U. S. DEPARTMENT OF COMMERCE
DANIEL C. ROPER, Secretary
NATIONAL BUREAU OF STANDARDS
LYMAN J. BRIGGS, Director

COLORS AND FINISHES FOR CAST STONE

COMMERCIAL STANDARD CS53–35

Effective Date for New Production August 30, 1935

A RECORDED STANDARD OF THE INDUSTRY

Approved by the American Standards Association
as American Tentative Standard CS53–35

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U. S. DEPARTMENT OF COMMERCE NATIONAL BUREAU OF STANDARDS

PROMULGATION

OF

COMMERCIAL STANDARD CS53–35

FOR

COLORS AND FINISHES FOR CAST STONE

On May 17, 1935, at the instance of The Cast Stone Institute, a general conference of representative manufacturers, distributors, and users of cast stone adopted a recommended commercial standard for colors and finishes for cast stone. The industry later accepted and approved for promulgation by the United States Department of Commerce, through the National Bureau of Standards, the standard as shown herein.

The standard is effective for new production from August 30, 1935.

Promulgation recommended.

I. J. Fairchild,
Chief, Division of Trade Standards.

Promulgated.

Lyman J. Briggs,
Director, National Bureau of Standards.

Promulgation approved.

Daniel C. Roper,
Secretary of Commerce.

COLORS AND FINISHES FOR CAST STONE

COMMERCIAL STANDARD CS53-35

PURPOSE

1. As usually written, specifications on the appearance of cast stone are subject to widely different interpretations by different manufacturers, which leads to confusion and misunderstanding. While such attributes as strength, density, and absorption can be definitely specified and easily measured by tests, appearance is intangible and is not susceptible to a written description which is definite enough to have but one interpretation. From the standpoint of the responsible manufacturer it is extremely important that specifications be complete and clear, since he cannot submit an intelligent competitive bid unless he knows exactly what is wanted and what other manufacturers will bid on. This standard provides a solution of these difficulties by simplifying the preparation, interpretation, and enforcement of specifications on colors and finishes for cast stone.

2. It is not the purpose of this standard to limit the range of colors, textures, and finishes in cast stone. Under its present scope it merely sets up tangible examples of the most frequently occurring colors and finishes. These samples provide standards of comparison by which cast stone of these particular colors and finishes can be specified and judged. To the extent that they exemplify cast stone of enduring and pleasing appearance these samples provide a standard of comparison for all cast stone regardless of color and finish.

SCOPE

3. This standard covers those colors and finishes which constitute a very large proportion of the production of the cast-stone industry. As the demand arises this standard may be extended to include other colors and finishes.

BASIS OF STANDARDIZATION

4. The principles and practices underlying the manufacture of cast stone are of such uniform and constant application as to permit a very close control of the color and finish of the finished product. Cast stone can be made to meet any reasonable predetermined requirements as to color and finish; one manufacturer, if he desires, can satisfactorily duplicate the product of any other manufacturer.

5. The factors which affect the appearance of cast stone are color of aggregate, size and grading of aggregate, pigment, cement, proportions of mix, method of molding, and nature and extent of surface

treatment. Without any attempt to define or restrict materials and methods used in producing cast stone, uniform results as to appearance can be obtained by establishing a definite visual standard to which manufacturers can conform. Judgment as to color and finish of the product can then be made without reference to how the results were obtained.

6. In matching the original sample, materials similar to those comprising the standard sample may be used, but substitutions should be limited to the same representative class of materials as those forming the standard sample. It is expected and has previously been demonstrated that raw materials of sufficient similarity for the production of cast stone matching a given sample are generally available to manufacturers throughout the country. Standard reference samples of cast stone therefore in no wise restrict competition among manufacturers but instead tend to broaden and equalize competition. Of equal importance, standard reference samples will provide a means by which purchasers of cast stone can specify exactly what is desired and a standard by which the delivered product can be judged as to appearance.

METHOD OF MAKING COMPARISONS

7. In making comparisons with standard reference samples, observations shall be made from a distance of 10 feet. The surfaces being compared shall be in the same vertical plane. Comparisons shall be made by the light from a northern sky. A neutral gray mask with two apertures 4 inches square and 6 inches apart shall be used to expose equal areas of the two surfaces to be compared. The surfaces being compared shall be considered to match satisfactorily if there is no appreciable difference in their appearance under the specified conditions of comparison.

ARBITRATION COMMITTEE

8. Final decision in the settlement of misunderstandings disagreements, or disputes arising from claims concerning off-color or off-finish samples or shipments may be made by the following committee, composed of a representative from each of the following organizations:

The Cast Stone Institute.
American Institute of Architects.
Portland Cement Association.
Division of Clay and Silicate Products, National Bureau of Standards.
Division of Trade Standards, National Bureau of Standards.

STANDARD SAMPLES

9. The standard colors and finishes for cast stone shall be designated as in table 1.

TABLE 1.—*Standard colors and finishes for cast stone*

Designation	Color	Finish	Designation	Color	Finish
SS-10A	Gray	Rubbed.	SS-15A	Buff	Rubbed.
SS-10B			SS-15B		
SS-10C			SS-15C		
SS-20A	Gray	Bushhammered.	SS-25A	Buff	Bushhammered.
SS-20B			SS-25B		
SS-30	Gray	Etched.	SS-35	Buff	Etched.
SS-40	Gray	Brushed.	SS-45	Buff	Brushed.

10. The original standard color and finish samples shall be retained at the National Bureau of Standards. Reference samples (4½ by 6½ by 1 inch) certified by The Cast Stone Institute as constituting satisfactory duplicates of the master samples, for use by manufacturers in production control may be obtained from The Cast Stone Institute at $2.50 each in lots of 4 or more and $3 each in lots of less than 4.

AMERICAN STANDARD

This commercial standard was approved as American Tentative Standard CS53–35 by the American Standards Association on November 1, 1935.

EFFECTIVE DATE

The standard became effective for new production on August 30, 1935.

STANDING COMMITTEE

The following comprises the membership of the standing committee, which is to review, prior to circulation for acceptance, proposed revisions to keep the standard abreast of progress.

ERNEST A. WEIDEMANN, President, The Cast Stone Institute, Economy Concrete Co., of Va., Inc., Box 1223, Richmond, Va.

A representative from the American Institute of Architects, 1741 New York Avenue, Washington, D. C.

R. C. MCMILLAN, Portland Cement Association, National Press Building, Washington, D. C.

JOHN TUCKER, Jr., Division of Clay and Silicate Products, National Bureau of Standards, Washington, D C.

F. W. REYNOLDS, representing Division of Trade Standards, National Bureau of Standards, Washington, D. C.

HISTORY OF PROJECT

On June 17, 1932, at the request of The Cast Stone Institute, a preliminary conference of manufacturers of cast stone appointed a special committee comprising representatives of all interests of the industry for the purpose of selecting proposed standard samples of cast stone for color and finish. Fourteen standard samples were selected by the committee and duplicates were distributed by The Cast Stone Institute to various Federal, State, and municipal construction departments, and to private architectural offices for use in selecting and specifying the color and texture of cast stone for particular jobs.

The preliminary conference proposed that the standard-sample plan be tried out for a reasonable period after which it would be presented to a general conference for official adoption on a national basis.

On May 17, 1935, after appropriate adjustments in the text, a general conference of manufacturers, distributors, and users voted to adopt the proposed commercial standard with the understanding that it would be circulated to all directly concerned for written acceptance. Official acceptances estimated to represent a satisfactory majority of production by volume having been received, and in the absence of active opposition, a circular letter dated August 30, 1935, was issued to the trade announcing successful completion of the standard as a guide for the purchase, production, and acceptance of 14 standard colors and finishes for cast stone.

APPENDIX

The following specifications are not to be considered a part of Commercial Standard CS53–35, but are offered as a guide in the preparation of complete working specifications for each job. Additional requirements on architectural details may be included as necessary or desired. The suggested specifications cover:

(a) Cast stone purchased under Federal Specification SS–S–721.
(b) Cast stone purchased under private specifications.

(a) CAST STONE PURCHASED UNDER FEDERAL SPECIFICATION SS-S-721

Quality, type, finish, workmanship, etc.—Material indicated on drawings as cast stone shall be the product of an established plant having capacity and facilities for producing the specified quality and quantity of cast stone without delaying the progress of the work.

Cast stone shall be type no. —[1] as classified by Federal Specification SS–S–721 and shall meet all applicable requirements and tests of that specification. It shall closely match in color, finish, and texture cast stone reference sample no. —.[1] All pieces shall be true to dimensions and profiles shall have sharp, straight edges. Moldings and arrises shall be sharp, true, and continuous at the joints. All ornamentation shall faithfully reproduce models or details and, unless otherwise specified, shall be treated to show a texture and appearance similar to the rest of the work.

(b) CAST STONE PURCHASED UNDER PRIVATE SPECIFICATIONS

Quality, type, finish, workmanship, etc.—Material indicated on drawings as cast stone shall be the product of an established plant having capacity and facilities for producing the specified quality and quantity of cast stone without delaying the progress of the work.

Cast stone shall have a compressive strength of not less than 5,000 pounds per square inch and an absorption not greater than 7 percent when tested according to the requirements of American Concrete Institute Tentative Specification P–3–A–29T or Federal Specification SS–S–721.

Cast stone shall closely match in color, finish, and texture cast stone reference sample no. —.[1] All pieces shall be true to dimensions and profiles shall have sharp straight edges. Moldings and arrises shall be sharp, true, and continuous at the joints. All ornamentation shall faithfully reproduce models or details and unless otherwise specified, shall be treated to show a texture and appearance similar to the rest of the work.

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[1] To be filled in by the architect.

ACCEPTANCE OF COMMERCIAL STANDARD

This sheet properly filled in, signed, and returned will provide for the recording of your organization as an acceptor of this commercial standard.

Date_____

Division of Trade Standards,
National Bureau of Standards,
Washington, D. C.

Gentlemen:

Having considered the statements on the reverse side of this sheet, we accept the Commercial Standard CS53–35 as our standard of practice in the

Production [1] Distribution [1] Use [1]

of colors and finishes for cast stone.

We will assist in securing its general recognition and use, and will cooperate with the standing committee to effect revisions of the standard when necessary.

(Cut on this line)

Signature_____

(Kindly typewrite or print the following lines)

Title_____

Company_____

Street address_____

City and State_____

[1] Please designate which group you represent by drawing lines through the other two. In the case of related interests, trade papers, colleges, etc., desiring to record their general approval, the words "In principle" should be added after the signature.

TO THE ACCEPTOR

The following statements answer the usual questions arising in connection with the acceptance and its significance:

1. *Enforcement.*—Commercial standards are commodity specifications voluntarily established by mutual consent of the industry. They present a common basis of understanding between the producer, distributor, and consumer and should not be confused with any plan of governmental regulation or control. The United States Department of Commerce has no regulatory power in the enforcement of their provisions, but since they represent the will of the industry as a whole, their provisions through usage soon become established as trade customs, and are made effective through incorporation into sales contracts by means of labels, invoices, and the like.

2. *The acceptor's responsibility.*—The purpose of commercial standards is to establish for specific commodities, nationally recognized grades or consumer criteria, and the benefits therefrom will be measurable in direct proportion to their general recognition and actual use. Instances will occur when it may be necessary to deviate from the standard and the signing of an acceptance does not preclude such departures; however, such signature indicates an intention to follow the commercial standard where practicable, in the production, distribution, or consumption of the article in question.

3. *The Department's responsibility.*—The major function performed by the Department of Commerce in the voluntary establishment of commercial standards on a Nation-wide basis is fourfold: First, to act as an unbiased coordinator to bring all branches of the industry together for the mutually satisfactory adjustment of trade standards; second, to supply such assistance and advice as past experience with similar programs may suggest; third, to canvass and record the extent of acceptance and adherence to the standard on the part of producers, distributors, and users; and fourth, after acceptance, to publish and promulgate the standard for the information and guidance of buyers and sellers of the commodity.

4. *Announcement and promulgation.*—When the standard has been endorsed by companies representing a satisfactory majority of production, the success of the project is announced. If, however, in the opinion of the standing committee of the industry or the Department of Commerce, the support of any standard is inadequate, the right is reserved to withhold promulgation and publication.

ACCEPTORS

Individuals and organizations listed below have indicated, in writing, acceptance of this specification as their standard of practice in production, distribution, or use, but such endorsement does not signify that they may not find it necessary to deviate from the standard, nor does it signify that the producers so listed guarantee all of their products to conform with the requirements of this standard.

ASSOCIATIONS

American Institute of Architects, Structural Service Department, Washington, D. C.
American Institute of Architects, San Diego Chapter, San Diego, Calif. (in principle).
Building Officials Conference of America, Washington, D. C.
Cast Stone Institute, Chicago, Ill.
National Concrete Masonry Association, Chicago, Ill. (in principle).
Portland Cement Association, Chicago, Ill.

FIRMS

Altfillisch, Charles, Decorah, Iowa.
American Artstone Co., New Ulm, Minn.
Architectural Cast Stone Co., Chicago, Ill.
Architectural Decorating Co., Inc., Seattle, Wash.
Architectural Stone Co., Inc., New Orleans, La.
Architectural Stone Co., Inc., Turners Falls, Mass.
Arnold Stone Co. of North Carolina, Inc., Greensboro, N. C.
Art Cement Products Co., Springfield, Mass. (in principle).
Art Stone Co., Gloversville, N. Y.
Art Stone & Tile Co., Wilmington, Del.
Atlanta Board of Education, Planning and Engineering Department, Atlanta, Ga.
Auler, Jensen & Brown, Oshkosh, Wis.
Badger Concrete Co., Oshkosh, Wis.
Baker & Vogel, Seattle, Wash. (in principle).
Bial, Geo. F., Hasbrouck Heights, N. J.
Bishop, Horatio W., Los Angeles, Calif.
Blithe, Wesley Lesher, Philadelphia, Pa.
Bourne, Frank A., Boston, Mass.
Brainerd, Harry B., New York, N. Y.
Braseth & Houkom, Fargo, N. Dak.
Browne & Fitz-Gibbon, Norfolk, Va.
Brust, Peter, Milwaukee, Wis.
Buechner & Orth, St. Paul, Minn.
Buffalo Litholite Co., Lackawanna, N. Y.
Cambridge Cement Stone Co., Brighton, Boston, Mass.
Carder, Macon O., Amarillo, Tex.
Carroll, John J., Atlantic City, N. J.
Castone, Inc., St. Paul, Minn.
Cement Products Co., The, Davenport, Iowa.
Cement Stone & Supply Co., The, Wichita, Kans.
Central Concrete Construction Co., Louisville, Ky. (in principle).
Child, Harry Charles, Sayre, Pa.
Clark, Jr., A. P., Washington, D. C.
Clark, Carl W., Cortland, N. Y.
Concrete Products Co., Inc., The, Salina, Kans.
Conrad & Cummings, Binghamton, N. Y.
Cram & Ferguson, Boston, Mass.
Crandell, M. L., Glens Falls, N. Y.
Cut Art Stone Co., Savannah, Ga.
Cuthbert & Cuthbert, Ann Arbor, Mich.
Davidge, George, Alhambra, Calif.
De Jarnette, C. W., Des Moines, Iowa.
Dennis & Dennis, Macon, Ga.
Devlin, Edward A., Trenton, N. J.
Dextone Co., The, New Haven, Conn.
Dodge & Morrison, New York, N. Y.
Donovan, John J., Berkeley, Calif. (in principle).
Dorchester Cement Stone Co., Dorchester, Mass.
Eastern Cement Stone Co., Malden, Mass.
Economy Concrete Co. of Virginia, Inc., Richmond, Va.
Emerson & Norris Co., Boston, Mass.
Eschweiler & Eschweiler, Milwaukee, Wis.
Esenwein & Johnson, Buffalo, N. Y.
Everett Concrete Products Co., Everett, Wash.
Fall River Cast Stone Co., Fall River, Mass.
Farias Cast Stone Co., J. R., Los Angeles, Calif.
Faris, Frederic, Wheeling, W. Va.
Florida, University of, State Board of Control, Gainesville, Fla. (in principle).
Formigli Architectural Stone Co., Berlin, N. J.
Gall, Harry L. C., New York, N. Y.

Gervais Co., Henry, San Francisco, Calif. (in principle).
Good Stone Manufacturing Co., Inc., Rochester, N. Y.
Gordon & Kaelber, Rochester, N. Y.
Grassi & Co. "Travertite" Works, Inc., P., San Francisco, Calif.
Gray Concrete Pipe Co., Thomasville, N. C.
Greig Cast Stone Works, James, Jacksonville, Fla.
Gribben, J. Upton, Columbus, Ohio.
Grisanti Ornamental Plaster Co., Inc., Louisville, Ky.
Hahn, Stanley Worth, Alexandria, Va. (in principle).
Hamlin & Hood, Pasadena, Calif.
Hardison Stone Co., Birmingham, Ala.
Harper & West, Boston, Mass.
Harrison, Merritt, Indianapolis, Ind. (in principle).
Hart & Shape, New York, N. Y.
Higgins, Charles H., New York, N. Y.
Holsman & Holsman, Chicago, Ill.
Jacoby & Everett, Allentown, Pa.
Jamme, Bernard E., Summit, N. J.
Johnson Cast Stone Co., F. H., Ellsworth, Wis.
Johnson Co., W. O., Omaha, Nebr.
Keich & O'Brien, Warren, Ohio (in principle).
Kimball, Steele & Sandham, Omaha, Nebr. (in principle).
Kingsbury, Frederick, Needham, Mass.
Kohn, Robert D., Charles Butler & Clarence S. Stein, New York, N. Y.
Lawrence, Holford & Allyn, Portland, Oreg.
Lodge, William P., San Diego, Calif. (in principle).
MacGruer & Co., San Francisco, Calif.
Mann & Co., Hutchinson, Kans.
Martin & Son, A. Oscar, Doylestown, Pa.
Marye, P. Thornton, Atlanta, Ga.
Mason & Co., George D., Detroit, Mich.
Massey Concrete Products Corporation, Chicago, Ill.
Maul Macotta Corporation, Detroit, Mich.
Mauran, Russell & Crowell, St. Louis, Mo.
Mayo & Mayo, Chicago, Ill. (in principle).
Meyers, Henry H., Alameda, Calif.
Meyers & Johnson, Erie, Pa.
Michelson, Harry M., San Francisco, Calif. (in principle).
Miller & Yeager, Terre Haute, Ind.
Mooser, William, San Francisco, Calif.
Morton Co., John J., Charlotte, N. C.
Mueller-Hair Architects, Hamilton, Ohio.
Muhlenberg Bros., Reading, Pa.
Mundie & Jensen, Chicago, Ill.
Myers, Nathan, Newark, N. J.
National Cast Stone Corporation, Bronx, New York, N. Y.
Nucarth Stone Corporation, Carthage, Mo.
Officer, Gwynn, Berkeley, Calif.
Olympian Stone Co., Seattle, Wash.
Ornamental Stone Co., Charlotte, N. C.
Parmelee, M. E., Knoxville, Tenn.
Paul & Russell, Inc., Westmont, N. J.
Pehrson, G. A., Spokane, Wash.
Pember & Demers, Albany, N. Y.
Pennsylvania, Commonwealth of, Department of Property and Supplies, Bureau of Construction, Harrisburg, Pa.
Polaris Concrete Products Co., West Duluth, Minn.
Rackle & Sons Co., The Geo., Cleveland, Ohio.
Redondo & Co., F., San Antonio, Tex.
Reid, Jr., William H., Billings, Mont.
Richards, McCarty & Bulford, Columbus, Ohio.
Robinson Co., The M. C., Ashtabula, Ohio.
Rochester Cast Stone Co., Rochester, N. Y.
Russell, Lance & Muri, Tacoma, Wash.
Sagamore Duntile Manufacturing Co., Sagamore, Mass.
Shanley, Geo. H., Great Falls, Mont.
Shaver, Chas. W., Salina, Kans.
Sioux Cast Stone Co., Sioux City, Iowa.
Smith, Harold R., Colorado Springs, Colo.
Southern Cast Stone Co., Inc., Knoxville, Tenn.
Staub, John F., Houston, Tex.
Stoetzel, Ralph E., Chicago, Ill.
Texas Technological College, Lubbock, Tex. (in principle).
Thomas Cast Stone Co., Ernest, Portland, Oreg.
Thorn, Louis F., Yonkers, N. Y.
Thorne, Henry Calder, Ithaca, N. Y.
Tomlinson, Webster, Joilet, Ill.
Troast & Associates, N. Lester, Juneau, Alaska.
Trusswall Stone Co., The, Kansas City, Kans.
Tyler Art Stone Works, Tyler, Tex.
United Engineers & Constructors, Inc., Philadelphia, Pa.
Universal Atlas Cement Co., Chicago, Ill. (in principle).
Valentine, Chas. W., Milwaukee, Wis.
Van Dyck, A. R., & Floyd W. Brown, Minneapolis, Minn.
Virginia Polytechnic Institute, Blacksburg, Va.
Ward, Walter G., Manhattan, Kans. (in principle).
Watkins, J. S., Los Angeles, Calif.
Watkins Co., Ltd., Vernon, Calif.
Willatsen, Andrew, Seattle, Wash.
Wischmeyer, Wm. F., St. Louis, Mo.

Wright, Frank H., Detroit, Mich. (in principle).
Wyatt & Nolting, Baltimore, Md.
Zantzinger & Borie, Philadelphia, Pa.
Zoller & Muller, New York, N. Y.

UNITED STATES GOVERNMENT

Federal Emergency Administration of Public Works, Housing Division, Washington, D. C. (in principle).
Federal Housing Administration, Technical Division, Washington, D. C.
Interior Department, Indian Service, Washington, D. C.
United States Treasury Department, Washington, D. C.
Veterans' Administration, Washington, D. C.
War Department, Ordnance Department, Washington, D. C.
War Department, Construction Division, Office Quartermaster General, Washington, D. C.

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53–35.	Colors and finishes for cast stone.
54–35.	Mattresses for hospitals.
55–35.	Mattresses for institutions.
56–36.	Oak flooring.

NOTICE.—Those interested in commercial standards with a view toward accepting them as a basis of everyday practice in their industry, may secure copies of the above standards, while the supply lasts, by addressing the Division of Trade Standards, National Bureau of Standards, Washington, D. C.

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