



This Guide Specification is intended for use by design professionals. Edit to suit project requirements and coordinate with Division 01.

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GS Guide Specification

PART 1 – GENERAL

1.1 SUMMARY

A. Section Includes:

1. Western Blended Products Western One-Pass Plaster® factory-prepared exterior cement plaster system.
2. Fiber-reinforced, pre-blended sanded cement plaster basecoat.
3. Metal lath and accessories.
4. Optional Crack Resistant System (CRS).
5. Exterior finish coatings.

B. System Applications:

Western One-Pass Plaster is a universal exterior cement plaster system suitable for:

1. One-Coat Stucco Systems (3/8-inch to 1/2-inch).
2. Conventional Two-Coat Scratch and Brown Systems.
3. Scratch and Double-Back method in accordance with 2024 IBC Section 2512.8 (Alternate Method of Application).
4. Monolithic Conventional Stucco applications up to 7/8-inch thickness in a single application where permitted by ER-382.

C. Related Sections:

1. Section 06 16 00 – Sheathing.
2. Section 07 27 00 – Weather-Resistive Barriers.
3. Section 07 62 00 – Sheet Metal Flashing and Trim.
4. Section 07 92 00 – Joint Sealants.
5. Section 09 24 23 – Crack Resistant System (CRS).

1.2 REFERENCES

- A. IAPMO UES ER-382.
- B. ASTM C926 – Application of Portland Cement-Based Plaster.
- C. ASTM C1063 – Installation of Lathing and Furring to Receive Portland Cement-Based Plaster.
- D. ASTM C847 – Metal Lath.
- E. ASTM C150 – Portland Cement.
- F. ASTM C897 – Aggregate for Job-Mixed Portland Cement-Based Plasters.
- G. ASTM C144 – Aggregate for Masonry Mortar.
- H. 2024 International Building Code (IBC).
- I. 2024 International Residential Code (IRC).

Where conflicts occur, IAPMO UES ER-382 and IBC/IRC shall govern, in that order.

1.3 SYSTEM DESCRIPTION

A. General:

The Western One-Pass® System is a factory-prepared, sanded, fiber-reinforced exterior cement plaster assembly evaluated under IAPMO UES ER-382 for use in one-coat and conventional stucco wall systems.

The system is designed to provide a universal exterior plaster solution suitable for commercial, institutional, mixed-use, custom residential, and residential construction. Its multi-application capability allows a single product to be specified across varying project types



Access current system documentation and technical data.



Western One-Pass
System Page



Section 09 24 23

Western One-Pass Exterior Stucco System

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and wall assemblies while maintaining compliance with recognized building codes and third-party evaluation criteria.

Fire-resistance-rated assemblies and NFPA 285-compliant wall assemblies are available when constructed in accordance with ER-382.

Unlike traditional conventional stucco systems governed solely by prescriptive code language, Western One-Pass assemblies are evaluated under ER-382, providing additional third-party verification of permitted thicknesses, configurations, and system performance.

B. System Components:

1. Approved substrate.
2. Code-compliant weather-resistive barrier.
3. Self-furred metal lath.
4. Western One-Pass Plaster applied in accordance with permitted system configuration.
5. Optional Crack Resistant System (CRS).
6. Selected finish system.

C. Thickness Configurations and Application Methods:

Western One-Pass Plaster provides expanded thickness flexibility not commonly available in traditional plaster formulations. The system may be installed in the following exterior plaster system configurations where permitted by ER-382 and applicable code:

1. One-Coat Stucco Application:
 - Nominal minimum 3/8-inch thickness.
 - May be increased up to 1/2-inch where permitted by ER-382 and lath configuration.
 - Suitable for code-compliant one-coat stucco assemblies in residential and light commercial construction.
2. Conventional Two-Coat Scratch and Brown Application:
 - 3/8-inch scratch coat.
 - 3/8-inch brown coat.
 - Total nominal thickness: 3/4 inch.
 - Suitable for commercial and custom residential construction requiring conventional stucco systems.
3. Scratch and Double-Back Method:
 - Initial 3/8-inch application.
 - Followed by additional plaster application to achieve required total thickness.
 - Installed in accordance with 2024 IBC Section 2512.8 (Alternate Method of Application) and ER-382.
 - Provides scheduling flexibility while maintaining required total plaster thickness.
4. Monolithic Conventional Application:
 - Up to 7/8-inch thickness in a single application where permitted by ER-382 and approved lath assemblies.
 - Provides enhanced impact resistance, increased mass, and improved surface durability characteristics.
 - Suitable for commercial, institutional, and high-traffic environments where increased plaster thickness is desired.

Increased plaster thickness may enhance rigidity of the cement plaster membrane, improve impact resistance, and contribute to long-term surface durability when installed in accordance with ER-382.

D. Finish Coat Options:

1. WBP Exterior Stucco Finish.
2. WBP Premium Acrylic Finish with PAF Primer where required.
3. WBP Specialty Finishes





Section 09 24 23

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GS Guide Specification

4. Exterior finish coatings manufactured by additional listees recognized under IAPMO UES ER-382.
5. Standard acrylic paints or elastomeric coatings in accordance with the finish coat installation instructions.

E. The system is non-structural and does not eliminate cracking caused by structural movement.

1.4 SUBMITTALS

A. Product Data:

1. Western One-Pass Plaster Technical Data Sheet..
2. CRS Technical Data Sheet (if specified).
3. Exterior Finish Coat Technical Data Sheet.

B. Evaluation Report:

1. Current copy of IAPMO UES ER-382.

C. Warranty Documentation:

1. Submit manufacturer's warranty for specified warranty tier.

D. Samples:

1. Finish texture and color samples when required.

1.5 QUALITY ASSURANCE

I be located and detailed in accordance with the Contract Documents prepared by the design authority. Installation of control joints shall otherwise comply with ASTM C1063 and applicable Evaluation Reports.

D. Do not install stucco components until unsatisfactory substrate conditions have been corrected.

PART 2 – PRODUCTS

2.1 MANUFACTURER

A. Basis of Design: Western Blended Products (WBP).

B. Products shall be manufactured by Western Blended Products or produced under license in accordance with IAPMO UES ER-382.

C. Substitutions shall comply with Division 01 requirements.

2.2 MATERIALS

A. Western One-Pass® Plaster:

1. Factory-prepared, fiber-reinforced modified portland cement plaster.
2. Compliant with ER-382.
3. Suitable for one-coat, scratch and brown, scratch and double-back, and monolithic conventional stucco applications.
4. Applied to a nominal minimum thickness of 3/8 inch and may be applied up to 7/8 inch where permitted by ER-382 and approved lath assemblies.





Section 09 24 23

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2.3 LATH AND ACCESSORIES

A. Metal lath complying with ASTM C847.

B. Installation in accordance with ASTM C1063 and ER-382.

C. Accessories:

1. Casing beads.
2. Weep screeds.
3. Control joints.
4. Expansion joints.

- Control joints and building expansion joints affecting the stucco assembly shall be located and detailed in accordance with the Contract Documents prepared by the design authority. Installation of control joints shall otherwise comply with ASTM C1063 and applicable Evaluation Reports.

2.4 WEATHER-RESISTIVE BARRIER

A. Code-compliant WRB installed in accordance with applicable building code and ER-382.

B. Integration with flashings shall maintain continuity of drainage plane.

2.5 OPTIONAL CRACK RESISTANT SYSTEM (CRS)

A. BPS Armor CRS reinforcing basecoat.

B. Alkali-resistant fiberglass reinforcing mesh.

C. Installed at minimum 1/16-inch embedment thickness.

D. Installed in accordance with CRS Guide Specification.

2.6 FINISH COATS

A. WBP Exterior Stucco Finish.

B. WBP Premium Acrylic Finish with PAF Primer where required.

C. WBP Specialty Finishes.

D. Exterior finish coatings manufactured by additional listees recognized under IAPMO UES ER-382.

E. Standard acrylic paints or elastomeric coatings.

1. All coatings applied in accordance with manufacturer's written instructions.

F. The system is non-structural and does not eliminate cracking caused by structural movement, substrate instability, improper joint placement, or building movement.

PART 3 – EXECUTION





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GS Guide Specification

3.1 EXAMINATION

- A. Verify substrates:
1. Comply with ER-382.
 2. Structurally sound.
 3. Are properly braced.
 4. Free of bond-inhibiting materials.
- B. Do not proceed until unsatisfactory conditions are corrected.

3.2 PREPARATION

- A. Install weather-resistive barrier in accordance with code and ER-382.
- B. Integrate flashing components to maintain positive drainage.
- C. Install metal lath in accordance with ASTM C1063 and ER-382.
- D. Install control joints and coordinate building expansion joints affecting the stucco assembly as detailed in the Contract Documents. Installation of control joints shall otherwise comply with ASTM C1063 and applicable Evaluation Reports.

3.3 INSTALLATION

- A. Apply Western One-Pass plaster in accordance with selected system configuration and permitted thickness under ER-382.
- B. Ensure uniform embedment and proper rodding to achieve consistent thickness.
- C. Hard-float the plaster to promote densification.
- D. Moist cure for minimum 48 hours.
- E. Where CRS is specified, install reinforcing layer prior to finish application.

3.4 CURING AND PROTECTION

- A. Maintain moist curing for minimum 48 hours.
- B. Protect installed materials from freezing, rapid drying, precipitation, and damage until adequately cured.

3.5 FINISH APPLICATION

- A. Apply selected finish coating after basecoat curing.
- B. Premium Acrylic Finish assemblies requiring extended warranty tiers shall include PAF Primer.

3.6 FIELD QUALITY CONTROL

- A. Verify basecoat thickness.
- B. Verify placement of control joints and integration at building expansion joints conform to the Contract Documents.
- C. Inspect for uniform texture and finish consistency.

END OF SECTION 09 24 23

