

DRAFT, SUPPORT SYSTEMS & RADIUS PIECES

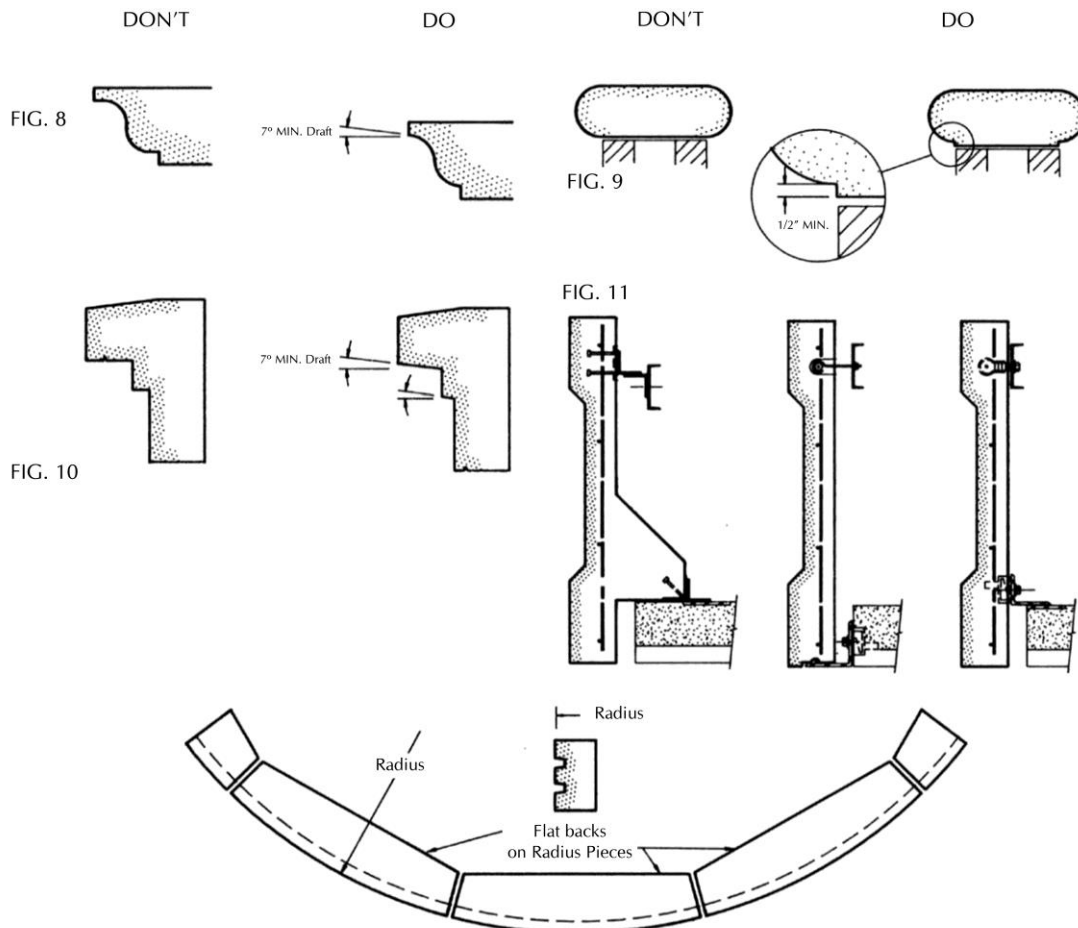
Fig. 8. Projecting portions of sections, in general, should not exceed their thickness. A 7 to 9 degree draft is usually needed to separate the production pieces from the mould and may be provided by the manufacturer even where 90 degrees is shown on the drawings.

The intersection of the unexposed or back side with the formed sides should not come to a feather edge in the mould. This can be avoided by using a shoulder as shown in Fig. 9.

The preferred section shown in Fig. 10 can be efficiently produced from a one-piece face pattern. The alternative section must be drawn across a multi-piece pattern after each casting due to no mould draft, resulting in higher costs and compromised quality.

Use standard building stone anchors as shown on page 82 whenever possible. Where relieving angles cannot be positioned to carry the load, threaded or adjustable inserts can be employed (Fig.11).

Allow enough space in the masonry wythe to make curved pieces straight on the back. This need not apply to coping and similar sections where the major unexposed side is flat at the masonry bed joint.



This Technical Bulletin addresses generally accepted practices, methods and general details for the use of Architectural Cast Stone. This document is designed *only as a guide* and is *not* intended for any specific application or project. It is the responsibility of design and construction professionals to determine the applicability and appropriate application of any detail to a specific project based on professional judgment, specific project conditions, manufacturer’s recommendations and solid understanding of product characteristics. The Cast Stone Institute makes no express or implied warranty or guarantee of the techniques or construction methods identified herein. Technical references shall be made to the edition of the International Building Codes for the location of the structure, the latest edition of the TMS 402/406 Masonry Standards document and TMS 404, 504, 604 Standards for Design, Fabrication and Installation of Architectural Cast Stone.

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