1. Scope

1.1 This specification covers concrete made from materials continuously batched by volume, mixed in a continuous mixer, and delivered to the purchaser in a freshly mixed and unhardened state as hereinafter specified. Requirements for quality of concrete shall be either as hereinafter specified or as specified by the purchaser. When the requirements of the purchaser differ from this specification, the purchaser’s specification shall govern. This specification does not cover the placement, consolidation, finishing, curing, or protection of the concrete after delivery to the purchaser. Tests and criteria for batching accuracy and mixing efficiency are specified herein.

1.2 The values stated in either SI units, shown in brackets, or inch-pound units are to be regarded separately as standard. The values stated in each system may not be exact equivalents; therefore, each system shall be used independently of the other. Combining values from the two systems may result in nonconformance with the standard.

1.3 This specification references notes and footnotes which provide explanatory material. These notes and footnotes (excluding those in tables and figures) shall not be considered as requirements of this specification.

1.4 This standard does not purport to address all the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use. (Warning—Fresh hydraulic cementitious mixtures are caustic and may cause chemical burns to skin and tissue upon prolonged use.)

2. Referenced Documents

2.1 ASTM Standards:

C31/C31M Practice for Making and Curing Concrete Test Specimens in the Field
C33 Specification for Concrete Aggregates
C39/C39M Test Method for Compressive Strength of Cylindrical Concrete Specimens
C94/C94M Specification for Ready-Mixed Concrete
C125 Terminology Relating to Concrete and Concrete Aggregates
C127 Test Method for Density, Relative Density (Specific Gravity), and Absorption of Coarse Aggregate
C136 Test Method for Sieve Analysis of Fine and Coarse Aggregates
C138/C138M Test Method for Density (Unit Weight), Yield, and Air Content (Gravimetric) of Concrete
C143/C143M Test Method for Slump of Hydraulic-Cement Concrete
C150/C150M Specification for Portland Cement
C173/C173M Test Method for Air Content of Freshly Mixed Concrete by the Volumetric Method
C231 Test Method for Air Content of Freshly Mixed Concrete by the Pressure Method
C260 Specification for Air-Entraining Admixtures for Concrete
C330 Specification for Lightweight Aggregates for Structural Concrete
C494/C494M Specification for Chemical Admixtures for Concrete
C567 Test Method for Determining Density of Structural Lightweight Concrete
C595/C595M Specification for Blended Hydraulic Cements
C618 Specification for Coal Fly Ash and Raw or Calcined Natural Pozzolan for Use in Concrete


3 For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For Annual Book of ASTM Standards volume information, refer to the standard’s Document Summary page on the ASTM website.

*A Summary of Changes section appears at the end of this standard
C637 Specification for Aggregates for Radiation-Shielding Concrete
C989/C989M Specification for Slag Cement for Use in Concrete and Mortars
C1017/C1017M Specification for Chemical Admixtures for Use in Producing Flowing Concrete
C1064/C1064M Test Method for Temperature of Freshly Mixed Hydraulic-Cement Concrete
C1077 Practice for Agencies Testing Concrete and Concrete Aggregates for Use in Construction and Criteria for Testing Agency Evaluation
C1157/C1157M Performance Specification for Hydraulic Cement
C1240 Specification for Silica Fume Used in Cementitious Mixtures
C1602/C1602M Specification for Mixing Water Used in the Production of Hydraulic Cement Concrete

2.2 ACI Documents:
CP-1 Technician Workbook for ACI Certification of Concrete Field Testing Technician-Grade I
211.1 Standard Practice for Selecting Proportions for Normal, Heavyweight, and Mass Concrete
211.2 Standard Practice for Selecting Proportions for Structural Lightweight Concrete
301 Standard Specifications for Structural Concrete
304.6R Guide for Use of Volumetric-Measuring and Continuous-Mixing Concrete Equipment
305R Hot Weather Concreting
306R Cold Weather Concreting
318 Building Code Requirements for Structural Concrete and Commentary

3. Terminology
3.1 Definitions: For definitions of terms used in this specification, refer to Terminology C125.
3.2 Definitions of Terms Specific to This Standard:

| TABLE 1 Recommended Total Air Content for Air-Entrained Concrete |
|-------------------|-------------------|-------------------|-------------------|-------------------|-------------------|
| Exposure Condition | Total Air Content, % | Nominal Max Sizes of Aggregate, in. [mm] |
| Mild               | 4.5       | 4.0       | 3.5       | 3.0       | 2.5       | 2.0       | 1.5       |
| Moderate           | 6.0       | 5.5       | 5.0       | 4.5       | 4.5       | 4.0       | 3.5       |
| Severe             | 7.5       | 7.0       | 6.0       | 6.0       | 5.5       | 5.0       | 4.5       |

4. Basis of Purchase
4.1 The basis of purchase shall be the cubic yard or cubic metre of fresh concrete as it is continuously discharged from the batching and mixing apparatus.
4.2 The volume of fresh concrete in a given batch shall be determined by, or calculated from, a calibrated indicating device driven directly by the batching apparatus.

5. Materials
5.1 In the absence of designated applicable specifications covering requirements for quality of materials, the following specifications shall govern:

5.2 Cementitious Materials:
5.2.1 Hydraulic Cement—Hydraulic cement shall conform to Specification C150/C150M, Specification C595/C595M, or Specification C1157/C1157M (Note 2).
5.2.2 Supplementary Cementitious Materials—Coal Fly Ash or natural pozzolans shall conform to Specification C618. Slag Cement shall conform to Specification C989/C989M. Silica Fume shall conform to Specification C1240.

5.3 Aggregates—Normal weight aggregates shall conform to Specification C33. Lightweight aggregates shall conform to Specification C330 and heavyweight aggregates shall conform to Specification C637.

5.4 Water—Water shall conform to Specification C1602/C1602M.

5.5 Air-Entraining Admixtures—Air-entraining admixtures shall conform to Specification C260 (Note 3).

5.6 Chemical Admixtures—Chemical admixtures shall conform to either Specification C494/C494M or C1017/C1017M, as applicable (Note 3).

Note 3—In any given instance, the required dosage of air-entraining, accelerating, and retarding admixtures may vary. Therefore, a range of dosages should be allowed which will permit obtaining the desired effect.

Note 2—These different cementitious materials will produce concretes of different properties and should not be used interchangeably.

6 Available from the Volumetric Mixer Manufacturers Bureau, 900 Spring Street, Silver Spring, MD 20910, www.vmm.org.

74x64'c

8 Available from American Concrete Institute (ACI), P.O. Box 9094, Farmington Hills, MI 48333-9094, http://www.aci.org.


10 Available from the Volumetric Mixer Manufacturers Bureau, 900 Spring Street, Silver Spring, MD 20910, www.vmm.org.
6. Ordering Information

6.1 In the absence of designated applicable general specifications, the purchaser shall specify the following:

6.1.1 Designated size or sizes of coarse aggregate,
6.1.2 Slump or slumps desired at the point of delivery (see 10.3),
6.1.3 When air-entrained concrete is specified, the air content of samples taken at the point of discharge from the transportation unit (see 10.4 and Table 1 for the total air content and tolerances) (Note 4),
6.1.4 When structural lightweight concrete is specified, the density as fresh density, equilibrium density, or oven-dry density (Note 5), and
6.1.5 Which of Options A, B, or C shall be used as a basis for determining the proportions of the concrete to produce the required quality (see 6.2, 6.3, or 6.4).

NOTE 4—In selecting the specified air content, the purchaser should consider the exposure conditions to which the concrete will be subjected. Air contents less than shown in Table 1 may not give the required resistance to freezing and thawing, which is the primary purpose of air-entrained concrete. Air contents higher than the levels shown may reduce strength without contributing any further improvement of durability.

NOTE 5—The density of fresh concrete, which is the only density determinable at the time of delivery, is always higher than the equilibrium density, or oven-dry density. Definitions of, and methods for determining or calculating equilibrium density and oven-dry density, are covered in Test Method C567.

6.2 Option A:

6.2.1 When the purchaser requires the manufacturer to assume full responsibility for the selection of the proportions for the concrete mixture, the purchaser shall also specify the following:

6.2.1.1 Requirements for compressive strength as determined on samples taken from the mixer at the point of discharge and evaluated in accordance with Section 11. The purchaser shall specify the requirements in terms of the compressive strength of standard specimens cured under standard curing conditions for moist curing. Unless otherwise specified, the age at test shall be 28 days, and
6.2.2 At the request of the purchaser, the manufacturer shall, prior to the actual delivery of the concrete, furnish a statement to the purchaser, giving the dry mass of cement and saturated surface-dry mass of fine and coarse aggregate and quantities, type, and name of admixtures (if any) and of water per cubic yard or cubic metre of concrete that will be used in the manufacture of each class of concrete ordered by the purchaser. The manufacturer shall also furnish evidence satisfactory to the purchaser that the materials to be used and proportions selected will produce concrete of the quality specified.

6.3 Option B:

6.3.1 When the purchaser assumes responsibility for the proportioning of the concrete mixture, the purchaser shall also specify the following:

6.3.1.1 Cement content in pounds per cubic yard or kilograms per cubic metre of concrete, or equivalent units,
6.3.1.2 Maximum allowable water content in gallons per cubic yard or litres or kilograms per cubic metre of concrete or equivalent units, including surface moisture on the aggregates, but excluding water of absorption (Note 6), and
6.3.1.3 If admixtures are required, the type, name, and dosage range to be used. Admixtures shall not be used as a substitute for a portion of specified amounts of cement without the written approval of the purchaser.

NOTE 6—The purchaser, in selecting requirements for which he assumes responsibility should give consideration to requirements for workability, placeability, durability, surface texture, and density, in addition to those for structural design. The purchaser is referred to ACI Standard Practice 211.1 for normal weight concrete, and ACI Standard Practice 211.2 for lightweight concrete, for the selection of proportions that will result in concrete suitable for various types of structures and conditions of exposure. The water-cement ratio of most structural lightweight concretes cannot be determined with sufficient accuracy for use as a specification basis.

6.3.2 At the request of the purchaser, the manufacturer shall, prior to the actual delivery of the concrete, furnish a statement to the purchaser giving the sources, densities, and sieve analyses of the aggregates and the dry mass of cement and saturated surface-dry mass of fine and coarse aggregate and quantities, type, and name of admixture (if any) and of water per cubic yard or cubic metre of concrete that will be used in the manufacture of each class of concrete ordered by the purchaser.

6.4 Option C:

6.4.1 When the purchaser requires the manufacturer to assume responsibility for the selection of the proportions for the concrete mixture with the minimum allowable cement content specified, the purchaser shall also specify the following in addition to the requirements of 6.1.1 through 6.1.5:

6.4.1.1 Required compressive strength as determined on samples taken from the mixer at the point of discharge and evaluated in accordance with Section 11. The purchaser shall specify the requirements for strength in terms of tests of standard specimens cured under standard curing conditions for moist curing. Unless otherwise specified, the age at test shall be 28 days.
6.4.1.2 Minimum cement content in pounds per cubic yard or kilograms per cubic metre of concrete (Note 7), and
6.4.1.3 If admixtures are required, the type, name, and dosage range to be used. The cement content shall not be reduced when admixtures are used.

6.4.2 At the request of the purchaser, the manufacturer shall, prior to the actual delivery of the concrete, furnish a statement to the purchaser, giving the dry mass of cement and saturated surface-dry mass of fine and coarse aggregate and quantities, type, and name of admixture (if any) and of water per cubic yard or cubic metre of concrete that will be used in the manufacture of each class of concrete ordered by the purchaser. The manufacturer shall also furnish evidence satisfactory to the purchaser that the materials to be used and proportions selected will produce concrete of the quality specified. Whatever strengths are attained the quantity of cement used shall not be less than the minimum specified.

NOTE 7—Option C can be distinctive and useful only if the designated minimum cement content is at about the same level that would ordinarily be required for the strength, aggregate size, and slump specified. At the same time, it must be an amount that will be sufficient to ensure durability.
under expected service conditions, as well as satisfactory surface texture and density, in the event specified strength is attained with it. Attention is directed to ACI Standard Practices 211.1 and 211.2 for additional information on mixture proportions.

6.5 The proportions arrived at by Options A, B, or C for each class of concrete and which are approved for use in a project shall be assigned a designation (7CV.PK7, etc.) to facilitate identification of each concrete mixture delivered to the project. This is the designation required in 15.1.7 and supplies information on concrete proportions when they are not given separately on each delivery ticket as outlined in 15.2. However, each delivery of concrete shall be covered by a delivery ticket showing enough information to establish that the mix conforms to the mix designs previously approved for the work.

6.6 The purchaser shall ensure that the manufacturer is provided copies of all reports of tests performed on concrete samples taken to determine compliance with specification requirements. Reports will be provided on a timely basis.

7. Controlling and Measuring Materials

7.1 Cement, fine and coarse aggregates, water, and admixtures shall be measured by volume. Devices such as counters, calibrated gate openings, control valves, or flowmeters shall be available for controlling and determining the quantities of the ingredients discharged. The entire measuring and dispensing mechanism shall produce the specified proportions of each ingredient within the tolerances in 7.8.

Note 8—The recommendations of the equipment manufacturer in the operation of the equipment and in calibrating and using the various gages, revolution counters, speed indicators, or other control devices should be followed.

7.2 All indicating devices that bear on the accuracy of proportioning and mixing of concrete shall be in full view and near enough to be read by the operator while concrete is being produced. The operator shall have convenient access to all controls.

7.3 The proportioning and indicating devices shall be individually checked by following the equipment manufacturer’s recommendations as related to each individual concrete batching and mixing unit. Adequate standard volume measures, scales, and weights shall be made available for the checking accuracy of the proportioning mechanism.

7.4 Yield Check—Essentially, the volume of concrete discharged from the mixer is checked by first determining the mass of the amount of concrete discharged during some number of revolutions, or as determined by some other output indicator; this is then followed immediately by a determination of the density. The mass of concrete discharged divided by the density is equal to the number of cubic feet or cubic metres mixed and discharged during the chosen interval. The accuracy of the output indicator is thus checked by this expedient. For further guidance and a suggested calibration procedure, refer to ACI 304.6R and VMMB 100-01.

Note 9—It is recommended that about 2.5 to 3.0 ft³ [0.070 to 0.085 m³] be discharged for this purpose; this amount of concrete will weigh from 350 to 500 lb [160 to 225 kg] and can be discharged into and contained in a 35 or 55-gal [130 to 210-dm³] drum or other suitable container which in turn can be placed on a scale of adequate capacity. The output of a batcher-mixer unit may be indicated by the number of revolutions, travel of a belt, or changes in gage readings; if so, these figures should be used as a measure of output.

7.5 Proportioning Check—Whenever the sources or characteristics of the ingredients are changed, or the characteristics of the mixture are noted to have changed, the purchaser is permitted to require a check of the fine aggregate content and the coarse aggregate content by use of the washout test. Essentially, in the washout test, 1 ft³ [0.03 m³] of concrete is washed through a No. 4 [4.75-mm] sieve and through a No. 100 [150-μm] sieve; that retained on the No. 4 sieve is normally considered coarse aggregate whereas that passing the No. 4 and retained on the No. 100 sieve is considered fine aggregate. Corrections to the quantity of aggregates (per cubic foot or cubic metre of concrete) shall be made if the original sieve analysis of each aggregate is available.

7.6 The rate of water supplied the continuous mixer shall be measured by a calibrated flowmeter coordinated with the cement and aggregate feeding mechanism, and with the mixer. The device for the control of water shall be capable of delivering to the batch the required quantity. The rate shall be capable of being adjusted in order to control slump at the desired levels and to determine that the water-cement (permitted or required) ratios are being met.

7.7 Liquid admixtures shall be dispensed through a controlled flowmeter.

7.8 Tolerances in proportioning the various ingredients are as follows:

<table>
<thead>
<tr>
<th>Ingredient</th>
<th>Tolerance</th>
</tr>
</thead>
<tbody>
<tr>
<td>Cement, mass %</td>
<td>0 to +4</td>
</tr>
<tr>
<td>Fine Aggregate, mass %</td>
<td>±2</td>
</tr>
<tr>
<td>Coarse Aggregate, mass %</td>
<td>±2</td>
</tr>
<tr>
<td>Admixtures, mass or volume %</td>
<td>±3</td>
</tr>
<tr>
<td>Water, mass or volume %</td>
<td>±1</td>
</tr>
</tbody>
</table>

The tolerances are based on a volume/mass relationship established by calibration of the measuring devices furnished as an integral part of the whole equipment.

Note 10—It is noted that to meet these tolerances, attention should be given to:

1. Degree of compaction of the cement,
2. Grading and other physical characteristics of the fine and coarse aggregates,
3. Moisture content and bulking factor of the fine aggregate,
4. Viscosity of the admixture, and
5. Other factors of influence, for example, mechanical condition and weather.

8. Mixing Mechanism

8.1 The continuous mixer shall be an auger-type mixer or any other type suitable for mixing concrete to meet the required consistency and uniformity requirements (see 14.2.3).

8.2 Each batching and mixing unit, or both, shall carry in a prominent place a metal plate or plates on which is plainly marked the gross volume of the unit in terms of mixed concrete. The mixer shall produce a thoroughly mixed and uniform concrete.
9. Mixing and Delivery

9.1 The batcher-mixer unit shall contain in separate compartments all the necessary ingredients needed for the manufacture of concrete. The unit shall be equipped with calibrated proportioning devices to vary the mix proportions and it shall produce concrete as required by this specification and those of the project.

9.2 Cold Weather Concrete—Concrete delivered in cold weather shall have the applicable minimum temperature indicated in the following table. (The purchaser shall inform the producer as to the type of construction for which the concrete is intended.)

<table>
<thead>
<tr>
<th>Section Size, in. (mm)</th>
<th>Temperature, °F (°C)</th>
</tr>
</thead>
<tbody>
<tr>
<td>&lt;12</td>
<td>55</td>
</tr>
<tr>
<td>12 to 36</td>
<td>50</td>
</tr>
<tr>
<td>36 to 72</td>
<td>45</td>
</tr>
<tr>
<td>&gt;72</td>
<td>40</td>
</tr>
</tbody>
</table>

The maximum temperature of concrete produced with heated aggregates, heated water, or both, shall at no time during its production or transportation exceed 90 °F [32 °C].

9.3 The producer shall deliver the concrete during hot weather at concrete temperatures as low as practicable, subject to the approval of the purchaser.

9.4 When air-entrained concrete is desired, the purchaser shall specify the total air content of the concrete. See Table 1 for total air content (Note 4).

10. Slump and Air Content

10.1 Slump, air-content, and temperature tests shall be made at the time of placement at the option of the inspector as often as is necessary for control checks. In addition, these tests shall be made, when specified and always when strength specimens are made (11.2).

10.2 If the measured slump, temperature, or air content falls outside the specified limits, a check test shall be made immediately on another portion of the same sample. In the event of a second failure, the concrete shall be considered to have failed the requirements of the specification.

10.3 Tolerances in Slump:

10.3.1 Unless other tolerances are included in the project specifications, the following shall apply:

10.3.1.1 When the project specifications for slump are written as a “maximum” or “not to exceed” requirement:

<table>
<thead>
<tr>
<th>Specified Slump</th>
<th>Tolerance, in. (mm)</th>
</tr>
</thead>
<tbody>
<tr>
<td>3 in. [75 mm] or less</td>
<td>+0–1 1⁄2 [40]</td>
</tr>
<tr>
<td>More than 3 in. [75 mm]</td>
<td>+0–2 1⁄2 [65]</td>
</tr>
</tbody>
</table>

This option is used only if one addition of water is permitted on the job provided such addition does not increase the water-cement ratio above the maximum permitted by the specifications.

10.3.1.2 When the project specifications for slump are not written as a “maximum” or “not to exceed” requirement:

<table>
<thead>
<tr>
<th>Specified Slump</th>
<th>Tolerance, in. (mm)</th>
</tr>
</thead>
<tbody>
<tr>
<td>2 in. [50 mm] and less</td>
<td>± ½ [15]</td>
</tr>
<tr>
<td>More than 2 in. [50 mm] through 4 in. [100 mm]</td>
<td>±1 [25]</td>
</tr>
<tr>
<td>More than 4 in. [100 mm]</td>
<td>±1 1⁄2 [40]</td>
</tr>
</tbody>
</table>

10.4 When air-entrained concrete is desired, the purchaser shall specify the total air content of the concrete. See Table 1 for total air content (Note 4).

10.5 The air content of air-entrained concrete when sampled from the transportation unit at the point of discharge shall be within a tolerance of ±1.5 of the specified value.

11. Strength

11.1 When strength is used as a basis for acceptance of the concrete, standard specimens shall be made and cured under standard curing conditions in accordance with the applicable provisions of Practice C31/C31M. The technician performing the strength test shall be certified as an ACI Concrete Laboratory Testing Technician—Grade I or II or by an equivalent written and performance test program.

11.2 One strength test set of two cylinders and the accompanying slump, temperature, and air content tests shall be made for each 25 yd³ [20 m³] of concrete or fraction thereof, or whenever significant changes have been made in the proportioning controls. There shall be at least one strength test made for each class of concrete placed in 1 day.

11.3 For each strength test, two standard-size cylinders shall be made (see 14.2.2). The test result shall be the average of the strength of the two specimens except that, if any specimen shows definite evidence other than low strength, of improper sampling, molding, handling, curing, or testing, it shall be discarded and the strength of the remaining cylinder shall then be considered the test result.

11.4 The representative of the purchaser shall ascertain and record the delivery ticket number for the concrete and the exact location in the work where the concrete represented by each strength test was deposited.

11.5 To conform to the requirements of this specification, strength tests representing each class of concrete must meet the following two requirements (Note 14):

11.5.1 The average of any three consecutive strength tests shall be equal to, or greater than, the specified strength, \( f'_c \), and

11.5.2 No individual strength test shall be more than 500 psi [3.5 MPa] below the specified strength, \( f'_c \).

Note 14—Due to variations in materials, operations, and testing the average strength necessary to meet these requirements will be substantially higher than the specified strength. The amount higher depends upon the standard deviation of the test results and the accuracy with which that value can be estimated from prior data as explained in ACI 318 and ACI 301. Pertinent data is given in Table 2.
12. Failure to Meet Strength Requirements

12.1 In the event that concrete tested in accordance with the requirements of Section 11 fails to meet the strength requirements of this specification, the manufacturer of the concrete and the purchaser shall confer to determine whether agreement will be reached as to what adjustment, if any, shall be made. If an agreement on a mutually satisfactory adjustment cannot be reached by the manufacturer and the purchaser, a decision shall be made by a panel of three qualified engineers, one of whom shall be designated by the purchaser, one by the manufacturer, and the third chosen by these two members of the panel. The question of responsibility for the cost of such arbitration shall be determined by the panel. Its decision shall be binding, except as modified by a court decision.

13. Test Methods and Practices

13.1 Test the concrete in accordance with the following ASTM methods:

13.1.1 Compression Test Specimens—Use standard moist curing in accordance with the applicable provisions of Practice C31/C31M.

13.1.2 Compression Tests—Test Method C39/C39M.

13.1.3 Yield, Unit Weight—Test Method C138/C138M.


13.1.5 Slump—Test Method C143/C143M.

13.1.6 Temperature—Test Method C1064/C1064M.

13.2 The testing laboratory performing acceptance tests of concrete shall meet the requirements of Practice C1077.

14. Inspection

14.1 Materials, Batching Facilities, and Mixing Facilities—The manufacturer shall afford the inspector all reasonable access (without charge) for obtaining necessary samples of materials used in the concrete, and for making necessary checks of the batching and mixing facilities to determine if the concrete is being produced in accordance with this specification. All tests and inspection shall be so conducted as not to interfere unnecessarily with the batching, mixing, and discharge of the concrete to the purchaser.

14.1.1 The volume of plastic and unhardened concrete shall be checked daily on projects requiring more than 50 yd³ [40 m³] of concrete per day (see 7.4).

14.1.2 The manufacturer of the concrete shall conduct calibration and mixer efficiency tests at intervals not exceeding 6 months. Data on such tests using materials proposed for use in the project shall be furnished to the purchaser upon request. The amount of various ingredients (cement, fine and coarse aggregate, admixtures, and water) shall be checked as required in 7.5.

14.2 Fresh Concrete:

14.2.1 The contractor shall afford the inspector all reasonable access and assistance (without charge) for the procurement of samples of fresh concrete at the time of placement so as to determine conformance of the concrete to this specification.

14.2.2 At any time after at least 2 ft³ [0.05 m³] of concrete have been discharged, one sample of concrete shall be taken for the slump test, the air content test, if required, and the strength test. The sample shall be at least 2 ft³ in volume. Two cylinders for each age of test shall be made. Tests for slump or air content or both shall be started within 5 min of sampling; these tests shall then be completed as expeditiously as possible. Molding of specimens for strength tests shall be started within 15 min of sampling. The time for making these tests and specimens shall be as short as possible.

14.2.3 Samples for determining the uniformity of mixing shall be taken at arbitrarily designated times. After at least 2 ft³ [0.05 m³] have been discharged, a sample of at least 4 ft³ [0.10 m³] shall be taken followed by another sample being taken no sooner than after 4 min of continuous discharge or 1 yd³ [0.75 m³] whichever is smaller. These samples shall be checked for conformance to the criteria set forth in Annex A1.

14.2.4 Tests of concrete required to determine compliance with this specification shall be made by a certified ACI Concrete Field Testing Technician, Grade I or equivalent. Equivalent personnel certification programs shall include both written and performance examinations as outlined in ACI CP-1.

14.3 Laboratory reports of concrete test results used to determine compliance with this specification shall include a statement that all tests performed by the laboratory or its agents were in accordance with the applicable test methods or shall note all known deviations from the prescribed procedures (Note 15). The reports shall also list any part of the test methods not performed by the laboratory.

Note 15—Deviation from standard test methods may adversely affect test results.

15. Batch Ticket Information

15.1 The manufacturer of the concrete shall furnish to the purchaser with each increment of discharged concrete, a delivery ticket or a statement of particulars on which is shown the following:

15.1.1 Name of concrete supplier,

15.1.2 Serial number of the delivery ticket or statement,

15.1.3 Date; starting time, and finishing time,
15.1.4 Identification number of batching or mixing equipment, or both,
15.1.5 Name of the purchaser,
15.1.6 Specific designation of the job (name and location),
15.1.7 Specific class or designation of the concrete in conformance with that employed in the job specification, and
15.1.8 Amount of concrete in cubic yards or cubic metres,
and reading of the revolution counter or other device that indicates quantity of concrete.

15.2 Additional information designated by the purchaser and required by the job specifications shall be furnished when requested, such as:
15.2.1 Type, brand, and amount of cement,
15.2.2 Type, name, and amount of each admixture,
15.2.3 Information necessary to calculate total mixing water added by the producer. Total mixing water includes free water on the aggregates and water batched by the producer from the mixing equipment or other sources,
15.2.4 Maximum size of aggregate,
15.2.5 Mass or volumes of fine and coarse aggregate,
15.2.6 Notation of calibrated settings for flow control of fine and coarse aggregate, added water, and admixtures,
15.2.7 Ingredients certified as being previously approved,
and
15.2.8 Signature or initials of the person operating the batching or mixing apparatus.

16. Keywords
16.1 ready-mixed concrete; testing

ANNEX
(Mandatory Information)

A1. CONCRETE UNIFORMITY REQUIREMENTS

A1.1 Scope
A1.1.1 This annex includes test procedures and uniformity requirements for use in the evaluation of concrete produced in conformance with Specification C685/C685M by an individual batching-mixing unit, loaded to rated capacity.

A1.2. Significance and Use
A1.2.1 These tests and requirements are used to evaluate loading and operating procedures; verify the accuracy of proportioning and indicating systems; and determine if mixing uniformity has been degraded by excessive wear or by accumulations of hardened concrete, or both (Note A1.1).

NOTE A1.1—The method of loading the batching-mixing unit, proper maintenance, and other factors may have an effect on the ability of the unit to produce uniformly mixed concrete. For this reason, the use of this test method not only measures the efficiency of the mixer, but also the combined effect of the method of loading and operating the unit.

A1.2.2 This annex provides additional procedures and cautions that are necessary in the application of existing test methods and practices when used to determine the uniformity of freshly mixed concrete.

A1.3 Concrete Mixture
A1.3.1 Test a concrete mixture with proportions typical of the anticipated use (Note A1.2).

NOTE A1.2—Recommended test mix parameters are available from the Volumetric Mixer Manufacturers Bureau[7]. Normally, it is not necessary to test all mixtures produced unless they are made with greatly different slump, for instance 1 in. [25 mm] and 6 in. [150 mm]; or greatly different nominal maximum size aggregates such as ¾ in. [9.5 mm] and 1½ in. [37.5 mm].

A1.4. Testing Apparatus and Materials
A1.4.1 The apparatus and materials shall conform to the requirements of the appropriate referenced ASTM Standards.

A1.4.2 Other special equipment as required by this annex and not specifically described in the referenced ASTM Standards is identified in the subsequent sections.

A1.5. Sampling
A1.5.1 Take samples of the concrete discharge at approximately 15 and 85 % of the unit rated capacity by intercepting the full discharge stream (Note A1.3).

NOTE A1.3—Concrete with slumps over about 5 in. [125 mm] may segregate on the mixer blades or in the chute if discharge is stopped and started during the sampling process. For this reason, all samples should be taken without stopping or starting discharge during the sampling procedure.

A1.6 Slump
A1.6.1 Perform two slump tests on each sample in accordance with Test Method C143/C143M. Start testing the slump of each sample within 5 min after it was obtained.

A1.6.2 Calculate the average of the two tests performed on each sample.

A1.7 Fresh Concrete Density (Unit Weight)
A1.7.1 Determine the fresh concrete density of each sample in accordance with Test Method C138/C138M. If applicable, using a concrete sample in a ¼ -ft³ [7-L] air meter container to determine fresh concrete density; then using that same compacted sample to determine air content by Test Method C231; and then further using that sample to determine the coarse aggregate content percent is not prohibited (Note A1.4).

NOTE A1.4—Determination of fresh concrete density in a larger ½-ft³.
[14-L] container may provide a somewhat more accurate determination. The use of a separate sample of concrete for determination of coarse aggregate content may also improve accuracy, as some segregation or loss of coarse aggregate may occur when striking off the air content test sample.

A1.7.2 Calculate the fresh concrete density of the sample as follows:

\[ D = \frac{(M_c - M_a)}{V_m} \]  

(A1.1)

where:

- \( D \) = fresh concrete density (unit weight), \( \text{lb/ft}^3 \) [\( \text{kg/m}^3 \)].
- \( M_c \) = mass of the measure filled with concrete, \( \text{lb} \) [\( \text{kg} \)].
- \( M_a \) = mass of the measure empty, \( \text{lb} \) [\( \text{kg} \)], and
- \( V_m \) = volume of the measure, \( \text{ft}^3 \) [\( \text{m}^3 \)].

A1.8 Air Content

A1.8.1 Use Test Method C231 or Test Method C173/C173M, as applicable, to determine the air content of the concrete.

A1.9 Air Free Fresh Concrete Density (Air Free Unit Weight)

A1.9.1 Calculate the air free fresh concrete density of each sample as follows:

\[ AFFD = \frac{(100 \times D)}{(100 - A)} \]  

(A1.2)

where:

- \( AFFD \) = air free fresh concrete density, \( \text{lb/ft}^3 \) [\( \text{kg/m}^3 \)].
- \( D \) = fresh concrete density, \( \text{lb/ft}^3 \) [\( \text{kg/m}^3 \)] as measured in A1.7, and
- \( A \) = air content, \%, as measured in A1.8.

A1.10 Coarse Aggregate Content

A1.10.1 Determine the coarse aggregate content by either the Dry or Wet Method as follows. When the coarse aggregate content is determined from a separate sample of concrete not used for other tests, use a minimum sample mass of 25 lb [10 kg] for concrete made with \( \frac{3}{4} \) in. [19.0 mm] or smaller nominal maximum size coarse aggregate, or minimum mass of 50 lb [20 kg] for concrete made with larger aggregate (Note A1.5).

Note A1.5—As noted in A1.7.1, the fresh concrete density and air content sample can be used for determination of coarse aggregate content. When this option is chosen, the amount of coarse aggregate recovered may be as little as 14 lb [6.4 kg], and the precision of the sieve analysis determination may be somewhat less than indicated in Test Method C136.

A1.10.2 Use the mass of the sample as determined in A1.7, or take another portion of the sample in a convenient-sized container and determine the mass of concrete. When concrete contains aggregate larger than 1 in. [25.0 mm] nominal maximum size, use a concrete sample large enough to yield a sample of coarse aggregate for final sieving at least as large as that required by Test Method C136.

A1.10.3 Wash the sample over a No. 4 [4.75 mm] sieve sufficiently to remove the cement and most of the fine aggregate. Determine the coarse aggregate mass using method A1.10.3.1 or A1.10.3.2.

A1.10.3.1 Dry Method—Dry the sample and sieve in accordance with Test Method C136. Determine \( CA_{dry} \), the dry mass of coarse aggregate retained on the No. 4 [4.75 mm] sieve.

A1.10.3.2 Wet Method—Continue to carefully sieve the washed sample over the No. 4 [4.75 mm] sieve, washing to remove the remainder of the fine aggregate. Determine the mass of the wet sample immersed in water as in Test Method C127. Determine \( CA_{SSD} \), the saturated surface dry mass of the aggregate retained on the No. 4 [4.75 mm] sieve as follows:

\[ CA_{SSD} = \frac{C}{\left(1 - \frac{1}{G_{SSD}}\right)} \]  

(A1.3)

where:

- \( CA_{SSD} \) = saturated surface dry mass of the coarse aggregate, \( \text{lb} \) [\( \text{kg} \)],
- \( C \) = immersed mass of the aggregate, \( \text{lb} \) [\( \text{kg} \)], and
- \( G_{SSD} \) = relative density (specific gravity) of the aggregate (SSD).

A1.10.4 Calculate the coarse aggregate content percent by mass, by expressing the mass of coarse aggregate (\( CA_{dry} \) or \( CA_{SSD} \)) as a percentage of the mass of the original concrete sample.

A1.11 Compressive Strength

A1.11.1 Make and cure a minimum of two cylinders, either 6 by 12 in. [150 by 300 mm] or 4 by 8 in. [100 by 200 mm], from each sample of concrete in accordance with Practice C31/C31M. Cure cylinders as required, except that initial curing shall be by immersion in lime water immediately after molding. Maintain the water temperature between the required 60 to 80 °F [16 to 27 °C] for the initial 24 to 48 h. Finally, cure the cylinders in accordance with Practice C31/C31M until ready for testing.

A1.11.2 Test the cylinders at 7 days in accordance with Test Method C39/C39M. Average the strength of the 7-day tests of cylinders from each sample and express that value as a percentage of the average of all cylinders made from that batch tested at the same age.

A1.11.3 Examine the results of tests of individual cylinders made from the same sample of concrete and exclude the results from that sample if the range of tests exceeds 8.0 % when two cylinders are tested and 9.5 % when three are tested (Note A1.6).

Note A1.6—On the average, these ranges should not be exceeded more than roughly 1 time in 20. The values for permissible ranges of individual cylinders are from the precision statement in Test Method C39/C39M. Although the d2s (difference two sigma) values in Test Method C39/C39M are for 6 by 12-in. [150 by 300-mm] cylinders, available data suggest that 4 by 8-in. [100 by 200-mm] cylinder results should be only slightly less precise.

A1.12 Required Uniformity

A1.12.1 Units are required to conform to the minimum requirements of Table A1.1.

A1.13 Report

A1.13.1 Report the following information:

A1.13.1.1 Unit identification and rated capacity.

A1.13.1.2 Description of the unit configuration.

A1.13.1.3 Description of the loading and operating procedures.
A1.13.1.4 Unit control settings.

A1.13.1.5 Identification of testing agency or agencies including:

1. Corporate name and address,
2. Responsible official,
3. Indication that all testing personnel are certified as required in 14.2.4, and
4. Indication that all tests were performed in accordance with the referenced test methods as modified herein.

A1.13.1.6 Concrete test data including:

1. Individual test results for each slump, air content, fresh concrete density, air free fresh concrete density, coarse aggregate content (including method, wet or dry), and 7-day compressive strength (including cylinder size),
2. Averages of duplicate tests made on the same sample,
3. Range of results of tests on the two samples, and
4. Comparison of that range with the maximum permitted in Table A1.1.

### SUMMARY OF CHANGES

Committee C09 has identified the location of selected changes to this specification since the last issue, C685/C685M–11, that may impact the use of this specification. (Approved December 15, 2014)

1. Revised Section 5—Updated referenced standards.
2. Revised Section 6—Removed the term bags and removed redundant language.

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