



Designation: C1364 – 10a

Standard Specification for Architectural Cast Stone¹

This standard is issued under the fixed designation C1364; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

1. Scope

1.1 This specification includes the physical properties, sampling, testing, tolerance, and appearance requirements for architectural cast stone.

1.2 Cast stone units covered under this specification include both wet cast and vibratory dry tamp products. Production methods of cast stone can vary among manufacturers; many production methods are acceptable provided the delivered cast stone meets the requirements of this specification.

1.3 Surface textures, finish, color, or other special features should be specified separately by the purchaser.

1.4 The values stated in inch-pound units are to be regarded as standard. The values given in parentheses are mathematical conversions to SI units that are provided for information only and are not considered standard.

1.5 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

2. Referenced Documents

2.1 ASTM Standards:²

- A615/A615M Specification for Deformed and Plain Carbon-Steel Bars for Concrete Reinforcement
- C33 Specification for Concrete Aggregates
- C150 Specification for Portland Cement
- C173/C173M Test Method for Air Content of Freshly Mixed Concrete by the Volumetric Method
- C231 Test Method for Air Content of Freshly Mixed Concrete by the Pressure Method
- C260 Specification for Air-Entraining Admixtures for Concrete

¹ This specification is under the jurisdiction of ASTM Committee C27 on Precast Concrete Products and is the direct responsibility of Subcommittee C27.20 on Architectural and Structural Products.

Current edition approved Oct. 1, 2010. Published November 2010. Originally approved in 1997. Last previous edition approved in 2010 as C1364 – 10. DOI: 10.1520/C1364-10A.

² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

- C426 Test Method for Linear Drying Shrinkage of Concrete Masonry Units
 - C494/C494M Specification for Chemical Admixtures for Concrete
 - C595 Specification for Blended Hydraulic Cements
 - C618 Specification for Coal Fly Ash and Raw or Calcined Natural Pozzolan for Use in Concrete
 - C666/C666M Test Method for Resistance of Concrete to Rapid Freezing and Thawing
 - C979 Specification for Pigments for Integrally Colored Concrete
 - C989 Specification for Slag Cement for Use in Concrete and Mortars
 - C1157 Performance Specification for Hydraulic Cement
 - C1194 Test Method for Compressive Strength of Architectural Cast Stone
 - C1195 Test Method for Absorption of Architectural Cast Stone
 - D1729 Practice for Visual Appraisal of Colors and Color Differences of Diffusely-Illuminated Opaque Materials
 - D2244 Practice for Calculation of Color Tolerances and Color Differences from Instrumentally Measured Color Coordinates
- #### 2.2 ACI Standards:
- 318 Building Code Requirements for Reinforced Concrete³

3. Terminology

3.1 Definitions:

3.1.1 *cast stone, n*—an architectural precast concrete building unit intended to simulate natural cut stone.

3.1.2 *vibrant dry tamp (dry cast) products, n*—cast stone manufactured from zero slump concrete densely compacted by apparatus. (See Note 1.)

3.1.3 *wet cast products, n*—cast stone manufactured from measurable slump concrete consolidated by apparatus. (See Note 1.)

NOTE 1—Apparatus used in the production of cast stone may include automatic, semi-automatic, or manual devices that deploy internal or external vibration, vibrant tamping, vibration under pressure, centrifugal

³ Available from American Concrete Institute (ACI), P.O. Box 9094, Farmington Hills, MI 48333.