

METHOD OF CUTTING GRANITE

From the architect's drawings the draftsmen of the granite business make up setting plans. Each stone is figured as to length and rise and allowance is made for mortar at the joints. This setting plan is then submitted to the architect for approval and correction. As soon as the architect's approval has been secured on the setting plans, the sizes of each piece are listed and this list is sent to the quarry together with the number of each stone take from the setting plans. The quarrymen proceed to get out the stones to make the sizes as listed and paint on each stone its number. In the mean time the draftmen have been making diagrams of each stone showing the various dimensions and finishes required. In cases where there is molded work or any irregular work, the diagrams are accompanied by full size zinc patterns.

As soon as the stock comes in from the quarry, the foreman of the cutting shed assigns each stone to a cutter and gives him the diagram corresponding with the number painted on that particular stone. The first thing the cutter does is take the stone out of wind. This is done by chiseling draft spots on the three low corners and the fourth corner reduced into the same plane with the other three corners. Next chalk lines are snapped from corner to corner and draft lines chiseled along the top of the stone following these lines. After this has been done the stone has a margin of about one inch all around the stone, ~~XXXX~~ The stone is next placed under a surfacing machine. A four pointed tool is first used to reduce the stone all over the top to a surface slightly higher than the margin lines around the stone. Bush hammer blades are next substituted for the four point and the surface is brought to a true and accurate plane.

This stone is then ready for the hand cutter. Chalk lines are snapped on the bush hammered surface thereby laying out on the smooth surface of the stone the ~~XX~~ length and rise of the required dimensions. The four edges of the stone are then broken down and chisel drafts run around these edges. The beds and joints are then completed by removing the surplus stone with a point and hammer.

The above is the process used in manufacturing a plain piece of ashlar. Practically the same process is used in making stones on which there is molded work except that of course more hand work is required in shaping up this type of work.