

Artisan Stucco

LIME MORTARS & MATERIALS

Multi-Layer Plaster System

Preparation, mixing and application of Artisan Stucco
Base Layer, Floated Finish, Fine Finish and WaterProof Finish
for vertical surfaces

INSTRUCTION MANUAL

V2.03 ENG - APRIL 2025

About the Artisan Stucco Multi-Layer System

Artisan Stucco plasters are crafted using a multi-layer system, designed to ensure durability, beauty, and versatility. Each layer in this system serves a specific purpose, contributing unique properties to the final plaster. By working together, these layers create a robust, long-lasting finish for vertical surfaces that can be tailored to meet the needs of any project.

The final layer of the plaster system determines the overall appearance and finish of your project, whether smooth, textured, polished or shiny. For detailed information about the various finishes and their specific layer requirements, visit our website at www.artisanstuccomortars.com.

This manual provides step-by-step guidance on the preparation and application of the four layers in the Artisan Stucco plaster system. Each layer is explained in detail, highlighting its individual function and unique qualities. Depending on factors like location, substrate, and the desired final result, you will apply two, three, or all four layers to achieve the best outcome for your project.

Please note: This manual is written for plasterers with extensive experience in applying specialized plasterwork and the associated preparations, including plastering in wet areas, plastering outdoors and experience with mixing and applying hand crafted plasters.

Take no risks and always seek advice from a specialist plasterer.

The Four Layers

Base Layer (BL1/BL2)

A render or scratch coat applied to level the substrate and provide optimal adhesion for subsequent layers. Proportions and composition vary based on whether it's used indoors, outdoors, or on specific substrates.

Floated Layer (SL1)

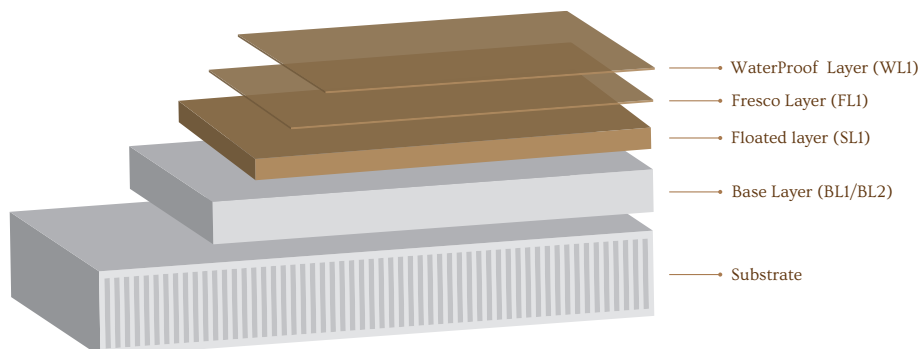
This intermediate or finishing layer adds depth and texture. Proportions differ for indoor and outdoor applications. Applied on a fully dried Base Layer (BL1/BL2).

Fresco Layer (FL1)

A polished layer that can serve as an intermediate or finishing layer. Applied fresh-on-fresh to the Floated Layer (SL1), it creates a smooth surface with a silky shine finish, adding a refined and luxurious feel to the plaster.

Waterproof Layer (WL1)

A waterproof finishing layer with a shiny finish that provides protection against moisture. Applied fresh-on-fresh to the Fresco Layer (FL1) and Floated Layer (SL1), it combines functionality with an elegant, polished appearance.



How to Use This Manual

This manual is organized by finish type to help you easily identify the steps required for your specific project. Each section provides clear instructions for applying the necessary layers, including proportions, tools, and techniques.

1. Base Layer (BL1/BL2)

The first section explains how to prepare and apply the base layer. It ensures the substrate is even and ready for the next layer. The Base Layer must be fully dried before applying any consecutive layers.

2. Floated Finish (BL1/BL2 + SL1)

The second section details the Floated Layer (SL1) application on a dry base layer (BL1/BL2). This segment provides guidance for achieving a textured finish.

3. Fresco Finish (BL1/BL2 + SL1 + FL1)

The third section focuses on advanced finishes, starting with the Fresco Layer (FL1), applied wet-on-wet over the Floated Layer (SL1).

4. Waterproof Finish (BL1/BL2 + SL1 + FL1 + WL1)

For additional protection and a shiny finish, this section explains how to add the Waterproof Layer (WL1) wet-on-wet over the Fresco Layer as described above.

Preparation and planning

When applying plaster, work is typically divided into sections called **giornatas**, which refer to the area of plaster that can be applied and finished in a single day by one experienced applier.

For finishes applied wet-on-wet, such as the Fresco and Waterproof layers, the area that can be completed in a day will be smaller, as each subsequent layer must be applied before the previous one fully dries. This requires careful timing and planning to ensure seamless application and optimal results.

Properly planning and placing your giornatas is essential to avoid creating dry-on-dry layered joints in areas that will be exposed to water or temperature fluctuations. Whenever possible, position the edges of giornatas along natural breaks or boundaries within the project, such as corners, edges, or architectural features, to minimize their visibility.

Desired finish	Layers	Total m ² per day *
Base Layer	BL1/BL2	8 m ² to 15 m ²
Floated Finish	SL1	8 m ² to 15 m ²
Fresco Finish	SL1 + FL1	6 m ² to 10 m ²
Waterproof Finish	SL1 + FL1 + WL1	4 m ² to 8 m ²
* Approximation, depending on experience and the complexity of the object.		

Please note: applying the final layers for the Fresco and Waterproof Finish on a dry layer will change the quality, performance and esthetics of your plaster.

Colour Consistency and Mixing

When using coloured lime, especially on larger surfaces or multiple giornatas, it is crucial to have all the Lime Putty required for the project precoloured in one batch. Since Artisan Stucco lime is hand-mixed to order using natural pigments, slight colour variations between batches are possible.

As lime putty does not settle until dry, you can prepare mortar for an entire week if kept well-sealed and hydrated. Always remix thoroughly before use, as minerals will sink to the bottom of the container.

Recommended Sands

Use silica or calcium carbonate sands for your mixes and **avoid using dolomite sand**. If these recommended sands are not available in your area, contact us for assistance in finding a suitable substitute.

Outdoor Projects

When plastering exterior walls, we recommend using a plinth made from a moisture-resistant material. The plinth should have a minimum height of 30 cm to ensure durability and protection.

For exterior walls with overhangs smaller than 70 cm, we recommend applying a mineral, water-repellent, and breathable impregnation to the final finish after the plaster has fully dried to enhanced durability and protection. Recommended product: FAKOLITH - FK-3 Plus N.

NB: For some layers the ingredient and proportions differ for indoor and outdoor use. Check the instructions carefully to ensure correct mixing and application.

Temperature and moisture

Plastering should not be carried out if there is a risk of temperatures dropping below 5°C during application or the drying process, as this can compromise the quality and durability of the plaster.

Additionally, the drying plaster must be protected from rain both during application and throughout the drying period to ensure proper curing and long-term performance.

Drying time is approximately 1 day per millimeter of plaster thickness, depending on conditions such as temperature, humidity, and ventilation, so plan your project accordingly.

Application technique

Artisan Stucco Mortars plaster contains no additives, so adherence and moisture retention rely on the material itself, your application technique, and the nature of the supporting wall. As a result, you will need to adjust your application techniques and pacing to suit each specific situation.

Mixing and Material Storage

Mix all the mortar you need on the first day to streamline the workflow, but keep some coloured lime putty unused in case additional mortar is required later. Ensure that all tubs containing mixed mortars are well sealed to prevent contamination from sand, dust, or other materials.

After completing the project, it is advisable to leave a bucket with approximately 5 litres of coloured lime putty with the customer for any future repairs.

Profiles and corners

Especially the Fine Finish and WaterProof Finish require some pressure during application. It is advisable to use profiles for a clean result. Alternatively you can round corners slightly when plastering the intermediate Floated layer (SL1). Always use appropriate profiles in wet areas of bathrooms and showers.

Test the Material Before Application

Applying FineFinish (FL1) and the Waterproof Layer (WL1) requires skill and experience to achieve the desired result. If you are unfamiliar with these materials, we strongly recommend creating a large test piece using all required layers before applying them to your project. This will allow you to practice the techniques, understand the application process, and adjust to the materials' unique characteristics.

Since the waterproof plastering technique requires considerable craftsmanship, we cannot guarantee results without proper application. For additional guidance or detailed product information, please contact us directly. We are happy to provide support and help you achieve the best possible outcome.

Warning: Artisan Stucco Lime Putty, FineFinish and WaterProof contain hydrated, or slaked lime. When using these products, please consider that hydrated lime is an alkaline material that can cause mild burns on exposed skin and serious eye damage. Wear gloves, covering clothing and eye protection. In case of contact with eyes, immediately flush with large amounts of clean water and consult a doctor.



1. Base Layer - BL1/BL2

The Base Layer is the foundation of the Artisan Stucco multi-layer system. It serves as a render or scratch coat that evens out the substrate, provides optimal adhesion for subsequent layers, and helps regulate moisture during the application of fresh plaster. Depending on the substrate, whether brick, natural stone, boards, or concrete, you will use different materials and proportions to ensure the best results.

This chapter outlines the preparation, application, and drying process for two types of base layers:

BL1: For natural stone, brick, and similar substrates.

BL2: For board surfaces, concrete, and other smooth substrates.

By following the instructions in this chapter, you will create a durable, moisture-regulating foundation for the next layers, ensuring the longevity and quality of your plaster system.

Base Layer - Coarse Render Coat (BL1) - For brick and natural stone substrates

Materials	Indoor	Outdoor
Lime Putty (white)	1 bucket of 20kg	1 bucket of 20kg
Masonry sand (0-2 mm)	2 bags of 25kg	2,5 bags of 25kg
for every	4-5 m ²	4-5 m ²
Layer thickness	10-12 mm	10-12 mm

This base layer (BL1) must be applied at a thickness of at least 10 mm (between 10 mm and 12 mm). The consumption per bucket of lime is approximately 4 m². Before you start plastering, thoroughly wet the bricks with water.

Once this layer becomes leather-hard, you can apply another layer if needed to straighten it out. Build a homogeneous coarse structure to create a good grip for your next plaster layer.

Base Layer - Fine Render Coat or Scratch Coat (BL2) - For boards and concrete substrate

Materials	Indoor	Outdoor
Artisan Stucco Lime Putty (white)	1 bucket of 20kg	1 bucket of 20kg
Grouting sand (0-1 mm)	2 bags of 25kg	2,5 bags of 25kg
for every	5-6 m ²	5-6 m ²
Layer thickness	5-7 mm	5-7 mm

This base layer (BL2) must be applied at a thickness of 5-7 mm, with a consumption of approximately 5 m² per bucket of lime. On board surfaces, first apply a mineral primer or an adhesive mortar to the substrate to ensure proper adhesion.

Recommended adhesive mortar: UNILIT 15/P1, UNILIT 15/P2
 Recommended primer: HAGA Mineralputzgrundierung

It is not necessary to wet the primer or adhesive mortar before applying the base layer.

Before application

- Ensure the substrate is completely dry and clean, free of paint, previous plasters, salts, algae, lichens, or any other incompatible organic or mineral deposits.
- Protect the wall from rain and temperatures below 5°C until the newly applied mortar has fully dried.

Application

- Mix the sand and lime in a large tub using a hand mixer to ensure a consistent blend. If needed, add small amounts of clean water until the mortar is easy to work with.
- Apply the mixture to the wall using a carbonated iron or stainless steel trowel.
- Float the surface with a plastic floater to compact the material and create a flat, structured, and gripping surface.

Drying

Allow the base layer to dry completely before applying the next layer. Drying time is approximately 1 day per millimetre of thickness, depending on conditions such as temperature, humidity, and ventilation.



2. Floated Stucco Finish - SL1

The Floated Stucco Finish (SL1) is the basic finishing render in the Artisan Stucco multi-layer system. It is a versatile and durable finishing layer that can be tailored to a rough or fine-grained texture, depending on the desired aesthetic and application method. Suitable for both indoor and outdoor use, the Floated Finish creates a textured surface that serves as either the final layer or a base for additional layers, such as the Fresco or Waterproof finishes.

This layer is designed to adhere to a fully dried, properly prepared and moistened base layer (BL1 or BL2). The Floated Finish is applied at a thickness of 3-5 mm and can be customized using different sands, with the color of the sand influencing the final appearance of the plaster.

We recommend using Artisan Stucco Marble Sand, for an optimal mechanical and frost resistance, as well as its bright white colour enhances the final finish and allows for the brightest and most vibrant colour of your finished plaster.

Materials	Indoor	Outdoor
Artisan Stucco Lime Putty (Coloured)	1 bucket of 20kg	1 bucket of 20kg
Joint sand or Marble Sand (0-1 mm)	2 bags of 25kg	2,5 bags of 25kg
for every	7-8 m ²	7-8 m ²
Layer thickness	3-5 mm	3-5 mm

Note: The application process for the Floated Stucco Layer (SL1) differs depending on whether it is used as a finishing layer or an intermediate layer. Please refer to the appropriate instructions below.

Before Application

Plan your giornate effectively to avoid creating dry-on-dry layered joints, especially in areas highly exposed to water or temperature changes.

The base layer must be wetted before applying the finishing layer.

For brickwork and stone: apply plenty of water to thoroughly moisten the surface.
For board surfaces: lightly mist the surface using a spray bottle.

Application of the Floated layer as a finishing layer

- Mix all the sand and lime in a large tub using a hand mixer to achieve a consistent blend. If needed, add small amounts of clean water until the mortar is easy to work with.
- Apply the mortar as smoothly as possible and compact it with a wooden floater.
- Once the mortar becomes leather-hard (or when no moisture is shining on the surface), finish the plaster with a sponge.
- Sponge the surface again as the plaster starts to carbonate. During this stage, the plaster will temporarily darken due to the chemical carbonation process. The mortar will dry faster on a brick or stone surface than on board surfaces.

If sponge lines are not desired, use a horsehair brush to create a more compact and smooth finish.

Drying

Protect the plaster from rain and environmental factors during the drying period. Drying time is approximately 1 day per millimetre of thickness, depending on conditions such as temperature, humidity, and ventilation.

For outdoor applications with overhangs smaller than 70 cm, apply a mineral, water-repellent, and breathable impregnation to the surface after the plaster has fully dried to ensure enhanced durability.

Recommended product: FAKOLITH - FK-3 Plus N.

Application of the Floated layer as an intermediate layer

The floated intermediate layer is applied to a fully dried and moistened Base Layer. After applying the intermediate Floated layer, the Fresco Layer (FL1) and, if needed, the Waterproof Layer (WL1) are applied directly onto the SL1 while it is still wet.

- Mix all the sand and lime in a large tub using a hand mixer to achieve a consistent blend. If needed, add small amounts of clean water until the mortar is easy to work with.
- Apply the mortar as smoothly as possible and compact it with a wooden floater.
- When the mortar is still slightly wet, smooth the plaster with a sponge. The lines from the sponge should remain somewhat visible. These will be covered by the next layer.
- Immediately after sponging, smooth the surface with an iron or steel trowel to press the sand grains into the mortar. This will create small (1 mm) holes in the surface, improving adhesion for the next layer.

This layer must now become leather-hard before applying the next layer. If the plaster is too dry, the following layers will not adhere properly.

For further instructions on application of the Fresco layer (FL1) and WaterProof layer (WL1), please refer to the next sections.



3. Fresco Finish - FL1

The Fresco Layer (FL1) creates a silky smooth finish with a subtle shine, providing a refined and luxurious appearance. This true fresco plaster, suitable for both indoor and outdoor use, is applied wet-on-wet directly onto the Floated Layer (SL1) and is crafted using Artisan Stucco FineFinish paste.

In addition to its elegant finish, the Fresco Layer combines breathability and durability, allowing moisture to pass through while creating a seamless, long-lasting surface. This balance makes it ideal for both traditional and modern applications.

Materials	Indoor & Outdoor
Artisan Stucco FineFinish (Coloured)	1 bucket of 5 liters
for every	15 m ²
Layer thickness	0 mm

Before Application

Thoroughly mix the FineFinish mortar paste before use, ensuring that no minerals are stuck to the bottom of the bucket.

Application

Once the intermediate Floated layer (SL1) is leather-hard, the Fresco layer, or polish layer, can be applied using a stainless steel trowel with rounded corners. The intermediate layer should still be moist, not glossy, and should not stick to your fingers.

Applying the FineFinish

Apply the polished layer very thinly to fill the pores of the intermediate layer. Start with a small section of about 0.25 m². Remove excess mortar immediately and polish the surface. You may apply it in multiple thin layers if necessary. Apply small amounts of mortar to any remaining rough spots and holes. Continue this process until all the pores are filled and the surface is smooth.

Polishing

Repeat this process until the entire wall is covered. If there is too much moisture, bubbles and lines from the trowel may appear. In that case, wait until the layer dries slightly. The more you polish, the more pores will be filled. The plaster will harden as it compacts, developing a satin finish.

Corners and edges

Apply some pressure during this process to close the pores, but handle fragile corners with care. When rounding the corners on all of the layers, use a steel rounded corner tool. If you are not experienced with this technique, it is advisable to use profiles.

If you stop after this layer, you will have a Fresco Finish.

The WaterProof Layer is applied while the Fresco layer is still wet. If the plaster is too dry, the following layer will not adhere properly.

To continue with the WaterProof Layer (WL1), please visit the next section.

Drying

Protect the plaster from rain and environmental factors during the drying period. Drying time is approximately 1 day per millimetre of thickness, depending on conditions such as temperature, humidity, and ventilation.

For outdoor applications with overhangs smaller than 70 cm, apply a mineral, water-repellent, and breathable impregnation to the surface after the plaster has fully dried to ensure enhanced durability.

Recommended product: FAKOLITH - FK-3 Plus N.



4. WaterProof Finish - WL1

The Waterproof Layer (WL1) is an additional layer in the Artisan Stucco multi-layer system, designed to provide water resistance and a polished, glossy finish. Applied wet-on-wet directly onto the Fresco Layer (FL1), it creates a seamless and durable surface, making it particularly suitable for wet areas such as showers and bathrooms.

In addition to its protective properties, the Waterproof Layer enhances the plaster’s appearance by intensifying its colour and flame and adding a reflective sheen. This layer is an excellent choice when both water resistance and an elegant finish are desired.

Materials	Indoor & Outdoor
Artisan Stucco WaterProof (Coloured)	1 bucket of 1 liter
for every	10 m ²
Layer thickness	0 mm

Before Application

Thoroughly mix the WaterProof mortar paste before use, ensuring that no minerals are stuck to the bottom of the bucket.

Application

The application method for the Waterproof Layer (WL1) is the same as for the Fresco Layer (FL1).
First, spread the mortar evenly using a stainless steel trowel with rounded corners, allowing it to soak into the underlying layer. Then, remove any excess mortar and begin polishing. If no immediate gloss appears, the underlying layer may still be too moist.
The longer you polish, the stronger the gloss will become. You can also apply additional pressure during the polishing process to enhance the surface shine.

If the Fresco Layer is too wet to apply the Waterproof Layer, you can cover the project airtight with plastic and continue the next day. However, since the Fresco Layer must remain moist during the application of the Waterproof Layer, this approach is not recommended in warm or dry conditions. Close doors and windows, and be mindful of room heating to retain moisture.

Drying

Protect the plaster from rain and environmental factors during the drying period. Drying time is approximately 1 day per millimetre of thickness, depending on conditions such as temperature, humidity, and ventilation.

Protective Wax

To preserve the glossy crystallization created by the Waterproof Layer (WL1) and seal any open pores, apply a breathable wax after the plaster has completely dried, which typically takes one to two weeks.

For long-term protection, apply a full layer of wax every three years. It can also be used during regular cleaning routines to disinfect surfaces and remove lime deposits caused by tap water.

Recommended product: KREMER Cere-Stucco Soap.

Maintenance

For long-term protection, apply a full layer of wax every three years. It can also be used during regular cleaning routines to disinfect surfaces and remove lime deposits caused by tap water.

For more detailed maintenance instructions, visit our website or inquire about our maintenance plans.

Impregnation

For outdoor applications with overhangs smaller than 70 cm, apply a mineral, water-repellent, and breathable impregnation to the surface after the plaster has fully dried to ensure enhanced durability. When using a mineral impregnation on an outside wall, a wax layer is optional.

Recommended product: FAKOLITH - FK-3 Plus N.

Important Application Advice

The technique of creating waterproof plasterwork using lime putty requires significant skill and experience. As such, we cannot guarantee results without proper application. We strongly recommend creating a large test piece to practice the technique, familiarize yourself with our products, and fully understand the preparation and application process required for each specific project.

For additional guidance or detailed product information, please contact us directly. We are happy to provide support and help you achieve the best possible results.

NOTES



EN: CONTAINS: SLAKED LIME - DANGER - Causes skin irritation. Causes serious eye damage. Wear protective gloves/ protective clothing/eye protection/face protection. IF IN EYES: Rinse cautiously with water for several minutes. Remove contact lenses, if present and easy to do. Continue rinsing. CAS No: 1305-62-0

FR: CONTIENT: CHAUX ÉTIENTE - DANGER - Provoque une irritation cutanée. Provoque des lésions oculaires graves. Porter des gants de protection/des vêtements de protection/un équipement de protection des yeux/du visage. EN CAS DE CONTACT AVEC LES YEUX: rincer avec précaution à l'eau pendant plusieurs minutes. Enlever les lentilles de contact si la victime en porte et si elles peuvent être facilement enlevées. Continuer à rincer. No. CAS: 1305-62-0

DE: ENTHÄLT: GELÖSCHTER KALK - GEFAHR - Verursacht Hautreizungen. Verursacht schwere Augenschäden. Schutzhandschuhe/Schutzkleidung/Augenschutz/Gesichtsschutz tragen. BEI KONTAKT MIT DEN AUGEN: Einige Minuten lang behutsam mit Wasser spülen. Eventuell vorhandene Kontaktlinsen nach Möglichkeit entfernen. Weiter spülen. CAS Nr: 1305-62-0

NL: BEVAT: GEBLUSTE KALK - GEVAAR - Veroorzaakt huidirritatie. Veroorzaakt ernstig oogletsel. Beschermende handschoenen/beschermende kleding/oogbescherming/gelaatsbescherming dragen. BIJ CONTACT MET DE OGEN: voorzichtig afspoelen met water gedurende een aantal minuten; contactlenzen verwijderen, indien mogelijk; blijven spoelen. CAS Nr: 1305-62-0

Application results depend on proper preparation, skill, technique, and environmental conditions. We recommend conducting tests before starting any project and consulting our team for additional guidance if needed. The application of lime plasters requires knowledge and experience. Always choose an experienced plasterer.

The information provided in this manual has been compiled with the utmost care by Artisan Stucco Mortars. We strive to keep the content accurate, up-to-date, and as complete as possible. However, no rights can be derived from this manual, and Artisan Stucco Mortars accepts no liability for any inaccuracies, omissions, or the consequences of applying the information contained herein. Artisan Stucco Mortars reserves the right to correct typographical errors and update the content without prior notice.