

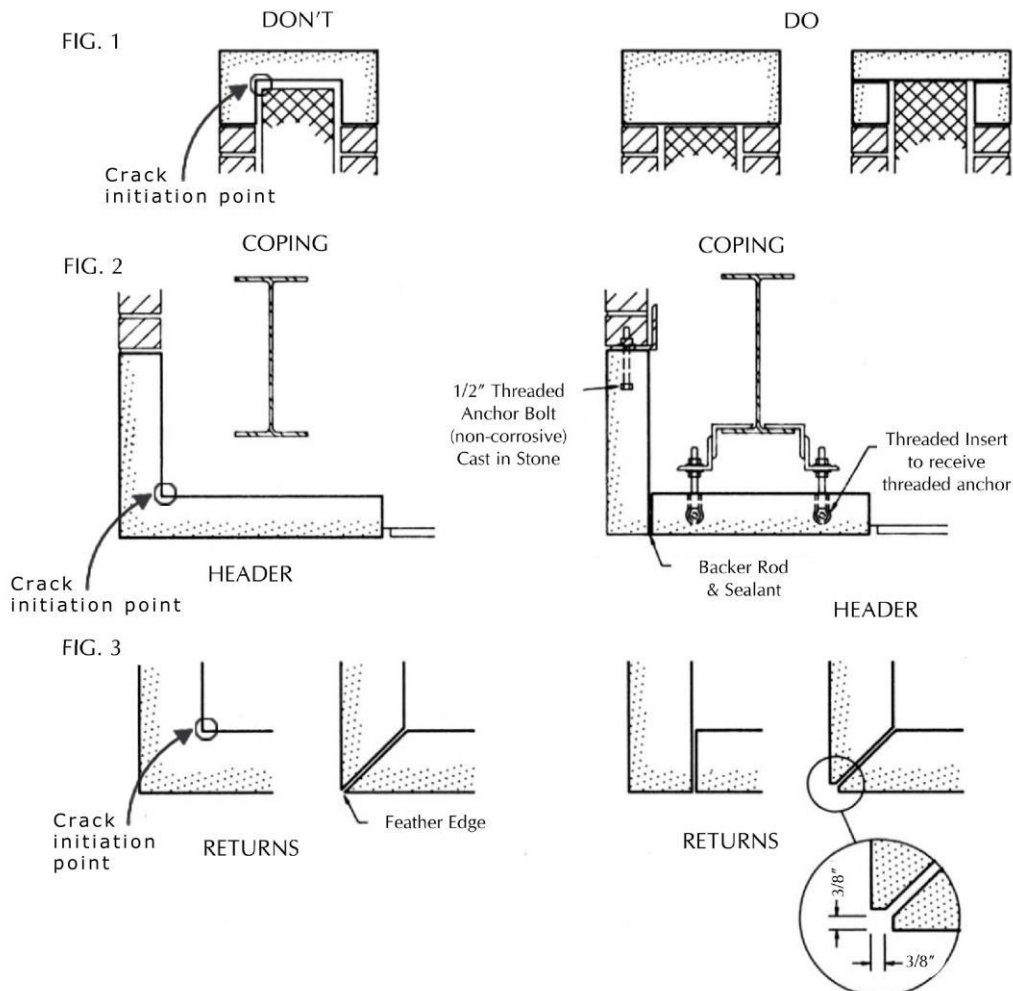
## “L” SHAPES, “U” SHAPES AND FEATHER EDGES

Moulds for manufacturing Cast Stone can be made from a wide variety of materials. The product is cast using either the Vibrant Dry Tamp or wet cast system. Regardless of the process used, a knowledge of the fundamentals of casting can benefit the building budget tremendously.

Nearly all shapes are cast face down in the mould. The mould creates five formed sides and one unformed back side. For maximum economy, the unformed side should be kept flat and left unexposed. L or U shape stones present casting problems and should be avoided whenever possible.

The coping section shown in Fig. 1 will cost more than either of the alternative sections shown due to more labor intense moulding, manufacturing, shipping and setting operations. Fig. 2 shows a header with a long vertical leg which will prohibit multiple daily castings when using the Vibrant Dry Tamp process and cause air voids in the wet cast process. Considerably less product could be packaged on a truckload using either method.

Fig. 3 illustrated the two best corner conditions; the butt joint and the quirk joint. The flat on a quirk must accommodate the largest aggregate used in the mix.



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