

# ARCHITECTURAL **precast**

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# ARCHITECTURAL precaster

SECOND QUARTER 2024



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## PRESIDENT'S MESSAGE

*Jesse Thompson, Northern Design*

*"If it was easy, everyone would be doing it."*

I'm willing to bet that's a phrase many of us use on the weekly. As an architectural precast producer, there's a surprise or new challenge around every corner. Our ability to navigate those situations, find solutions and execute results is what makes us an integral player on every project's team.

The APA gives us the tools we need and experience we crave to hone those skills and be the best version of ourselves. Plant Certification keeps us on our toes and educational content keeps us on the front edge of the wave of progress and innovation.

APA Associate and Professional Members are not only there for us when we need materials and services, they are the cornerstone of our group's comradery and bring their knowledge and personality to both meetings and the APA's educational webinars. We are strong because we are supported by the best in the industry ... that means a lot.

The Spring Workshop in Tacoma was a wild success. Over 90 registrants attended to enjoy fun social events, hands-on demonstrations at Northwest's brand-new precast facility and a level of open collaboration that you just don't see in such a competitive industry.



More of the same is expected in beautiful Park City in late October. This year's APA Convention is not to be missed, with impactful speakers and a special Plant Tour at Unlimited Designs, one of North America's leading GFRC producers.

Enjoy the summer -- see you in Utah!

Jesse

## LUNCH & LEARN WEBINAR

**3D Modeling: From Sales to Manufacturing - How to Make Your Software Work for You**

**Rod Johnson**  
Lucas Concrete Products

**July 31st - 12:00 p.m. (EDT)**

View on the APA YouTube Channel:  
[@architecturalprecast](#)





# An In-Depth Look at an APA Award Winning Project

THE TEMPIETTO AT LARZ ANDERSON PARK

NORTHERN DESIGN PRECAST

APA 2023 CRAFTSMANSHIP AWARD WINNER

APA 2023 DESIGN AND MANUFACTURING AWARD WINNER

Klopfert Martin Design Group (Architect)

SumCo Eco Contracting (General Contractor)

## Overview

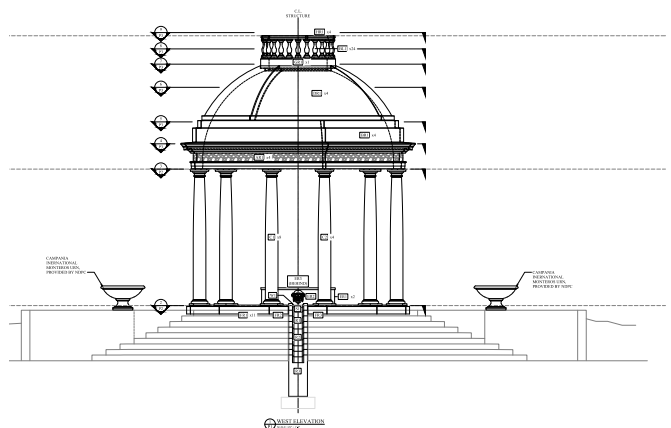
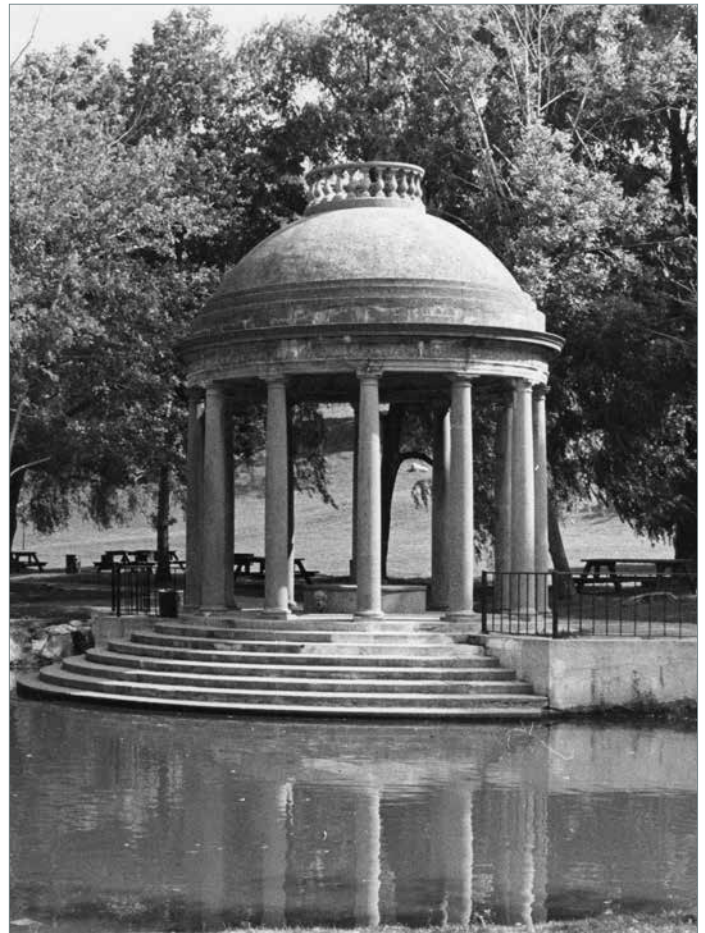
This project involved the complete restoration of a historic, 100+ year old tempietto, which offers solace at the far end of a pond in this beautiful park. The “Temple of Love” was originally built in 1910. The town’s primary objective in this project was to retain the historic character and detail of the structure, replacing it in kind and allowing the park to stay true to itself for the next century and beyond.

## Design

With the exception of the granite veneer, terrazzo paving and the cast in place wing walls, stairs and outside ring, the remainder of the project is precast: the fountain basin with integral Saytr’s mask and runnel stones that channel down to the water; the ring of stylobate base stones and the baluster assembly at the peak; the two flower urns and the egg shelled dome panels; the twelve (12 foot tall) columns and the brow band above with granite veneer inlay; it is all precast.

The centerpiece of the assembly is the water basin, which pulls water from the pond and flushes it back out through the Saytr’s mask mouth and down the precast runnel stones. The Saytr’s mask was recreated from the existing stone. Retained during demolition, the Northern Design team repaired the face to its original shape and detail, then made a rubber mold to incorporate it into the face of the basin / bathtub wall mold.

Northern Design was tasked with replicating that feature, so the mask was poured with a white color, which can be seen in the pictures. They poured that part of the piece first, wet setting pins and pouring the rest of the piece (with the primary mix) a few hours later. The design team



*continued on next page*



also created confidence in the build by incorporating notches in the middle ring and dome roof stones so they could “Lego-connect” and work upwards towards a self-supporting system. Lastly, the granite inlay was a huge part of the design, not only to replicate the size and shape of the granite itself, but the overall texture of the veneer (more jagged and uneven than modern veneer) and the color and depth of the grout (which has a slightly different tone than the precast).

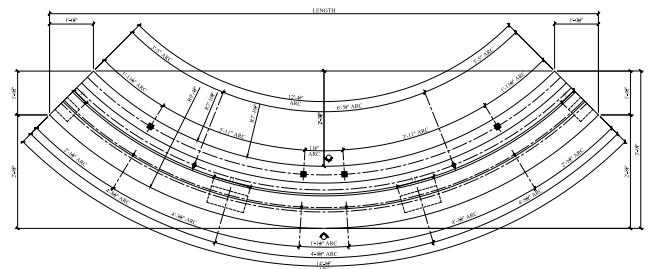
### Compatibility With Natural Surroundings

Many who visit the park make it a habit to circle the pond and this unique structure is the highlight of that walk. The original was very impressive, and the Northern Design team often contemplated the difficulty of building a structure of that nature over 112 years earlier. The tempietto offers a sense of peace, quiet and solitude in a township that rests just outside a major city. A true escape from the chaos and busyness of life. On the other hand, the concrete nature of this structure offers a sense of safety and fortitude. The earthy color and tone of the

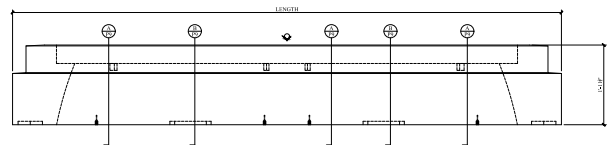
assembly ties it into the nature that surrounds it, and it is no wonder why people are drawn to sit and stay a while. The tempietto is truly a relic that deserves to be honored and it is fitting that this architectural centerpiece is forever preserved.

### Manufacturing Excellence

Matching the existing concrete was a challenge. The old mix contained a tiny white aggregate and the different parts of the structure had weathered differently and were obviously failing. The Northern Design team worked closely with the design team and historical consultant to find a happy medium, where the new Tempietto would dawn the same tone, look and feel as the original, all while providing a mix design that would be consistent and durable. Using a slightly larger stone was critical for the latter, so a crushed granite that yielded great strength and was a very close color match was used. Northern Design added black sand to the mix to give the stone an aged appeal. The mix also contained a combination of dry pigments to create an earth tone that simulated the existing components.

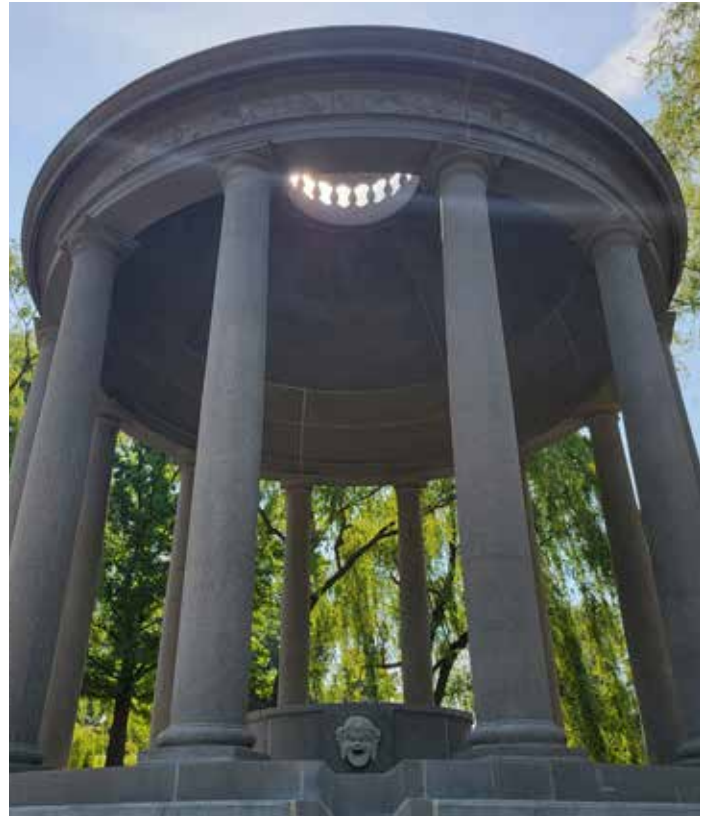


3B11 TOP VIEW PLAN



3B11 FRONT VIEW



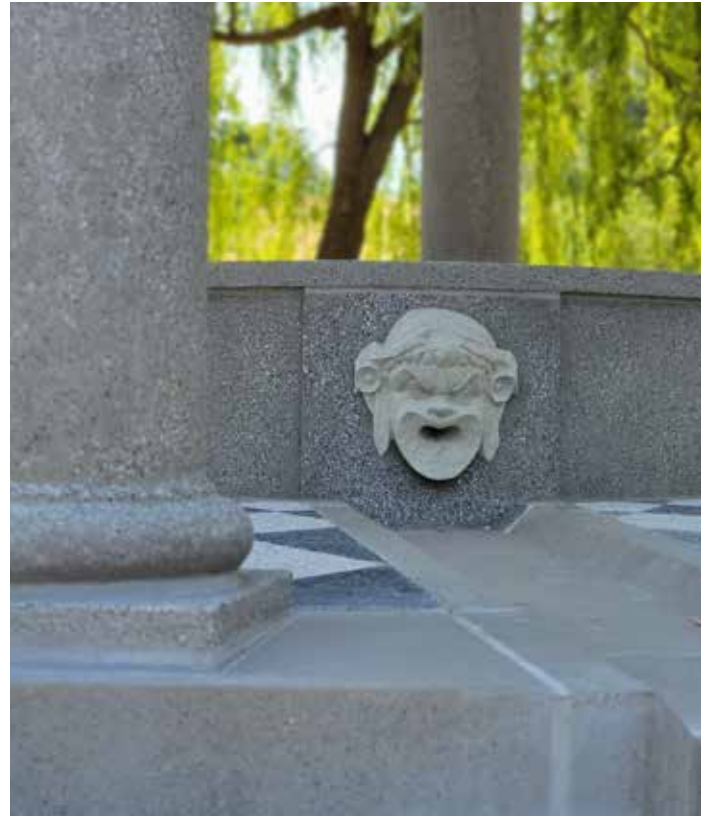


Additional consistency was achieved with both careful pouring techniques and extensive finishing. With pieces of this nature the ND team had little control on pour direction, which is a key factor when trying to control air voids, aggregate distribution and overall quality of finish, face to face. The runnels were almost five feet tall, so they were poured on their sides.

The columns were poured vertically as well, at over twelve feet tall, they required meticulous patching and stoning to control the quality, aggregate exposure and overall consistency. The dome panels are exposed both inside and out, so they were poured like a skateboard ramp -- the mold sitting like an amphitheater with a separate cover mold to hold the 6" thickness. The ND team had to remove the cover about four hours after the pour and steel trowel that inside face in order to achieve a smooth, consistent finish. All the different precast elements on this project posed their own challenges when it came to finishing, not to mention that certain portions of the design required a light finish, to accent the more dominant medium aggregate exposure.







## Challenges

The design and production of the 81 pieces in this project was a tumultuous journey for the ND team. They were able to navigate the challenges with detailed survey work, precise modeling, creative mold preparation and strategic production and finishing. The scanning, modeling, drafting, engineering, detailing (and lots of doubling-checking) took roughly 6 months. Building the sixteen molds and overall production ran another 6 months.

Modeling, mold making and finishing were all equally challenging and important for this project. The model had to be perfect, and the molds had to reflect the model. The finishing was difficult because of varying pour directions and all the precast coming together as one solid unit. Jesse Thompson, Northern Design's President said, "There was little room for error when it came to finish, so the experience and hard work that our employees put into that aspect of the project was a big reason why it was such a success."

## Awards

The Tempietto project received two APA Awards in both Craftsmanship, and Design and Manufacturing. Northern Design's Thompson said, "Due to the unique and difficult nature of this decorative historical restoration, there are few precasters who would be willing to tackle and that could successfully execute a project like this. I am proud of the effort and skill that the Northern Design team applied to this job and them doing so in an award-winning fashion."

### BY THE NUMBERS:

Pieces: 81 Pieces  
 Production Duration: 12 Months Total  
 Molds: 16  
 Total Cubic Feet of Material: 1500

The 2024 UHPC Workshop, held in Tacoma, WA, garnered remarkable support and attendance! The workshop included plant tours at Northwest Precast and Concrete Technologies, engaging educational sessions, and a scenic dinner cruise. More than 90 attendees received hands-on instruction in UHPC production as well as classroom instruction on the unique properties of UHPC, the business cases for using UHPC and more.

To see all photos from the event use the following link: <https://dropevent.com/APA2024SpringWrkshp>



**EDUCATION AND  
HANDS ON  
INSTRUCTION**





**CONNECTIONS  
AND  
CONVERSATIONS**





**PLANT  
TOURS**



**JOIN US IN PARK CITY**



**OCTOBER 25-28, 2024**  
**2024 APA ANNUAL CONVENTION**  
Grand Summit Hotel – Park City, Utah

# 2024 PRELIMINARY SCHEDULE OF EVENTS

(As of 4/2/24)  
Subject to change

## FRIDAY, OCTOBER 25

- 3:00 p.m. – 5:30 p.m. Vendor Registration & Tabletop Displays Setup
- 4:00 p.m. – 5:30 p.m. Attendee Registration Desk Open
- 6:30 p.m. – 8:30 p.m. Opening Night Event

## SATURDAY, OCTOBER 26

- 8:00 a.m. – 12:00 p.m. Registration Desk Open
- 8:00 a.m. – 12:00 p.m. Associate Displays Open
- 8:30 a.m. – 9:00 a.m. General Membership Meeting
- 9:00 a.m. – 10:15 a.m. General Session
- 10:15 a.m. – 10:45 a.m. Associate Displays Open / Beverage Break
- 10:45 a.m. – 12:00 p.m. General Session
- 12:00 p.m. – 12:30 p.m. Associate Member Meeting
- 12:30 p.m. – 6:00 p.m. Afternoon On Your Own
- 6:00 p.m. – 7:00 p.m. Cocktail Reception
- 7:00 p.m. Dinner On Your Own

## SUNDAY, OCTOBER 27

- 8:00 a.m. – 11:15 a.m. Registration Desk Open
- 8:00 a.m. – 11:00 a.m. Associate Displays Open
- 8:30 a.m. – 9:45 a.m. General Session
- 9:45 a.m. – 10:15 a.m. Associate Displays Open / Beverage Break
- 10:15 a.m. – 11:15 a.m. General Session: Producer Roundtable Discussions
- 11:15 a.m. – 12:00 p.m. Tabletop Displays Breakdown
- 12:30 p.m. 10th Annual JBT Championship Golf Tournament
- 6:30 p.m. – 8:30 p.m. APA Awards for Excellence Dinner & Ceremony

## MONDAY, OCTOBER 28

- 8:00 a.m. – 11:30 a.m. Plant Tours & Breakfast

## HOTEL INFORMATION

### Park City Resort - Grand Summit Hotel

4000 Canyons Resort Dr  
Park City, UT 84098  
<https://www.parkcitymountain.com/plan-your-trip/stay/grand-summit.aspx>

### HOTEL RESERVATIONS

Call 855.948.0697 and follow the prompts to the Grand Summit Hotel to receive the discounted rate of \$234 plus a \$35 reduced resort fee per night plus taxes. Mention the APA Annual Convention.

Park City Resort will only be able to offer this reduced rate until **Monday, September 30, 2024**. Please note the APA can only reserve a certain number rooms at the discounted rate. **Once the room block is sold out, even if that day is prior to the cutoff date, a higher prevailing room rate will apply.** Make your reservations today!

For more information on the APA Convention please visit the APA website at [www.archprecast.org](http://www.archprecast.org) or contact the office at 850.205.5637.



Register for Convention  
at [archprecast.org/  
2024-convention](http://archprecast.org/2024-convention)



## Let Your Passion Fuel You!

*By Mack Story*

It was the fall of 2008. The Great Recession was upon us. After 20 years working in multi-billion-dollar organizations, I had resigned to start my Lean Manufacturing consulting business.

I was on my way to meet a potential client, cruising along in my Corvette Z06 listening to music on my iPod through my stereo, as the song title moved across my screen.

Then, the music stopped; a man started talking.

I glanced at the screen. It was a 1 hour overview of *The 7 Habits of Highly Effective People* by Stephen R. Covey. I remembered a friend had downloaded it to my iPod for me...3 years earlier!

I let it play. I had never heard anything like it. That decision changed my life for the better.

*“Educate & obey your conscience. Educate your conscience by studying literature that inspires you the most. Then obey it. Little by little, as you obey it, you will get more education.”*

*~ Stephen R. Covey*

I had accidentally discovered my passion: Personal Growth & Leadership Development.

I began focusing on personal growth & leadership development. Today, I've published 15 books, released 400+ podcast episodes, spoken at Yale, & traveled through 40 states in a single year.

You don't have to be sick to get better. But, you must be intentional, passionate, & take constant action to “get better.”

That's exactly what I did in '08. I didn't just listen, nod my head in agreement, & then, move on like I had never heard it. I took action. Since that day, I've been a full-time student of growth & development content. My personal transformation has been exceptional.

I also discovered John C. Maxwell a few years after Covey. John had this to say about passion:

*"Take a look at four truths about passion & what it can do for you..."*

*Passion is the first step to achievement - Your desire determines your destiny. The stronger your fire, the greater the desire & the greater the potential.*

*Passion increases your willpower - There is no substitute for passion. It is fuel for the will. If you want anything badly enough, you can find the willpower to achieve it.*

*Passion changes you - If you follow your passion, instead of others' perceptions, you can't help but become a more dedicated, productive person. In the end, your passion will have more influence than your personality.*

*Passion makes the impossible possible - Human beings are so made that whenever anything fires their soul, impossibilities vanish.*

*A fire in the heart lifts everything in your life. A leader with great passion & few skills always outperforms a leader with great skills & no passion."*

Make it happen or someone else will. It might as well be YOU! Keep climbing!



Mack Story is the founder of Blue-Collar Leadership. For more information on his books, podcasts and more, go to: <https://bluecollarleaders.com>

## LUNCH & LEARN WEBINAR ○○○○

**3D Modeling: From Sales to Manufacturing - How to Make Your Software Work for You**

**Rod Johnson**  
Lucas Concrete Products

**July 31st - 12:00 p.m. (EDT)**

View on the APA YouTube Channel:  
**@architecturalprecast**





Welcome back, in this addition of the APA Precaster we will cover repairing terracotta clad precast.

## Repairing Terracotta Clad Precast

By Kiley Marcoe, Metro Precast & Stone Services, Inc.

Repairing terracotta requires a few more steps and a few more products than repairing precast concrete but with the help of manufacturers such as Conproco or Cathedral Stone the repair process is much less intimidating.

Terracotta projects can have only one color or many different colors. On projects with only one or two terracotta colors, you can have the repair mortar custom color matched by the manufacturer, this takes about two weeks. On projects with multiple terracotta colors, it is recommended not to worry about the repair mortar color, the color matching will be performed after the repair is installed during the color/paint step.

On projects with only one or two terracotta colors, you may have the manufacturer develop a custom repair mortar if you have the lead time, if time is of the essence, you can follow the below procedures for multicolored terracotta. You will need a repair mortar such as M-100, Terra-matrix, or equivalent color matched mortar. You will also need a clear terracotta glaze such as Terra-Finish, Terra Cotta Glaze or equivalent, either in matte or gloss depending on the terracotta finish. You will not need the Terra-color/paint product, the color is in the repair mortar.

**Step 1** - Prepare the damaged area to eliminate feather edges and remove all dust.

**Step 2** - Install the custom-colored repair mortar over building by a ¼".

**Step 3** - Shave and sand the repair after initial set to create the correct shape and profile.

**Step 4** - Apply glaze to the repair.

The below images are of typical color charts and color sample kits. Custom colors are available.



The below images are of the repair process.



On projects with multiple colors of terracotta we prefer to use only one repair mortar color and color the repairs during the Terra-color/paint step, this avoids purchasing a custom repair mortar for each color. We develop the Terra-color/paint colors in house, but the manufacturers can handle this for you. We find it faster to reorder and helps to avoid over-purchasing by using a local paint store.

**Step 1** - Develop a matching Terra-color/paint that matches each color of terracotta through a series of samples.

**Step 2** - Prepare the damaged area to eliminate feather edges and remove all dust.

**Step 3** - Install the generic-colored repair mortar over building by a ¼".

**Step 4** - Shave and sand the repair after initial set to create the correct shape and profile.

**Step 5** - Color the repair using custom colored Terra-color or color matched masonry paint.

**Step 6** - Apply glaze to the repair.

The images on the next page show the Terra-color/paint color matching process for projects with multiple terracotta colors.



The below images show a terracotta repair. It is important to know when to replace versus repair.



A successful precast repair is equal parts following procedures, experience, and artistic ability.

Until next time, Kiley Marcoe

Metro Precast & Stone Services, Inc. Metroprecast.com

## The APA knows that having the right tools is essential to your success.

APA members are NOW ELIGIBLE for substantial discounts on office supplies through Office Depot's ODP business to business platform. You can receive up to 75% off ODP's "Best Value List" items and the average savings for participants is 24%.

There is no minimum purchase required and next-business-day delivery is **FREE** for online orders of more than \$50 (excludes furniture). You can even set up direct billing, if desired.



For more details, go to: <https://bit.ly/APA-ODP>