

### PRODUCT DESCRIPTION

**BASIC USE** - A calcium silicate building stone unit used in full-bed masonry veneer construction for both interior and exterior applications. For residential, commercial and institutional applications.

**COMPOSITION AND MATERIALS** - Manufactured calcium silicate building stone units contain no Portland cement. They are pressure-formed and autoclave cured; resulting in high-density, severe weathering modular building stone units, with one or more finished faces. Refer to ARRISCRAFT•NOTE – Calcium Silicate Masonry Units for further information. They may be site cut, trimmed and finished to custom lengths, shapes or sizes, as necessitated by site conditions.

**SHAPES AND SIZES** - Arriscraft Building Stone products are available in a variety of standard sizes.

### CAMBRIDGE PRODUCED BUILDING STONE

	CODE	HEIGHT	LENGTH	BED
Citadel® Building Stone	CIT23	60 mm (2-3/8")	Random	92 mm (3-5/8")
	CIT36	97 mm (3-13/16")	Random	92 mm (3-5/8")
	CIT52	133 mm (5-1/4")	Random	90 mm (3-1/2")
	CIT81	203 mm (8-1/8")	Random	90 mm (3-1/2")
	OLD11	279 mm (11")	Random	90 mm (3-1/2")
Edge Rock Building Stone	EDG50	125 mm (4-15/16")	Random	90 mm ± 13 mm (3-1/2" ± 1/2")
	EDG102	260 mm (10-1/4")	Random	90 mm ± 13 mm (3-1/2" ± 1/2")
Fresco Building Stone	FRE23	60 mm (2-3/8")	Random	92 mm (3-5/8")
	FRE36	97 mm (3-13/16")	Random	92 mm (3-5/8")
	FRE52	133 mm (5-1/4")	Random	90 mm (3-1/2")
	FRE81	206 mm (8-1/8")	Random	90 mm (3-1/2")
Laurier Building Stone	LAU23	60 mm (2-3/8")	Up to 600 mm (23-5/8")	95 mm (3-3/4")
	LAU52	133 mm (5-1/4")	Up to 600 mm (23-5/8")	90 mm (3-1/2")
	LAU81	206 mm (8-1/8")	Up to 600 mm (23-5/8")	90 mm (3-1/2")
	LAU11	279 mm (11")	Up to 600 mm (23-5/8")	90 mm (3-1/2")
Metropolitan Building Stone	MET20	49 mm (1-15/16")	Up to 803 mm (31-5/8")	92 mm (3-5/8")
	MET42	108 mm (4-1/4")	Up to 803 mm (31-5/8")	92 mm (3-5/8")
	MET64	165 mm (6-1/2")	Up to 803 mm (31-5/8")	92 mm (3-5/8")
Shadow Stone® Building Stone	SHA22	59 mm (2-5/16")	Up to 600 mm (23-5/8")	92 mm ± 6 mm (3-5/8" ± 1/4")
	SHA50	127 mm (5")	Up to 803 mm (31-5/8")	83 mm ± 6 mm (3-1/4" ± 1/4")
	SHA75S	194 mm (7-5/8")	Up to 600 mm (23-5/8")	86 mm ± 6 mm (3-3/8" ± 1/4")
Urban Ledgestone	UL22	59 mm (2-5/16")	Up to 771.5 mm (30-3/8")	90 mm (3-1/2")
	UL35	92 mm (3-5/8")	Up to 771.5 mm (30-3/8")	90 mm (3-1/2")
	UL50	127 mm (5")	Up to 803 mm (31-5/8")	90 mm (3-1/2")

Shipped material also includes a percentage of shorter random length units which can be used by the installer in creating the ashlar bond patterns and around openings and at internal corners. Contact your local Arriscraft representative or dealer for additional information.

**TOLERANCES** - Arriscraft Building Stone products are fabricated to a tolerance of ±3 mm (1/8"). Split, rocked, or tumbled units, by the nature of their random finish, may have dimensional variations exceeding this value. Units shall exhibit a texture approximately equal to the approved sample when viewed under diffused daylight illumination at a 6 Metre (20 foot) distance. Minor chipping resulting from shipment and delivery shall not be grounds for rejection. Minor chips shall not be obvious under diffused daylight illumination from a 6 Metre (20 foot) distance.

**LIMITATIONS** - Manufactured masonry products are generally intended for above grade installations. All manufactured masonry units, regardless of their composition, are inherently absorptive, and none are intended for use below grade. Units installed below grade will wick

moisture from the soil that is in contact with the masonry units and create a condition known as "rising damp" in the masonry veneer.

In colder climates, masonry walls at grade may become exposed to de-icing compounds. Like all types of manufactured masonry units, calcium silicate masonry units should not be installed where they will be directly exposed to de-icing compounds used to melt snow and ice from pavements. For information about installing masonry at grade refer to the "At Grade Design Ideas" brochure. The function of caps and copings is to prevent moisture from entering the building envelope through the top of the wall. As most manufactured masonry units are produced in relatively short lengths, if they are used as a cap or coping material, more mortar joints are required between the individual units. These mortar joints are the most likely entry point for moisture to infiltrate the building envelope. As such, it is generally recommended within the industry that longer components, such as quarried stone or metal parapet cap flashing, be used to reduce the number of joints thereby limiting the areas that may allow moisture infiltration of the building envelope.

**FINISHES** - Standard surface finishes for each Building Stone product include sandblasted, split, rocked and tumbled in various combinations.

**COLOURS** - Standard colours for each of the Building Stone products are as follows:

- Citadel®: Algonquin, Desert Brown, Cashmere, Driftwood, French Country, Hickory (OLD11), Infinity, Manitoulin Mist, Montana Sand, Traditional Grey, Turret Buff (OLD11), Willow Breeze
- Edge Rock: Delta, Glacier
- Fresco: Eclipse, Silverado, Twilight
- Laurier: Honey Brown (LAU81, 11), Ivory White, Mahogany, Maple Sugar (LAU23,52), Mosaic Blend (LAU23, 52, 81), Walnut, Charcoal, Midnight Grey, Onyx (LAU23, 52), Opal
- Shadow Stone®: Avalanche, Collingwood, Driftwood, Sierra, Steel Grey, Tacoma
- Urban Ledgestone: Dusk, Frost
- Metropolitan: Greyrock, Nutmeg, Oakmoss, White

Colours within each product group may be blended in a wall to achieve a more natural appearance. Information pertaining to common colour blends for each product line is available upon request. Not all colours within a product group are available in all sizes. Contact Arriscraft for a detailed listing of colours and sizes available. Custom colours are also available on a minimum order basis. As a manufactured product, Arriscraft Building Stone products are monitored for colour consistency. Slight variations between batches may occur, and it is recommended that the installer mix units from different skids during installation.

Consultants should review samples prior to selecting a particular colour and finish.

### TECHNICAL DATA

**APPLICABLE STANDARDS** - Required properties for calcium silicate masonry units are described in ASTM C73, Standard Specification for Calcium Silicate Face Brick (Sand-Lime Brick). This standard classifies calcium silicate products as either moderate-weathering or severe-weathering depending on the material's tested physical properties of compressive strength and 24-hour absorption.

Calcium Silicate Building Stone products meet the requirements of this standard.

## INSTALLATION

**DELIVERY** - Arriscraft Building Stone products are delivered to the site in protective packaging.

**HANDLING** - Lift skids with proper and sufficiently long slings or forks with protection to prevent damage to units. Protect edges and corners. Storage - Store Arriscraft Building Stone products in a manner designed to prevent damage and staining of units. Stack units on timbers or platforms at least 76 mm (3") above grade. Place polyethylene or other plastic film between wood and other finished surfaces of units when stored for extended periods of time. Stored units should be covered if exposed to extreme weather conditions.

Do not use de-icing compounds to remove ice from masonry surfaces.

**Preparatory Work** - It may be advantageous under hot, dry weather or windy conditions to pre-dampen the units prior to placement in the wall. Damp units should be surface dry at the time of placement.

For additional information when constructing in hot or cold weather refer to the ARRISCRAFT•TECH bulletins titled Hot Weather Masonry Construction and Cold Weather Masonry Construction.

**INSTALLATION** - Arriscraft Building Stone products must be installed using approved materials and techniques for each specific installation. Construct masonry veneer with an adequate number of elastic movement joints, properly located to accommodate differential movement. Refer to ARRISCRAFT•NOTE – Building Movement Joints for further information.

Construct masonry veneer in accordance with [CSA A371-94: Masonry Construction for Buildings](#), and any local requirements stipulated by the authorities having jurisdiction.

Mortar joints between units in any direction should be consistent to the following thicknesses:

- Citadel®: 13mm (1/2")
- Edge Rock: 10 mm (3/8")
- Fresco: 13mm (1/2")
- Laurier: 13mm (1/2")
- Shadow Stone®: 10 mm (3/8")
- Urban LedgeStone: 10 mm (3/8")
- Metropolitan: 10 mm (3/8")

Mortar for unit masonry veneer should be a Type N Portland cement-lime mix, proportioned to a 1:1:6 ratio.

- 1 part Portland cement (CSA A3001, Type GU)
- 1 part hydrated lime (CSA C207, Type S - Special); and
- 6 parts masonry sand (CSA A179-14)

When properly combined with the appropriate quantity of water, it will produce a general-purpose mortar, exhibiting good workability and board life in its plastic state, and good durability and flexibility in its hardened state; and conforming to CSA A179-14 - Mortar and Grout for Unit Masonry. For Further information, refer to ARRISCRAFT•NOTE – Mortar for Masonry Veneer.

Project specific considerations may necessitate the use of other mixes at the designer's discretion. For applications where flexural strength is of particular importance to the design, consult with our Technical Services Department for further recommendations.

Arriscraft recommends constructing masonry veneer with proper drainage mechanisms, including clear draining air spaces, through wall flashing membranes and weep hole vents. The air spaces must be at least 25 mm (1") wide, and kept clear of debris, protrusions, mortar fins and droppings. Weep hole vents should be installed at the same level as through wall flashing membranes and spaced not more than 610 mm (24") on centre horizontally. Refer to ARRISCRAFT•NOTE – Moisture Management for further information.

Arriscraft Building Stone products must be connected to a structural substrate with an approved masonry connection system, designed by the consultant for each specific installation. Refer to ARRISCRAFT•NOTE – Connectors – Part I, Masonry Ties.

**BOND PATTERNS** - Arriscraft Building Stone products are each installed using different bonding patterns. These are typically described as a percentage ratio, from the smallest to the largest sized units, as follows:

- Citadel® Building Stone: • 3-Unit Bond: 20:40:40 • 4-Unit Bond: 20:20:40:20 • 5-Unit Bond: 10:20:40:20:10
- Edge Rock Building Stone: • 2-Unit Bond: 75:25
- Fresco Building Stone: • 3-Unit Bond: 20:40:40 • 4-Unit Bond: 20:20:40:20
- Laurier Building Stone: • 3-Unit Bond: 20:50:30 • 4-Unit Bond: 15:40:30:15
- Shadow Stone®: • 2-Unit Bond: 70:30 • 3-Unit Bond: 20:50:30
- Urban LedgeStone: • 3-Unit Coursed Bond: 20:30:50 • 3-Unit Ashlar Bond: 20:50:30
- Metropolitan: 3-Unit Coursed Bond: 17:33:50 • 3-Unit Ashlar Bond: 20:50:30

Refer to the ARRISCRAFT•CADD sample details for illustrations of each recommended bond pattern.

Standard bond patterns may also be modified by changing the ratio of small to large units. Contact your local Arriscraft representative or dealer for specific information on custom bond patterns.

## AVAILABILITY AND COST

**AVAILABILITY** Arriscraft Building Stone products are available throughout the continental United States, as full-bed masonry units. Delivery times for orders will vary based on the complexity of what is required. Arriscraft cannot be responsible for delays due to fire, acts of God, or any other cause beyond its control or which could not be reasonably foreseen.

Contact Arriscraft for a list of dealers in your area.

**COST** Quoted on a project basis for job-specific manufacturing to project requirement.

## WARRANTY

Arriscraft warrants its products against deterioration for the life of the building, provided the products have been erected and used according to accepted masonry standards, within the guidelines of local building codes and as recommended by the manufacture.

Complete warranty information is outlined on the Arriscraft standard form of Product Warranty.

## MAINTENANCE

Arriscraft Building Stone products should have excess mortar removed from their faces by brushing as they are placed within the wall at the point of tooling.

Clean Building Stone in accordance with the cleaning guidelines in ARRISCRAFT•CARE. Various masonry detergents and cleaning systems can change the colour of masonry products. Acid-based cleaning agents will darken the colour of the masonry units.

Always pre-test cleaning agents and methods on the job-site mock-up panel or a small inconspicuous area of the wall. The Consultant and/or Owner should approve the test area prior to the start of full-scale cleaning operations.

Refer to ARRISCRAFT•CARE – Cleaning Guidelines and ARRISCRAFT•NOTE – Cleaning Masonry for further information.

Arriscraft does not recommend the application of water repellent or graffiti-proofing sealers to its masonry products.

## TECHNICAL SERVICES

Arriscraft offers consultation services to assist with the preparation of details, specifications and with pricing. Enquiries are addressed promptly and without obligation.

Arriscraft distributes an integrated technical information system including:

- ARRISCRAFT•CADD are sample details which are available in .dwg, .dxf, and .pdf formats.
- ARRISCRAFT•DATA are product data sheets.
- ARRISCRAFT•NOTE are technical discussions with respect to building construction issues and
- ARRISCRAFT•SPEC are master guide specification sections.
- All of these technical resources are available to be downloaded from the Arriscraft web site at [www.arriscraft.com](http://www.arriscraft.com).

## RELATED REFERENCES

Arriscraft also makes available samples for colour and finish, coursing charts and copies of test reports upon request.

