

BRITISH STANDARD

Cast stone – Specification

ICS 91.100.15



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Summary of pages

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Foreword

Publishing information

This British Standard is published by BSI and came into effect on 29 August 2008. It was prepared by Technical Committee B/524, *Precast concrete products*. A list of organizations represented on this committee can be obtained on request to its secretary.

Supersession

This British Standard supersedes BS 1217:1997, which is withdrawn.

Information about this document

This new edition of BS 1217 takes cognizance of the publications of BS EN 771-5 and BS EN 845-2 and represents the requirements of a long-established industry manufacturing products both for buildings and for use in other applications. It does not represent a full review or revision of the Standard which will be undertaken in due course.

Apart from a general tidying of the text, omission of any requirements regarding concreting material, the Standard concentrates on product requirements. The reinforcement section has been extended to permit non-metallic material provided such reinforcement has the requisite reinforcing properties. Annex C remains informative on slenderness ratios and minor improvements have been made to the figures to make them clearer.

Presentational conventions

The provisions of this standard are presented in roman (i.e. upright) type. Its requirements are expressed in sentences in which the principal auxiliary verb is “shall”.

Commentary, explanation and general informative material is presented in smaller italic type, and does not constitute a normative element.

Requirements in this standard are drafted in accordance with *The BSI guide to standardization – Section 2: Rules for the structure, drafting and presentation of British Standards*, subclause **11.3.1**, which states, “Requirements should be expressed using wording such as: ‘When tested as described in Annex A, the product shall ...’”. This means that only those products that are capable of passing the specified test will be deemed to conform to this standard.

Contractual and legal considerations

This publication does not purport to include all the necessary provisions of a contract. Users are responsible for its correct application.

Compliance with a British Standard cannot confer immunity from legal obligations.

1 Scope

This British Standard specifies performance requirements for cast stone products other than for those products conforming to BS 5642-1, *Sills*, BS 5642-2, *Copings*, BS EN 771-5, *Manufactured stone masonry units* and BS EN 845-2, *Lintels*, which contain product specific requirements.

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

BS 1881-208, *Testing concrete – Part 208: Recommendations for the determination of the initial surface absorption of concrete*

BS EN 12390-2, *Testing hardened concrete – Part 2: Making and curing specimens for strength tests*

BS EN 12390-3, *Testing hardened concrete – Part 3: Compressive strength of test specimens*

3 Terms and definitions

For the purposes of this British Standard, the following terms and definitions apply.

3.1 cast stone

any material manufactured with aggregate and cementitious binder, intended to resemble in appearance, and which may be used in a similar way to, natural stone

NOTE Cast stone units are either homogeneous throughout or consist of facing and backing materials.

3.2 visual face

any face or part of a cast stone unit visible after completion of works

3.3 exposed face

any face which is not bedded or otherwise protected in the works (e.g. with mortar or bitumen)

NOTE Unbedded parts of a sill face or faces exposed to a cavity are examples of exposed faces. Visual faces are exposed faces but not necessarily vice versa.

3.4 interface

irregular face between the facing and backing mixes in two-part mixes

NOTE See Clause 4.

4 Two-part mix units

When cast stone units are made from separate facing and backing mixes:

- a) visual faces shall have a minimum facing mix thickness of 20 mm at any point;
- b) a bond between the facing and backing mixes shall be made either by a mechanical key or by inter-diffusion.