



ARCHITECTURAL CAST STONE

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CSI, APA and IDOT Certified www.ACSGreenStone.com

CONCRETE STANDARDS

February 23, 2015

The specifications listed below are met by all mix designs manufactured by Architectural Cast Stone. These test procedures were developed using ASTM/PCI MNL-117 and PCI MNL 130 methods. The test results are kept for (2) years and are available upon customer request. Additional tests are performed on a periodic basis to insure the quality of our precast is maintained.

Our suppliers are also required to provide us with test results from the raw materials that have been provided to us. ASTM/PCI MNL-117/IDOT/CDOT requirements are used as a guideline upon accepting raw materials.

SECTION 3450- PRECAST ARCHITECTURAL CONCRETE

(Compliant with ACI 318(M), PCI MNL-117)

AIR	6-8 % (Severe Weather) (ACI-533R)
WATER ABSORPTION	6 % Max. (ASTM C-642, By Weight)
STRENGTH	5000 PSI Min. (ASTM C-39, 28 Day)
SLUMP	2 ½ - 3 inches
FREEZE-THAW	<5% (ASTM C-666)
CEMENT	Per ASTM C-150

SECTION 4720- CAST STONE

(Compliant with ASTM-1364)

AIR	6-8 % (Severe Weather) (ASTM C-231)
WATER ABSORPTION	6 % Max. (ASTM C-1195, By Weight)
STRENGTH	6500 PSI Min. (ASTM C-1194, 28 Day)
SLUMP	2 ½ - 3 inches
FREEZE-THAW	<5% (ASTM C-666)
LINEAR SHRINKAGE	0.065% Max. (ASTM C-426)

SECTION 3455- GLASS FIBER REINFORCED CONCRETE (GFRC) UNITS

(Compliant with PCI MNL 130 the manual for Quality Control for Glass Fiber Reinforced Concrete Products)

CEMENT	ASTM C-150 Type I or Type III
WATER	Potable (> .35 water to cement ratio).
AGGREGATES	Fine sand (< # 16 sieve)
ACRYLIC COPOLYMER	Compliance with Appendix G of PCI MNL 130(FORTON V-774)
COLOR	If applicable, conforming to ASTM C-979
GLASS FIBER	Compliant to PCI "Recommended practices for Glass Fiber Reinforced Concrete Products"

GRANITE CAST™ - CEMENTATIOUS BASED CAST GRANITE

AIR	6 – 8% (Severe Weather – ASTM C-231
WATER ABSORPTION	6% Max (ASTM C-1195, by Weight)
STRENGTH	6500 PSI Min. (ASTM C-1194, 28 Day)
FREEZE THAW	<5% (ASTM C-666)
CEMENT	Per ASTM C-150 Type I or Type III
COLOR	If applicable, conforming to ASTM C-979
WATER	Potable (> .40 Water to Cement)
LINEAR SHRINKAGE	0.065% Max. (ASTM C-426)

SECTION 4720- CAST STONE(COPOLYMER ENHANCED)

(Compliant with ASTM-1364)

AIR	6-8 % (Severe Weather) (ASTM C-231)
WATER ABSORPTION	<6 % (ASTM C-1195, By Weight)
STRENGTH	6500 PSI Min. (ASTM C-1194, 28 Day)
SLUMP	2 ½ - 3 inches
FREEZE-THAW	<5% (ASTM C-666)
LINEAR SHRINKAGE	0.065% Max. (ASTM C-426)
COPOLYMER	DUOMATRIX-C