



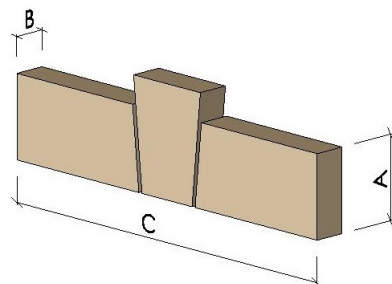
**Melton**<sup>TM</sup>  
**Classics**  
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*fine architectural millwork products*

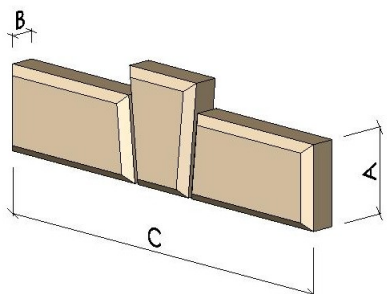
# MeltonStone<sup>TM</sup>

## Three Piece Jack Arches

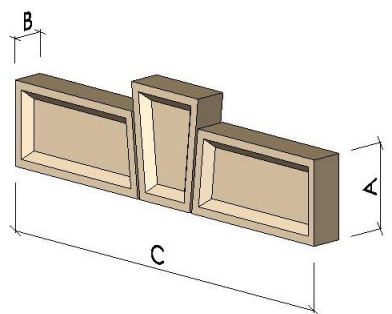
<b>PIECE MARK</b>	<b>A</b>	<b>B</b>	<b>C</b>
<b>20-05</b> (3 COURSE)	7 5/8"	3 5/8"	UP to 52 3/4"
<b>20-10</b> (3 COURSE)	7 5/8"	3 5/8"	UP to 72"
<b>20-15</b> (4 COURSE)	10 1/4"	3 5/8"	UP to 52 3/4"
<b>20-20</b> (4 COURSE)	10 1/4"	3 5/8"	UP to 72"
<b>20-25</b> (4 CRSE QUEEN)	12 3/8"	3 5/8"	UP to 52 3/4"
<b>20-30</b> (4 CRSE QUEEN)	12 3/8"	3 5/8"	UP to 72"
<b>20-35</b> (5 COURSE)	13"	3 5/8"	UP to 52 3/4"
<b>20-40</b> (5 COURSE)	13"	3 5/8"	UP to 72"



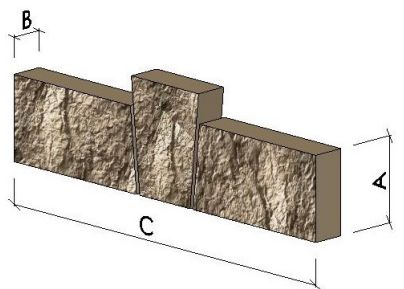
<b>PIECE MARK</b>	<b>A</b>	<b>B</b>	<b>C</b>
<b>21-05</b> (3 COURSE)	7 5/8"	3 5/8"	UP to 52 3/4"
<b>21-10</b> (3 COURSE))	7 5/8"	3 5/8"	UP to 72"
<b>21-15</b> (4 COURSE)	10 1/4"	3 5/8"	UP to 52 3/4"
<b>21-20</b> (4 COURSE)	10 1/4"	3 5/8"	UP to 72"
<b>21-25</b> (4 CRSE QUEEN)	12 3/8"	3 5/8"	UP to 52 3/4"
<b>21-30</b> (4 CRSE QUEEN)	12 3/8"	3 5/8"	UP to 72"
<b>21-35</b> (5 COURSE)	13"	3 5/8"	UP to 52 3/4"
<b>21-40</b> (5 COURSE)	13"	3 5/8"	UP to 72"



<b>PIECE MARK</b>	<b>A</b>	<b>B</b>	<b>C</b>
<b>22-05</b> (3 COURSE)	7 5/8"	3 5/8"	UP to 52 3/4"
<b>22-10</b> (3 COURSE)	7 5/8"	3 5/8"	UP to 72"
<b>22-15</b> (4 COURSE)	10 1/4"	3 5/8"	UP to 52 3/4"
<b>22-20</b> (4 COURSE)	10 1/4"	3 5/8"	UP to 72"
<b>22-25</b> (4 CRSE QUEEN)	12 3/8"	3 5/8"	UP to 52 3/4"
<b>22-30</b> (4 CRSE QUEEN)	12 3/8"	3 5/8"	UP to 72"
<b>22-35</b> (5 COURSE)	13"	3 5/8"	UP to 52 3/4"
<b>22-40</b> (5 COURSE)	13"	3 5/8"	UP to 72"



<b>PIECE MARK</b>	<b>A</b>	<b>B</b>	<b>C</b>
<b>23-05</b> (3 COURSE)	7 5/8"	3 5/8"	UP to 52 3/4"
<b>23-10</b> (3 COURSE)	7 5/8"	3 5/8"	UP to 72"
<b>23-15</b> (4 COURSE)	10 1/4"	3 5/8"	UP to 52 3/4"
<b>23-20</b> (4 COURSE)	10 1/4"	3 5/8"	UP to 72"
<b>23-25</b> (4 CRSE QUEEN)	12 3/8"	3 5/8"	UP to 52 3/4"
<b>23-30</b> (4 CRSE QUEEN)	12 3/8"	3 5/8"	UP to 72"
<b>23-35</b> (5 COURSE)	13"	3 5/8"	UP to 52 3/4"
<b>23-40</b> (5 COURSE)	13"	3 5/8"	UP to 72"





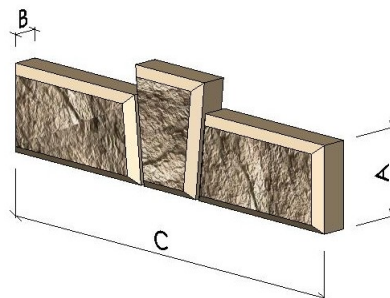
**Melton**<sup>TM</sup>  
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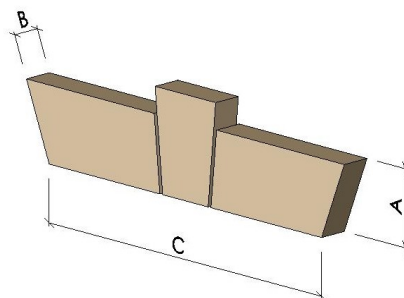
# MeltonStone<sup>TM</sup>

## Three Piece Jack Arches

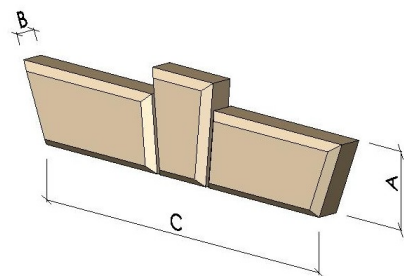
<b>PIECE MARK</b>	<b>A</b>	<b>B</b>	<b>C</b>
<b>24-05</b> (3 COURSE)	7 5/8"	3 5/8"	UP to 52 3/4"
<b>24-10</b> (3 COURSE)	7 5/8"	3 5/8"	UP to 72"
<b>24-15</b> (4 COURSE)	10 1/4"	3 5/8"	UP to 52 3/4"
<b>24-20</b> (4 COURSE)	10 1/4"	3 5/8"	UP to 72"
<b>24-25</b> (4 CRSE QUEEN)	12 3/8"	3 5/8"	UP to 52 3/4"
<b>24-30</b> (4 CRSE QUEEN)	12 3/8"	3 5/8"	UP to 72"
<b>24-35</b> (5 COURSE)	13"	3 5/8"	UP to 52 3/4"
<b>24-40</b> (5 COURSE)	13"	3 5/8"	UP to 72"



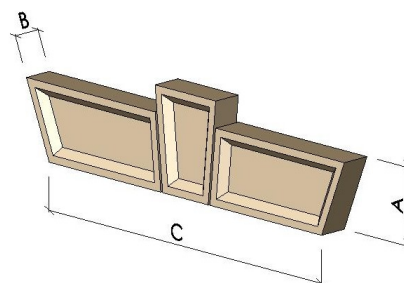
<b>PIECE MARK</b>	<b>A</b>	<b>B</b>	<b>C</b>
<b>25-05</b> (3 COURSE)	7 5/8"	3 5/8"	UP to 52 3/4"
<b>25-10</b> (3 COURSE)	7 5/8"	3 5/8"	UP to 72"
<b>25-15</b> (4 COURSE)	10 1/4"	3 5/8"	UP to 52 3/4"
<b>25-20</b> (4 COURSE)	10 1/4"	3 5/8"	UP to 72"
<b>25-25</b> (4 CRSE QUEEN)	12 3/8"	3 5/8"	UP to 52 3/4"
<b>25-30</b> (4 CRSE QUEEN)	12 3/8"	3 5/8"	UP to 72"
<b>25-35</b> (5 COURSE)	13"	3 5/8"	UP to 52 3/4"
<b>25-40</b> (5 COURSE)	13"	3 5/8"	UP to 72"



<b>PIECE MARK</b>	<b>A</b>	<b>B</b>	<b>C</b>
<b>26-05</b> (3 COURSE)	7 5/8"	3 5/8"	UP to 52 3/4"
<b>26-10</b> (3 COURSE)	7 5/8"	3 5/8"	UP to 72"
<b>26-15</b> (4 COURSE)	10 1/4"	3 5/8"	UP to 52 3/4"
<b>26-20</b> (4 COURSE)	10 1/4"	3 5/8"	UP to 72"
<b>26-25</b> (4 CRSE QUEEN)	12 3/8"	3 5/8"	UP to 52 3/4"
<b>26-30</b> (4 CRSE QUEEN)	12 3/8"	3 5/8"	UP to 72"
<b>26-35</b> (5 COURSE)	13"	3 5/8"	UP to 52 3/4"
<b>26-40</b> (5 COURSE)	13"	3 5/8"	UP to 72"



<b>PIECE MARK</b>	<b>A</b>	<b>B</b>	<b>C</b>
<b>27-05</b> (3 COURSE)	7 5/8"	3 5/8"	UP to 52 3/4"
<b>27-10</b> (3 COURSE)	7 5/8"	3 5/8"	UP to 72"
<b>27-15</b> (4 COURSE)	10 1/4"	3 5/8"	UP to 52 3/4"
<b>27-20</b> (4 COURSE)	10 1/4"	3 5/8"	UP to 72"
<b>27-25</b> (4 CRSE QUEEN)	12 3/8"	3 5/8"	UP to 52 3/4"
<b>27-30</b> (4 CRSE QUEEN)	12 3/8"	3 5/8"	UP to 72"
<b>27-35</b> (5 COURSE)	13"	3 5/8"	UP to 52 3/4"
<b>27-40</b> (5 COURSE)	13"	3 5/8"	UP to 72"





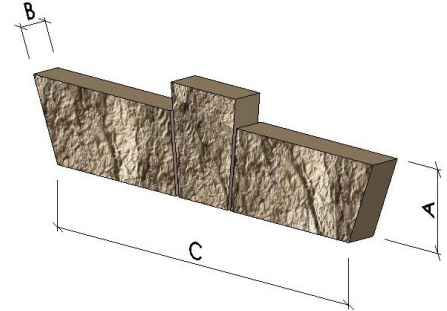
**Melton<sup>TM</sup> Classics**  
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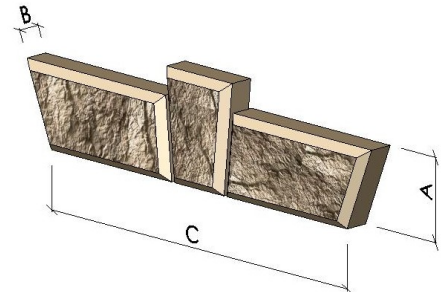
# MeltonStone<sup>TM</sup>

## Three Piece Jack Arches

<b>PIECE MARK</b>	<b>A</b>	<b>B</b>	<b>C</b>
<b>28-05</b> (3 COURSE)	7 5/8"	3 5/8"	UP to 52 3/4"
<b>28-10</b> (3 COURSE)	7 5/8"	3 5/8"	UP to 72"
<b>28-15</b> (4 COURSE)	10 1/4"	3 5/8"	UP to 52 3/4"
<b>28-20</b> (4 COURSE)	10 1/4"	3 5/8"	UP to 72"
<b>28-25</b> (4 CRSE QUEEN)	12 3/8"	3 5/8"	UP to 52 3/4"
<b>28-30</b> (4 CRSE QUEEN)	12 3/8"	3 5/8"	UP to 72"
<b>28-35</b> (5 COURSE)	13"	3 5/8"	UP to 52 3/4"
<b>28-40</b> (5 COURSE)	13"	3 5/8"	UP to 72"



<b>PIECE MARK</b>	<b>A</b>	<b>B</b>	<b>C</b>
<b>29-05</b> (3 COURSE)	7 5/8"	3 5/8"	UP to 52 3/4"
<b>29-10</b> (3 COURSE)	7 5/8"	3 5/8"	UP to 72"
<b>29-15</b> (4 COURSE)	10 1/4"	3 5/8"	UP to 52 3/4"
<b>29-20</b> (4 COURSE)	10 1/4"	3 5/8"	UP to 72"
<b>29-25</b> (4 CRSE QUEEN)	12 3/8"	3 5/8"	UP to 52 3/4"
<b>29-30</b> (4 CRSE QUEEN)	12 3/8"	3 5/8"	UP to 72"
<b>29-35</b> (5 COURSE)	13"	3 5/8"	UP to 52 3/4"
<b>29-40</b> (5 COURSE)	13"	3 5/8"	UP to 72"





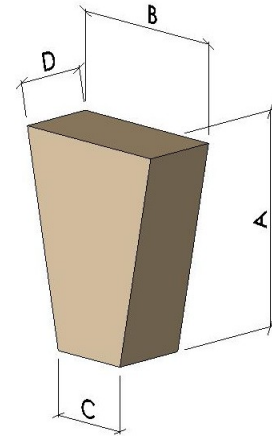
**Melton**<sup>TM</sup>  
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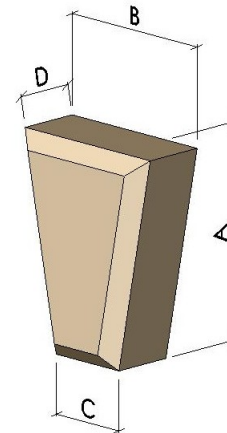
# MeltonStone<sup>TM</sup>

## Keystones

<b>PIECE MARK</b>	<b>A</b>	<b>B</b>	<b>C</b>	<b>D</b>
<b>01-05</b> (BABY)	4 1/8"	4"	2 1/4"	3 5/8"
<b>01-10</b> (BULLSEYE)	6 3/4"	6 5/8"	3"	3 5/8"
<b>01-15</b> (3 COURSE)	7 5/8"	6"	3"	3 5/8"
<b>01-20</b> (4 COURSE)	10 1/4"	8"	4"	3 5/8"
<b>01-25</b> (4 CRSE QUEEN)	12 3/8"	8"	4"	3 5/8"
<b>01-30</b> (5 COURSE)	13"	8 3/4"	4"	3 5/8"
<b>01-35</b> (6 COURSE)	15 5/8"	10"	6"	3 5/8"
<b>01-40</b>	4 1/8"	4"	2 1/4"	2"
<b>01-45</b>	6 3/4"	6 5/8"	3"	2"
<b>01-50</b>	7 5/8"	6"	3"	2"
<b>01-55</b>	10 1/4"	8"	4"	2"
<b>01-60</b>	13"	8 3/4"	4"	2"
<b>01-65</b>	15 5/8"	10"	6"	2"



<b>PIECE MARK</b>	<b>A</b>	<b>B</b>	<b>C</b>	<b>D</b>
<b>02-05</b> (BABY)	4 1/8"	4"	2 1/4"	3 5/8"
<b>02-10</b> (BULLSEYE)	6 3/4"	6 5/8"	3"	3 5/8"
<b>02-15</b> (3 COURSE)	7 5/8"	6"	3"	3 5/8"
<b>02-20</b> (4 COURSE)	10 1/4"	8"	4"	3 5/8"
<b>02-25</b> (4 CRSE QUEEN)	12 3/8"	8"	4"	3 5/8"
<b>02-30</b> (5 COURSE)	13"	8 3/4"	4"	3 5/8"
<b>02-35</b> (6 COURSE)	15 5/8"	10"	6"	3 5/8"
<b>02-40</b>	4 1/8"	4"	2 1/4"	2"
<b>02-45</b>	6 3/4"	6 5/8"	3"	2"
<b>02-50</b>	7 5/8"	6"	3"	2"
<b>02-55</b>	10 1/4"	8"	4"	2"
<b>02-60</b>	13"	8 3/4"	4"	2"
<b>02-65</b>	15 5/8"	10"	6"	2"





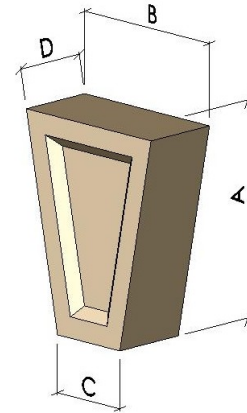
**Melton<sup>TM</sup>  
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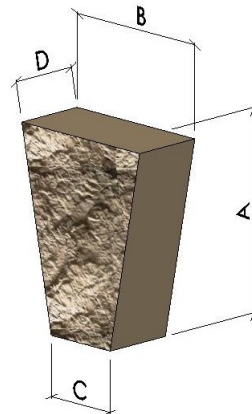
# MeltonStone<sup>TM</sup>

## Keystones

<b>PIECE MARK</b>	<b>A</b>	<b>B</b>	<b>C</b>	<b>D</b>
<b>03-05</b> (BABY)	4 1/8"	4"	2 1/4"	3 5/8"
<b>03-10</b> (BULLSEYE)	6 3/4"	6 5/8"	3"	3 5/8"
<b>03-15</b> (3 COURSE)	7 5/8"	6"	3"	3 5/8"
<b>03-20</b> (4 COURSE)	10 1/4"	8"	4"	3 5/8"
<b>03-25</b> (4 CRSE QUEEN)	12 3/8"	8"	4"	3 5/8"
<b>03-30</b> (5 COURSE)	13"	8 3/4"	4"	3 5/8"
<b>03-35</b> (6 COURSE)	15 5/8"	10"	6"	3 5/8"
<b>03-40</b>	4 1/8"	4"	2 1/4"	2"
<b>03-45</b>	6 3/4"	6 5/8"	3"	2"
<b>03-50</b>	7 5/8"	6"	3"	2"
<b>03-55</b>	10 1/4"	8"	4"	2"
<b>03-60</b>	13"	8 3/4"	4"	2"
<b>03-65</b>	15 5/8"	10"	6"	2"



<b>PIECE MARK</b>	<b>A</b>	<b>B</b>	<b>C</b>	<b>D</b>
<b>04-05</b> (BABY)	4 1/8"	4"	2 1/4"	3 5/8"
<b>04-10</b> (BULLSEYE)	6 3/4"	6 5/8"	3"	3 5/8"
<b>04-15</b> (3 COURSE)	7 5/8"	6"	3"	3 5/8"
<b>04-20</b> (4 COURSE)	10 1/4"	8"	4"	3 5/8"
<b>04-25</b> (4 CRSE QUEEN)	12 3/8"	8"	4"	3 5/8"
<b>04-30</b> (5 COURSE)	13"	8 3/4"	4"	3 5/8"
<b>04-35</b> (6 COURSE)	15 5/8"	10"	6"	3 5/8"
<b>04-40</b>	4 1/8"	4"	2 1/4"	2"
<b>04-45</b>	6 3/4"	6 5/8"	3"	2"
<b>04-50</b>	7 5/8"	6"	3"	2"
<b>04-55</b>	10 1/4"	8"	4"	2"
<b>04-60</b>	13"	8 3/4"	4"	2"
<b>04-65</b>	15 5/8"	10"	6"	2"





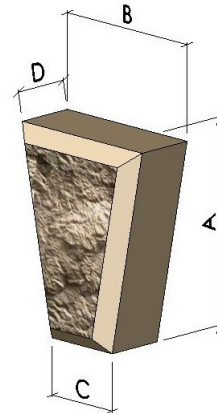
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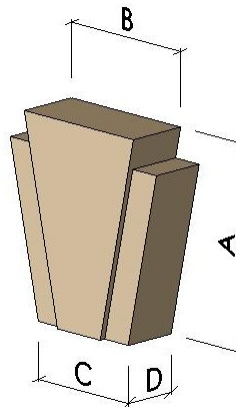
# MeltonStone<sup>TM</sup>

## Keystones

<b>PIECE MARK</b>	<b>A</b>	<b>B</b>	<b>C</b>	<b>D</b>
<b>05-05</b> (BABY)	4 1/8"	4"	2 1/4"	3 5/8"
<b>05-10</b> (BULLSEYE)	6 3/4"	6 5/8"	3"	3 5/8"
<b>05-15</b> (3 COURSE)	7 5/8"	6"	3"	3 5/8"
<b>05-20</b> (4 COURSE)	10 1/4"	8"	4"	3 5/8"
<b>05-25</b> (4 CRSE QUEEN)	12 3/8"	8"	4"	3 5/8"
<b>05-30</b> (5 COURSE)	13"	8 3/4"	4"	3 5/8"
<b>05-35</b> (6 COURSE)	15 5/8"	10"	6"	3 5/8"
<b>05-40</b>	4 1/8"	4"	2 1/4"	2"
<b>05-45</b>	6 3/4"	6 5/8"	3"	2"
<b>05-50</b>	7 5/8"	6"	3"	2"
<b>05-55</b>	10 1/4"	8"	4"	2"
<b>05-60</b>	13"	8 3/4"	4"	2"
<b>05-65</b>	15 5/8"	10"	6"	2"



<b>PIECE MARK</b>	<b>A</b>	<b>B</b>	<b>C</b>	<b>D</b>
<b>06-05</b> (4 COURSE)	10 1/4"	6 7/8"	6"	3 5/8"
<b>06-10</b> (5 COURSE)	13"	9 1/4"	7 5/8"	3 5/8"
<b>06-15</b> (6 COURSE)	15 5/8"	10 1/4"	8"	3 5/8"
<b>06-20</b>	10 1/4"	6 7/8"	6"	2"
<b>06-25</b>	13"	9 1/4"	7 5/8"	2"
<b>06-30</b>	15 5/8"	10 1/4"	8"	2"







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## Sills

<b>PIECE MARK</b>	<b>A</b>	<b>B</b>	<b>C</b>	
70-05	3 5/8"	5"	23 5/8"	
70-10	3 5/8"	7 5/8"	23 5/8"	
70-15	3 5/8"	5"	35 5/8"	
70-20	3 5/8"	7 5/8"	35 5/8"	
70-25 ***	Up to 5"	Up to 8"	35 5/8"	
70-30 ***	Up to 8"	Up to 10"	35 5/8"	
70-05L or 70-05R	3 5/8"	5"	23 5/8"	
70-10L or 70-10R	3 5/8"	7 5/8"	23 5/8"	
70-15L or 70-15R	3 5/8"	5"	35 5/8"	
70-20L or 70-20R	3 5/8"	7 5/8"	35 5/8"	
71-05	5"	5"	23 5/8"	
71-10	5"	7 5/8"	23 5/8"	
71-15	5"	5"	35 5/8"	
71-20	5"	7 5/8"	35 5/8"	
71-25 ***	Up to 7"	Up to 7"	35 5/8"	
71-30 ***	Up to 8"	Up to 10"	35 5/8"	
71-05L or 71-05R	5"	5"	23 5/8"	
71-10L or 71-10R	5"	7 5/8"	23 5/8"	
71-15L or 71-15R	5"	5"	35 5/8"	
71-20L or 71-20R	5"	7 5/8"	35 5/8"	
72-05	3 5/8"	10"	23 5/8"	
72-10	3 5/8"	12"	23 5/8"	
72-15	3 5/8"	10"	35 5/8"	
72-20	3 5/8"	12"	35 5/8"	
72-25 ***	Up to 4"	Up to 10"	35 5/8"	
72-30 ***	Up to 7"	Up to 15"	35 5/8"	
72-05L or 72-05R	3 5/8"	10"	23 5/8"	
72-10L or 72-10R	3 5/8"	12"	23 5/8"	
72-15L or 72-15R	3 5/8"	10"	35 5/8"	
72-20L or 72-20R	3 5/8"	12"	35 5/8"	
73-05	7 5/8"	4 1/4"	23 5/8"	
73-10	10 1/4"	4 1/4"	23 5/8"	
73-15	7 5/8"	4 1/4"	35 5/8"	
73-20	10 1/4"	4 1/4"	35 5/8"	
73-25 ***	Up to 10"	Up to 5"	35 5/8"	
73-30 ***	Up to 15"	Up to 5"	35 5/8"	
73-05L or 73-05R	7 5/8"	4 1/4"	23 5/8"	
73-10L or 73-10R	10 1/4"	4 1/4"	23 5/8"	
73-15L or 73-15R	7 5/8"	4 1/4"	35 5/8"	
73-20L or 73-20R	10 1/4"	4 1/4"	35 5/8"	

\*\*\* Fill in custom dimensions on custom order sheet



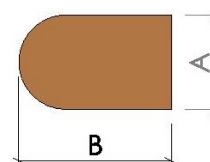
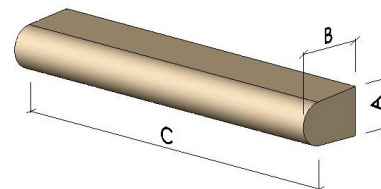
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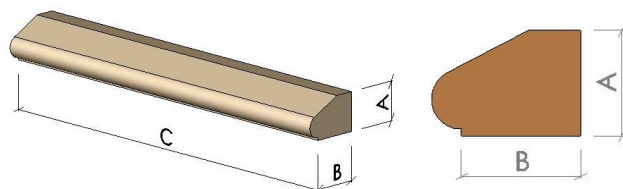
## Sills

PIECE MARK	A	B	C
74-01	3 5/8"	3 5/8"	23 5/8"
74-02	3 5/8"	5 5/8"	23 5/8"
74-05	3 5/8"	7 5/8"	23 5/8"
74-06	5"	3 5/8"	23 5/8"
74-07	5"	5 5/8"	23 5/8"
74-10	5"	7 5/8"	23 5/8"
74-11	3 5/8"	3 5/8"	35 5/8"
74-12	3 5/8"	5 5/8"	35 5/8"
74-15	3 5/8"	7 5/8"	35 5/8"
74-16	5"	3 5/8"	35 5/8"
74-17	5"	5 5/8"	35 5/8"
74-20	5"	7 5/8"	35 5/8"

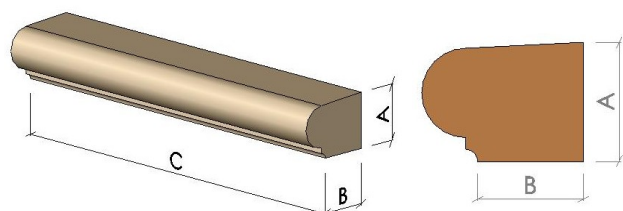


74-01L or 74-01R	3 5/8"	3 5/8"	23 5/8"
74-02L or 74-02R	3 5/8"	5 5/8"	23 5/8"
74-05L or 74-05R	3 5/8"	7 5/8"	23 5/8"
74-06L or 74-06R	5"	3 5/8"	23 5/8"
74-07L or 74-07R	5"	5 5/8"	23 5/8"
74-10L or 74-10R	5"	7 5/8"	23 5/8"
74-11L or 74-11R	3 5/8"	3 5/8"	35 5/8"
74-12L or 74-12R	3 5/8"	5 5/8"	35 5/8"
74-15L or 74-15R	3 5/8"	7 5/8"	35 5/8"
74-16L or 74-16R	5"	3 5/8"	35 5/8"
74-17L or 74-17R	5"	5 5/8"	35 5/8"
74-20L or 74-20R	5"	7 5/8"	35 5/8"

PIECE MARK	A	B	C
75-05	3 1/2"	4"	23 5/8"
75-10	5"	6 5/8"	23 5/8"
75-15	3 1/2"	4"	35 5/8"
75-20	5"	6 5/8"	35 5/8"
75-05L or 75-05R	3 1/2"	4"	23 5/8"
75-10L or 75-10R	5"	6 5/8"	23 5/8"
75-15L or 75-15R	3 1/2"	4"	35 5/8"
75-20L or 75-20R	5"	6 5/8"	35 5/8"



PIECE MARK	A	B	C
76-05	5"	4 1/2"	23 5/8"
76-10	5"	6 1/2"	23 5/8"
76-15	5"	4 1/2"	35 5/8"
76-20	5"	6 1/2"	35 5/8"
76-05L or 76-05R	5"	4 1/2"	23 5/8"
76-10L or 76-10R	5"	6 1/2"	23 5/8"
76-15L or 76-15R	5"	4 1/2"	35 5/8"
76-20L or 76-20R	5"	6 1/2"	35 5/8"







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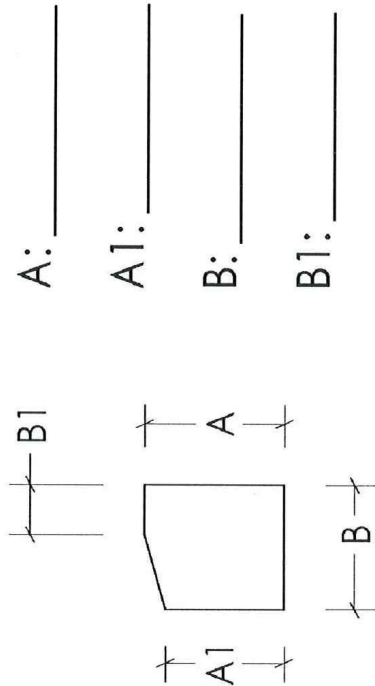
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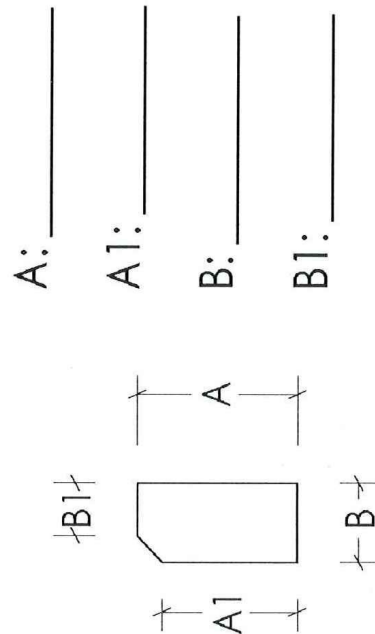
## Sample of Custom Order Sheet

Copy Unfilled Order Sheet, Fill in Dimensions and Fax Sheet back along with

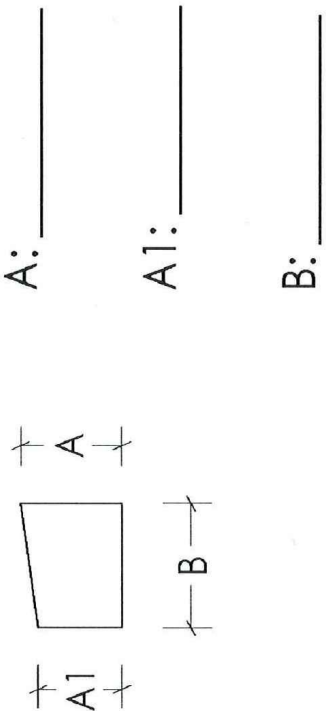
Circle One: 71-25 / 71-30



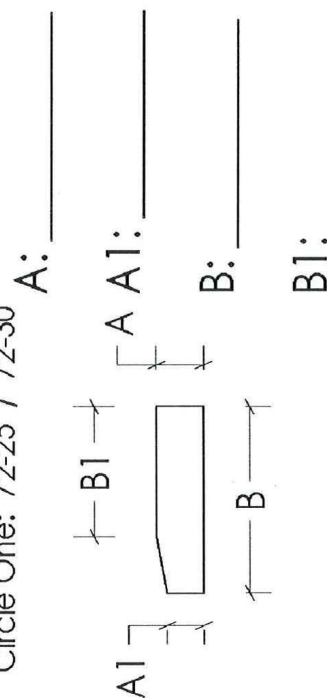
Circle One: 73-25 / 73-30



Circle One: 70-25 / 70-30



Circle One: 72-25 / 72-30



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## Patch Kits

PATCH KIT	COLOR	SIZE
500-05 500-10	White White	1 GALLON 5 GALLON
501-05 501-10	Buff Buff	1 GALLON 5 GALLON
502-05 502-10	Natural Natural	1 GALLON 5 GALLON
503-05 503-10	Gray Gray	1 GALLON 5 GALLON
504-05 504-10	Custom Custom	1 GALLON 5 GALLON

Patch Kits are available in our standard colors and all custom colors. If needing a custom color Patch Kit, then please specify the custom color on the order sheet.

**Patch Kits include:**

- Patch
- Patch Applicator (Foam)
- Mixture Instructions
- Application Instructions

### Patch Kits

<i>Piece Mark</i>	<i>Description</i>	<i>Size</i>	<i>Price</i>
500-05	White	1 Gallon	40.00
500-10	White	5 Gallon	125.00
501-05	Buff	1 Gallon	40.00
501-10	Buff	5 Gallon	125.00
502-05	Natural	1 Gallon	40.00
502-10	Natural	5 Gallon	125.00
503-05	Gray	1 Gallon	40.00
503-10	Gray	5 Gallon	125.00
504-05	Custom	1 Gallon	40.00
504-10	Custom	5 Gallon	125.00



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## INSPECTION & ACCEPTANCE

On site inspection and acceptance of Cast Stone should be performed at time of delivery and again after all material has been installed, pointed and cleaned. Final Inspection should be done prior to application of water repellents. The on site inspector should be familiar with the project specification as well as the applicable referenced standards. Test reports of compressive strength, absorption and other physical properties should be on file as well as the approved sample.

Before installation, check the color and texture of the approved sample against the delivered product. Cast Stone should approximate the color and texture of the approved sample when viewed under good typical lighting conditions at a 10 foot distance and should show no obvious imperfections other than minimal color and texture variations from a 20 foot distance. In addition to issues concerning color and texture, the inspector (and stone setter) must be familiar with the dimensional requirements of the installation as they pertain to joint sizes and interfaces with other materials.

Stones should always be appraised for color when dry as dampness will darken the surface color and make it appear blotchy. Curing time differentials may affect color since moisture will be retained within units for 6 months even in dry weather. Samples which have been stored indoors for long periods of time may look considerably different than product which was manufactured only a short time before delivery.

Texture of Cast Stone should be approximately equal to the approved sample when viewed from a 10' distance in good typical lighting. Do not appraise texture under a sun wash when sunlight is skimming across the surface parallel to the plane of the stone face as this will unfairly accentuate minor irregularities.

Minor variations in color and texture from stone to stone should be accepted within the limits of the accepted range, either established by several samples or mockups or by deviations from instrumentally measured color coordinates. In general, expect color variation to be approximately equal to a good natural cut limestone project. More color variation should be expected than from building materials with painted or applied finishes.

Some projects will show more color variation than others. Units containing gray cement will show more light-dark variations than those containing white cement. Colors which require high amounts of integral pigments such as reds and browns will vary more than moderately neutral shades such as buff. Special mixes containing contrasting and multi-colored aggregates may be subject to extreme color deviations when compared to homogeneous facing mixes.

Variations in color within the same stone may be caused by efflorescence or free lime migrating to the outer surface. This can usually be remedied by proper wash down. Staining, mortar smears or uneven washing can also cause color variations within stones and the manufacturer should be consulted for recommended treatment of these problems.



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## INSPECTION & ACCEPTANCE

Patching is perhaps the greatest source of dissatisfaction with finished installations. When months have elapsed between the date of manufacture and the date of repairs, significant differences in color may exist between properly repaired areas and the remainder of the stone. These areas should be left alone and will blend in over time through curing, natural weathering and ultraviolet light. It is a mistake to require an instant color match at time of repair since this will usually cause dark patches later on.

Common deficiencies which are not normally acceptable in high quality Cast Stone installations include:

1. Bug holes or air voids on the finished surfaces.
2. Ragged or chipped edges on formed edges.
3. Stains on exposed faces from foreign substances.
4. Twist, warp, out of square or bow exceeding tolerances.
5. Out of plane or pie shaped joints, or large or small joints out of tolerance.
6. Areas of rough texture or smoothness not matching sample from 10'.
7. Backup concrete bleeding through exposed faces.
8. Visible cracks exceeding 0.005".
9. Reinforcing shadows or exposure on face.
10. Rust on surface caused by staining, reinforcement or iron pyrites.
11. Installation not matching joint layout on approved shop drawings.
12. Form marks or local depressions in excess of 0.030".

Building owners and their representatives will often apply some wishful thinking when viewing and touching a small 12" sample and then trying to imagine the way an entire facade will look. Wherever possible, an investment should be made in mockup panels and/or sample units. The sample units should demonstrate a variety of shapes and casting configurations, including vertically cast surfaces if they are to be encountered.

Careful quality control of Cast Stone units by competent personnel at the plant combined with qualified ongoing inspection and acceptance at the job site ensures that all parties are aware of each others expectations. This eliminates disappointing results at the end of the job since very little can be done to change the appearance of Cast Stone after it has been set into the structure.

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## CLEANING PROCEDURES

During construction, prevention against staining is mandatory and becomes the best solution for a clean finished project. Every effort should be taken to protect the Cast Stone during storage, setting, and after installation. Storage of Cast Stone should be above ground on non-staining planks or pallets. The storage site should be away from heavy construction traffic. Cast Stone stored for an extended period of time should be kept on pallets or non-staining planking and covered with non-staining tarpaulins. After setting, columns, pilasters, entry jambs, window sills and all stone with projecting profiles should be protected with non-staining material during the remaining construction.

Regardless of the degree of care exercised during construction, a final wash down will be needed and, normally, whatever is specified to clean the brickwork will adequately clean the Cast Stone. A variety of commercial cleaners are available and most contain detergents combined with mild solutions of phosphoric and/or muriatic acids. Extreme care should be taken when applying acidic cleaners to areas where joints are left open or where sealant is used as jointing material. The sealant manufacturer should be contacted to ascertain compatibility with cleaning materials. Acids left behind the stone on masonry wythe may cause corrosion problems later on.

The most common stains due to construction are dirt and mortar. Dirt can be removed by scrubbing with a mild detergent and water. Mortar stains require brushing a solution of one part hydrochloric acid to six parts water on the stain. Soak the stone with water prior to adding any acid solution to prevent surface burning. Consult the brick supplier prior to applying acids to trim items. Insure that lower stone courses are frequently drenched with water because as acid is rinsed down the wall it can gather strength when reapplied. Take necessary steps to protect windows, door, and grade materials.

When unusual stains are encountered, the same procedures which are recommended to clean concrete will normally clean Cast Stone. The Portland Cement Association publishes a guide for the removal of stains in concrete. The most important step to stain removal is identifying the stain and its cause. There are degreasers and paint removers readily available. Any treatment should be tested on a small inconspicuous area prior to cleaning the main units.

Dunnage materials used in the packing and transport of Cast Stone can leave stains (or clean spots) after becoming wet. Wood packaging products can transfer resins to the surface which may be easily removed. However, solid dunnage made from fresh timber can cause dunnage marks which become difficult to remove. Packing and dunnage materials should always allow the exposed surfaces to breathe, especially when stones are palletized or placed into storage shortly after manufacture. This will avoid color differentials due to moisture becoming trapped on the surface of the stone.

Power washing and sandblasting are not recommended procedures for cleaning Cast Stone. Metal fiber brushes are not to be used for scrubbing Cast Stone.

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PATCHING

The best insurance against chipped stone is care in handling and protection of the unit after installation. Even with all of the special care and protection, building stone still becomes chipped from time to time and a certain amount of patching is to be expected.

Any chip obvious from a 20' distance should be patched. Chips measuring 1/4" and less across the face should not be patched and are usually left alone. Stone units with chips larger than 8" square should be replaced, unless the damaged portion can be salvaged and bonded back to the unit. Most cracks can be patched if the units are reinforced.

Climatic conditions must be taken into consideration before patching is to commence. Do not patch stone in freezing weather or if a freeze is anticipated within 24 hours. On hot sunny days patching should be done during the morning hours where the Cast Stone is shaded or at temperatures less than 90 degrees Fahrenheit. Patches should be covered with a damp cloth and plastic sheet to prevent the cement from hydrating too quickly.

The same material that was used to manufacture the Cast Stone should be used for patching. Experimental batches should not be used in an effort to obtain an instant color match. The water/cement ration used should be as close as possible to the mix at the time of manufacture. Acrylic bonding agents may be used, but not in place of water. Use as a wetting agent; less than a tablespoon per handful of patching material. Never use metal tools for applying a patch. Stones which were acid etched at the factory will require the same treatment applied to the patch.

A properly executed patch will not match in color immediately. Dry cast products will appear lighter where repaired; wet cast products may appear darker. Patches that match immediately or in two or three days have a tendency to change color later on after weathering. Through curing, weathering and ultraviolet light, the patch will eventually return to the original stone color. This process could take 3 months to a year or longer depending on the climatic conditions and exposure to the weather.

Patches which cannot be seen from a 20' distance when viewed in good typical lighting should be accepted. Request bulletin #36 on Inspection and Acceptance.

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## SEALANTS

The decision on whether to use mortar with pointed joints or sealant joints between stones is a common one. All head joints at coping stones and joints at column covers, cornices, platforms, soffits, window sills and in general, all stone sections with projecting profiles, exposed top joints or rigid suspension connections to the supporting structure should be "soft" sealant joints.

Mortar joints are best suited for masonry-bound trim items such as belt courses, lintels, window surrounds, date stones, inscription blocks, quoins, keystones and similar applications. Always rake and point mortar joints rather than full-bed setting and finishing in one operation.

Sealant joints allow for movement at the vertical joints. Leave head joints dry when setting. It is a mistake to use mortar in combination with sealant in the same joint. An allowance for compression is required for the system to be effective. After setting, prime the ends of the stones, insert properly sized foam backup rod and gun in sealant.

Since sealant systems are not intended to bear weight, use plastic setting pads or lead shims when setting the stones on a soft bed joint. The sealant is not intended to adhere to the foam backer rod. The sealant should adhere to the parallel surfaces only. The foam rod should be placed to a depth approximately equal to the width of the joint.

Sealants are specified under section 07920. The most common types are one-part "moisture cure" or "air cure." Two part systems are also available which require the mixing of materials together to allow chemically induced curing.

The inherent properties of silicone products make them excellent sealant materials. Silicones provide superior weathering resistance and perform over a wide range of service temperatures. They are easy to apply, have low shrinkage rates, and can accommodate high movement. While organic materials tend to crack, dry up, and become brittle or even revert with age, silicones remain flexible and durable.

Two component, polyurethane sealants are tough and elastic, allowing for movement of up to 50% of the joint width. They are also durable, flexible and form a watertight bond with most building materials. According to the manufacturers, these formulations offer weather tight seals in caulking joints today for as long as 20 years under normal application conditions and ten years under severe conditions.

Allowance for thermal and other movement should be within 25% of the joint size. For instance, a normal 3/8" joint should be expected to compress to approximately 1/4" and expand to approximately 1/2" during elongation.

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## Terms & Conditions

### **MeltonStone Catalog Items**

1. Completely Fill out and Return Sales Order Via Fax or E-mail Included with Catalog.
2. Do Not Duplicate Sales Order
3. If Distributor issues Purchase Order, A copy of the Sales Order that is included with catalog must be attached and become exhibit "A" of the purchase order, Melton Classics, Inc. and or MeltonStone terms for payment and condition must be included as part of the Purchase Order prior to our acceptance and approval of purchase order.
4. Client will receive Order Confirmation within 24 Hours from date of receipt.
5. It is the full responsibility of the client to (a) verify all quantities (b) verify dimensions (c) verify design.
6. All Prices in our catalog are shown F.O.B. our manufacturing plant in Valdosta, Georgia.
7. Melton Classics, Inc. is not responsible for damage during shipping or off-loads.
8. All Items in this Catalog are priced in Standard Texture and in our four (04) Standard Colors.
9. Melton Classics, Inc. and/or MeltonStone has the right to Lien client and project for non payment.
10. Client will be responsible for all Legal fees and cost to collect outstanding balances and/or Past Due Invoices.
11. Clients are required to pay Sales Tax unless exempt in advance and all proper paper work are provided in advance.

### **MeltonStone Custom Orders**

1. Custom Quotation is issued to Client upon request of Non Catalog Items.
2. Client will be responsible to provide in a timely manner all and any drawings required to price and or bid and develop shop drawings upon request from Melton Classics, Inc. and/or MeltonStone.
3. If client issues Purchase Order, Our Order Confirmation shall become an exhibit as part of the purchase order, our terms for payment and condition must be included as part of the Purchase Order prior to our approval.
4. All Items are priced in Standard Texture and our four (04) Standard Colors. If Custom Color and Matching is required Melton Classics, Inc. and/or MeltonStone must be notified at time of pricing. Melton Classics, Inc. and/or MeltonStone will provide up-charge cost when Quotation is submitted for approval.
5. Shop Drawings and/or Typical Piece Drawings will be provided unless otherwise noted at Melton Classics, Inc. discretion.
6. Shop Drawings and/or Piece Drawings must be returned stamped approved within 1 week from date of submittal.
7. It is the full responsibility of the client to (a) verify all quantities (b) verify dimensions (c) verify design (d) verify field dimensions (e) provide templates if necessary (f) provide all art work necessary.
8. Any alteration or deviation from quantities and description submitted involving extra cost will be executed only upon written order and will become an extra charge over and above this Quotation.
9. Excludes engineering of any connection and/or attachment, installation and/or erection, clean caulk, sealers, patching of erection damage, ledge angles, structural bracing, structural support & loose anchors, unless otherwise noted on this Quotation.
10. In some circumstances field cutting may be required.
11. All Prices in our catalog are shown F.O.B. our Manufacturing Plant in Valdosta, Georgia.
12. Melton Classics, Inc. and or MeltonStone is not responsible for damage during shipping or off-loads.
13. All Custom Orders are invoiced as follows:
  - a) 50% Start-up Fee
  - b) Remaining Balance will have to be paid 5 business days prior to shipment.
14. Melton Classics, Inc. and/or MeltonStone has the right to Lien client and project for non payment .
16. Client will be responsible for all Legal fees and cost to collect outstanding balances and/or Past Due Invoices.
17. All agreements contingent upon strikes, accidents, weather or delays beyond our control.
18. All Custom Quotations may be withdrawn within 15 days if not accepted by client.