



Designation: C932 – 06 (Reapproved 2019)

Standard Specification for Surface-Applied Bonding Compounds for Exterior Plastering¹

This standard is issued under the fixed designation C932; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

This standard has been approved for use by agencies of the U.S. Department of Defense.

1. Scope

1.1 This specification covers minimum requirements for exterior surface-applied bonding compounds for improving the adhesion of cementitious material to concrete or other masonry surfaces or any structurally sound surfaces.

1.2 This specification also covers test methods for determining performance requirements and physical properties.

1.3 The values stated in inch-pound units are to be regarded as the standard. The SI metric values given in parentheses are approximate and are provided for information purposes only.

1.4 The following safety hazards caveat pertains only to the test methods described in Sections 9, 10, 11, and 12 in this specification: *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

1.5 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

2. Referenced Documents

2.1 *ASTM Standards:*²

[C11 Terminology Relating to Gypsum and Related Building Materials and Systems](#)

[C109/C109M Test Method for Compressive Strength of](#)

[Hydraulic Cement Mortars \(Using 2-in. or \[50-mm\] Cube Specimens\)](#)

[C150 Specification for Portland Cement](#)

[C305 Practice for Mechanical Mixing of Hydraulic Cement Pastes and Mortars of Plastic Consistency](#)

[C511 Specification for Mixing Rooms, Moist Cabinets, Moist Rooms, and Water Storage Tanks Used in the Testing of Hydraulic Cements and Concretes](#)

[C778 Specification for Standard Sand](#)

3. Terminology

3.1 Definitions used in this specification shall be in accordance with Terminology [C11](#).

4. Physical Properties

4.1 *Surface Applied Bonding Compound*—A freeze-thaw stable composition, suitable for brush, roller, or spray application. It shall be tinted to show by visual inspection where it has been applied. The tint shall not bleed through the material being bonded.

4.2 *Consistency*—The bonding compound shall be free of foreign matter as determined by visual inspection and shall be of such uniform consistency that when applied in accordance with the producer's directions by brush, roller, or spray to concrete, masonry, or other structurally sound surface, the bonding compound shall flow on evenly and dry uniformly.

4.3 *Film Characteristics*—The film-forming property shall be determined by visual inspection to determine the presence of a continuous film not broken by fisheyes, cracking, pull-back, or any other discontinuity in the film surface. It shall not be noticeably affected by alkaline surfaces or weak acids.

4.4 *Re-Emulsification*—Product conforming with this specification shall not re-emulsify.

5. Performance Requirements

5.1 *Bonding Capability*—The bonding compound shall be capable of bonding cementitious materials when applied in accordance with the producer's directions and tested as specified in Section 12.

¹ This specification is under the jurisdiction of ASTM Committee C11 on Gypsum and Related Building Materials and Systems and is the direct responsibility of Subcommittee C11.02 on Specifications and Test Methods for Accessories and Related Products.

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² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

*A Summary of Changes section appears at the end of this standard

5.2 *Degradation*—Bonding compound which separates shall be able to be re-mixed to a uniform consistency when tested as specified in Section 10.

5.3 *High Temperature Test*—The bond strength shall be not less than 150 psi (1034 kPa) when tested as specified in Section 9.

5.4 *Freeze-Thaw Stability*—The bond strength shall be not less than 150 psi (1034 kPa) and 100 psi (690 kPa) when tested under the dry and wet conditions, respectively, as specified in Section 11.

5.5 *Tensile Bond Strength*—Bond strength of a fresh sample or a 6-month-old sample of bonding compound shall have an average tensile strength of not less than 150 psi (1034 kPa) and 100 psi (690 kPa) when tested under the dry and wet conditions, respectively, as specified in Section 12.

6. Sampling

6.1 Take a sample of not less than 2.2 lb (1000 g) from each shipment or consignment for analysis and tests. Except in special cases, take the sample from not less than three separate containers, chosen at random. In addition, take samples from containers that appear to be nonrepresentative, and test separately. Place the samples immediately in airtight glass containers and transport to the testing laboratory in these containers. Take precautions to reduce evaporation or drying to a minimum. Thoroughly mix the bonding compound in the container if there is a tendency for liquid phase separation.

7. Apparatus

7.1 *Moist Cabinet*—Specification C511.

7.2 *Oven*—A forced draft type oven, having a temperature controlled at 140 ± 5 °F (60 ± 3 °C) for high temperature tests.

7.3 *Freezer*—A freezer having a controlled temperature of -10 ± 2 °F (-23 ± 1 °C).

7.4 *Balance*—A balance capable of weighing not less than 5.5 lb (2500 g) at a precision of 0.0002 lb (0.1 g).

7.5 *Timing Device*—An instrument capable of reading to the nearest second.

7.6 *Tamper*—A tamper made up of a nonabsorptive, nonabrasive, non-brittle material and having a cross section of ½ in. by 1 in. (13 × 25 mm) and approximately 5 to 6 in. (130 to 150 mm) long. The tamping face shall be flat and at right angles to the length of the tamper.

7.7 *Straight Edge*—A steel straight edge not less than 4 in. (100 mm) long and not less than ¼ in. (1.6 mm) nor more than ⅛ in. (3.2 mm) in thickness.

7.8 *Spatula*—A spatula with a metal blade 6 in. (150 mm) in length and ½ in. (13 mm) in width, with straight edges.

7.9 *Paint Brush*—A standard 1 in. (25 mm) wide brush, with synthetic bristles.

7.10 *Testing Machine*—Any type that is of sufficient capacity and that is capable of applying the load continuously and without shock at the rate of 0.05 in. (1.27 mm) per minute, with provision for adjustment of the rate of loading.

7.11 *Briquet Molds*—The molds for making test specimens shall be made of metal not attacked by the mortar and shall have sufficient material in the sides to prevent spreading during molding. Gang molds, when used, shall be of the type shown in Fig. 1. The dimensions of the briquet molds shall conform to the following requirements: width of mold, between inside faces, at waist line of the briquet, 1 in. (25.4 mm) with permissible variations of ± 0.01 in. (0.25 mm) for molds in use and ± 0.005 in. (0.13 mm) for new molds; thickness of molds measured at the point of greatest thickness on either side of the mold at the waist line, 1 in. (25.4 mm) with permissible variations of $+0.004$ in. (0.10 mm) and -0.002 in. (0.05 mm) for new molds and -0.02 in. (0.5 mm) for molds in use. The briquet specimens shall conform to the dimensional requirements shown in Fig. 2.

7.12 *Saw*—A table saw equipped with an abrasive cutting blade or other blade suitable for cutting cementitious materials.

7.13 *Clips for Briquet Testing Machine*—The clips for holding the tension test specimen shall be in accordance with Fig. 3.

8. Conditioning

8.1 *Room Temperature and Humidity*—Maintain the air temperature in the vicinity of the mixing and testing area at 70 ± 5 °F (21 ± 3 °C). Maintain the relative humidity at 50 ± 2 %.

8.2 *Temperature of the Mixing Water*— 72 ± 2 °F (22 ± 1 °C).

9. High Temperature Test

9.1 *Significance and Use*—This test method provides procedures for evaluating the adhesive strength of bonding compounds after being exposed to accelerated aging at high temperature.

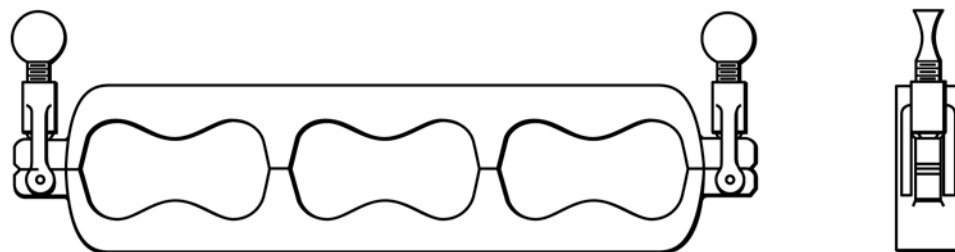


FIG. 1 Briquet Gang Mold