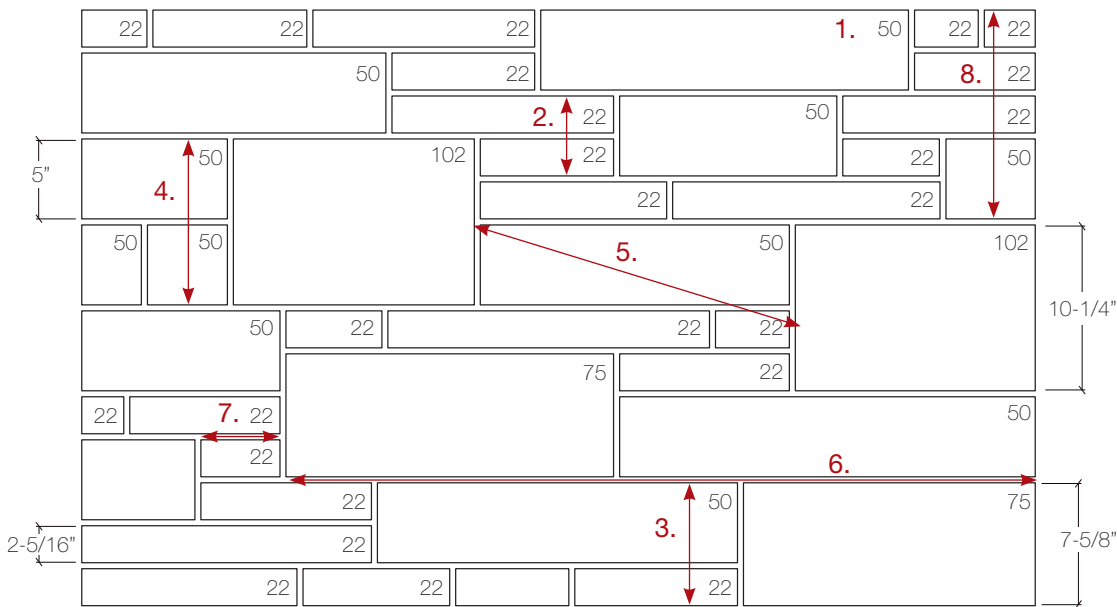


# 4-Unit Shadow Stone™ Building Stone

Typical Elevation • 30:40:20:10 Bond • 3/8" Mortar Joints



## Guidelines for Installation:

1. 50s can be either SHA50 or EDG50.
2. Two SHA22 units laid on top of each other will bond with one SHA50/EDG50.
3. A SHA22 and SHA50/EDG50 combination will bond with one SHA75S.
4. Two SHA50/EDG50 units laid on top of each other will bond with one EDG102.
5. To maintain the standard ratio of sizes in the wall, EDG102 units should be placed approximately 2' apart. EDG102 units should not touch each other.
6. Maximum 5 to 6 foot horizontal joint length depending on wall dimensions.
7. Minimum 4" overlap of vertical joints.
8. Vertical joints are generally formed with a combination of three units. Maximum vertical joint is 10-1/4".

## Avoid:

- Stepping or stringing together more than 2 units of the same height.
- Creating box patterns in the wall.
- Stack bonding.

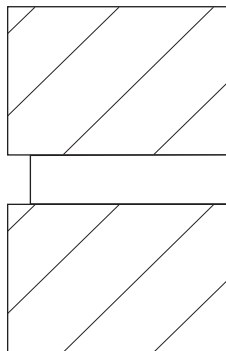
Size	Pieces* per 32 sq. ft.	Nominal Length of one Piece
SHA22	22	24"
SHA50*/ EDG50	11	32" / 24"
SHA75S	5	24"
EDG102	2	24"

\*One piece of Building Stone may be comprised of 2 or more pieces.

# General Installation Guidelines

- Arriscraft recommends the use of a Portland cement-lime mortar, proportioned to a 1:1:6 ratio.
- Masonry units should be laid with full head and bed joints except where they are used for weep holes or ventilation.
- Bevel mortar from rear face to prevent protrusion into cavity.
- Prevent excessive mortar droppings by cutting off excess mortar with trowel as the units are laid.
- Butter head joints of unit being placed in wall.
- Place unit to tightly compress mortar.
- Do not re-adjust unit once it has been set in place.
- Tool joints when mortar is thumbprint hard. This timing will depend on the mortar properties and weather conditions.
- Tool joints to a tightly compressed surface to achieve the most weather resistance. Concave tooled joints provide the best resistance to moisture penetration.
- After tooling, any excess mortar and dust should be brushed from the masonry surface using a soft bristle brush. Avoid rubbing or pressing the mortar into the units.
- Refer to additional guidelines on the BASIC CARE sheet.

## Joint Profile:



Raked