SECTION 047200 - CAST STONE MASONRY

PART 1 - GENERAL

1.1 RELATED DOCUMENTS

A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 SUMMARY

A. Section Includes:

1. Cast stone trim[.][**including the following:**]

a. Window sills.
b. Lintels.
c. Surrounds.
d. Coping.
e. Wall caps.
f. Belt courses.
g. Water tables.
h. Quoins.
i. Pilasters.
j. Column covers.
k. Medallions.

2. Cast stone steps.
3. Cast stone bollards.
4. Cast stone benches.
5. Cast stone curbing.

B. Related Sections:

1. Section 034500 "Precast Architectural Concrete."
2. Section 042000 "Unit Masonry" for installing cast stone units in unit masonry.

1.3 ACTION SUBMITTALS

A. Product Data: For each type of product indicated.

1. For cast stone units, include construction details, material descriptions, dimensions of individual components and profiles, and finishes.

B. LEED Submittals:

1. Product Certificates for Credit MR 5: For products and materials required to comply with requirements for regional materials indicating location and distance from Project of material manufacturer and point of extraction, harvest, or recovery for each raw material. Include statement indicating cost for each regional material and the fraction by weight that is considered regional.

C. Shop Drawings: Show fabrication and installation details for cast stone units. Include dimensions, details of reinforcement and anchorages if any, and indication of finished faces.

1. Include building elevations showing layout of units and locations of joints and anchors.

D. Samples for Initial Selection: For colored mortar.

E. Samples for Verification:

1. For each color and texture of cast stone required, 10 inches (250 mm) square in size.
2. For colored mortar. Make Samples using same sand and mortar ingredients to be used on Project.[**Label Samples to indicated types and amounts of pigments used.**]

F. Full-Size Samples: For each [**color**] [**texture**] [**and**] [**shape**] of cast stone unit required.

1. Make available for Architect's review at Project site[**or at manufacturing plant, if acceptable to Architect**].
2. Make Samples from materials to be used for units used on Project[**immediately before beginning production of units for Project**].
3. Approved Samples may be installed in the Work.

1.4 INFORMATIONAL SUBMITTALS

A. Qualification Data: For [**manufacturer**] [**and**] [**testing agency**].

1. Include copies of material test reports for completed projects, indicating compliance of cast stone with ASTM C 1364.

B. Material Test Reports: For each mix required to produce cast stone, based on testing according to ASTM C 1364[**, including test for resistance to freezing and thawing**].

1. Provide test reports based on testing within previous two years.

1.5 QUALITY ASSURANCE

A. Manufacturer Qualifications: A qualified manufacturer of cast stone units similar to those indicated for this Project, that has sufficient production capacity to manufacture required units, and is a plant certified by [**the Cast Stone Institute**] [**the Architectural Precast Association**] [**or**] [**the Precast/Prestressed Concrete Institute for Group A, Category AT**].

B. Testing Agency Qualifications: Qualified according to ASTM E 329 for testing indicated.

C. Source Limitations for Cast Stone: Obtain cast stone units through single source from single manufacturer.

D. Source Limitations for Mortar Materials: Obtain mortar ingredients of a uniform quality, including color, from one manufacturer for each cementitious component and from one source or producer for each aggregate.

E. Mockups: Furnish cast stone for installation in mockups specified in Section 042000 "Unit Masonry."

F. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects[**and set quality standards for materials and execution**].

1. Build mockup of typical wall area as shown on Drawings.

1.6 DELIVERY, STORAGE, AND HANDLING

A. Coordinate delivery of cast stone[**with unit masonry work**] to avoid delaying the Work[**and to minimize the need for on-site storage**].

B. Pack, handle, and ship cast stone units in suitable packs or pallets.

1. Lift with wide-belt slings; do not use wire rope or ropes that might cause staining. Move cast stone units, if required, using dollies with wood supports.
2. Store cast stone units on wood skids or pallets with nonstaining, waterproof covers, securely tied. Arrange to distribute weight evenly and to prevent damage to units. Ventilate under covers to prevent condensation.

C. Store cementitious materials on elevated platforms, under cover, and in a dry location. Do not use cementitious materials that have become damp.

D. Store mortar aggregates where grading and other required characteristics can be maintained and contamination can be avoided.

1.7 PROJECT CONDITIONS

A. Cold-Weather Requirements: Do not use frozen materials or materials mixed or coated with ice or frost. Do not build on frozen substrates. Comply with cold-weather construction requirements in ACI 530.1/ASCE 6/TMS 602.

1. Cold-Weather Cleaning: Use liquid cleaning methods only when air temperature is 40 deg F (4 deg C) and above and will remain so until cast stone has dried, but no fewer than seven days after completing cleaning.

B. Hot-Weather Requirements: Comply with hot-weather construction requirements in ACI 530.1/ASCE 6/TMS 602.

PART 2 - PRODUCTS

2.1 CAST STONE MATERIALS

A. General: Comply with ASTM C 1364 and the following:

B. Portland Cement: ASTM C 150, Type I or Type III, containing not more than 0.60 percent total alkali when tested according to ASTM C 114. Provide natural color or white cement as required to produce cast stone color indicated.

C. Coarse Aggregates: Granite, quartz, or limestone complying with ASTM C 33; gradation and colors as needed to produce required cast stone textures and colors.

D. Fine Aggregates: Natural sand or crushed stone complying with ASTM C 33, gradation and colors as needed to produce required cast stone textures and colors.

E. Color Pigment: ASTM C 979, synthetic mineral-oxide pigments or colored water-reducing admixtures; color stable,[**free of carbon black,**] nonfading, and resistant to lime and other alkalis.

F. Admixtures: Use only admixtures specified or approved in writing by Architect.

1. Do not use admixtures that contain more than 0.1 percent water-soluble chloride ions by mass of cementitious materials. Do not use admixtures containing calcium chloride.
2. Use only admixtures that are certified by manufacturer to be compatible with cement and other admixtures used.
3. Air-Entraining Admixture: ASTM C 260.[**Add to mixes for units exposed to the exterior at manufacturer's prescribed rate to result in an air content of 4 to 6 percent, except do not add to zero-slump concrete mixes.**]
4. Water-Reducing Admixture: ASTM C 494/C 494M, Type A.
5. Water-Reducing, Retarding Admixture: ASTM C 494/C 494M, Type D.
6. Water-Reducing, Accelerating Admixture: ASTM C 494/C 494M, Type E.

G. Reinforcement: Deformed steel bars complying with ASTM A 615/A 615M, Grade 60 (Grade 420). Use galvanized or epoxy-coated reinforcement when covered with less than 1-1/2 inches (38 mm) of cast stone material.

1. Epoxy Coating: ASTM A 775/A 775M.
2. Galvanized Coating: ASTM A 767/A 767M.

H. Embedded Anchors and Other Inserts: Fabricated from [**stainless steel complying with ASTM A 240/A 240M, ASTM A 276, or ASTM A 666, Type 304**] [**steel complying with ASTM A 36/A 36M, and hot-dip galvanized to comply with ASTM A 123/A 123M**].

2.2 CAST STONE UNITS

A. Manufacturers: Subject to compliance with requirements, [**provide products by one of the following**] [**available manufacturers offering products that may be incorporated into the Work include, but are not limited to, the following**]:

1. <**Insert, in separate subparagraphs, manufacturers' names**>.

B. Regional Materials: Cast stone units shall be manufactured within 500 miles (800 km) of Project site from aggregates[**and cement**] that have been extracted, harvested, or recovered, as well as manufactured, within 500 miles (800 km) of Project site.

C. Provide cast stone units complying with ASTM C 1364 using either the vibrant dry tamp or wet-cast method.

1. Provide units that are resistant to freezing and thawing as determined by laboratory testing according to ASTM C 666/C 666M, Procedure A, as modified by ASTM C 1364.

D. Fabricate units with sharp arris and accurately reproduced details, with indicated texture on all exposed surfaces unless otherwise indicated.

1. Slope exposed horizontal surfaces 1:12 to drain unless otherwise indicated.
2. Provide raised fillets at backs of sills and at ends indicated to be built into jambs.
3. Provide drips on projecting elements unless otherwise indicated.

E. Fabrication Tolerances:

1. Variation in Cross Section: Do not vary from indicated dimensions by more than 1/8 inch (3 mm).
2. Variation in Length: Do not vary from indicated dimensions by more than 1/360 of the length of unit or 1/8 inch (3 mm), whichever is greater, but in no case by more than 1/4 inch (6 mm).
3. Warp, Bow, and Twist: Not to exceed 1/360 of the length of unit or 1/8 inch (3 mm), whichever is greater.
4. Location of Grooves, False Joints, Holes, Anchorages, and Similar Features: Do not vary from indicated position by more than 1/8 inch (3 mm) on formed surfaces of units and 3/8 inch (10 mm) on unformed surfaces.

F. Cure units as follows:

1. Cure units in enclosed moist curing room at 95 to 100 percent relative humidity and temperature of 100 deg F (38 deg C) for 12 hours or 70 deg F (21 deg C) for 16 hours.
2. Keep units damp and continue curing to comply with one of the following:

a. No fewer than five days at mean daily temperature of 70 deg F (21 deg C) or above.
b. No fewer than six days at mean daily temperature of 60 deg F (16 deg C) or above.
c. No fewer than seven days at mean daily temperature of 50 deg F (10 deg C) or above.
d. No fewer than eight days at mean daily temperature of 45 deg F (7 deg C) or above.

G. Acid etch units after curing to remove cement film from surfaces to be exposed to view.

H. Colors and Textures: [**Match Architect's samples**] [**Match existing units**] [**As selected by Architect from manufacturer's full range**].

I. Color and Texture: Provide units with fine-grained texture and buff color resembling Indiana limestone.

J. Color and Texture: Provide units with fine texture and red-brown color resembling brownstone on adjacent buildings.

2.3 MORTAR MATERIALS

A. Provide mortar materials that comply with Section 042000 "Unit Masonry."

B. Regional Materials: Aggregate for mortar[**, cement, and lime**] shall be manufactured within 500 miles (800 km) of Project site from materials that have been extracted, harvested, or recovered, as well as manufactured, within 500 miles (800 km) of Project site.

C. Portland Cement: ASTM C 150, Type I or II, except Type III may be used for cold-weather construction. Provide natural color or white cement as required to produce mortar color indicated.

D. Hydrated Lime: ASTM C 207, Type S.

E. Portland Cement-Lime Mix: Packaged blend of portland cement and hydrated lime containing no other ingredients.

F. Masonry Cement: ASTM C 91.

1. Products: Subject to compliance with requirements, [**provide the following**] [**provide one of the following**] [**available products that may be incorporated into the Work include, but are not limited to, the following**]:

a. Capital Materials Corporation; Flamingo Color Masonry Cement.
b. Cemex S.A.B. de C.V.; [**Brikset Type N**] [**Citadel Type S**] [**Dixie Type S**] [**Kosmortar Type N**] [**Richmortar**] [**Victor Plastic Cement**].
c. Essroc, Italcementi Group; [**Brixment**] [**or**] [**Velvet**].
d. Holcim (US) Inc.; [**Mortamix Masonry Cement**] [**Rainbow Mortamix Custom Buff Masonry Cement**] [**White Mortamix Masonry Cement**].
e. Lafarge North America Inc.; [**Lafarge Masonry Cement**] [**Magnolia Masonry Cement**] [**Trinity White Masonry Cement**].
f. Lehigh Cement Company; [**Lehigh Masonry Cement**] [**Lehigh White Masonry Cement**].
g. National Cement Company, Inc.; Coosa Masonry Cement.
h. <**Insert manufacturer's name; product name or designation**>.

G. Mortar Cement: ASTM C 1329.

1. Products: Subject to compliance with requirements, [**provide the following**] [**provide one of the following**] [**available products that may be incorporated into the Work include, but are not limited to, the following**]:

a. Lafarge North America Inc.; [**Lafarge Mortar Cement**] [**or**] [**Magnolia Superbond Mortar Cement**].

b. <**Insert manufacturer's name; product name or designation**>.

H. Mortar Pigments: Natural and synthetic iron oxides and chromium oxides, compounded for use in mortar mixes and complying with ASTM C 979. Use only pigments with a record of satisfactory performance in masonry mortar.

1. Products: Subject to compliance with requirements, [**provide the following**] [**provide one of the following**] [**available products that may be incorporated into the Work include, but are not limited to, the following**]:

a. Davis Colors; True Tone Mortar Colors.
b. Lanxess Corporation; Bayferrox Iron Oxide Pigments.
c. Solomon Colors, Inc.; SGS Mortar Colors.
d. <**Insert manufacturer's name; product name or designation**>.

I. Colored Cement Product: Packaged blend made from [**portland cement and hydrated lime**] [**masonry cement**] [**or**] [**mortar cement**] and mortar pigments, all complying with specified requirements and containing no other ingredients.

1. Colored Portland Cement-Lime Mix:

a. Products: Subject to compliance with requirements, [**provide the following**] [**provide one of the following**] [**available products that may be incorporated into the Work include, but are not limited to, the following**]:

1) Capital Materials Corporation; Riverton Portland Cement Lime Custom Color.
2) Holcim (US) Inc.; Rainbow Mortamix Custom Color Cement/Lime.
3) Lafarge North America Inc.; Eaglebond Portland & Lime.
4) Lehigh Cement Company; Lehigh Custom Color Portland/Lime Cement.
5) <**Insert manufacturer's name; product name or designation**>.

2. Colored Masonry Cement:

a. Products: Subject to compliance with requirements, [**provide the following**] [**provide one of the following**] [**available products that may be incorporated into the Work include, but are not limited to, the following**]:

1) Capital Materials Corporation; Flamingo Color Masonry Cement.
2) Cemex S.A.B. de C.V.; Richcolor Masonry Cement.
3) Essroc, Italcementi Group; Brixment-in-Color.
4) Holcim (US) Inc.; Rainbow Mortamix Custom Color Masonry Cement.
5) Lafarge North America Inc.; U.S. Cement Custom Color Masonry Cement.
6) Lehigh Cement Company; Lehigh Custom Color Masonry Cement.
7) National Cement Company, Inc.; Coosa Masonry Cement.
8) <**Insert manufacturer's name; product name or designation**>.

3. Formulate blend as required to produce color indicated or, if not indicated, as selected from manufacturer's standard colors.
4. Pigments shall not exceed 10 percent of portland cement by weight.

5. Pigments shall not exceed 5 percent of [**masonry cement**] [**or**] [**mortar cement**] by weight.

J. Aggregate for Mortar: ASTM C 144.

1. For mortar that is exposed to view, use washed aggregate consisting of natural sand or crushed stone.
2. For joints less than 1/4 inch (6 mm) thick, use aggregate graded with 100 percent passing the No. 16 (1.18-mm) sieve.
3. White-Mortar Aggregates: Natural white sand or crushed white stone.
4. Colored-Mortar Aggregates: Natural sand or crushed stone of color necessary to produce required mortar color.

K. Water: Potable.

2.4 ACCESSORIES

A. Anchors: Type and size indicated, fabricated from [**Type 304 stainless steel complying with ASTM A 240/A 240M, ASTM A 276, or ASTM A 666**] [**steel complying with ASTM A 36/A 36M, and hot-dip galvanized to comply with ASTM A 123/A 123M**].

B. Dowels: 1/2-inch- (12-mm-) diameter, round bars, fabricated from [**Type 304 stainless steel complying with ASTM A 240/A 240M, ASTM A 276, or ASTM A 666**] [**steel complying with ASTM A 36/A 36M, and hot-dip galvanized to comply with ASTM A 123/A 123M**].

C. Proprietary Acidic Cleaner: Manufacturer's standard-strength cleaner designed for removing mortar/grout stains, efflorescence, and other new construction stains from new masonry without discoloring or damaging masonry surfaces. Use product expressly approved for intended use by cast stone manufacturer and expressly approved by cleaner manufacturer for use on cast stone and adjacent masonry materials.

1. Manufacturers: Subject to compliance with requirements, [**provide products by one of the following**] [**available manufacturers offering products that may be incorporated into the Work include, but are not limited to, the following**]:

a. Diedrich Technologies, Inc.
b. EaCo Chem, Inc.
c. ProSoCo, Inc.
d. <**Insert manufacturer's name**>.

2.5 MORTAR MIXES

A. Comply with requirements in Section 042000 "Unit Masonry" for mortar mixes.

B. Do not use admixtures including pigments, air-entraining agents, accelerators, retarders, water-repellent agents, antifreeze compounds, or other admixtures unless otherwise indicated.

1. Do not use calcium chloride in mortar or grout.

2. Use [**portland cement-lime**] [**masonry cement**] [**or**] [**mortar cement**] mortar unless otherwise indicated.

C. Comply with ASTM C 270, Proportion Specification.

1. For setting mortar, use [**Type S**] [**Type N**].
2. For pointing mortar, use [**Type N**] [**Type O**].

D. Pigmented Mortar: Use colored cement product[**or select and proportion pigments with other ingredients to produce color required. Do not add pigments to colored cement products**].

1. Pigments shall not exceed 10 percent of portland cement by weight.
2. Pigments shall not exceed 5 percent of [**masonry cement**] [**or**] [**mortar cement**] by weight.
3. Mix to match Architect's sample.
4. Application: Use pigmented mortar for exposed mortar joints.

E. Colored-Aggregate Mortar: Produce required mortar color by using colored aggregates and natural color or white cement as necessary to produce required mortar color.

1. Mix to match Architect's sample.
2. Application: Use colored aggregate mortar for exposed mortar joints.

2.6 SOURCE QUALITY CONTROL

A. Engage a qualified independent testing agency to sample and test cast stone units according to ASTM C 1364.

1. Include one test for resistance to freezing and thawing.

PART 3 - EXECUTION

3.1 EXAMINATION

A. Examine substrates and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work.

B. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 SETTING CAST STONE IN MORTAR

A. Install cast stone units to comply with requirements in Section 042000 "Unit Masonry."

B. Set cast stone as indicated on Drawings. Set units accurately in locations indicated with edges and faces aligned according to established relationships and indicated tolerances.

1. Install anchors, supports, fasteners, and other attachments indicated or necessary to secure units in place.
2. Coordinate installation of cast stone with installation of flashing specified in other Sections.

C. Wet joint surfaces thoroughly before applying mortar or setting in mortar.

D. Set units in full bed of mortar with full head joints unless otherwise indicated.

1. Set units with joints [**1/4 to 3/8 inch (6 to 10 mm)**] [**3/8 to 1/2 inch (10 to 13 mm)**] <**Insert dimension**> wide unless otherwise indicated.
2. Build anchors and ties into mortar joints as units are set.
3. Fill dowel holes and anchor slots with mortar.
4. Fill collar joints solid as units are set.
5. Build concealed flashing into mortar joints as units are set.
6. Keep head joints in coping and other units with exposed horizontal surfaces open to receive sealant.
7. Keep joints at shelf angles open to receive sealant.

E. Rake out joints for pointing with mortar to depths of not less than 3/4 inch (19 mm). Rake joints to uniform depths with square bottoms and clean sides. Scrub faces of units to remove excess mortar as joints are raked.

F. Point mortar joints by placing and compacting mortar in layers not greater than 3/8 inch (10 mm). Compact each layer thoroughly and allow it to become thumbprint hard before applying next layer.

G. Tool exposed joints slightly concave when thumbprint hard, using a jointer larger than joint thickness unless otherwise indicated.

H. Provide sealant joints at copings and other horizontal surfaces, at expansion, control, and pressure-relieving joints, and at locations indicated.

1. Keep joints free of mortar and other rigid materials.
2. Build in compressible foam-plastic joint fillers where indicated.
3. Form joint of width indicated, but not less than [**3/8 inch (10 mm)**] [**1/2 inch (13 mm)**] <**Insert dimension**>.
4. Prime cast stone surfaces to receive sealant and install compressible backer rod in joints before applying sealant unless otherwise indicated.
5. Prepare and apply sealant of type and at locations indicated to comply with applicable requirements in Section 079200 "Joint Sealants."

3.3 SETTING ANCHORED CAST STONE WITH SEALANT-FILLED JOINTS

A. Set cast stone as indicated on Drawings. Set units accurately in locations indicated with edges and faces aligned according to established relationships and indicated tolerances.

1. Install anchors, supports, fasteners, and other attachments indicated or necessary to secure units in place.

2. Shim and adjust anchors, supports, and accessories to set cast stone in locations indicated with uniform joints.

B. Keep cavities open where unfilled space is indicated between back of cast stone units and backup wall; do not fill cavities with mortar or grout.

C. Fill anchor holes with sealant.

1. Where dowel holes occur at pressure-relieving joints, provide compressible material at ends of dowels.

D. Set cast stone supported on clip or continuous angles on resilient setting shims. Use material of thickness required to maintain uniform joint widths. Hold shims back from face of cast stone a distance at least equal to width of joint.

E. Keep joints free of mortar and other rigid materials. Remove temporary shims and spacers from joints after anchors and supports are secured in place and cast stone units are anchored. Do not begin sealant installation until temporary shims and spacers are removed.

1. Form open joint of width indicated, but not less than [**3/8 inch (10 mm)**] [**1/2 inch (13 mm)**] <**Insert dimension**>.

F. Prime cast stone surfaces to receive sealant and install compressible backer rod in joints before applying sealant unless otherwise indicated.

G. Prepare and apply sealant of type and at locations indicated to comply with applicable requirements in Section 079200 "Joint Sealants."

3.4 INSTALLATION TOLERANCES

A. Variation from Plumb: Do not exceed 1/8 inch in 10 feet (3 mm in 3 m), 1/4 inch in 20 feet (6 mm in 6 m), or 1/2 inch (12 mm) maximum.

B. Variation from Level: Do not exceed 1/8 inch in 10 feet (3 mm in 3 m), 1/4 inch in 20 feet (6 mm in 6 m), or 1/2 inch (12 mm) maximum.

C. Variation in Joint Width: Do not vary joint thickness more than 1/8 inch in 36 inches (3 mm in 900 mm) or one-fourth of nominal joint width, whichever is less.

D. Variation in Plane between Adjacent Surfaces (Lipping): Do not vary from flush alignment with adjacent units or adjacent surfaces indicated to be flush with units by more than 1/16 inch (1.5 mm), except where variation is due to warpage of units within tolerances specified.

3.5 ADJUSTING AND CLEANING

A. Remove and replace stained and otherwise damaged units and units not matching approved Samples. Cast stone may be repaired if methods and results are approved by Architect.

B. Replace units in a manner that results in cast stone matching approved Samples, complying with other requirements, and showing no evidence of replacement.

C. In-Progress Cleaning: Clean cast stone as work progresses.

1. Remove mortar fins and smears before tooling joints.
2. Remove excess sealant immediately, including spills, smears, and spatter.

D. Final Cleaning: After mortar is thoroughly set and cured, clean exposed cast stone as follows:

1. Remove large mortar particles by hand with wooden paddles and nonmetallic scrape hoes or chisels.
2. Test cleaning methods on sample; leave one sample uncleaned for comparison purposes. Obtain Architect's approval of sample cleaning before proceeding with cleaning of cast stone.
3. Protect adjacent surfaces from contact with cleaner by covering them with liquid strippable masking agent or polyethylene film and waterproof masking tape.
4. Wet surfaces with water before applying cleaners; remove cleaners promptly by rinsing thoroughly with clear water.
5. Clean cast stone by bucket-and-brush hand-cleaning method described in BIA Technical Notes 20.
6. Clean cast stone with proprietary acidic cleaner applied according to manufacturer's written instructions.

END OF SECTION 047200