2016
Cast Stone Institute
Excellence Awards

~ Winners ~
Residential Excellence

431 W. Deming
Chicago, Illinois

Producer Member: Architectural Cast Stone
West Chicago, Illinois

Architect: Michael Hershenson Architects

2016 Excellence Award Winners
What is the scope of the project?
This project was a new urban residential structure constructed in one of Chicago’s most exclusive areas. Cast Stone was used extensively as an accent material.

2016 Excellence Award Winners
What is the role of Cast Stone?

Cast Stone was used as a hardscape element for planters and fence posts and extensively on the structure for columns, surrounds, bands, cornices, medallions and coping. This residence was built at a development that we previously completed the hardscape elements for.
How was Cast Stone critical to the success of this project?

In an area of the city that for almost 150 years has exclusively used limestone, Cast Stone and its benefits are resonating with the younger generation of the urban elite. In this area of the city there are numerous examples of limestone failing on buildings. Seen as an engineered material manufactured in a plant setting with strict quality control – cast stone rivals limestone in appearance but can far exceeds its performance.
Judges Comments

- Classy Townhouse - city application
- Handsome use of Cast Stone, well designed
- Not ostentatious
- Cast Stone supported the design
Residential Excellence

Barnett Residence

Fort Lauderdale, Florida

Producer Member: Premier Stoneworks, LLC

Delray Beach, Florida

Architect: Jeffery Smith / Smith Architectural Group

2016 Excellence Award Winners
What is the scope of the project?

This residence incorporates a number of highly customized cast stone features and carvings. We carved the intricate Corinthian capitals designed in various sizes for the columns throughout the home and then replicated in miniature for the balustrade railings along the patio areas. Cast Stone elements included: 4,936 linear feet of exterior moldings, 1,850 linear feet of interior molding, balusters, columns, 577 corbels and finals, veneer panels, pavers, casings, wainscots, frieze and crowns.
There was a major emphasis on the Cast Stone as it plays a significant role in bringing the architect vision to life. It defined the style and set the mood for the entire house. The home is adorned in Cast Stone with a textured, rustic finish while the Moorish elements define many of the patio and window elements.

What is the role of Cast Stone?

2016 Excellence Award Winners
How was Cast Stone critical to the success of this project?
The residence is designed in a pleasing blend of traditional Mediterranean style complimented by the infusion of Moorish architecture. The Cast Stone not only adds elegance and timeless look but, it blends the two styles together.
Judges Comments

- Incredible detail – very well done
- Good jointery
- Intricate – most importantly true to it’s style
- Consistent cast stone throughout the project
Residential Excellence

Tilton Residence
The Woodlands, Texas

Producer Member: Siteworks, Inc.
Houston, Texas

Architect: Todd Rice / Rice Residential Design, LLC

2016 Excellence Award Winners
What is the scope of the project?

This was a new residence which included multi-colored Cast Stone veneer, ornate entry surround, window surrounds, banding, Tuscan columns, column caps, wall coping, and chimney caps.
What is the role of Cast Stone?

The colors that are interwoven throughout the tri-colored Cast Stone veneer was hand-selected by the owner and creates the illusion of travertine marble. Intricate Cast Stone cartouches above the entry and windows add a delicate and refined touch that a simple keystone or other material would be unable to create. The addition of Tuscan columns on the second-level balcony provides a level of stately sophistication while creating a warm and inviting atmosphere for both residents and guests.
How was Cast Stone critical to the success of this project?

It was important that the multi-colored Cast Stone while imitating the marble, blended with the stucco to create a flawless finish. Using Cast Stone allowed the owner to not only customize with their color preference, but also determine how much or little of a marbleized look they wanted. Care also had to be taken to ensure that one color did not become dominant. The banding between the first and second level breaks up the monotony of the stucco and allows appreciation of the intricate and subtle stonework. Overall, the owner was able to create an elegant, stately look that was more cost-effective than using other materials such as travertine marble or hand carved stone.
Judges Comments

• Crisp and sharp details

• High Degree of Difficulty – Cast Stone is seamlessly integrated

• Sophisticated in it’s balance
Commercial Excellence

Church of the Incarnation

*Dallas, Texas*

**Producer Member:** Dallas Cast Stone Inc.

*Dallas, Texas*

**Architect:** HH Architects

2016 Excellence Award Winners
What is the scope of the project?

The original Church of the Incarnation Episcopal Church was built in 1950-1952. This new addition includes -- a narthex addition in front of the existing sanctuary -- a welcoming center -- an educational building -- the Ascension Chapel -- and a prayer room. All of these buildings are tied together by a hallway over 400 feet long.

The original church is Cast Stone so they wanted to use Cast Stone on the addition to tie it together. Cast Stone is used intricately in every area of the church addition. The original water table was continued all around the church. Windows are trimmed inside and out. Tracery windows (of which there are six different) are used in the Welcoming Center and the Ascension Chapel. There are numerous arches all throughout this project inside and out, which are a key element throughout this gothic style structure. The repetitive arch windows on the long hall, both inside and out, are a great use of Cast Stone as are the three piece finials of which there are over 70. Over 70 interior columns create colonnades that allow for a timeless experience while walking the halls.
What is the role of Cast Stone?

Cast Stone is the element that ties all of the building materials together. It grounds everything. A very simple color yet very intricate detail. Cast Stone brings harmony and unity to this project, but also shines on its own throughout. Simple yet refined – timeless.

2016 Excellence Award Winners
The flexibility of forming Cast Stone in a 1,000 different shapes and sizes gives the building its uniqueness. The designer allowed us to use our expertise and abilities to craft Cast Stone for this project which was a great privilege. This project is beautiful now, but as it ages, will become even more attractive and appreciated.

How was Cast Stone critical to the success of the project?

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Judges Comments

- Impressive with way the Cast Stone is integral to the design
- Great addition to original structure
- Cast Stone is well crafted on the interior and exterior
- Timeless look and design will serve the church well for many years to come.

2016 Excellence Award Winners
Commercial Excellence
SMU Simmons Hall
Dallas, Texas

Producer Member: Advanced Architectural Stone
Fort Worth, Texas

Architect: Perkins & Will Architects

2016 Excellence Award Winners
What is the scope of the project?
This is a new building on the campus of Southern Methodist University consisting of a 40,000 square foot facility housing a teaching design lab, student assessment lab, classrooms, and the Department of Teaching and Learning.

2016 Excellence Award Winners
What is the role of Cast Stone?

Cast Stone is used throughout the buildings on this large university campus to provide visual unity of the campus and to allow maximum building design flexibility, taking into account the academic purpose of each building. Cast Stone on Simons Hall reflects a strong Georgian influence in its oversized columns and the glass and Cast Stone porticos bookend the building.

2016 Excellence Award Winners
How was Cast Stone critical to the success of the project?

Cast Stone accomplished the design intent of the architects on this project. Unity of look with other campus buildings and oversized Cast Stone columns at the entrance were used to express a building serving a new generation of teachers and leaders using evidence-based strategies in education.

2016 Excellence Award Winners
Judges Comments

- Impressive amount of Cast Stone used for the project and it is well designed

- Consistency of color and production is outstanding

- Without the Cast Stone the buildings falls flat – with the Cast Stone they stand out as exceptional
Restoration Excellence

Lebanon VA Hospital

Pennsylvania

Producer Member: Sun Precast Company

Beaver Springs, Pennsylvania

Architect: Harrel Design Group

2016 Excellence Award Winners
What is the scope of the project?
This restoration project encompasses several elements of the main building at the Lebanon VA Hospital. The scope includes replacement of the existing ornate elements including the parapet coping, large urns, window surrounds, chimney caps, triangular pediment heads and detailed ornamental crest panel.

2016 Excellence Award Winners
What is the role of Cast Stone?

The role of Cast Stone was to replicate the original intricate elements, while matching the remaining Cast Stone that was not being replaced.
How was Cast Stone critical to the success of the project?

The replacement Cast Stone is a perfect replication of the original structure. The intricate architectural details were replicated using hand sculpting techniques to enhance the original details prior to casting with rubber and fiberglass molds. Cast Stone served to maintain the historical integrity of the project, and allowed for maintaining the fine architectural details of the building.
Judges Comments

- Good job replicating the original materials
- High degree of difficulty getting the original pieces out of the brick and then replacing with the new Cast Stone
- Ability to replicate and the diversity and amount of items replaced

2016 Excellence Award Winners
Restoration Excellence

Immaculate Conception Catholic Church

*Houston, Texas*

**Producer Member:** Siteworks, Inc.

*Houston, Texas*

**Architect:** In-House

2016 Excellence Award Winners
What is the scope of the project?
This project is a restoration of the Bell Tower originally built in 1956. The Cast Stone consists of sixteen columns replacing the original, deteriorated limestone columns supporting the bell tower arches and roof structure.

2016 Excellence Award Winners
What is the role of Cast Stone?

Cast Stone was selected for its ability to be reinforced and manufactured to match the 60 year old limestone. The original limestone columns were installed and anchored with ferrous metal anchors that began to rust causing large chunks of the column to break off, creating a serious hazard of large pieces of stone falling 65 feet to the walkways below.

2016 Excellence Award Winners
How was Cast Stone critical to the success of the project?
Cast Stone was critical in order to maintain the integrity of the original bell tower. It was also the most cost-effective choice which allowed the project to fit into the church’s budget since the price of hand carving the sixteen ornate column capitals would have been very expensive.
Judges Comments

• Degree of difficulty to replicate the columns was incredible seeing what they had to work with from the deteriorated columns.

• Consistent coloration – accurate restoration

• Photos were compelling
Hardscape Excellence

HBU Belin Tower and Plaza

*Houston, Texas*

Producer Member: **Siteworks, Inc.**

*Houston, Texas*

Architect: **Alec A Luong / PGAL**

2016 Excellence Award Winners
What is the scope of the project?

This project is a new building located at the main entrance of Houston Baptist University. The Cast Stone on this project consists of eight 1’-0” diameter x 9’-3” columns, four 2’-9” diameter x 24’-2” columns, four arches, quoins, frieze with graphics, sign panel with graphics, soffits, window surrounds, entablature, and cornices.

2016 Excellence Award Winners
What is the role of Cast Stone?

“The Belin Tower is meant to be the standard bearer for the future design of all campus buildings in the Georgian/Federalist style. With that in mind the building needed to be constructed using materials that would provide a 100+ year lifespan. Cast Stone was the obvious choice to do the detailed window surrounds corbeled cornices, columns, quoins, and arches . . . that define those styles. The Cast Stone was chosen for its color compatibility to the weathered brick veneer to complete the material palette.”
The entry arches into the double barrel vault of the structure are true gravity arches. The Cast Stone arch sits in perfect compression in order to avoid an unsightly lintel underneath the entrance that would have been prone to rusting over time. The necessity to hide all modern structural elements to bring out the historic look was a key component of this project. The Cast Stone column surrounds also allowed us to get the correct entasis on the columns, something that is very difficult to replicate in any other medium. Historic columns true to form must have this in order to complete the effect.

By using Cast Stone we were able to create custom pieces that perfectly coursed out with the modular brick to get the desired historic effect. Dentil spacing on cornices is a set ratio, and by making custom pieces we were able to get the desired ratio with the minimum amount of pieces and without adversely affecting the modular brick. Had we used an off the shelf GFRC profile, we would have needed to adjust the size of the building – with Cast Stone that wasn’t an issue at all.
HBU Belin Tower and Plaza

Hardscape Excellence

Judges Comments

• Intricacy of the Cast Stone produced and installed

• Word carvings in the Cast Stone added to the structure

• Consistent color

• High degree of difficulty with most items placed high off the ground
Hardscape Excellence

Lincoln Landing Renovation

Lockport, Illinois

Producer Member: Architectural Cast Stone
West Chicago, Illinois

Architect: GFGR, Inc.

2016 Excellence Award Winners
What is the scope of the project?

This hardscape project consisted of the removal of the natural stone hardscape in a city park and replacing it with all Cast Stone to identically replicate the natural stone as the natural stone, installed ten years ago, had failed.
What is the role of Cast Stone?
Cast Stone was used to create seating, signage, retaining wall, and coping elements.

Excellence Award Entries
How was Cast Stone critical to the success of the project?

A wealthy benefactor had donated this park to the city and was heartbroken when, after a very short period of time, the natural stone started to fail. Once again this benefactor was willing to give back to his community and replace the stone, but only if he had assurance that the replacement stone would not fail. Cast Stone was critical to this project because not only could we replicate the three different textures the natural stone but of much greater importance we could guarantee to the donor the performance of the stone over time. With our CSI Plant Certification, historical product test data, the ability to add an integral water repellant and our 10 year warranty the donor was able to achieve the necessary comfort level and chose Cast Stone to replace the natural stone.
Judges Comments

• Unique Project – the texture and consistency of the Cast Stone as well as the color made for an excellent application.

• The texture of the Cast Stone units was one of the things that intrigued the most.
Unique Architectural Feature Excellence

Bearded Man

*Miami Beach, Florida*

Producer Member: **Premier Stoneworks, LLC.**
*Delray Beach, Florida*

Architect: **Shulman & Associates**

2016 Excellence Award Winners
The Bearded Man is a highly complex custom carving. This unique and intricate architectural feature not only required hand carving the entire piece but, also required creating renderings and interpreting historical photos dating back to 1950’s. The scope was divided into different components and included; the face, the hat which formed a bell curve balcony, the conch shells forming ears, the side pilasters and shell details surrounding the entire piece.

What is the scope of the project?

2016 Excellence Award Winners
What is the role of Cast Stone?

Not an ordinary project, this custom carving is entirely made out of cast stone. The Cast Stone is what makes this a memorable and magnificent masterpiece. It adorns an entrance to a building and is more than an accent, it is a piece of history being revived to its glory days. The Bearded Man was first carved out in clay, liquid rubber was then brushed in order to pick up all the complex details and get it ready to create positive and negative molds. Utilizing historical photographs and different elements to create this carving, ensured that no detail will be lost and casting it in Cast Stone ensured that this masterpiece will withstand the test of time.
How was Cast Stone critical to the success of the project?

The cast stone played a crucial role in the success of this masterpiece because, it allowed us to illustrate the distinctive architecture and history of Miami Beach. It is because of Cast Stone that this sculpture once again is adored and photographed by visitors from around the world. This historical restoration required precision, attention to details, interpretation of historical photos and creativity.
Judges Comments

• This entry shows why we recommended this category
• The piece was replicated well especially considering it came from only a photo
• Exceptionally detailed feature -- Awesome
• An artistic work of art

2016 Excellence Award Winners
Unique Architectural Feature Excellence

Old Parkland Buildings A, B & C
~ Corinthian Capitals ~

Dallas, Texas

Producer Member: Advanced Architectural Stone
Fort Worth, Texas

Architect: Beck Design

2016 Excellence Award Winners
What is the scope of the project?

This project consists of 9.5 acres of both new and renovated office buildings. There are eight primary buildings located within this campus. The Parkland campus complements the original and historic landmark structures on this master-planned business campus. There is approximately 200,000 square feet of office space within the complex.

2016 Excellence Award Winners
There are many unique features on this project, but this one caught the imagination of the architects in a special sense. This feature is the mammoth Corinthian Capitals facing outward from the project. These capitals replicated limestone capitals of the same size and design on the opposite side of the building. The owner and architects for the project expressed that the cast stone capitals were visually identical to the limestone at substantial reduction in cost and time; thereby meeting the overall completion time for the project.

What is the role of Cast Stone?

2016 Excellence Award Winners
How was Cast Stone critical to the success of the project?

Cast stone was the primary design element of the building. This is a great example of cast stone being used as a value-added material, by replacing the very ornamental designs originally specified as limestone with cast stone; creating flexibility in design, cost and timing.
Judges Comments

- Intricacy of leaves on the capitals is breathtaking
- Impressive project with a high degree of difficulty
- You can see the scale of the capitals when seeing a workmen next to them – massive!
- Consistency with a high level of craftsmanship
Manufacturing Excellence

Old Parkland Buildings A, B & C

Dallas, Texas

Producer Member: Advanced Architectural Stone

Fort Worth, Texas

Manufacturing Excellence Award Winners
What is the scope of the project?
This project consists of 9.5 acres of both new and renovated office buildings. There are eight primary buildings located within this campus. The Parkland campus compliments the original and historic landmark structures on the master-planned business campus. There is approximately 200,000 square feet of office space within the complex. We produced the Cast Stone for all of the buildings.
What special molding or casting techniques were necessary to illustrate the Architect’s concept on the project?

Unique detailing and molding for Cast Stone are found throughout the project. Details that are significant included the elements at the entry to Oak Lawn Hall with its radius multi-storied entrance using specially designed columns, profiles, egg-n-dart roping and large dentils to complete the portico. Other building entrances have similar creativity in the Cast Stone design.
Almost every piece of Cast Stone had a special and detailed design, from profiles, to chamfer, bevels, and special ornamentation. There were many pieces that weighted up to 3,000 lbs. and more. While size does complicate production processes, the exaggerated detail everywhere on the project is what made this project stand-out. On the installation side of the project, the company had to help design and engineer numerous jigs so that the specialty pieces could be set.
Were there unique project requirements that presented particular challenges and how were they met?

This project took place over several years. Consistency in every aspect of this project was required. Color and texture were computer driven. Quality control of batch design on a production-day basis was a part of the manufacturing process. The project involved a large number of molds which were important to the overall success of the finished product. For example, all the mold work on the entrance to the buildings required both CNC design and artisan finishes.
Judges Comments

• This is an amazing project

• The columns, bases, and capitals are so massive and ornate making it a manufacturing master piece.

• The dental and inlay work was spectacular.
Manufacturing Excellence

Private Residence - Chimneys

Private Location

Producer Member: Sun Precast Company
Beaver Springs, Pennsylvania

Manufacturing Excellence Award Winners
What is the scope of the project?

This project consisted of fabricating (5) large decorative Cast Stone chimney extensions for a very large private residence, incorporating (5) unique designs and shapes, to fit over the original chimneys.
What special molding or casting techniques were necessary to illustrate the Architect’s concept on the project?

The Cast Stone chimney designs created significant mold fabrication and casting challenges. Each chimney had unique dimensions and radii, each with different architectural artwork on the exterior. The "through the wall" decorative patterns near the tops of the chimneys, ultimately serve as the outlet for the chimneys, while creating the striking architectural appearance. Incorporating all of the various architectural details into the relatively small mold space, proved to be a significant challenge.
Manufacturing Excellence

The molding process was extremely complex, as each chimney had unique designs, and different radii, requiring a new mold for each chimney. The recessed architectural features required hundreds of individual elements to be handmade and custom shaped to fit the radius of the mold surface.

Degree of Difficulty

The molding process was extremely complex, as each chimney had unique designs, and different radii, requiring a new mold for each chimney. The recessed architectural features required hundreds of individual elements to be handmade and custom shaped to fit the radius of the mold surface.

Manufacturing Excellence Award Winners
Were there unique project requirements that presented particular challenges and how were they met?
The largest challenge of the project was incorporating the unique architectural elements while meeting the overall functionality requirements of a chimney extension. The Cast Stone chimneys also have a solid one-piece cap, which prevents rain and snow from entering directly into the chimney flue.
Judges Comments

• The chimney tops were so unique they made the mansion.

• The mold work was a manufacturing marvel. Such a difficult project done very well.
Manufacturing Excellence

Church of the Incarnation

Dallas, Texas

Producer Member: Dallas Cast Stone Inc.
Dallas, Texas

Manufacturing Excellence Award Winners
What is the scope of the project?

The original Church of the Incarnation Episcopal Church was built in 1950-1952. This new addition includes -- a narthex addition in front of the existing sanctuary -- a welcoming center -- an educational building -- the Ascension Chapel -- and a prayer room. All of these buildings are tied together by a hallway over 400 feet long.

The original church is Cast Stone so the addition was made from Cast Stone which is used intricately in every area of the church addition. The original water table was continued all around the church. Windows are trimmed inside and out. Tracery windows (of which there are six different) are used in the Welcoming Center and the Ascension Chapel. There are numerous arches all throughout this project inside and out, which are a key element throughout this gothic style structure. The repetitive arch windows on the long hall, both inside and out, are a great use of Cast Stone as are the three piece finials of which there are over 70. Over 70 interior columns create colonnades that allow for a timeless experience while walking the halls.
What special molding or casting techniques were necessary to illustrate the Architect’s concept on the project?

There were over two hundred plaster forms and triple that of wood and bondo forms involved in this project.
This is one of the most complex projects we have ever been a part of in our years of manufacturing Cast Stone.

**Degree of Difficulty**

Manufacturing Excellence Award Winners
Were there unique project requirements that presented particular challenges and how were they met?

The design of the new buildings created multiple compound skews that affected the Cast Stone scope tremendously. The many angles of the buildings features marrying with the complex skews of the Cast Stone profiles created quite a task in the detailing and form work departments.
Judges Comments

- The church is simply gorgeous.
- The mold work and engineering are fantastic.
- The stained glass windows inside and out are awesome.
- The church is truly a landmark.