3,500-4,000 sq. ft. per ton (360-410 m<sup>2</sup> per metric ton) of plaster.

**Compliance with Standards:** IMPERIAL veneer finish meets ASTM Designation C587.

**Warning:** Store all IMPERIAL gypsum base, FIBEROCK abuse-resistant panels and DUROCK cement board flat. Panels are heavy and can fall over, causing serious injury or death. Do not move unless authorized.

**Storage:** Store material in a cool, dry place. Avoid direct sunlight. Maintain temperature above 40 °F (4 °C).

**Shelf Life:** Up to 6 months under protected storage conditions. Rotate stock.

**Availability and Cost:** IMPERIAL veneer finish is distributed throughout the United States. Contact a United States Gypsum Company sales office or sales person for additional information.

**Packaging:** IMPERIAL veneer finish is available in 50 lb. (22.7 kg) bags.

**Submittal Approvals:**

<b>Job Name</b>	
<b>Contractor</b>	<b>Date</b>

**WARNING!**

When mixed with water, this material hardens and becomes very hot - sometimes quickly. DO NOT attempt to make a cast enclosing any part of the body using this material. Failure to follow these instructions can cause severe burns that may require surgical removal of affected tissue or amputation of limb. Long-term breathing of respirable crystalline silica dust can cause permanent lung damage and/or cancer. Dust may cause irritation to eyes, skin, nose, throat and

upper respiratory tract. Avoid irritation by reducing exposure to dust. Use in a well-ventilated area or provide sufficient local ventilation. Wash with soap and water after use. Do not ingest. If dusty, wear a NIOSH/MSHA-approved dust respirator. Wear eye protection. If eye contact occurs, flush thoroughly with water for 15 minutes. If irritation persists, call physician. If ingested, call physician. Product information and MSDS: (800) 507-8899 or www.usg.com.

**KEEP OUT OF REACH OF CHILDREN.**

**Trademarks**

The following trademarks used herein are owned by United States Gypsum Company: DIAMOND, DURABOND, DUROCK, EASY SAND, FIBEROCK, FIRECODE, IMPERIAL, SHEETROCK, STRUCTO-BASE, USG.

**Note**

Products described here may not be available in all geographic markets. Consult your U.S. Gypsum Company sales office or representative for information.

**Notice**

We shall not be liable for incidental and consequential damages, directly or indirectly sustained, nor for any loss caused by application of these goods not in accordance with current printed instructions or for other than the intended use. Our liability is expressly limited to replacement of defective goods. Any claim shall be deemed waived unless made in writing to us within thirty (30) days from date it was or reasonably should have been discovered.

**Safety First!**

Follow good safety and industrial hygiene practices during handling and installation of products and systems. Take necessary precautions and wear the appropriate personal protective equipment as needed. Read material safety data sheets and related literature on products before specification and/or installation.



# Imperial® Veneer Finish



## For strong, abrasion-resistant interior finishes

- Durable and stable. IMPERIAL® brand veneer finish offers the durability needed in high-traffic areas.
- Economical construction. Substantial savings in finishing materials and application time.
- Fast finishing. IMPERIAL veneer finish is usually ready for next-day decoration with a latex-based breather-type paint.
- Provides noncombustibility. When used with IMPERIAL® brand gypsum base, IMPERIAL plaster systems provide fire-resistant construction.

## Description

IMPERIAL veneer finish is a high-strength veneer plaster designed for single-coat application over IMPERIAL gypsum base, or as a high-strength finish over veneer or conventional high-strength sanded basecoats. Applied in 1/16" to 3/32" thicknesses, it is formulated for hand application. It produces a hard, 3,000 lb./in.<sup>2</sup> compressive strength, abrasion-resistant finished surface.

IMPERIAL veneer finish may be used in one-coat work or as a finish over IMPERIAL® brand veneer basecoat in two-coat work, or as a finish over DIAMOND® brand veneer basecoat applied to either DUROCK® brand cement board or FIBEROCK® brand abuse-resistant panels treated with USG™ plaster bonder. Smooth-trowel or texture finishes are recommended. IMPERIAL veneer finish over IMPERIAL or DIAMOND veneer basecoats should be selected when very high surface hardness and abrasion resistance is desired in a two-coat veneer system. Though easily textured, smooth-coat finishing is achieved by ensuring that the initial application is completed with minimal lap marks and voids, as this product's hardness makes it difficult to remove blemishes and cat faces during final troweling. Also suitable as a finish applied to job-sanded STRUCTO-BASE® brand gypsum plaster to provide the ultimate in surface hardness with conventional plaster assemblies.

## Limitations

1. IMPERIAL veneer finish is not recommended for use directly over portland cement basecoat, concrete block, interior monolithic concrete, FIBEROCK abuse-resistant panels or DUROCK cement board. Use DIAMOND veneer basecoat directly over concrete block, FIBEROCK abuse-resistant panels, DUROCK cement board, or over USG plaster bonder on monolithic concrete before application of the finish.
2. Plaster application on masonry or concrete walls or ceilings coated with bituminous compounds or other water-proofing agents is not recommended. Exterior walls should be furred.
3. Not recommended where contact with water or excessive moisture may be encountered.

## Directions

### Preparation

Protect from moisture during storage and on the job. In cold weather, heat the interior of the building to a minimum of 55 °F (13 °C) for an adequate period before the application of plaster, while basecoat and finish is being applied, and until the finish is dry. Air circulation should be kept at a minimum level during application and until proper set has been achieved.

If possible, maintain building temperature-humidity combination in the "normal drying" area of the graph shown on next page. When abnormally dry conditions exist, relative humidity often can be increased by wetting down the floor periodically. During these periods, make every effort to reduce air movement by closing windows and deflecting heater blower and duct output away from the surfaces being plastered. If the building temperature-humidity combination is in the "rapid drying" area of the graph, or IMPERIAL gypsum base is applied over steel studs, or in certain applications to framing spaced 24" o.c., special joint reinforcement measures must be taken. Follow the directions below in "Joint Treatment."

### Joint Treatment

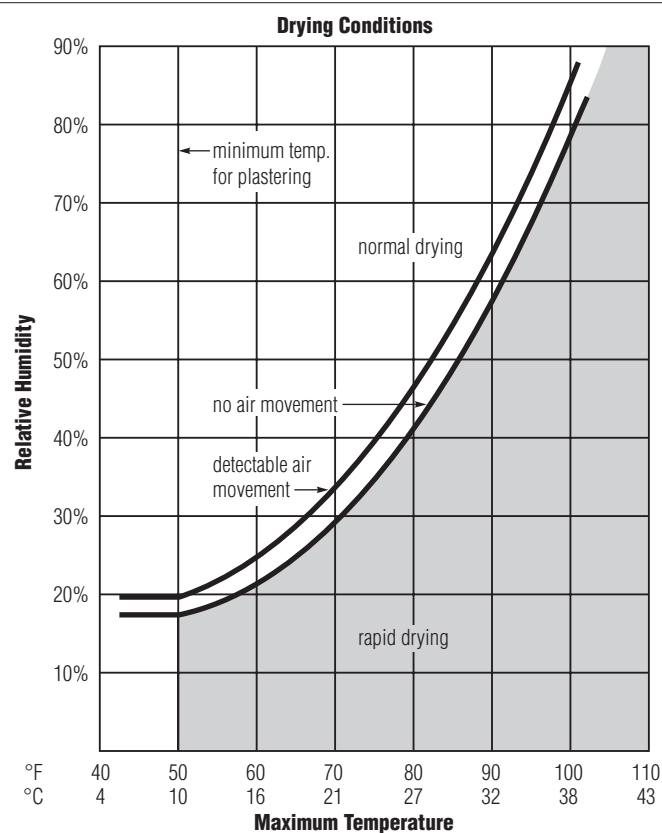
**Normal drying conditions** Apply IMPERIAL® brand tape over all joints (edges and ends). Do not overlap tape at intersections.

Align IMPERIAL® brand Type P (pressure-sensitive) tape over the joint and press into place over the entire length of the joint. Eliminate wrinkles and assure maximum adhesive bond by pressing the entire length of tape with a steel finishing knife or trowel. Press the tape into corners with a corner tool. Do not overlap.

Alternatively, attach IMPERIAL® brand Type S tape with spring-driven hand stapler using 3/8" staples. Use two staples at each end of the tape; staple the remainder at staggered 24" intervals. At wall-ceiling angles, staple every 18" to 24" along the ceiling edge only. For wall-to-wall interior angles, staple every 18" to 24" on one edge only, working from top to bottom. Position the tape to bridge the joint at all interior corners without overlapping. For fire-rated assemblies, staple either Type P or Type S tape, 8" o.c.

**Rapid drying conditions** When building temperature-humidity conditions fall in the “rapid drying” area of the graph or IMPERIAL gypsum base is applied over steel studs, or in certain applications to framing spaced 24” o.c., use SHEETROCK® brand joint tape embedded with SHEETROCK® brand DURABOND® setting-type joint compound or SHEETROCK® brand EASY SAND™ lightweight setting-type joint compound. Mix the joint compound in a clean 5 gal. container (plastic is preferred). Use a commercial potato masher or a 1/2” heavy-duty 200- to 300-rpm electric drill with a drywall compound-type paddle. Drill speed must not exceed 400 rpm. Use the amount of water shown on the bag, and always sift the powder into the water to ensure complete wetting. Stir vigorously for 3 minutes; if lumps remain, allow the mix to soak for a minute or two then restir until smooth. **Note:** Do not contaminate compound with other materials, dirty water or previously mixed batches. Do not retemper batches.

Butter joints with compound using a trowel or steel finishing knife to force compound into the joints. Center SHEETROCK joint tape and press it into the fresh compound with trowel held at a 45° angle. Draw trowel along joint with sufficient pressure to remove excess compound, ensuring the tape is wetted and covered with a thin skim coat of the excess compound to reduce the possibility of edge wrinkling and/or curling. Wipe clean. Allow joint treatment to set; then apply a separate coat of joint compound to *completely cover the tape*, using a 10” or 12” knife or trowel, feathering it 2” to 3” beyond the edges of the tape. Allow it to set and dry before plastering. Joint areas prepared in this manner should be surface-dampened with a light application of water by brush, felt or spayer just prior to the plaster application to ensure proper absorption. Failure to do this can cause excessive initial absorption, while completely wet joints will not allow required absorption.



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**Mixing**

Mix plaster with a cage-type paddle driven by a heavy-duty drill capable of producing 900-1,000 rpm minimum under no load. Approximate water-plaster ratio for IMPERIAL veneer finish (hand application) is 7-8 qt./50 lb. (8-9 L/22.7 kg) bag.

Place the water in a 12- to 15-gal. smooth-sided container. Start the mixer, slowly add plaster and mix at least 2 minutes to disperse lumps completely. Do not mix more than 5 minutes.

For sand float finish, add up to 20 lb. (9 kg) clean silica sand per 50-lb. bag of IMPERIAL veneer finish to achieve desired texture. The use of more than 12.5 lb. (5.7 kg) of sand per bag will result in strength development of less than 3,000 psi. Apply plaster in the normal manner but omit final troweling. After surface has become firm, float to desired texture using sponge, carpet or other float. Use water sparingly.

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**Plastering**

IMPERIAL veneer finish provides a wide range of finish options with distinct application systems:

**One-coat system** Scratch in a tight, thin coat of IMPERIAL veneer finish over the entire area, immediately doubling back with plaster from same batch to full thickness of 1/16" to 3/32". Fill all voids and imperfections. Final-trowel after surface has become firm, holding the trowel flat and using water sparingly. Do not over-trowel.

For textured surfaces, with or without the addition of job-added sand, final troweling is omitted. The surface is textured naturally as the material firms and water is removed into the base.

Best results are obtained with continuous application from angle to angle. Where joining is unavoidable, use the trowel to terminate unset plaster in sharp clean edge—do not feather out. Bring adjacent plaster up to terminated edge and leave level. Do not overlap. During finish troweling, use excess material to fill and bridge joining.

**Over IMPERIAL veneer basecoat (two-coat system)** IMPERIAL veneer basecoat or DIAMOND veneer basecoat applied to IMPERIAL gypsum base, or concrete block or monolithic concrete treated with USG plaster bonder. Leave the surface rough and open for the proper bond of finish coat. Allow the basecoat to set to provide proper suction for the finish coat. IMPERIAL veneer finish is applied as indicated above for a one-coat system.

**Veneer plaster over FIBEROCK abuse-resistant panels** Veneer plasters provide increased resistance to abrasion, indentation and penetration when used over FIBEROCK abuse-resistant panels in commercial and institutional applications such as schools and high-traffic retail locations.

In this two-coat veneer plaster system, DIAMOND veneer basecoat and IMPERIAL veneer finish are applied over FIBEROCK abuse-resistant panels attached to framing. Space wood or steel framing 16" o.c. or 24" o.c. Position all ends and edges of panels over framing members, except when joints are at right angles to framing members, as in perpendicular application or when end joints are back-blocked. On walls, fasteners are spaced a maximum of 12" o.c. For ceiling applications, nails should be spaced no more than 7" o.c., screws, 12" o.c. Prior to treatment of panel joints, apply USG plaster bonder in a continuous film to joint area according to application directions.

Treat joints with SHEETROCK joint tape and DURABOND setting-type joint compound or EASY SAND lightweight setting-type joint compound. Provide an additional coat of setting-type compound to fully conceal the tape. Allow to completely dry. When the joints are completely dry, treat the entire wall surface with USG plaster bonder according to the application directions. Then apply DIAMOND veneer basecoat 1/16" to 3/32" thick using scratch and double-back technique. This is accomplished by applying a tight, thin coat over the entire area, and immediately doubling back with plaster from the same batch to achieve full thickness. When basecoat plaster is firm, broom the surface to leave it rough and open for finish. With basecoat set and partially dry, apply IMPERIAL veneer finish using a scratch and double-back technique. Complete finishing when material is firm. Leave finished surface smooth and dense for decorating.

Note that 5/8" FIBEROCK abuse-resistant panels can be substituted for 5/8" IMPERIAL gypsum base, FIRECODE® core, or 1/2" IMPERIAL gypsum base, FIRECODE C Core, in any fire-rated design as long as 20-gauge steel framing is used and the above joint treatment procedure is followed.