

CRITERIA for FULL MEMBERSHIP:



1 DEFINITIONS

- i) The UKCSA shall refer to the United Kingdom Cast Stone Association.
- ii) Cast stone shall be defined as any material manufactured with aggregate and cementitious binder that is intended to resemble the appearance of, and be used in a similar way to, natural stone. Cast stone is either homogeneous throughout or consists of a facing material and a backing material.
- iii) In the context of these criteria, Member shall refer to a Full Member of the UKCSA

2 MANUFACTURING

- i) A Member shall have a UK facility dedicated to the manufacture of cast stone.
- ii) A Member shall have been producing cast stone to a minimum standard of BS 1217 for a continuous period of not less than five years.
- iii) A Member shall have had an average annual turnover for the last five years of not less than £350,000 in the production of cast stone.
- iv) A Member's turnover in the production of cast stone shall be readily identifiable and separated from any other turnover in any other operation which the Member may carry out.
- v) A Member shall have public liability insurances cover of a minimum £3,000,000 and shall submit a copy of the policy document to the UKCSA on an annual basis.
- vi) A Member shall inform customers in the event of sub-contracted products purchased from a non-UKCSA Member company being supplied to them.

3 FACILITY INSPECTION

- i) All new applicants for Membership shall submit their production facilities for inspection by duly authorised representatives of the UKCSA.
- ii) The facility inspection shall include investigation of, but not be restricted to, the items detailed in the UKCSA Operating Standard – Audit Document.
- iii) Membership of the UKCSA shall be conditional upon a favourable report from the facility inspection.
- iv) Membership of the UKCSA shall be conditional upon evidence being shown of full compliance with all items detailed in the UKCSA Operating Standard – Audit Document.

4 TESTING

- i) A Member shall comply fully with the UKCSA specification for cast stone and shall submit an annual return to confirm this.
- ii) A Member shall undertake regular testing to confirm compliance with the UKCSA specification for cast stone. The minimum testing required for compliance purposes shall be as detailed below.
- iii) COMPRESSIVE TESTING
 - a) Compressive testing shall be carried out on a set of three cubes in accordance with BS1881.
 - b) A set of three cubes shall be taken from representative samples of each of the semi-dry, wet cast, and backing mixes, as appropriate for the individual Member.
 - c) Each set of three cubes shall be taken from a single batch of representative mix, and compacted in the same way as the finished cast stone.

- d) The average compressive strength of a set of three cubes shall not be less than 35 MPa at 28 days old. No individual cube is to have a strength of less than 28 MPa.
- e) A Member shall carry out cube compressive testing on a set of three cubes taken from representative samples of each of their semi-dry, wet cast, and backing mixes, as appropriate for the individual Member, on a minimum of a weekly basis and submit the test results to the UKCSA.
- f) Compressive test results shall be relevant for the week in which the samples are taken for UKCSA compliance purposes.
- g) A Member with an annually calibrated in house compressive test machine may submit in house compressive test results for the weekly tests, together with a set of compressive test results from a UKAS accredited laboratory on a quarterly basis. Evidence of the UKAS traceable calibration for the in house compressive test machine shall be provided to the UKCSA on an annual basis.
- h) All weekly cube compressive test results from other Members shall be from UKAS accredited laboratories.

iv) CAPILLARY ABSORPTION TESTING (CAT)

- a) Capillary absorption testing shall be carried out in accordance with Appendix 2 of the UKCSA Technical Manual for cast stone.
- b) The mean co-efficient of water absorption due to capillary action of three samples shall not exceed 1.0 mg/mm², with no individual value exceeding 1.3 mg/mm².
- c) A Member shall carry out capillary absorption testing on a minimum of a quarterly basis on representative samples of their semi-dry mixes and on a minimum of an annual basis on representative samples of their wet cast mixes, as appropriate for the individual Member, and submit the test results to the UKCSA.
- d) CAT results shall be relevant for the quarter in which the samples are taken for UKCSA compliance purposes.
- e) A Member with a Third Party Assessed Quality Assurance Scheme for their capillary absorption testing may submit in house CAT results for semi-dry mix for one out of every two returns. The remaining semi-dry CAT results and all annual wet cast mix CAT results shall be from UKAS accredited laboratories. Evidence of the Third Party Assessment shall be provided to the UKCSA on an annual basis.
- f) All CAT results from other Members shall be from UKAS accredited laboratories.
- v) All conformity returns and test result shall be submitted to the UKCSA within 90 days of their due date.
- vi) A Member shall be allowed no more than a 5% failure rate for test results submitted to the UKCSA for compliance purposes, in line with normal statistical practice.

5 OPERATING STANDARD - AUDIT DOCUMENT

- i) A Member shall comply fully with all items detailed in the UKCSA Operating Standard – Audit Document.
- ii) A Member shall submit a completed Operating Standard – Audit Document on an annual basis, to confirm compliance with all items detailed.