Notes from the Executive Director

It seems like we just finish the summer issue when the fall issue is ready to go to press. This morning when I left the house it was 38 degrees, a sure sign that fall is coming to Vermont. Of course following on the heels of fall comes winter when I get a chance to meet many of you at conventions and talk about what has been going on in Barre over the past year. This year marked my 10th anniversary with the association and I thought of all the wonderful friendships I have cultivated over those years. Our office has changed dramatically over that time. Yes, even a small association sometimes has to weather the effects of downsizing, but I am confident that we are strong and already meeting the challenges of the 21st century with our members. When I began as Finance Director, we had a larger staff. Now with a smaller staff we find it is much more hectic, but still possible to provide you with all the information and materials you expect.

Competition from overseas was already an issue in 1996 and obviously a major one in 2005. One thing I am hearing more from retailers is that Barre craftsmanship and quality far surpasses anything they are seeing from overseas. Our members can take anything from rough stock to a partially finished product and make it a work of art. Barre craftsmanship will never be replaced and many retailers are telling me that they agree with that statement very much.

Several of you have mentioned to me that you would like to see a show again in Barre. Our last show was in August 1996, so the BGA Trustees have agreed that the time for another show is soon. I am working with President Judee Chatot, North Barre Granite, to put a committee together to work on a Barre event sometime in 2006. As soon as we have some of the details together, we will begin sending information out to all of you. Don’t forget that the winter issue of the magazine has been replaced with our annual calendar. We should have the dates for our event ready to post, along with some more details. In the meantime, remember BGA members are always ready to assist you with any questions or concerns. Along with superior quality products, you will find superb service with all the members of the Barre Granite Association. See you all at the upcoming conventions in Baltimore and Savannah.

John P. Castaldo
The raised letter mailbox post on the cover of this issue represents the craftsmanship passed down for generations at Barre Granite Association firms. At Montpelier Granite Works, Harold Prescott, worked after hours many days to make this beautiful, unique addition to his home.

John Castaldo, Executive Director, is celebrating his 10th year of service with the BGA. John began overseeing the financial strength of the organization; his transition into leadership includes attending many of the industry conventions. Conventions are a great way to stay abreast of new developments as well as staying in touch with sales representatives and colleagues. The 2006 convention calendar is on page 3.

This issue features the symbolism of floral motifs in memorialization on page 4. Insights into the process of creating a sculpture are highlighted on page 10.

The Rock of Ages quarry provides the finest granite for memorialization in the world to BGA member firms. Diane Clark, at GIV, provided a view from a small plane of the quarry taken by 14 year old son Travis, on a Barre Town School field trip to the Berlin Airport - page 9.

I want to recommend a fascinating new book about Carrara, Italy and the great sculptor, Michelangelo's Mountain, by Eric Scigliano. It has been described as "a masterful work...a new kind of narrative fiction, dancing seamlessly between past and present." Scigliano speaks in Barre on October 18th at the Vermont Historical Society. Please continue to let us know how we can best serve your needs as you market the highest quality granite products to your clients.

In closing, I thank many of you for taking the time to send suggestions by mail and e-mail.

Wishing you continued success,

Jim Eaton, Editor

Reprints of photographs in recent issues of Barre Life are available from the BGA office. Reproductions of any of the photographs from the previous three years are available for a nominal fee starting at $5.00 plus shipping and handling.
Granite Industry Convention Calendar

November 3-6, 2005
Central States Monument Convention
Indiana, Illinois, Iowa, Ohio, Wisconsin & the Northwest
Wisconsin Dells Wintergreen Resort
Eric Zabel, WAMB president
920-684-3829
zabelmonuments@lakefield.net

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Mid Atlantic Monument Builders Association
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Karen Gingrich
717-944-3441

February 3-6, 2006
MBNA 2006 100th Anniversary
Hyatt Regency Savannah
Savannah, Georgia
www.monumentalbuilders.org

February 24-26, 2006
New England Monument Dealers & N.Y. State Monument Builders Association
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*Lily*
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Heavenly bliss, The Virgin
The Annunciation, Our Lord’s human nature.

*Poppy*
The Poppy is the symbol of Fertility, Sleep, Rest, Peace

*Grape & Vine*
Symbol of our Lord and his followers, The Church and Unity.

*Ivy*
The Ivy has always been closely identified with Death and Immortality. It is a symbol of Fidelity and Eternal Life, and Undying Affection.

*Passion Flower*
Symbol of Christ, Christ’s Passion and Death; Redemption; Crucifixion

*Morning Glory*
Symbol of the Resurrection; Morning; Youth; Bonds of Love.

*Pansy*
The Pansy is a symbol of Remembrance and Meditation.

*Hollyhock*
Symbol of Ambition; Fecundity

*Oak Leaf*
Because of its Solidity and Endurance, the Oak is the symbol of the Strength; of Faith and Virtue, and of the Endurance of the Christian against adversity.

*Gladiolus*
Symbol of the Incarnation
Daisy
The Christ Child’s Innocency.
Youth. The sun of Righteousness.

Thistle
SCOTLAND
Symbol of Earthly Sorrow and Sin.

Bluebell
Symbol of Constancy.
Sorrowful Regret.

Lily of the Valley
Symbol of the Advent of Christ. Purity and Humility.

Tulip
Symbol of Charity and the Declaration of Love.

Floral Affusion
Symbol of Loveliness and Beauty.

Iris
Eloquence; A Message; Protection. Taken as an allusion to the sorrow of the Virgin at the Passion of Christ.

Narcissus
The Triumph of Divine Love, Sacrifice, and Eternal Life over Death, Selfishness, and Sin.

Acanthus
Symbol of Heavenly Gardens.

Evening Primrose
Lasting Love;
Memory; Youth and Sadness.

Christmas Rose
Nativity of our Lord.

Clematis
Symbol of Mental Beauty

Shamrock
Symbol of the Trinity and St. Patrick.

Holly
Christmas. A symbol of the Passion of Christ.

Anemone
Symbol of Immortality, Ressurection

Laurel
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For more information, contact the Vermont Granite Museum by calling 802-476-4605 write to PO Box 282 Barre, VT or visit www.granitemuseum.com.

**Clay Modeling**
Under the watchful eye of the instructor, students of any age will learn the techniques of 3-D clay sculpting and plaster casting. Classes are held every Saturday morning.

**Instructor:** Giuliano Cecchinelli

**Etching on Black Granite**
This class teaches students the theory of light and dark along with basic drawing techniques applied to etching on granite. Classes are held every other Saturday.

**Instructor:** Anita Lucero

**Sandblast Courses**
Each course is offered for one weekend. Several are repeated.

- **Advanced Cemetery Field Work:** techniques for round-raised, square-raised and V-sunk lettering are taught. October 21st – 23rd.

- **Advanced Sandblast:** Techniques for shape carving and 2nd cutting are instructed in this class – the natural next step for those who’ve had layout and 1st cut experience or instruction. October 21st – 23rd

**Open House Weekend: Beyond the Beginner** This class is designed for the sandblast student who has some experience with sandblasting, and would like instruction on specific techniques or practices such as shape carving, raised lettering and other ways to advance skills. November 4th - 6th or December 2nd - 4th.

**The 8th Annual Barre Granite Festival September 10th, 2005**
Held at the Vermont Granite Museum, the festival was fun for the young and young at heart with demonstrations and hands-on activities in stone. Plan to attend next Fall!
This 4'9" tall, full round abstract sculpture was carved from Cold Spring Diamond Pink Granite for the city of St. Cloud, Minnesota. The carving was commissioned by the St. Cloud Tourist and Convention Bureau for the second annual St. Cloud Granite Festival, which studio head George Kurjanowicz attended as featured artist.
What is considered the finest stone for crafting a memorial? The premium choice is Barre Gray from the Rock of Ages Quarry Division. Barre Granite Association manufacturing firms work directly with Robert Campo, Vice President, and his team of professionals to buy large blocks of the quality of stone by which all other memorial stone is measured.

Barre Gray – “We are proud of our Barre Gray® Granite and the Barre Gray name. This is the gray granite that all others are measured by. I say that because of its quality. Its low absorption and non-staining characteristics make this fine grained dark granite the logical choice when manufacturing a memorial. Our customers, which include BGA member firms, also appreciate the fact that when they buy a block of Barre Gray they know that they are supplying their customers with the best gray granite that is available in the market today.”

American Black - “Since acquiring the property in 1997 Rock of Ages has spent time and money to develop this quarry into the largest producer of quality black granite in the United States. This beautiful black material with white veining is used by several memorial manufacturers, including BGA members, who want to manufacture with a more economically priced domestic black granite which is widely accepted in the market place.”

Robert Campo, V.P., Rock of Ages Corp. - Quarry Division
Finished sculpture is usually presented in *Barre Life*, but I thought I would use this opportunity to stress the importance of the model as it relates to the finished product.

This new figure is the third in a series of ancient Celtic warriors. The clay model is 1/2 scale of an 8' sculpture. The clay, soon to be a plaster model, is the sculptor’s version of the draftsman’s “full-size.” It is the sculptor’s “3 - dimensional road map,” and will guide him through the process of enlargement or duplication in stone. The model functions importantly as a preview for the client, as well as providing the sculptor valuable reference for planning rough dimensional sawing, development of the figure, and in locating key elements of the composition. In this case there are four bronze pieces that will be attached to the sculpture. (Brooch pin, axe, dagger hilt, and torc.)

Corrections and improvements are made in the final stone enlargement, and the model is usually put away after 85 or 90% of the work is done. The last 10 - 15% of the project is done without the aid of the model. This allows for some spontaneity and relief from the painstaking measuring.

Many sculptors prefer to work without a model for repetitive cemetery work, but for original commissioned sculpture, I wouldn’t go anywhere without my “road map.”
This Dark Barre Granite monument was manufactured for Sutphen Memorials in Princeton, New Jersey. The all polished die features sandblast shaped carving in the recessed channels on both the front and the back, with sandblast lettering on the front and back as well. The tablet is 8' long, width 1', height 3'10". The 9' long base has a polished flat top and 10" polished margin on all four sides, balance rock pitched.
This Black Granite monument was created for Bellevue Memorials. The die is 1'6" long, 2' high, all polished with a flat top, laser etched double portrait and sandblast lettering. The bench is 4' long, 1'2" wide with legs 1' high. The base is 6' long, 1'6" wide. The turned vases are 10" in diameter, 1'6" tall, all polished, setting on a 1'2" square, polished top base with polished margin; balance rock pitched.
This stunning 17' memorial manufactured for Len Zeller in East Newmarket, Maryland was created with Belfast Black dies, pedestals and vases. The base and steps are made from Barre Gray Granite. The 9" gold leaf letters are a beautiful contrast with the custom bronze eternal flame. Overall size: 17'3" long, 10'9" wide and 6'4" high.
This original pyramid design was created with all polished Dark Barre Granite by Michael Weeks in memory of his mother. Manufactured for Tyrie and Son Memorials in Cockeysville, Maryland. The die is 8' wide, the all polished plinth is 9' sitting on a 10' polish top base with a polished margin 4 sides; balance rock pitched.
This design incorporates an all steeled Medium Barre Gray Granite die with a cut out to accommodate an all polished Impala Black Granite insert with a sandblast Celtic cross. Manufactured for Brown’s Monument Works in Monroe, Connecticut. The monument is enclosed by a stone wall with Barre Granite coping and posts. Overall die size: 9’ long, 4’8” high.
The stone replacement project required 934 square feet of Barre Regal copings, pillars, balusters, rails and wall panels with a bushhammer finish. The project began in February 2002 and was completed in August 2004. New sections of the wall were installed to replace damaged sections.
The new Columbarium Section of the Massachusetts Veterans' Memorial Cemetery in Winchendon utilizes the strength of Woodbury Granite for the cap roof and the beauty and endurance of the stone for the face.
This Medium Barre Gray Granite memorial has rounded top corners and hand cut columns. The images reflect the Weavers' interest in fiddling and painting. Simple, classic elegance. Die: 3' long, 2'6" high. Base: 3'8" with steeled top, balance rock pitch.
This 9-11 monument was designed and manufactured for **Martin Caufield Memorial Works, Honesdale, Pennsylvania.**

**Northern Granite** cut the Center Gem Mist 3' square all polished die.

**Pepin Granite** cut the Medium Barre Granite wings, plinth and base. Wings 1'4" long, 4' tall. Plinth 1'6" long, 1'5" wide, all steeled beveled face. Base 7'6" long, 1'10" wide, steel flat top, steeled bevel 4 sides, balance rock pitch.

Etching by **Stevens Branch Etchings, LLC** - story on page 22.

The 3'6" steel beams are from Ground Zero, powder coated. The plaques are aluminum.
The family monument created for Robert & Elizabeth Whalen of Witherbee & Whalen, Canton, New York was manufactured from Dark Barre Granite. The die is all steeled with a ridge top. The family name is presented with 4" hand tooled round raised letters, raised 1/2". Crosses 9" tall adorn the ends of the die. Inscriptions are on the back of the die. The length is 4'6". The height is 2'6". The 5'10" long base has a steeled top and a 2" steeled margin, 4 sides.
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How Stevens Branch Etchings Brought This 9-11 Memorial from Concept to Reality
by Randy Walker - Stevens Branch Etchings, LLC

Phil Monaghan, of Martin Caufield Memorials in Honesdale, Pennsylvania e-mailed me a digital file containing an artist's rendering of what this etching was supposed to look like. He wondered if the drawing could be brought to life using the computer to add shading, etc., as he needed to hold the look of this etching as close as possible to the original drawing. I asked Phil if we could re-create this scene using real people and pictures of Ground Zero as a backdrop. After consulting with the monument committee, I was given the go ahead as long as this looked like the original concept. I drove over to the Barre City Fire Department and found our Fire Chief, Peter John and showed him the concept rendering and asked if I could have a fireman pose similar to the fireman in the drawing. Peter agreed and talked with fireman Russ Wood and asked if he would suit up and be the model for this photo shoot. Russ gladly accepted and put on his full gear. We went outside in indirect light and using a digital camera I shot several pictures of Russ from several angles similar to the concept drawing.

After thanking everyone involved at the fire station, I was off to our local National Guard Armory in Berlin for the military aspect of this concept. I walked into the armory and discussed my need with the commanding officer and he advised me that for this to happen I needed permission from the National Guard Public Affairs Officer. He gave me her telephone number and I called her from my cell phone in the parking lot. After hearing my story, she agreed and told me to have the commanding officer call her at her office, which he did. The officer then instructed National Guardsmen, Timothy McCollum, to suit up in full battle gear and released an M-16 weapon that could be used for the purpose of the photo shoot. Once again, we went outside in indirect sunlight making sure that we were facing the same direction of the photo shoot with the fireman, so the shading would be similar. Like before, I took many digital photos from different angles similar to the rendering, so I had many options once I transferred these files to my computer system.

After thanking all who were involved at the National Guard armory, I was off to the office to put this all together in the computer. I stopped along the way to pick up a flag on a pole from a local church; I took pictures in varying angles of drapery so I had many options of what the flag would look like on this memorial. I had many pictures of the devastation at Ground Zero to use as a backdrop, so I started with that and added my cropped fireman, soldier, flag and pole to the backdrop and then blended it all together with additional shading, digital filters and adding small pieces of cropped backdrop around the figures so they would appear to all be part of the same moment in time. After a few minor blending changes, I was given the go ahead to etch this project quickly as this monument needed to be on-site for a 9-11 memorial service, and I was only one week away from that. We completed the project, and got it shipped in time to meet my customers needs.

Stevens Branch Etchings, LLC specializes in custom designed etchings that many might think would be impossible to do. Our motto is “If it can be done, it can be done here well!”
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Lettering Small and Large

by Jim Eaton, Editor

What are the limits to creating small lettering and large lettering in granite and stone? The simple answer is that the smallest size using sandblasting is 1/2". I spoke with several industry professionals with extensive experience and knowledge of sandblast process. Here is their consensus.

Todd Tosi, Tosi Custom Sandblast – “The type of stone is a factor. Different granites have different size grain. For example Mahogany has a larger grain than Barre Gray. Some of the black granites, technically gabbro, have a very fine workable grain. The challenge with small letters is the very small center details on letters such as a, e, d, and p. We say 1/2” is the lowest limit.”

Jeff Salvador in the technical rep for Miles Supply agreed, explaining that the stencil used in the process from major manufacturers like Anchor and 3M limits the small end to 1/2”. He mentioned some field research, on a project driven request for the smaller inscriptions on a marble like stone done by Jim Moulton, the sandblast foreman at Adams Granite Co. He had provided Jim with finer than usual media, 120 silicone carbide. A rarely used Mylar stencil material called Photoblast was provided by the project designer. Moulton showed me the project which they completed shown below but stated, “granite is a much harder material. He said 1/2” is as small as I would recommend.”

Sherman Cochran, Cochran’s Inc., has developed computer guided sandblasting and laser etching equipment. He said his “automated sandblast unit would provide 1/2” lettering, but for smaller lettering such as on a poem, laser etching on a dark granite is possible as small as you want to go.” Randy Walker, Stevens Branch Etchings, LLC, made the same point. “Extremely small letters and details are technically possible with computer controlled laser etching on dark granite with today’s technology.”

Large letters simply require large budgets. Skilled craftsman can cut stone in the classical tradition as large as you would like. The large K is part of a project underway at Dartmouth College in Hanover, N.H. by Granite Importers. Eight foot and larger lettering is available from select BGA firms.

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Thanks to Bob Couture at Family Memorials for passing on one of his customer’s technical questions. If you have any questions about the design or manufacturing processes, please let us know at Barre Life. We welcome suggestions and your article submissions for review.
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TCS Memorials
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32 Granite Street
Barre, VT 05641
800-672-9900/802-476-8718
Fax: 802-476-6962
Jim@TCSMemorials.com

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Todd Tosti
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West Berlin, VT 05663
802-476-3851
Fax: 802-476-3851
| Accounting | Salvador & Babic PC  
| Tom Babic  
| 240 S. Main Street, Barre, VT 05641  
| 802-476-8673 – Fax: 802-479-5165 |
| Artisans | Barre Sculpture Studios  
| Jerry Williams  
| 2 Sunset Avenue  
| Montpelier, VT 05602  
| 802-479-0669 – Fax: 802-476-0916  
| statue@adelphia.net  
| www.barresculpture.com |
| John P. Hanna | Sculpture Studios  
| John P. Hanna  
| 369 Cutler Corner Road  
| Barre, VT 05641  
| 802-479-2889 – Fax: 802-479-5730  
| Cell: 802-272-8076 |
| Eric Oberg, Sculptor | 1777 W. County Road  
| Calais, VT 05648  
| 802-223-2551  
| Fax: 802-223-2551  
| www.granitesculptor.com  
| eoberg@together.net |
| Sofia’s Studios, Inc. | Sofia Shatkvska  
| 42 Richardson Road  
| Washington, Vermont 05675  
| 802-883-5490 |
| Stanislaw Lutoslawski | Sculpture Studio  
| Stanislaw Lutoslawski  
| P.O. Box 265, E. Barre, VT 05649  
| 802-479-2531 – Fax: 802-479-2531  
| stlut@aol.com |
| Stevens Branch Etchings, LLC | Randy Walker  
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| rwalker@sketch.com  
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| 292 North Main St., Barre, VT 05641  
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| spoczobut@chittenden.com  
| www.Chittenden.com |
| Community National Bank | Steve Garin  
| 316 North Main Street, Barre, VT 05641  
| 802-476-6565 – Fax: 802-476-1185  
| barre@communitynationalbank.com  
| www.communitynationalbank.com |
| Key Bank of Vermont | Jennifer Flies  
| 315 N. Main Street, Barre, VT 05641  
| 802-476-4135 – Fax: 802-476-3316  
| www.key.com |
| Computer Services | Breen Systems  
| Management, Inc.  
| Matthew P. Mertens  
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| 802-879-4212 – Fax: 802-879-1717  
| mert@breeensys.com  
| www.breeensys.com |
| Educational | The Vermont Granite Museum of Barre  
| Tess Taylor  
| General Manager  
| P.O. Box 282, Barre, VT 05641  
| 802-476-4605 – Fax: 802-476-6866  
| info@granitemuseum.com  
| www.granitemuseum.com |
| Insurance | Berg, Carmolli & Kent, Inc.  
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| 802-479-1046 – Fax: 802-479-2761  
| dickh@BCKinsurance.com  
| Denis, Ricker & Brown Inc.  
| Matt Lumsden  
| P.O. Box 565, Montpelier, VT 05601  
| 802-229-0563 – Fax: 802-229-9327  
| mlumsden@drbinsurance.com |
| Investing | Edward D. Jones  
| Hans Aspre  
| 322 North Main Street, Suite 4  
| Barre, VT 05641  
| 802-476-6200 – Fax: 888-233-5557  
| www.edwardjones.com |
| Legal Services | Zalinger, Cameron & Lambek, PC  
| J. Scott Cameron  
| 140 Main Street  
| P.O. Box 1310  
| Montpelier, VT 05601  
| 802-223-1000 – Fax: 802-223-5271  
| jscameron@zclpc.com |
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| printldb@aol.com |
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| terry@dessureau.com  
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| Ducharme’s Machine Shop | Pierre Ducharme  
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| Granitville, VT 05654  
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| Granite City Tool Company | Donald Allen  
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| 800-451-4570 / 802-476-3137  
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| vgctmail@aol.com  
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| Gran-Quartz L.P. | Peter deKok  
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802-479-0101 – Fax: 802-479-0135
800-639-2901
bseel@reynoldsandson.com
tgoulette@reynoldsandson.com
mshatney@reynoldsandson.com
www.reynoldsandson.com

**Stone Tech, Inc.**
Diamond Tools
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P.O. Box 661, Barre, VT 05641
802-476-3122 – Fax: 802-476-4140
StoneTech@verizon.net

**Trow & Holden Company**
Norm Akley
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For more information about Maplecroft contact Paul Heller
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Barre, VT 05641
www.maplecroftvermont.com
A New BGA 2 DVD Set is Available - 21st Century Granite Innovation & Craftsmanship

The Barre Granite association is proud to announce a new 2 DVD set highlighting innovative new technologies in the granite industry. **21st Century Granite Innovation & Craftsmanship** provides a behind the scenes look at the large computerized saws that have become state of the art equipment in the industry.

The DVD features scenes of the latest equipment and skilled, talented, craftsman in action producing memorials and granite products of the highest caliber. **21st Century Granite Innovation & Craftsmanship VOLUME 1** is designed to be played in your retail show room to showcase the process of memorial art creation for your clients with a music sound track. The second DVD **VOLUME 2** includes narration and facts pertaining to the granite industry scenes and is useful for answering commonly asked questions. Running time is approximately 15 minutes.

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22. Single Video, approximately 10 minutes $19.95

23. Continuous Viewing of Video, approximately 2 hours, $24.95
This Bahama Blue Granite monument with a hand carved design in the 2' niche is 2" deep. The monument was manufactured for Bottaro Memorials in Springfield, Massachusetts. The die length is 3'6", the height 2'6", polish 5. The 5' base has a polished top with a 2" polished margin and an 8" cored hole.

Granite Industries of Vermont held its first production show on September 16th - 18th at the Bureau of Outdoor Recreation facility. The event was well attended with retailers coming from as far as Dubuque, IA. A wide variety of quality products were displayed.

The show was deemed a success and a good time was had by all.

Sofia Shatkivska of Sofia's Studios, Inc. is in the middle phase of the design process for Judee Chatot, North Barre Granite Co., for her personal monument. The design process involved several evolutions on paper before she started the clay model.
The portrait and police badge were laser etched on the Jet Black Granite die with a special cut top. The monument was manufactured for Melvin Monuments in Harrington, Delaware. Die: length 2’2”, height 3’, polish 3. Sub-base: length 2’6”, width 1”, polish top, polish scotia with lettering. Base: length 3’6”, width 2’, polish flat top, with a special cut front and 4” polished margin, balance rock pitched, etched and lettered.