

PRODUCT DESCRIPTION

BASIC USE - A stone masonry unit used for features, trim, ornamentation and facings. For residential, commercial and institutional applications.

COMPOSITION AND MATERIALS - Manufactured calcium silicate accessories contain no Portland cement. They are pressure-formed and autoclave cured; resulting in high-density, severe weathering modular accessories, 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.

ARRIS-cast are manufactured stone units fabricated from Portland cement, coarse and fine aggregates, granulated blast furnace slag, select admixtures and natural oxide pigments. The units are formed using the vibrant dry tamped (VDT) casting method, resulting in high-density, severe-weathering masonry units, with one or more finished faces. They may be site cut, trimmed and finished to custom lengths, shapes or sizes, as necessitated by site conditions.

SHAPES AND SIZES - Arriscraft Accessory products are available in a variety of standard shapes and sizes.

CAMBRIDGE PRODUCED ACCESSORIES

	CODE	HEIGHT	LENGTH	BED
Rocked Unit Sills	C236 813	2-3/8"	31-5/8"	6"
	C306 R	3-1/16"	31-5/8"	6"
	C406 R	3-5/8"	31-5/8"	5-5/8"
Keystones	KEY 10S	10-1/4"	8" x 6"	3-1/2"
	KEY 10R	10-1/4"	8" x 6"	3-1/2"
	KEY 12S	12-1/4"	8" x 6"	3-1/2"
	KEY 12R	12-1/4"	8" x 6"	3-1/2"
Quoins	QUO10A	10-1/4"	23-5/8"	3-1/2"
	QUO12A	12-1/4"	23-5/8"	3-1/2"
	QUO6A	5-7/8"	23-5/8"	3-1/2"

FORT VALLEY PRODUCED ACCESSORIES

	CODE	HEIGHT	LENGTH	BED
Rocked Unit Sills	GS315	3-1/8"	23-5/8"	5-1/2"
Keystones	KEY 7-5/8R	7-5/8"	6" x 4"	3-5/8"
	KEY 11-5/8R	11-5/8"	8-5/8" x 4"	3-5/8"
Address Stones	ADD 8 x 12	7-5/8"	11-5/8"	3-5/8"
	ADD 5 x 16	4-5/8"	15-5/8"	3-5/8"
	ADD 6 x 16	5-5/8"	15-5/8"	3-5/8"
	ADD 8 x 16	7-5/8"	15-5/8"	3-5/8"
Cast Stone Key-stones	7-5/8" Chamfered	7-5/8"	6" x 4"	3-5/8"
	10-1/4" Chamfered	10-1/4"	8" x 4"	3-5/8"
	11-5/8" Chamfered	11-5/8"	8-5/8" x 4"	3-5/8"
	7-5/8" Smooth	7-5/8"	6" x 4"	3-5/8"
	11-5/8" Smooth	11-5/8"	8-5/8" x 4"	3-5/8"

TOLERANCES - Arriscraft calcium silicate accessory products are fabricated to a tolerance of 1/8". Rocked units, by the nature of their random finish, may have dimensional variations exceeding this value.

ARRIS-cast keystones are fabricated to the following tolerances:

- Unit length: < L/260 or + 1/8", whichever is greater, with no single deviation greater than 1/4"
- Cross sectional dimensions: + 1/8"
- Warp, bow or twist: < L/360 or + 1/8", whichever is greater
- Locate of dowel holes, anchor slots, flashing grooves, false joints:
 - Formed sides: 1/8"
 - Unformed sides: 3/8"

Arriscraft Accessory products are fabricated to a tolerance of ±3 mm (1/8"). Rocked 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 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 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.

FINISHES - Standard surface finishes for each Accessory product include smooth and rocked, depending on the specific product type.

COLOURS - Cambridge accessory products are available in the White standard colour. Custom colours are also available on a minimum order basis.

Fort Valley standard colors for each of the accessory products are as follows:

- Cast Stone keystones: Brown, Gray, Tan, White
- Calcium silicate unit sills (GS315): Brown, Gray, Tan, White
- Calcium silicate address stones: Café, Limestone, Montecito, Suede
- Calcium silicate arches: Café, Limestone, Montecito, Suede
- Calcium silicate rocked unit sills: White

- Calcium silicate quoins: White

Custom colors are also available on a minimum order basis. As a manufactured product, Arriscraft accessory products are monitored for color consistency. Slight variations between batches may occur, and it is recommended that the installer mix units from different skids during installation.

Cast stone keystone color is intended to complement the corresponding calcium silicate color. We suggest evaluating pre-cleaned samples of all specified masonry materials prior to assessing color compatibility. Actual color and texture may vary slightly from production.

As a manufactured product, Arriscraft accessories are monitored for color 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 accessory products meet the requirements of this standard.

ARRIS.cast keystones meet the requirements of ASTM C1364, Standard Specifications for Architectural Cast Stone.

INSTALLATION

DELIVERY - Arriscraft accessory 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 accessory products in a manner designed to prevent damage and staining of units. Stack units on timbers or platforms at least 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 accessory 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 TMS 402-16, Building Code Requirements for Masonry Structures, and any local requirements stipulated by the authorities having jurisdiction.

Mortar joints between units in any direction should be 3/8" thick.

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

- 1 part Portland cement (ASTM C150, Type I);
- 1 part hydrated lime (ASTM C207, Type S - Special); and
- 6 parts masonry sand (ASTM C144).

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 ASTM C270-14 – Standard Specification for Mortar 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 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 24" on center horizontally. Refer to ARRISCRAFT•NOTE – Moisture Management for further information.

Arriscraft accessory 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.

AVAILABILITY AND COST

AVAILABILITY Arriscraft accessory products are available world-wide. 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 manufacturer. Complete warranty information is outlined on the Arriscraft standard form of Product Warranty.

MAINTENANCE

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

Clean accessory products 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.

RELATED REFERENCES

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

