

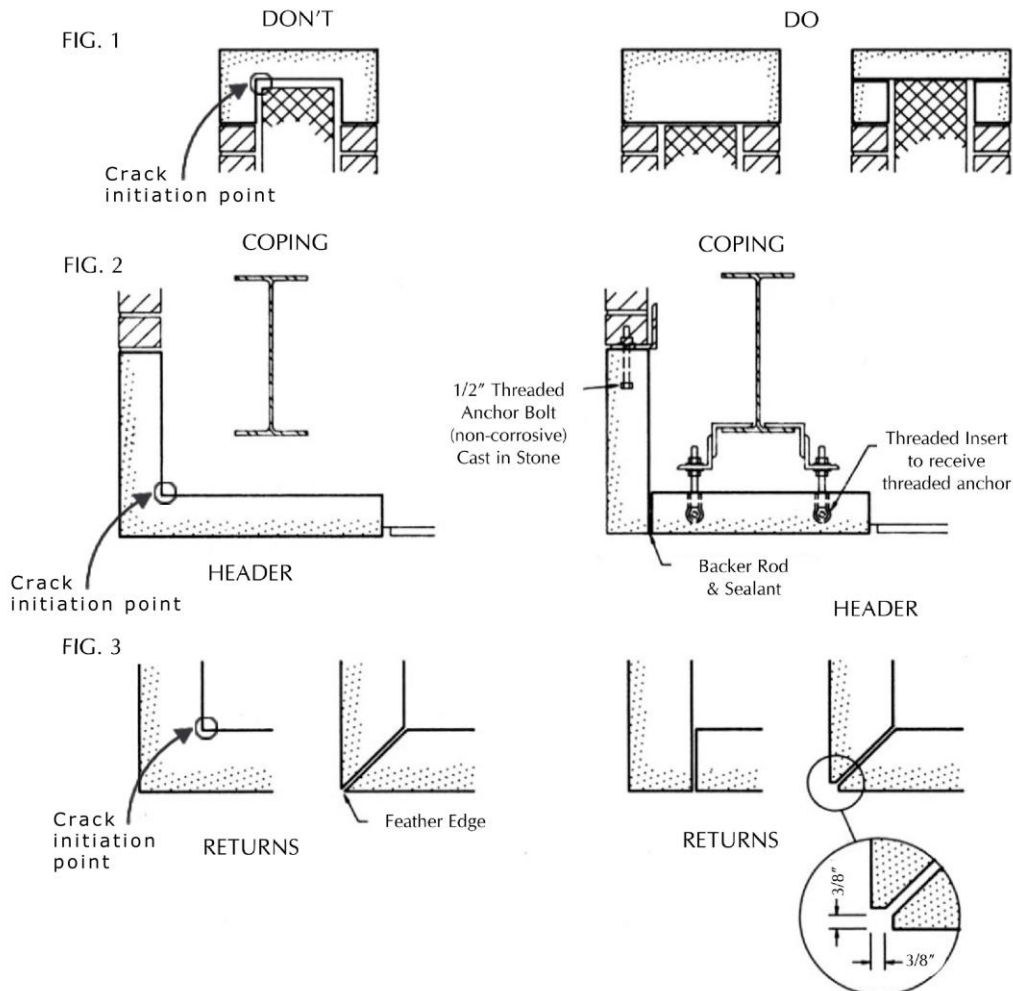
“L” SHAPES, “U” SHAPES AND FEATHER EDGES

Moulds for manufacturing Cast Stone can be made from a wide variety of materials. The product is cast using either the Vibrant Dry Tamp or wet cast system. Regardless of the process used, a knowledge of the fundamentals of casting can benefit the building budget tremendously.

Nearly all shapes are cast face down in the mould. The mould creates five formed sides and one unformed back side. For maximum economy, the unformed side should be kept flat and left unexposed. L or U shape stones present casting problems and should be avoided whenever possible.

The coping section shown in Fig. 1 will cost more than either of the alternative sections shown due to more labor intense moulding, manufacturing, shipping and setting operations. Fig. 2 shows a header with a long vertical leg which will prohibit multiple daily castings when using the Vibrant Dry Tamp process and cause air voids in the wet cast process. Considerably less product could be packaged on a truckload using either method.

Fig. 3 illustrated the two best corner conditions; the butt joint and the quirk joint. The flat on a quirk must accommodate the largest aggregate used in the mix.



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.

The Cast Stone Institute (CSI) is a not-for-profit organization created to advance the design, manufacture and use of Architectural Cast Stone. To further this goal, the CSI continually disseminates information to targeted construction industry audiences through presentations, programs and technical publications.