

Information Sheet

How the stones are made

Cast stone is made by two main methods: Semi-dry or Wet Cast. The Semi-dry method has two sub divisions, see below.

Semi-dry: two-part system	Semi-dry: one-part system	Wet cast system
<p>Cast stone is made from natural aggregates combined with a cementitious binder.</p> <p>The semi-dry production method uses low water content mixes.</p> <p>Stones made by this system are made from two separate mixes compacted together. The first mix is a “facing” mix, which is the visible part of the stone when it is built. The second mix is a backing mix, made from concrete also at a semi dry consistency. Most stones are made face down in the mould allowing immediate de-moulding, finishing and re-use of the mould.</p> <p>Finishing: Little finishing is required on semi-dry cast stone items as the moulds are of sufficient quality. However, our skilled stone-makers check each stone carefully to ensure that no blemishes exist and the stone has a uniform finish.</p> <p>Finishing techniques such as acid etching, sandblasting or special coatings may be applied if requested by the customer in advance of manufacture.</p>	<p>Similar to the two-part system, but no backing mix is used. The stone is all through facing mix.</p> <p>This system is used when the stone is too small to incorporate backing mix, typically less than 75mm thick, or when the shape of the stone is complex.</p> <p>Finishing: As per the two part system</p>	<p>The wet cast process uses an all through mix with much higher water content than the semi-dry method. Compaction is achieved using our vibrating table.</p> <p>Unlike the semi-dry method, wet cast stones can only be produced at the rate of one per day per mould.</p> <p>Also, depending on the finish required, there could be a significant amount of work involved to gain the desired result.</p> <p>Finishing: In addition to those offered for the semi-dry system, we are able to polish our wet cast stone.</p>