



## Notes to the Maker

Each climate type will yield distinct results in mix time and fluidization. Provided below is a guideline for the GFRC Blend to perform well in mix temperatures at or below 70°F. Note that you may have to fine tune this process if you are using this mix at more extreme temperatures. The GFRC Blend has approximately 24.3 lbs of cementitious material per bag. For the best results, follow a rigid and consistent mix process every time.

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### Prep

- Weigh out pigments in a small dish. Be sure to sift all facecoat pigments through a fine mesh screen <sup>1</sup> for clean and consistent color.
- Weigh out 5 to 8 grams of Dryflow into a small dish. Amount may vary depending on geography and time of year.
- Weigh 50 lbs <sup>2</sup> of dry mix (GFRC) in a clean 5 gal bucket
- Weigh out Batch Water: With or Without ice <sup>3</sup>
  - With Ice: In a separate & clean 5 gal bucket, add 4.3 lbs water + 1.5 lbs ice + 3 lbs of Liquid Acrylic Polymer
  - Without Ice: In a separate & clean 5 gal bucket, add 5.8 lbs water + 3 lbs of Liquid Acrylic Polymer

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### Stage 1

- Add 75% of the dry mix + all pigments into the water / ice (if applicable) / acrylic bucket
- Mix at high speed with a handheld mixer
- Add in the remainder of dry mix and mix at high speed until all of the dry mix has been completely blended
- Add 5 to 8 grams of Dryflow to achieve the proper mix fluidization
- Allow the mix to sit for 5 minutes

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### Stage 2

- After the mix has rested for 5 minutes, mix at high speed to ensure the consistency resembles a medium viscosity milkshake
- If required, trim the mix using Liquiflow Plasticizer. We suggest keeping Liquiflow in a ketchup squirt-bottle, and only adding a little at a time to trim to the desired mix fluidization. Do not trim with water.

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<sup>1</sup> We have been successful using an ONEIDA 6" fine mesh steel strainer for color pigments

<sup>2</sup> For facecoats, always weigh out exactly 50 lbs

<sup>3</sup> We recommend using ice in facecoats, backcoats or SCC mixes to improve the work time and workability of the material

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### Prep

- Weigh out pigments in a small dish. Be sure to sift all pigments through a fine mesh screen <sup>1</sup> for clean and consistent color. If the mix is being used as a backer coat, there is no need to sift pigments.
- For SCC mixes - Weigh out 15 grams of Dryflow into a small dish
- Weigh out 1.5 lbs of 19 mm AR Fiber - If using PVA or Acrylic fiber, choose correct loading and weight
- Pour 1 bag of dry mix (GFRC) into a clean 5 gal bucket
- Weigh out Batch Water: With or Without Ice <sup>2</sup>
  - With Ice: In a separate & clean 5 gal bucket, add 4.3 lbs water + 1.5 lbs ice + 3 lbs of Liquid Acrylic Polymer
  - Without Ice: In a separate & clean 5 gal bucket, add 5.8 lbs water + 3 lbs of Liquid Acrylic Polymer

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### Mixing

- Add 75% of the dry mix + all pigments into the water / ice (if applicable) / acrylic bucket
- Mix at high speed with a handheld mixer until color and mix has fully dispersed
- Add in the remainder of dry mix and mix at high speed until all of the dry mix has been completely blended
- For SCC - Add 15 grams of Dryflow plasticizer to achieve proper mix fluidization
- For Vertical Backer Coat - Do Not add any plasticizer.
- Slowly run the hand held mixer while lifting up and down in the bucket and begin adding the 1.5 lbs of AR Fiber into the mix. Do not run the mixer at high speeds, as it will break the fiber bundles.

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<sup>2</sup> We recommend using ice in facecoats, backcoats or SCC mixes to improve the work time and workability of the material

## IT'S ALL ABOUT THE INGREDIENTS

The Blendhouse GFRC Blend mix was developed by leaders in the decorative GFRC industry with the goal of achieving high strengths, workability, and flexibility. Pairing the this mix with the top performing concrete admixtures shown below, creates a user-friendly concrete system that serves as your go-to mix for all GFRC casting styles.



GFRC BLEND CONCRETE MIX HALF -PALLET  
28 Bags Per Half Pallet - 50 lbs Per Bag (SKU HB7-HP)



GFRC BLEND CONCRETE MIX PALLET  
56 Bags Per Pallet - 50 lbs Per Bag (SKU HB7-P)



ALKALI RESISTANT 19MM GLASS FIBER  
44 lbs Bag (SKU 1600)  
36 Bags Per Pallet (SKU 1601)



LIQUID ACRYLIC POLYMER  
55 Gal Drums (SKU 1500)  
5 Gal Pails 40 lbs (SKU 1501)



DRYFLOW POWDER PLASTICIZER  
5 Gal Pail 16.5 lbs (SKU 1301)  
2.5 Gal Pail 8.25 lbs (SKU 1302)



LIQUIFLOW LIQUID PLASTICIZER  
5 Gal Pail 40 lbs (SKU 1401)  
2.5 Gal Pail 20 lbs (SKU 1402)