



HADDONSTONE

MATERIAL DATA SHEET

Haddonstone® SEMI-DRY CAST Samples marked "H"

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"Haddonstone"® Semi-Dry Cast Limestone material comprising a low water content mix consisting of over 50% small sized crushed limestone (up to 3mm particle size) together with other fine aggregates. These aggregates are mixed together with white cement as the binder plus specialised admixtures, including integral water proofer to reduce water absorption, and cement pigments if colours other than Portland are required. The consistency of the mix achieved is fairly dry "earth moist" which is compacted either by hand tools or with pneumatic rams to ensure that the mix penetrates all the fine details of the mould. The material is held in the mould overnight then vapour cured to achieve equivalent of 14 days curing in the first 24 hours. This gives the product higher initial strength and stronger arrises plus reduced delivery times.

Criteria	Technical Performance
Trade Name	"Haddonstone"®
Manufacturer	Haddonstone Ltd, The Forge House, East Haddon, Northampton, NN6 8DB
Material Density	2,100kg/m ³
Compressive Strength **	Minimum Compressive Cube Strength at 28 days is greater than 35 N/mm ² (MPa)
Maximum Aggregate Size	0-3mm continuously graded
Finish	Ex-Mould (no finishing required)
Thermal Conductivity	Exposed 1.56 W/mK, Protected 1.46 W/mK
Water Absorption **	In accordance with UKCSA Technical Manual and BS 1217:2008. Last 12 months testing no result above max permitted mean of 1.0mg/mm ² nor any individual result exceed 1.3mg/mm ²
Fire Resistance	Non-Flammable, Non-Combustible, does not give off Toxic Gases Reaction to Fire: Euroclass A1
Freeze / Thaw Resistance	Complies with UKCSA Standards so products deemed Freeze/Thaw Resistant
Handling Reinforcement Specification	Where appropriate units may contain one or more high tensile, stainless steel, synthetic fibre or extruded Basalt reinforcement bar (30mm minimum cover)
Cast In Lifting Sockets available	No (not recommended due to the binding properties of a semi-dry mix)
Cast In Fixings available	No (not recommended due to the binding properties of a semi-dry mix)
Structural Reinforcement available	No (not recommended due to the binding properties of a semi-dry mix)
Colours Available	Portland, Bath, Ivory Limestone, Terracotta (special colour match service also available)

**** Testing is carried out in house, or periodically by outside independent laboratories in accordance with UKCSA standards**

For a full list of standards please refer to UK Cast Stone Association (UKCSA), of which Haddonstone is a Full Member:

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