XS PRECAST
HIGH STRENGTH POURBALE CASTING MIX

View More Info for this Product at
www.surecretedesign.com/product/concrete-countertops-mix
XS Precast™ is a dual component precast concrete bag mix that greatly reduces the materials and labor required to construct traditional precast concrete. No reinforcement steel is required, thinner precast pieces are routine, and quicker production times are accomplished. A stronger, denser and more flexible cementitious composite is created by combining cutting-edge technology with modern fiber advancements. With a wide range of coloring and texture selections along with the addition of optional aggregate loading (up to 10 lbs per bag) design considerations are nearly limitless. XS Precast produces concrete countertops, fireplace mantles and facades, shower surrounds, wall panels, furniture and many other architectural elements. XS Precast is the perfect medium for residential, commercial, and industrial applications.

**DESCRIPTION**

Fabrication of XS Precast should be inside a shop. Casting should take place when shop temperature and all materials are maintained between 50°F (10°C) and 90°F (32°C) throughout all fabrication and curing. Product will dry and cure slower at cool temperatures and conversely, faster at warm temperatures. Full cure is reached at approximately 30 days, like concrete. Although rare, at high altitudes and dry climates, some pieces may require covering with plastic to slow the cure and avoid curling.

**TECHNICAL DATA SHEET**

**PACKAGING**

50 lb (22.7 kg) bag

**MIXING RATIO**

1 gal (3.8 L) XS Precast Modifier to 1 – 50 lb (22.7 kg) bag of XS Precast + up to 16 oz. (0.5 L) water

**COVERAGE**

1 - 50 lb (22.7 kg) bag of XS Precast = approx. 9.8 ft² @ ½” (0.9 m² @ 12.7 mm) 7.2 ft² @ ¾” (0.64 m² @ 19 mm) OR 0.43 ft³ (0.01 m³)

**DENSITY**

126.1 lb/ft³ (2,018 kg/m³)

**COMPRRESSIVE STRENGTH ASTM C-109-08**

3 day - 9,800 PSI (67,569 kPa) 7 day - 10,540 PSI (72,671 kPa) 28 day - 10,730 PSI (73,981 kPa)

**FLEXURAL STRENGTH ASTM C-348-08**

3 day - 610 PSI (4,206 kPa) 7 day - 635 PSI (4,378 kPa) 28 day - 690 PSI (4,757 kPa)

**TENSILE STRENGTH ASTM C190-85**

3 day - 505 PSI (3,482 kPa) 7 day - 545 PSI (3,758 kPa) 28 day - 550 PSI (3,792 kPa)

**SHELF LIFE**

Under normal conditions: XS Precast bag mix and XS Precast Modifier when the container and packaging are kept dry and moisture free, out of direct sunlight, the shelf life of an unopened product is (12) months from the date of purchase. Additionally XS Precast Modifier should be protected from freezing. Storage for both products must be under roof and off the floor. Rotate inventory to maintain product that is within limits.

**APPLICATION**

Although not limited to it, the most common method of placement simply involves pouring XS Precast directly from the pail or mixing vessel into the form or mold.

XS Precast™

XS Precast Modifier

XS TruColor (color pack)

XS TruColor (pack)

XS Precast Modifier

XS Precast Modifier

Multiple bag batches

1. Utilize a mortar mixer (preferred with a horizontal helical [spiral] shaft) or a concrete mixer of sufficient size to allow the free vertical fall of product while mixing.
2. Maintain the ratio of 1 gal (3.8 L) XS Precast Modifier to 1 - 50 lb (22.7 kg) bag XS Precast.
3. Thoroughly mix XS Precast Modifier.
4. Place total amount of XS Precast Modifier for the entire mix into the mixer.
5. Add all XS TruColor to the modifier (if desired) and start mixer.
6. Slowly add one XS Precast bag at a time to the mixer to prevent material from forming dry fiber pockets.
7. Additional water may be added, not to exceed 16 oz. (0.5 L) per bag of XS Precast
8. After last bag is added, allow all material to thoroughly mix for 2 – 3 minutes. Visually inspect entire load to ensure that all fiber is blended.
**DEMOLD**

In warm weather 4-6 hours may be appropriate to de-mold. Cool temperature or pieces with extreme texture will require overnight drying. **XS Precast** should not be left in the mold past a 24 hour period, as curling of the piece is likely. A freshly de-molded sample should be handled similar to granite or natural stone, and should be well supported above the work surface to allow the free flow of air around the piece.

**CLEANING**

All **XS Precast** samples require cleaning, except those that are to be polished. **SCR** diluted with water 3:1 (3 parts water to 1 part **SCR**) is recommended. For specific directions on **SCR** refer to its TDS.

**SLURRY**

**XS Slurry** fills pin holes and voids to create a smooth surface. For specific directions on **XS Slurry** refer to its TDS.

**GRIND/POLISH**

If additional decorative aggregate was added to the **XS Precast** or if the desired appearance demands it, the product may successfully be polished.

1. Grind precast sample as soon as practical. Allow a minimum of 8 hours cure time.
2. When decorative aggregate is added, begin wet grinding with 50 grit diamond pad to expose aggregate. This step may be skipped if no decorative aggregate was added.
3. Proceed to wet grind with 100 grit diamond pad.
4. **LD1800** may be utilized with wet 100 grit grind to densify and fill pinholes with resultant color match slurry. For specific directions on **LD1800** refer to its TDS.
5. Allow **LD1800** and slurry to dry. Proceed with 200 grit and if any pinholes are still present add more **LD1800** and continue grinding.
6. Remove any excess dried slurry with the 200 grit.
7. Proceed through 400 grit polish. If stain and / or sealer is to be used do not polish past 400 grit, as a measure of profile must be maintained for stain penetration and sealer adhesion.
8. If desired and sealer is not used, one can continue polishing through 800 grit and beyond, however, such a piece is subject to staining.

**STAINING**

**XS Precast** accepts most concrete stains. **Eco-Stain** adds a desirable design element to any **XS Precast** piece and is eco-friendly and UV stable. Staining customarily follows slurry. For specific directions on **Eco-Stain** refer to its TDS.

**SEALING**

**XS Precast** pieces are completed by sealing. Two distinct sealers have been created for **XS Precast**:
- **XS-327** - hybrid water based polyurethane available in matte and gloss finish.
- **XS-PC12** - hybrid solvent based polyurea, color enhancing, high gloss mirror finish.
For specific directions on sealing refer to the appropriate TDS.

**SEAMING/ADHESION**

100% silicone caulk provides an excellent seaming and adhesive fastening material, as it allows for movement of the precast piece. **XS Precast** like any other concrete will undergo slight dimensional variations based upon its environment (e.g. shrinkage or expansion). Do not use caulking or adhesive that could “bleed” through the finished surface, such as petroleum based products. Large pieces and undermount sinks will require mechanical fastening.

**SUITABILITY SAMPLE**

Always prepare an adequate number of test samples for suitability for products’ intended use.

**CLEAN-UP**

Before **XS Precast** dries; spills and tools can be cleaned up with water.

**DISPOSAL**

Contact your local government household hazardous waste coordinator for information on disposal of unused product.

**LIMITATIONS**

For use by trained professionals that have read the complete TDS and SDS.

**WARRANTY**

Warranty of this product, when used according to the directions, is limited to refund of purchase price, or replacement of product (if defective), at manufactures/seller’s option. **SureCrete Design Products** shall not be liable for cost of labor or direct and/or incidental consequential damages.

**CAUTIONS**

KEEP OUT OF REACH OF CHILDREN. Inhalation: Avoid prolonged breathing of airborne dust, particularly present during mixing. Use NIOSH approved respirator for nuisance if threshold limit values are unsafe. Skin Contact: Skin contact may cause irritation. Remove contaminated clothing and wash affected skin with soap and water. Launder clothing before reuse. If symptoms persist, seek medical attention. Eyes: Wear safety eye protection when applying. Contact with eyes may cause irritation. Flush eyes with water for 15 minutes. If symptoms persist, seek medical attention.

**SAFETY DATA SHEETS**

The following are links to all available safety data sheets related to this product:
- [xtreme-series-xs-precast-sds.pdf](#)
- [xtreme-series-xs-modifier-sds.pdf](#)

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