Bluestem Private Residence
Andover, Kansas
Producer: Architectural Cast Stone, Inc., KS
Architect: Shelden Architecture
What is the scope of the project?

This is a new private residence with cast stone used throughout the project in a variety of applications including a stepped wainscot, sills, transition band, pilaster and pier caps, coping, planter bowls, and a large fireplace.
What is the role of Cast Stone?
The smooth cast stone contrasts with the rough natural stone used on the house. The light color of the stepped wainscot, sills, and band, create bold horizontal lines, which fits with the Prairie Style architecture of the house.
The wainscot and the simple, clean lines created by the sills and bands, are common elements in the Prairie Style of Frank Lloyd Wright. They are used to similar effect in this house, creating an aesthetic that is instantly recognizable. Wright’s influence extends to the house’s interior, where the fireplace is accented with geometric designs cast into large blocks that are reminiscent of his work in the Mayan Revival style.

How was Cast Stone critical to the success of this project?
Judges Comments

- The cast stone supports the overall architecture.
- Cleanliness of the joint lines shows good production and installation.
- Comprehensive use of cast stone in the interior and on the exterior compliment each other.
Private Residence in Wichita
Wichita, Kansas
Producer: Architectural Cast Stone, Inc., KS
Architect: Spangenberg Phillips Tice Architecture
What is the scope of the project?

This is a new private residence. Cast stone was used extensively throughout the project, including wainscot, caps, fire pit and wall coping, corbels, accents, door and window surrounds, keystones, sills, headers, and columns.
Private Residence in Wichita

Cast stone acts as an accent material where it is surrounded by brick, and takes the place of natural stone where a smoother finish was needed. The color of the cast stone was closely matched to the natural stone on the home, but the smooth finish helps to create some contrast.

What is the role of Cast Stone?

Cast stone acts as an accent material where it is surrounded by brick, and takes the place of natural stone where a smoother finish was needed. The color of the cast stone was closely matched to the natural stone on the home, but the smooth finish helps to create some contrast.
The design for the project called for a variety of custom surrounds and columns. The flexibility of cast stone allowed for production of the custom stone in a timely manner, and keep the project moving forward. And, by choosing cast stone, the homeowner was able to get the look of honed limestone they wanted, at a significant cost savings.

How was Cast Stone critical to the success of this project?
Private Residence in Wichita
Judges Comments

- Cast stone on the overall façade supports the design
- The cast stone presents well and enhances the façade.
- The cast stone in the hardscape surrounding the house matches that used on the home itself.
COMMERCIAL
Ward County Event Center
Monahans, Texas
Producer: Advanced Architectural Stone
Architect: Level 5 Design Group
What is the scope of the project?

The project had a massive radius seat wall on the exterior with all the interior entries accented with large cast stone trim.
What is the role of Cast Stone?
The exterior radius seat wall is used to accent the massive county seal logo. The interior entries are all trimmed with a massive surround.
How was Cast Stone critical to the success of this project?
The cast stone accent with the natural stone and masonry veneer brings dramatic attention to each area that it is used.
The use of cast stone in combination with the natural stone is appealing and interesting.

Well done interior which is important as this is where people will congregate most often.

The interior use of cast stone with the banding of rusticated then smooth in a pattern is great.

The excellent design of the interior hallways makes the long hallway not monotonous.
Texas State University Health Professions
San Marcos, Texas
Producer: Advanced Architectural Stone
Architect: Dr. B.J. Spencer AIA
What is the scope of the project?

The building inspires learning starting with a polished entry, modern finishes, natural light, and transparency of space. A communal stair links the levels, and distributed spaces were designed throughout the building to encourage and support study groups of various sizes.
The cast stone is used with rock-face natural stone and two colors of brick. The cast stone highlights the different products used in this large structure.

What is the role of Cast Stone?

The cast stone is used with rock-face natural stone and two colors of brick. The cast stone highlights the different products used in this large structure.
The cast stone was used extensively at the entry areas to enhance each area of the structure.

How was Cast Stone critical to the success of this project?
The cast stone was used extensively at the entry areas to enhance each area of the structure.
Judges Comments

- Cast stone supports the design even with a lot of cast stone on the project – they liked everything about this building.
- The heavy base of the building gradates and lightens up as you go from bottom to top of the building.
- Cast stone at entrance is compelling and sets the stage for the structure
- Blending of cast stone with other materials was done with a good design eye
COMMERCIAL

The McKenzie
Dallas, Texas
Producer: Advanced Architectural Stone
Architect: LRK - Looney Ricks Kiss
What is the scope of the project?
This is a 22 story 183 unit high rise residential building located in an exclusive neighborhood.
What is the role of Cast Stone?

Cast stone is used exclusively on the first two levels of the building and wraps into the interior of the motor court. Banding is used at every level as you look up the massive structure. Balustrades are also featured on several levels including the Penthouse balconies.
How was Cast Stone critical to the success of this project?
The cast stone shapes and enormous corbel brackets at level two brings the sophisticated and elegant look to the massive residential structure.
The McKenzie

Judges Comments

- Looks like a 1930's building in Dallas even though it's a new structure.
- Very consistent workmanship
- The cast stone gives the building a base and the actual cast stone has a high degree to complexity of the casting.
- Good detailing overall especially the entrances from the street to the indoor and first floors of the exterior.
COMMERCIAL

Highland Park United Methodist Church Family Center

University Park, Texas

Producer: Advanced Architectural Stone

Architect: Selzer Associates
Highland Park United Methodist Church Family Center

What is the scope of the project?
This is a high profile church located on the edge of a major University. This is a new facility that contains classrooms and meeting spaces, youth classes, gathering spaces, worship center, gymnasium, and two levels of underground parking.
The cast stone elements resemble the existing church that was built in the late 1920’s. The cast stone accents all the windows, pilaster and entry areas.

What is the role of Cast Stone?
The cast stone elements resemble the existing church that was built in the late 1920’s. The cast stone accents all the windows, pilaster and entry areas.
How was Cast Stone critical to the success of this project?
The entry detailing gives a welcoming to all visitors and members. The enormous bay window also enhances the structure.
Judges Comments

- Cast stone is very nice --- well-executed production and installation
- Bay window view is really nice on the end of building as are the other windows
- The overall design of this church center is exceptional and the cast stone compliments the structure.
RESTORATION
Montgomery Building
Spartanburg South Carolina

Producer: Cast Stone Systems
Architect: Sweet Sparkman Architects
What is the scope of the project?

The scope of the work was the restoration of the 10-story Montgomery Ward building constructed in the 1920’s. The cast stone encompasses the entire external skin on the building excluding the copper bay windows that are painted green.
The role of the cast stone was critical in replacing the original concrete exterior that had both aesthetically and structurally failed. The project consisted of over 1,200 pieces of cast stone that were critical in the project’s success. Hundreds of forms were crafted and countless hours spent painstakingly replicating the original exterior pieces.

What is the role of Cast Stone?

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

The owners required that the original detail be replicated, and the project depended on $12 million in tax credits that were granted successfully satisfying their requirements.

While the cast stone is a critical component in the success of the project, the Montgomery building is a vital part of a revitalization of the downtown and this made the project especially gratifying.
Montgomery Building
Judges Comments

- Impressive detail with great reproduction overall
- The reliefs and intricate entablature reproductions were exceptional!
- Cast stone can be a very unforgiving material which makes the successful production and installation of this project exceptional.
Anna Historical Society - Front Porch Renovation

Anna, Ohio

Producer: Custom Cast Stone

Architect: Anna District Historical Society
What is the scope of the project?

The home of the Anna District Historical Society, which was built in 1911, came with much needed repair and restoration. The original porch was completely removed and most of the stone block had failed and were unsalvageable. Once widely sold, classic rock face block is no longer manufactured in the sizes and styles featured on the ADHS house. The Board at ADHS wanted to completely replicate and restore the porch to it’s original look. Cast stone was the perfect option.

The restoration involved replication of every original rock face and smooth stone element of the original 1911 house. Over 60 different stone units were identified to be replicated. The most detailed units included the columns with multiple details, including assembly blocks with coved corners.
What is the role of Cast Stone?
The role of Cast Stone was to replicate the original stone elements and bring the home back to its original look after construction in 1911.
How was Cast Stone critical to the success of this project?

The goal of the project was to restore the home’s front porch to its original condition and look. Cast stone was versatile enough to create the detail, textures and colors of the original material while meeting the budget needs of the home’s owners.
Anna Historical Society - Front Porch Renovation

BEFORE

AFTER
Judges Comments

- This is an example of a great restoration project that clearly meets the criteria.
- It is a faithful representation and reproduction of the original.
- Excellent work for production and installation on this project which utilized cast stone for a reproduction of another material used in the past.
EVERYDAY EXCELLENCE
EVERYDAY EXCELLENCE

Venice Public Library
Venice, Florida
Producer: Premier Stoneworks
Producer: Sweet Sparkman Architects
What is the scope of the project?

The Venice Public Library is adorned with beautiful architectural cast stone elements on all four elevations of the building. The scope consisted of 5,300 liner feet of trim and caps which adorn the building, 19 small columns, 533 square feet of stone veneer and two full trucks of Florida shell totaling about 60,000 pounds.
What is the role of Cast Stone?

The design intent was to have something beautiful with a Florida Shell finish but the architect could not find any natural stone that would satisfy his vision. Using cast stone and working together with the CSI manufacturer allowed the architect to achieve the exact look he has envisioned. This project would not have worked if not for the flexibility of cast stone product and knowledge of its producers.
How was Cast Stone critical to the success of this project?

Cast Stone was critical to the success of the project because it not only adorns the entire library but it allowed the design intent to come to life. Using cast stone allowed the project to move forward on time and within the budget.
Judges Comments

- Good use of cast stone that shows how it can compliment a structure by the use of a visual texture
- The building has not only a good design but it has a nice “feel” to it.
- Excellent design, production and installation
Avant Multi Family Residences
Carmel, Indiana
Producer: Custom Cast Stone
Architect: The Housing Studio
Avant Multi Family Residences

Avant Apartments is a new 400 unit luxury apartment building which is a four story building with the exterior clad in architectural cast stone and metal panels.

The fabrication consisted of two separate production methods, and a two color blend, to create over 50% of the buildings exterior. Ensuring that the variegated blend look and finish was consistent between the two production methods was critical. Scored header, sills and bands were produced with the two colors blended by hand, while the large dimensional units, with the same blended colors, were produced through automation.
What is the role of Cast Stone?

Cast stone is the sole masonry component of the building’s exterior and therefore vital to making a visual and lasting impression for this high end project.
How was Cast Stone critical to the success of this project?

Cast stone was the one material that could combine the desired blended colors and maintain the highest standards of durability. It was important to the project that a consistent and natural look to the stone be achieved and work with the metal materials also chosen for the exterior.
Judges Comments

- The designer has taken a great approach to color issues by blending the colors within the cast stone panels.
- Entire veneer skin of the building utilizes different color mixes for the cast stone.
- It is a well executed project using simple shapes and ideas to create a structure with a modern use.
UNIQUE ARCHITECTURAL FEATURE
UNIQUE ARCHITECTURAL FEATURE

Bassett Furniture Store
Coral Gables, Florida
Producer: Premier Stoneworks
Architect: Burton Hersh, PA
What is the scope of the project?

It is a new building with modern and unique geometric shapes within the architectural stone panels. The scope of work on this project included manufacturing and installation of roughly 100 decorative panels on a facade of this one-story building.
What is the role of Cast Stone?

Custom artistic stone panels with unique geometric shapes that provide a fresh and modern look that encompasses the entire building. The cast stone panels serve as an artwork and an important role in the elevation.
How was Cast Stone critical to the success of this project?

The cast stone played a crucial role in the success of this project. Already a difficult design due to the size and the alignment of geometric shapes, this required skilled techniques and craftsmanship to execute. Not only does cast stone ensure durability but, it also allows to illustrate how a unique architectural feature can elevate a simple building. It is because of high quality cast stone that this free standing simple building will stand out on a major street and possibly be an inspiration for future designs.
Judges Comments

- We like it. It is well done and executed.
- The crisp lines and continuity create a dramatic effect.
- The consistent colors and excellent installation make this a winner.
UNIQUE ARCHITECTURAL FEATURE

Pool House Addition

Wichita, Kansas

Producer: Architectural Cast Stone

Architect: Greg Tice - SPT Architecture
What is the scope of the project?

This is a pool house addition for a private residence. Cast stone is used throughout the project in a variety of applications, including a stepped wainscot, pilasters, jambs, pilaster capitals, cornices, lunettes, surrounds, parapet coping, and caps. The pilaster capitals had to match existing capitals on the existing residence, which proved to be a complicated process.
What is the role of Cast Stone?

The pilaster capitals had to match the existing capitals on the house, but the homeowner would not allow any of the existing capitals to be removed so that a mold could be cast from them, and would not allow a cast to be made on site from the existing capitals, to eliminate the possibility of damage to the existing capitals. We were able to get around this challenge by working with the architect and builder, using technologies that are relatively new.
How was Cast Stone critical to the success of this project?

This was moderately difficult. The process involved in recreating the original capitals was a first, not only for us, but for the architect and the builder as well. There was a steep learning curve for these processes, and it took several attempts to get the digital models to a point where they could be successfully 3D printed and used to create the molds.
Pool House Addition

Judges Comments

- Capitals on the pool house are a feature that should be recognized.
- The pool house was to match the original house and the matching of the ornate capitals was achieved by photos only.
- It is an overall good design which compliments the original house.
UNIQUE ARCHITECTURAL FEATURE

Prosper Town Hall & Library
Prosper, Texas
Producer: Advanced Architectural Stone
Architect: Randall Scott Architects
Prosper Town Hall & Library

The architect was tasked with the design of a Town Hall & Library that reflected the character of the small, historic downtown. The majority of the downtown buildings consist of antique red brick and cast stone with metal and stone accents. The exterior design focused around timeless Beaux Arts government vocabulary with oversized arched Richardsonian windows and highly detailed brickwork borrowed from the adjacent historic downtown structures.

What is the scope of the project?
The architect was tasked with the design of a Town Hall & Library that reflected the character of the small, historic downtown. The majority of the downtown buildings consist of antique red brick and cast stone with metal and stone accents. The exterior design focused around timeless Beaux Arts government vocabulary with oversized arched Richardsonian windows and highly detailed brickwork borrowed from the adjacent historic downtown structures.
What is the role of Cast Stone?

The building is clad in antique red brick with traditional cast stone, natural limestone and metal accents. Large columns and entablatures mark distinct entrances to the Courts, Library & City Hall Complex. The building steps back at the third floor to provide roof terraces and verandas with views in all directions. It sits atop an elevated podium with the top of its cupola standing at over 100 feet above ground. Inside is a Great Hall which has a two story colonnade capped with 25 foot wide arches framing coffered ceilings appointed with historically accurate luminaires. An innovative feature was its ability to expand into dedicated shell space provided on each floor and onto third floor roof terraces on the east and west ends of the building. Until such time as the building needs to expand, these roof terraces provide unique amenity spaces for staff and the public to enjoy.
The decorative fluted columns and enormous entablature draw the focal attention to the frequently traveled entry ways. The cast stone veneer and water table at the projected pilasters enhances the brick projections significantly.

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

The decorative fluted columns and enormous entablature draw the focal attention to the frequently traveled entry ways. The cast stone veneer and water table at the projected pilasters enhances the brick projections significantly.
Judges Comments

- The capitals on this project were the highlight for the judging panel. They are unique and massive.
- These capitals are the extremely complex and therefore would have created a challenge for production and installation.
UNIQUE ARCHITECTURAL FEATURE

Market Square Tower
Houston, Texas
Producer: Advanced Architectural Stone
Architect: Jackson & Ryan Architects
**What is the scope of the project?**

This is the tallest residential high rise building in the city with 42 stories containing 463 luxury apartments. The entire lower façade is large chamfered cast stone veneer with huge projected pilasters. Notice the projected pool cantilevering from the 42nd floor.
The architect wanted significant attention to the projecting pilasters at the lower levels and highlighting the top of the building with massive extruding pilasters. The main entry has a large protruding balcony with enormous bracket assemblies supporting it.

**What is the role of Cast Stone?**

The architect wanted significant attention to the projecting pilasters at the lower levels and highlighting the top of the building with massive extruding pilasters. The main entry has a large protruding balcony with enormous bracket assemblies supporting it.
How was Cast Stone critical to the success of this project?

The cast stone on the lower and upper sections brought contrast to the lueders limestone veneer used on the rest of the building. The custom color created the desired tone that the architect was looking to achieve.
Market Square Tower
Market Square Tower

Judges Comments

- Although the building overall is impressive, the judging panel chose to highlight the rooftop pool area.
- They especially liked the design and placement of the large pillars at the edge of the building pool area.
- The pool extending over the building is also impressive.
HARDSCAPE
ENTRY THREE

HARDSCAPE

Elizabethtown College Sports Fitness & Wellness Center
Elizabethtown, Pennsylvania

Producer: Sun Precast
Producer: Cannon Design, Charlie Clements
What is the scope of the project?

This new college campus fitness and wellness facility incorporates many different cast stone elements to complement the varied construction materials, i.e. brick, block, granite, pavers, etc. The cast stone scope includes deep projecting bands, watertable, sills, seat walls / coping, fire pit coping and pier caps.
What is the role of Cast Stone?
The cast stone serves to cohesively tie-in the many other architectural materials, and provide accent to the unique architectural building features and design.
The custom cast stone not only provides visual interest by itself, but the cast stone significantly enhances the other surrounding materials, maximizing their visual impact on the building design. Cast stone allows for economic fabrication of the detailed mold work (raised chamfers, radius walls, deep bands) while providing the look and durability of natural stone.

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

The custom cast stone not only provides visual interest by itself, but the cast stone significantly enhances the other surrounding materials, maximizing their visual impact on the building design. Cast stone allows for economic fabrication of the detailed mold work (raised chamfers, radius walls, deep bands) while providing the look and durability of natural stone.
Judges Comments

- The cast stone has clean, straight lines which compliment the building and create a statement.
- The cast stone is “user-friendly” and comfortable in this university atmosphere.
- Well done cast stone production and installation
HARDSCAPE

Atlanta Botanical Gardens Fountain Replacement
Atlanta, Georgia
Producer: Bassco Cast Stone
Architect: Atlanta Botanical Gardens
The Atlanta Botanical Gardens needed to replace their existing main entry Limestone fountain that was crumbling. They were interested in replacing it with a cast stone fountain because of the great freeze-thaw properties that cast stone requires in the standards.

What is the scope of the project?

The Atlanta Botanical Gardens needed to replace their existing main entry Limestone fountain that was crumbling. They were interested in replacing it with a cast stone fountain because of the great freeze-thaw properties that cast stone requires in the standards.
What is the role of Cast Stone?
The role of cast stone was to replace an existing Limestone fountain with a more durable product that can withstand harsher environments and that looks great.
How was Cast Stone critical to the success of this project?

Cast Stone was critical in the success of this project because we were able to offer a more durable product that can withstand harsher environments.
Judges Comments

- One piece!
- This is a large impressive piece, especially considering the difficulty involved.
- Well executed and well done
2019 Cast Stone Institute
MANUFACTURING EXCELLENCE AWARDS

WINNERS
MANUFACTURING
Grapevine Public Safety Facility
Grapevine, Texas
Producer: Advanced Architectural Stone
What is the scope of the project?
The project had large cast stone elements at all of the entry areas.
What special molding or casting techniques were necessary to illustrate the Architect’s concept on the project?

The uniqueness of the veneer which had a recessed reveal which carried through to the inside on all the arches.
Degree of difficulty.
The project had fluted columns at the grand entry which were massive dry tamp pieces.
Were there project requirements that presented particular challenges, and how were they met.

This was a custom color project in which the architect wanted some variance from piece to piece to replicate a natural quarried stone. We created a slight color formula design that was required in our automated DCS color system in order to achieve the architects design.
Judges Comments

- The manufacturing of the different colors mixed along with the logistics of the palletizing and layout by the mason of the project correctly was well done.
- The sheer size of the huge massive pieces made this an award winner.
- The detail on the window and the doorway arches was difficult to organize.
- The border (reveal) was also a challenge and to get this all produced and installed correctly shows expert workmanship.
MANUFACTURING

AC Marriott
Spartanburg South Carolina
Producer: Cast Stone Systems, Inc.
What is the scope of the project?

The scope of the work was new construction of a 10-story hotel. We produced the architectural cast stone for the entire project including all cornices.
What special molding or casting techniques were necessary to illustrate the Architect’s concept on the project?

We manufactured the project using wood, rubber, CNC routers, and 3D printers to achieve the degree of detail required to match the designer’s intent.
The degree of difficulty was high requiring both wet cast and VDT cast stone. There was much detail and coordination involved with all the installation but especially the large upper cornice that required welded connections. The project was deceptively complicated.
Were there project requirements that presented particular challenges, and how were they met.
The cornice was extremely difficult to design and attach and required that weld plates correctly located.
Judges Comments

- The degree of difficulty and details, especially on the balcony areas, showed expert craftsmanship.
- The coordination of wet cast and dry tamp production methods was impressive.
- Lots of difficult intricate pieces to produce and install
- Well done project
- The crispness of the details was exceptional.
The McKenzie

Dallas, Texas

Producer: Advanced Architectural Stone
What is the scope of the project?
This is a 22 story 183 unit high rise residential building located on the eastern edge of an exclusive neighborhood.
What special molding or casting techniques were necessary to illustrate the Architect’s concept on the project?
The massive corbel brackets accented the detailed veneer at the lower levels. They required special attachments to the concrete structure.
Degree of difficulty.
Limited jobsite space required shipping early morning and late afternoon eliminating traffic delays.
Schedule was the challenge on this project. The mason had an 8 month schedule for completion.

Were there project requirements that presented particular challenges, and how were they met.

Schedule was the challenge on this project. The mason had an 8 month schedule for completion.
The McKenzie
Judges Comments

- Everything was well done, especially the balustrades.
- Color consistency is good.
- The large radial openings and elliptical arches are well done.
- Overall design of the insets of the windows was outstanding.
- A lot of cast stone on the building and all well done.