

**Huntsmans** is a small company in an industry increasingly dominated by a few very large operators. In its own area and in its particular market sectors, it is very much a leader - in terms of the range and quality of its products and because it still provides an essentially personal service.

Customers appreciate the special honey and buff colours of Huntsmans stone and its renowned frost-resistance. Rockery stone, chippings, slates, walling stone and gravels all carry with them the unique warmth of the Cotswolds. Other products such as agricultural lime and equestrian drainage media each have their own quality niches in competitive markets.

The company operates two key sites - a major hard rock quarry at Naunton near Stow-on-the-Wold and a sand and gravel quarry some 15 miles away at Bishops Cleeve.



## A long tradition

The origins of today's quarry at Naunton, go back hundreds of years when randomly quarried Cotswold slate was in demand far and wide. Such was its fame that it was even transported to London on river barges.



The focus changed in the 1920s when the unique frost resistance of this particular pocket of Jurassic limestone earned a new reputation as a high quality aggregate. In those days, the rock was worked by hand and transported by horse and cart.

The advent of mechanical power brought a steady expansion of the operation, and in 1936 Huntsmans Quarries became a private limited company. Updated crushing and screening plant was added in the 1960s as the quarry responded to the demand for aggregate, particularly for the M4 and M5 motorways. Investment has continued in more recent years as the operation has met increasingly demanding product and environmental specifications.

Today, Huntsmans is the only supplier of high quality aggregate within 30 miles of Stow-on-the-Wold. It is a major employer and contributor to the local economy.

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# AGGREGATES

Huntsmans has a long tradition of supplying aggregates to the construction industry over a wide area covering Gloucestershire, Worcestershire, Herefordshire, Wiltshire, Warwickshire and Oxfordshire. The company operates both crushed rock and sand and gravel quarries.

## CRUSHED ROCK

Crushed limestone comes from the company's quarry at Naunton, near Stow-on-the-Wold which produces a range consisting of:

- Clean aggregates for construction, drainage and concrete.
- Sub-base for roads and car parks
- General fills for construction
- Filter media for drainage
- Pipe beddings for pipelines
- Washed chippings for drives, paths and gardens
- Washed sands for concrete products and paving
- Milled lime for agriculture & concrete products
- Block for armour or decorative.

## SAND AND GRAVEL

Sand and gravel comes from the company's quarry at Bishops Cleeve. The following grades are available:

- Washed building sand
- Washed concrete sand for screeding and block paving
- Concrete mixture
- Washed gravel for construction, drainage and gardens.



*Drainage at Cheltenham racecourse*



*Rock armour, Bidford-on-Avon*



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**HUNTSMANS**

# AGRICULTURAL LIME

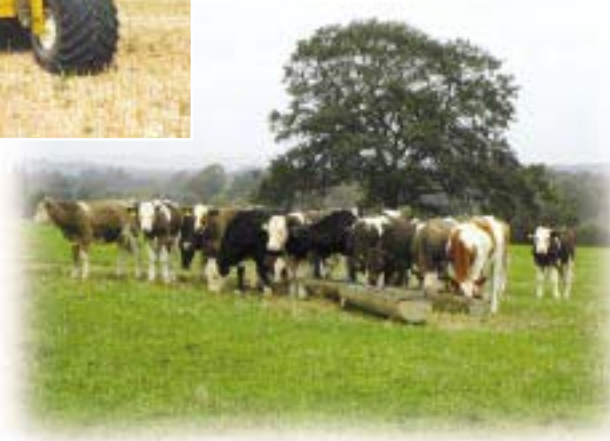
The importance of lime to good soil husbandry is often underestimated. Huntsmans has been producing quality agricultural lime for farmers for over 50 years. Through cooperation with selected independent merchants, Huntsmans can offer a cost-effective service from advice to application. The lime is manufactured to a high specification and stored under cover prior to delivery.

## AGRICULTURAL LIME

- Improves soil structure
- Is essential for maximum crop yields
- Improves stock, health and growth
- Is essential for maximum benefit from fertilisers and sprays
- Is a high value low-cost material
- Is distributed by skilled operators and modern machinery
- Can be delivered by a variety of vehicles to ensure access to awkward fields.

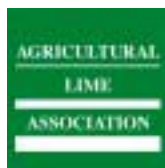
Farmers are also important users of aggregates for roads, tracks, buildings, drainage and other projects.

SPECIFICATION	
neutralising value	50%
sieve size	% passing
5 mm	100
3.35 mm	95
150 micron	30



Photography courtesy of LJ & MD Righton

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AGENT

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# EQUESTRIAN PRODUCTS

**Huntsmans operates at the heart of an area famed for its equestrian activities. As a result, its high quality drainage aggregates have become the first choice for racecourses, all-weather gallops and for indoor and outdoor ménages.**

Huntsmans offers a range of aggregates ideal for the varying drainage needs of the equestrian industry.

The company produces crushed rock, sand and gravel ranging from 150 mm down to 6mm single size. As with all Huntsmans products, our drivers pride themselves on delivering to the tightest of schedules and to the most difficult of locations.

Our aggregates have been extensively used in:

- All-weather gallops
- Racecourses such as Cheltenham, Stratford and Warwick
- Indoor and outdoor ménages
- Exercise tracks
- Horse-walkers.

Major contracts have included racing establishments in the Cotswolds, and all-weather facilities for trainers over a much wider area.



*Ménage at Micklands Hill Farm*



*Lavender Hill Stud all-weather gallops*



*Nigel Twiston-Davies all-weather gallops*

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# NATURAL STONE SLATES

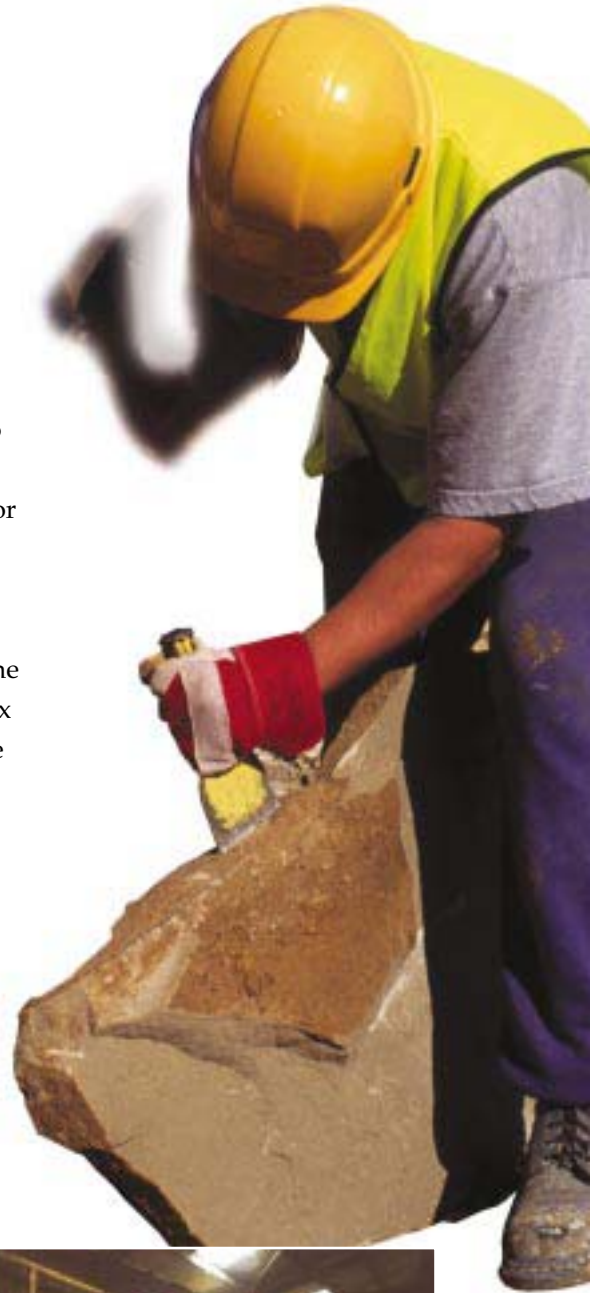
**Cotswold stone is known throughout the world as one of the most beautiful and durable of all building materials. Huntsmans traditional slates and walling stone bring you the timeless beauty and warm colouring of a stone laid down 160 million years ago.**



Huntsmans slates are hand-made in our own quarry using individually selected beds of Jurassic limestone. Every tile is unique and hand-dressed by our own craftsmen.

The stone is typically 1" (22 mm) thick and produces slates from 6" to 24" (150mm - 600mm) of varying widths. This creates opportunities for a number of interesting and traditional laying patterns.

Slates can be sold individually, by the metre-run or by the 'square' (ie. 10' x 10' [3.0m x 3.0m]). Large orders are supplied shrink-wrapped on pallets or in crates.



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# NATURAL COTSWOLD WALLING AND PAVING

**Cotswold stone is known throughout the world as one of the most beautiful and durable of all building materials. Huntsmans traditional slates and walling stone bring you the timeless beauty and warm colouring of a stone laid down 160 million years ago.**



## WALLING

The stone used for Huntsmans walling is hand-selected from the different beds in our Naunton quarry in order to offer our customers the unique variation of finish that makes Cotswold stone so special. Walling is available in two colours:

- Classic – the world-famous honey cream colour
- Premier - a buff, darker and more weathered appearance.

The stone can be delivered in small or large loads.

## PAVING

Paving in Cotswold stone brings a natural warmth to your garden on the gloomiest of winter days. The same hand-selection but with a random or sawn finish, means that our customers are assured of a quality product.



*Walling at Salperton Park Estate*

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This product list provides an overview of Huntsmans products. The list is constantly developing and individual products can often be tailored to meet customers' precise needs. Please contact our Sales Office to discuss your requirements in more detail and to check current prices.

PRODUCT	SPECIFICATION	TYPICAL USES
<b>Crushed Rock</b>		
Hardcore	As dug	General fill
Selected Hardcore	125mm crushed / screened	Farm roads, fill
Crusher Run	100, 75, 40 mm	Unclassified roads and foundation fill
6F1 & 6F2	BS 1377 Table 6/1 & 6/2	Capping layer for roads and general construction
Granular Sub-base	Type 1 to BS Clause 803	Highway approved roads
<b>Clean Aggregate</b>		
150mm	BS812 6G Table 6/1	Gabion, soakaways
100 & 75mm		General construction, drainage, equestrian
40mm	Type B to Clause 505	Filter media, French drains, equestrian
20, 14, 10, 6mm	BS882	Pipe bedding, concrete products, sports field drainage
Washed concrete sand	BS882 Table 4 Coarse/ Medium	Ready mixed concrete, concrete products, screeding, block paving
Limestone dust	3-0mm	Concrete products, blinding
Armour rock, Block stone	To specification	Revetments and protection
<b>Sand &amp; Gravel</b>		
Washed building sand	BS 1200 & BS 1199	Mortar & plastering
Washed concrete sand	BS 882 Table 4 Coarse/ Medium	Ready mixed concrete, concrete products, screeding, block paving
Concrete mixture	BS 882 Table 5	Concrete
Washed Gravels, 20, 10, 6mm	BS 882 Table 3	Construction, drainage, concrete, field sports drainage, pipe bedding
<b>Lime Products</b>		
Agricultural Lime	Fertiliser Regs 1991 (no 2197)	Soil improvement
<b>Natural Decorative Products</b>		
Washed Premier chippings	20, 14, 10, 6mm buff colour	Drives, paths and landscaping
Washed Classic chippings	20, 14, 10, 6mm honey colour	Drives, paths and landscaping
Washed Amber gravels	20, 10, 6mm	Drives, paths and landscaping
Natural hand finished Cotswold slates	To specification sizes from 6 to 24 inches	Roofing
Random sawn paving		Decorative patios
Hand selected walling	Classic or Premier	Natural Cotswold walling
Rockery stone	Hand selected to size	Decorative gardens
Dressed building stone	Hand selected and split	New build and restoration

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**HUNTSMANS**

# ENVIRONMENTAL PORTFOLIO



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**Huntsmans operates in an Area of Outstanding Natural Beauty and accepts a responsibility to minimise the impact of its work on the environment and on its neighbours in the local community.**

**Meticulous planning and strict management disciplines are applied to control impacts on a day-to-day basis.**

**Restoration of land previously quarried is an area in which the company recognises an opportunity to create exciting new environments and habitats. It acknowledges the significant help and encouragement it receives from local authorities, nature conservation bodies and individuals.**

# HUNTSMANS QUARRY

To date, the company has restored around 85 hectares of the 104 hectare quarry taking the opportunity to create a wildlife lake and to plant over 10,000 trees, 6,500 shrubs, and 2km of hedgerow.

Natural areas have recolonised to good effect and the site contains one of the largest known populations of the extremely rare Cotswold

Pennycress, together with a wide variety of flora and fauna. In addition, Huntsmans has created an SSSI of significant geological importance.

The majority of the land has successfully been returned to agricultural use. The restoration technique, adopted and refined by the company, has resulted in the latest 16 hectares being restored to a higher quality than prior to quarrying.



*Huntsmans Chairman, John Milner,  
receiving QPA Restoration Award  
from George Alagiah*



## BECKFORD QUARRY

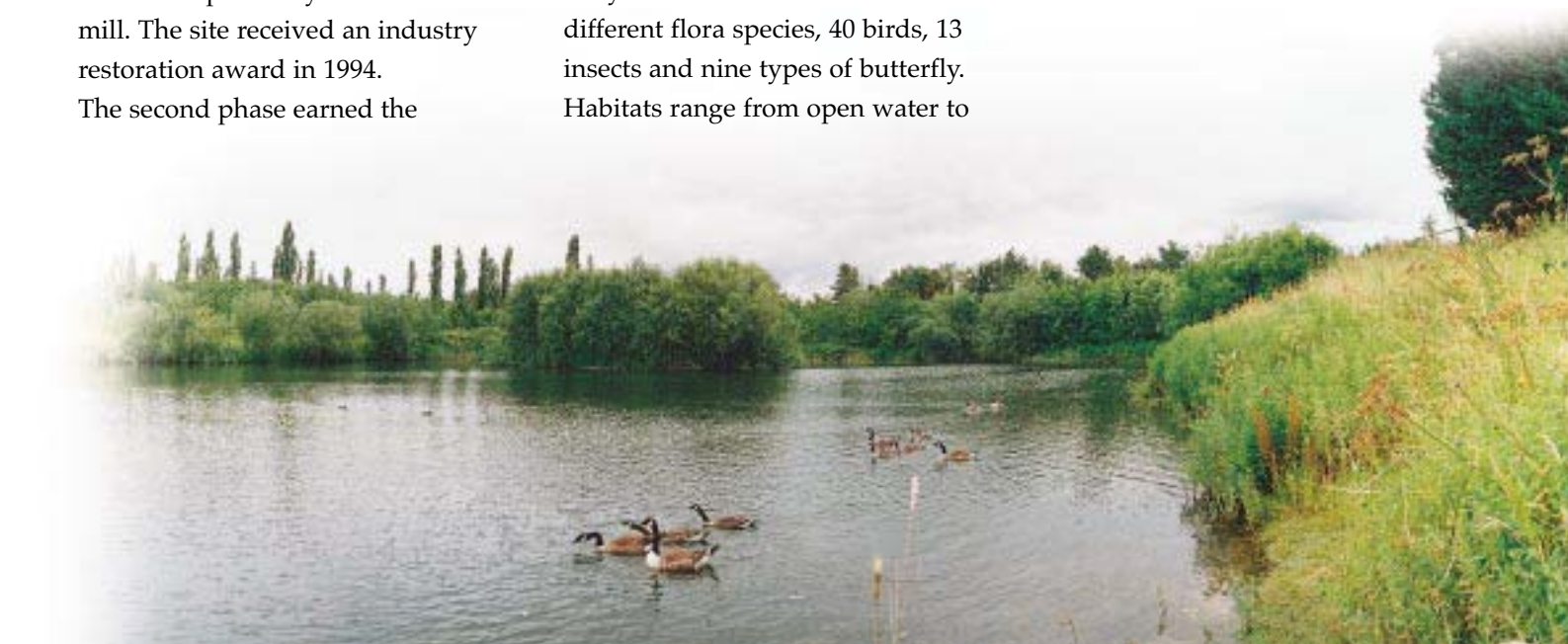
The company worked the original site for sand and gravel in carefully planned phases over 30 years, returning areas progressively to the landowner, who undertook further landscaping and tree planting. Reservoirs were created to irrigate fruit trees and to service greenhouses.

The plant area was restored in 1988 and was replaced by an attractive silk mill. The site received an industry restoration award in 1994. The second phase earned the

company a further award from the Quarry Products Association in 2002 following restoration to a wildlife reserve. Much of this area was worked below the water table, so forming the basis for today's lake.

The reserve represents one of the largest semi-natural habitats in an intensively farmed area and supports a surprising diversity of species. They include no fewer than 88 different flora species, 40 birds, 13 insects and nine types of butterfly. Habitats range from open water to

grassland and woodland. Quarrying has also left a geological exposure of sand cliffs that has earned designation as a Site of Special Scientific Interest.



# KEMERTON QUARRY



Sand and gravel extraction was the medium through which the company, between 1988 and 1998, created a superb wildlife reserve on land owned by Mr Adrian Darby OBE, a past chairman of the RSPB.

Quarrying created a mosaic of wetland habitats as well as woodland and dry grassland.

The result is an environment that attracts a wide range of birds. Its visitors include breeding lapwing, redshank, little ringed plover and reed warbler. It is also particularly important for waders on passage (25 species), wintering ducks (14 species) and raptors (nine species).



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**HUNTSMANS**

# HOME AND GARDEN



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Natural Cotswold stone has long been a favourite as a building and roofing material. But that same warmth has also made it popular for rockeries and, in chippings form, as an excellent foil for "soft" landscaping schemes.

# ROCKERY STONE

Huntsmans particular grade of Cotswold stone comes from a pocket of Jurassic limestone a few miles from Stow-on-the-Wold. It's honey or buff colour and frost resistance made it famous first as slate, which was (and still is) widely specified by architects.

The stone is naturally smooth, a feature that is preserved by mechanical extraction rather than by using the explosives employed for most limestones.

Rockery stone is then hand-selected and can be delivered in bulk, on individual pallets in bulk, or 'jumbo' bags.



*Photography courtesy of Mr & Mrs John Hall*



# CHIPPINGS

Huntsmans Cotswold chippings have the same golden appeal and are available in two hues – the honey-coloured Cotswold classic, and the rather harder and still more durable Premier, which has a more weathered and darker appearance.

Unlike other products on the market, Huntsmans chippings are washed to ensure a perfect appearance from the moment they are laid.

Chippings are available in 20mm, 14mm, 10mm and 6mm sizes and can be supplied loose, in bulk bags or small bags.



# GRAVELS

The Huntsmans range of washed amber gravels comes from its operation at Bishops Cleeve.

They are ideally suited for landscaping and pathways and are available as 20mm, 10mm and 6mm.

As with chippings, they can be supplied loose, in bulk bags or small bags.



## APPROXIMATE SPREAD RATES - 20MM CHIPPINGS/GRAVEL

1 Tonne = 20m<sup>2</sup> @ 25mm thick

1 Tonne = 25m<sup>2</sup> @ 20mm thick

### Note

*More material will be required to cover same area if using smaller sizes.  
No liability for the accuracy of spread rates is given as this can depend on ground conditions and compaction.*



# ROCKS FOR RHINOS ...



*Cotswold Wildlife Park*

# ... OR FOR YOUR GARDEN



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