



Texture Mat Instructions

PLANNING THE PROJECT

Decorative concrete is an attractive, economical alternative to natural paving materials or plain poured concrete. You can achieve many different looks and with advance planning you should be able to get just the right look for the project. The color of the concrete and the texture should be chosen to complement the natural surroundings and adjacent structures.

Special consideration should be given to the orientation of grout lines, particularly in repetitive patterns such as running bond brick or cobblestone. Generally, the area should be stamped so that long lines of the pattern run perpendicular to the length of the project. This will help reduce straight-line errors and provide a more pleasant overall appearance. Typically texture runs in straight lines (straight bond) even when walks or drives are curved.

Perform a trial run, placing mats in the area prior to the pour. The crew should know ahead of time where the first mat will be placed and in what direction stamping will proceed. Also, be aware of areas where a standard mat won't fit and plan accordingly.

PLACING CONCRETE

The concrete should be placed following normal procedures with a sub-grade and concrete base that meet the plan specifications and local requirements for mix, depth and reinforcement.

A normal or retarded-set, water-reducing admixture can be used, but admixtures must not contain Calcium Chloride. Non-chloride accelerators and air-entraining admixtures can be used. Refer to the admixture manufacturer for recommendations on the type and amount of admixture to use. (Please note: Some admixtures may affect color.) The concrete should be four inches or greater in thickness. Other considerations should be taken as outlined below.



Concrete Mix Checklist

- Minimum five sacks of cement per cubic yard
- Coarse aggregate not to exceed 3/8"
- Aggregate must be non-reactive
- Minimum practicable amount of water should be used
- Slump not to exceed 4"
- No high-range water reducing admixtures

COLORING CONCRETE

Bon Tool Co. offers two options for coloring concrete:

- **Integral Color:** Bon's Ironoxx™ powder is added to the ready mix truck. This combines the color with the mix prior to the pour and the slab is colored throughout, or;
- **Broadcast Method:** Bon True Color™ Hardener powder is applied to the freshly poured concrete surface. Bon True Color™ Hardener penetrates the top 1/8" of the concrete slab.

Ironoxx™ is available in 10 and 25 lb. disintegrating bags. Generally, 1-2 lbs. per 96 lbs of cement produces subtle colors; 2-4 lbs. yields medium shades; and 5 or more lbs. per 96 lbs. of cement yields more intense shades of color. (See Bon's color chart for approximate colors.) If using Bon Ironoxx™, float and finish following normal finishing procedures.

When using Bon's True Color™ Hardener, finish concrete following normal procedures using a Bon Tango Tamper, screed and wooden or magnesium float. The surface of the concrete must remain open. Do not steel trowel until after the final application of Color Hardener.

Overall coverage requirements vary according to the color selected and the desired intensity. Generally 60 pounds per 100 square feet is sufficient, though lighter or pastel colors may require as much as 100 pounds per 100 square feet. Two-thirds of the Color Hardener should be applied at first and one-third should be withheld for the second application and final touch up.

After initial floating and all excess bleed water has been absorbed, broadcast Bon True Color™ Hardener using a wide sweeping arm movement with the intention of covering as much concrete as possible with each throw. Allow the Hardener to be absorbed for several minutes until it has moistened sufficiently to work the color in with a wooden or magnesium float. One pass with the float should be sufficient. Do not over-work the concrete. If necessary, repeat this process in areas where natural concrete is showing through. When you are satisfied with the color, finish with a fresco or steel trowel.

NOTE:

- There should be no standing water on the concrete surface when applying Bon True Color™ Hardener. Do not over float or trowel. This will draw water to

the surface and reduce color intensity. Do not sprinkle or fog water on the concrete. This will cause variations in color intensity. Do not cover with plastic.

- Color Hardener settles during shipment. Before beginning, fluff the contents of the pail with your hand to break up clumps and provide a consistent airy feel throughout the pail.

APPLYING THE COLOR RELEASE AGENT

Bon Tool Co. Texture Mats will not work without the use of a Release Agent. This specially formulated powder prevents mats from sticking to freshly placed concrete. Generally 3.5 lbs. of material is required per 100 square feet.

As the slab approaches its optimum set for texturing, the Release Agent should be applied. It should be brushed onto the mats and broadcast across the surface of the concrete. There should be a uniform layer of release between the concrete and the texture mats; thick enough to prevent damp concrete from bleeding through to the mat, yet thin enough so as not to diminish the texture detail.

Choose a color of Bon True Color™ Release Agent to complement the color of the concrete. A Release Agent with a darker tone than the coloring agent will provide depth and shadowing in the finished concrete. Most of the Release Agent will be removed when the finished project is pressure washed. The primary concrete

The Basic Steps of Texturing Concrete



1. Finish concrete following normal practices, using Bon True Color™ Hardener or Ironox™ Integral Color.



2. Apply Release Agent.

color will dominate and approximately 20% of the Release Agent will adhere to the surface of the concrete.

NOTE:

- Release Agent settles during shipment. Before beginning, fluff the contents of the pail with your hand to break up clumps and provide a consistent airy feel throughout the pail.

TEXTURING CONCRETE

At the optimum time for texturing, great force is not necessary to press the mat into the concrete. Timing is critical so work should proceed without delay once texturing begins. Likewise, inspect the area periodically so that necessary touchup work can begin as soon as possible.

The process of laying the mats requires a team of two to four workers, each with a specific task. Below is an outline of a four-man crew as suggested for the largest recommended project pour, 400 square feet. More experienced crews may be able to color and stamp as much as 700 square feet per pour, but it is recommended to begin with smaller areas. This process can be adapted to fit specific project needs.

Worker #1. Prepares mats by brushing release agent on the mats. Fluffs the release agent throughout the application process. Broadcasts Bon True Color™ Release Agent. Identifies areas that require touch up work. Acts as a general helper.

Worker #2. Places the Texture Mats. The first mat should be carefully aligned, placed and tamped in at the starting point of the project. Repeat the process by placing the second mat next to the first. Place mats tightly together to avoid messy grout line patterns. Continue with mats on hand, leapfrogging the mats as they are removed and replaced in the concrete. A minimum of three mats should be used for smaller pours. Larger projects require additional mats.

Worker #3. Tamps the Texture Mats as they are placed. Mats should be tamped straight down into the concrete using no more force than necessary to press the mat flush to the concrete. Do not over tamp.

Worker #4. Carefully removes the tamped mats by lifting gradually from one side first to break the suction. Passes mats to Worker #1 for preparation of next placement.

ACCESSORY TOOLS

While texturing you may notice areas or grout lines that require touch up to make a deeper impression. Or, you may come across hard to reach areas that require a different type of tool to make an impression. The equipment list below outlines accessory tools you may need. Anticipate your needs before the job begins and have all the necessary tools on hand.

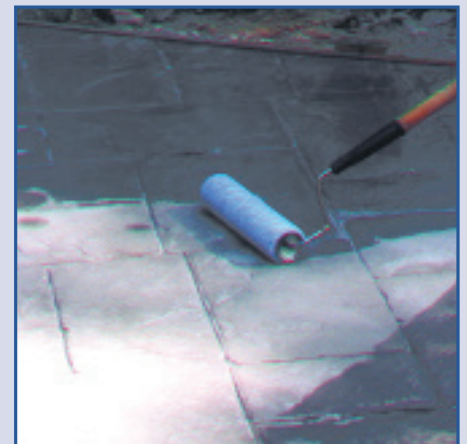
Wall Hugger “Floppy” Mat - A flexible mat with grout lines that bends to reach tight areas.



3. Tamp in Texture Mats.



4. Remove excess Release Agent.



5. Apply Sealer.

Some of the Urethane Texture Mat Patterns Available from Bon Tool Co.

	Old Spanish #12-699
	Slate #32-482 #32-483 #32-484
	Granite Sets #12-589
	Random Stone #12-598 #12-599 #12-794
	Running Bond #12-742
	Ashlar Cut Stone #12-595 #12-881 #12-882
	Herringbone Brick #12-698
	European Fan Cobblestone #12-596
	London Cobblestone #12-597

Accessory Mat - A thin mat with no grout lines used to touch up the pattern.

Touch Up Joint Wheel, "S" Touch Up Tool or Detail Chisel - Tools used to clean up grout lines in the concrete.

PRESSURE WASHING

After approximately 24 hours when the concrete has achieved initial set, use a high-pressure washer (3000 psi) to remove excess Release Agent from the surface of the concrete. Vary the distance of the wand to the surface of the concrete so that the release is unevenly removed. Try to spray so that some the release remains in the grout lines and deeper indentations. This will result in a more natural, aged and shadowed effect.

SEALING

When the slab is thoroughly dry, Bon's BossGloss™ or BossMatte™ Clear Enhancer should be applied using a roller. One gallon covers approximately 200 to 300 square feet.

A light coat should be applied in one direction and a second coat should be applied in a perpendicular direction in order to avoid unwanted lines. Be careful to avoid a build up of sealer in the corners.

Allow surface to thoroughly dry and cure for 48 hours.

SUPPORTING MATERIALS

INTRODUCTION TO TEXTURED CONCRETE VIDEO

- 16-minute video with basics on transforming ordinary concrete into affordable decorative surfaces (No charge)

Part#	Length	Format
01-199-BN	15 mins.	CD

Please note: When using integral color, many factors will affect the final color, including type and color of cement, aggregate, water, etc. It is always best to perform a test pour to determine variance of color. This brochure provides general advice. Bon Tool Co. assumes no responsibility for the application of this information nor guarantees results.

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