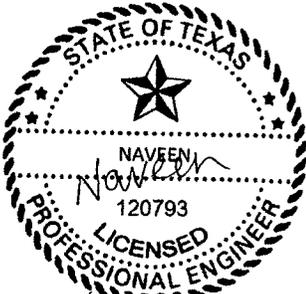


RADHA KRISHNA TEMPLE PHASE-I

STRUCTURAL SPECIFICATIONS

033000 - Cast-In-Place Concrete

034713 - Tilt-Up Concrete



2016.06.27



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SECTION 033000 - CAST-IN-PLACE CONCRETE

PART 1 - GENERAL

1.1 RELATED DOCUMENTS

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 SUMMARY

- A. Section includes cast-in-place concrete, including formwork, reinforcement, concrete materials, mixture design, placement procedures, and finishes, for the following:
 - 1. Footings.
 - 2. Slabs-on-grade.
 - 3. Suspended slabs.
 - 4. Building walls.

1.3 DEFINITIONS

- A. Cementitious Materials: Portland cement alone or in combination with one or more of the following: blended hydraulic cement, fly ash and other pozzolans, ground granulated blast-furnace slag, and silica fume; subject to compliance with requirements.

1.4 SUBMITTALS

- A. Product Data: For each type of product indicated.
- B. Steel Reinforcement Shop Drawings: Placing drawings that detail fabrication, bending, and placement. Include bar sizes, lengths, material, grade, bar schedules, stirrup spacing, bent bar diagrams, bar arrangement, splices and laps, mechanical connections, tie spacing, hoop spacing, and supports for concrete reinforcement.
- C. Material Certificates: For each of the following, signed by manufacturers:
 - 1. Cementitious materials.
 - 2. Admixtures.
 - 3. Form materials and form-release agents.
 - 4. Steel reinforcement and accessories.
 - 5. Waterstops.
 - 6. Curing compounds.
 - 7. Vapor retarders.
 - 8. Semirigid joint filler.
 - 9. Joint-filler strips.
 - 10. Repair materials.

- D. Material Test Reports: For the following, from a qualified testing agency, indicating compliance with requirements:
 - 1. Aggregates. Include service record data indicating absence of deleterious expansion of concrete due to alkali aggregate reactivity.
- E. Floor surface flatness and levelness measurements indicating compliance with specified tolerances.
- F. Field quality-control reports.

1.5 QUALITY ASSURANCE

- A. Installer Qualifications: A qualified installer who employs on Project personnel qualified as ACI-certified Flatwork Technician and Finisher and a supervisor who is an ACI-certified Concrete Flatwork Technician.
- B. Manufacturer Qualifications: A firm experienced in manufacturing ready-mixed concrete products and that complies with ASTM C 94 requirements for production facilities and equipment.
 - 1. Manufacturer certified according to NRMCA's "Certification of Ready Mixed Concrete Production Facilities."
- C. Testing Agency Qualifications: An independent agency, qualified according to ASTM C 1077 and ASTM E 329 for testing indicated.
 - 1. Personnel conducting field tests shall be qualified as ACI Concrete Field Testing Technician, Grade 1, according to ACI CP-1 or an equivalent certification program.
 - 2. Personnel performing laboratory tests shall be ACI-certified Concrete Strength Testing Technician and Concrete Laboratory Testing Technician - Grade I. Testing Agency laboratory supervisor shall be an ACI-certified Concrete Laboratory Testing Technician - Grade II.
- D. Source Limitations: Obtain each type or class of cementitious material of the same brand from the same manufacturer's plant, obtain aggregate from single source, and obtain admixtures from single source from single manufacturer.
- E. ACI Publications: Comply with the following unless modified by requirements in the Contract Documents:
 - 1. ACI 301, "Specifications for Structural Concrete," Sections 1 through 5.
 - 2. ACI 117, "Specifications for Tolerances for Concrete Construction and Materials."
- F. Concrete Testing Service: Engage a qualified independent testing agency to perform material evaluation tests and to design concrete mixtures.

1.6 DELIVERY, STORAGE, AND HANDLING

- A. Steel Reinforcement: Deliver, store, and handle steel reinforcement to prevent bending and damage.
- B. Waterstops: Store waterstops under cover to protect from moisture, sunlight, dirt, oil, and other contaminants.

PART 2 - PRODUCTS

2.1 FORM-FACING MATERIALS

- A. Smooth-Formed Finished Concrete: Form-facing panels that will provide continuous, true, and smooth concrete surfaces. Furnish in largest practicable sizes to minimize number of joints.
 - 1. Plywood, metal, or other approved panel materials.
 - 2. Exterior-grade plywood panels, suitable for concrete forms, complying with DOC PS 1, and as follows:
 - a. High-density overlay, Class 1 or better.
 - b. Medium-density overlay, Class 1 or better; mill-release agent treated and edge sealed.
- B. Rough-Formed Finished Concrete: Plywood, lumber, metal, or another approved material. Provide lumber dressed on at least two edges and one side for tight fit.
- C. Forms for Cylindrical Columns, Pedestals, and Supports: Metal, glass-fiber-reinforced plastic, paper, or fiber tubes that will produce surfaces with gradual or abrupt irregularities not exceeding specified formwork surface class. Provide units with sufficient wall thickness to resist plastic concrete loads without detrimental deformation.
- D. Void Forms: Biodegradable paper surface, treated for moisture resistance, structurally sufficient to support weight of plastic concrete and other superimposed loads.
- E. Chamfer Strips: Wood, metal, PVC, or rubber strips, 3/4 by 3/4 inch, minimum.
- F. Rustication Strips: Wood, metal, PVC, or rubber strips, kerfed for ease of form removal.
- G. Form-Release Agent: Commercially formulated form-release agent that will not bond with, stain, or adversely affect concrete surfaces and will not impair subsequent treatments of concrete surfaces.
 - 1. Formulate form-release agent with rust inhibitor for steel form-facing materials.
- H. Form Ties: Factory-fabricated, removable or snap-off metal or glass-fiber-reinforced plastic form ties designed to resist lateral pressure of fresh concrete on forms and to prevent spalling of concrete on removal.
 - 1. Furnish units that will leave no corrodible metal closer than 1 inch to the plane of exposed concrete surface.

2. Furnish ties that, when removed, will leave holes no larger than 1 inch in diameter in concrete surface.
3. Furnish ties with integral water-barrier plates to walls indicated to receive dampproofing or waterproofing.

2.2 STEEL REINFORCEMENT

- A. Reinforcing Bars: ASTM A 615, Grade 60, deformed.
- B. Steel Bar Mats: ASTM A 184, fabricated from ASTM A 615, Grade 60, deformed bars, assembled with clips.
- C. Plain-Steel Wire: ASTM A 82 as drawn.
- D. Deformed-Steel Wire: ASTM A 496.
- E. Plain-Steel Welded Wire Reinforcement: ASTM A 185, plain, fabricated from as-drawn steel wire into flat sheets.
- F. Deformed-Steel Welded Wire Reinforcement: ASTM A 497 flat sheet.

2.3 REINFORCEMENT ACCESSORIES

- A. Joint Dowel Bars: ASTM A 615, Grade 60, plain-steel bars, cut true to length with ends square and free of burrs.
- B. Bar Supports: Bolsters, chairs, spacers, and other devices for spacing, supporting, and fastening reinforcing bars and welded wire reinforcement in place. Manufacture bar supports from steel wire, plastic, or precast concrete according to CRSI's "Manual of Standard Practice," of greater compressive strength than concrete and as follows:
 1. For concrete surfaces exposed to view where legs of wire bar supports contact forms, use CRSI Class 1 plastic-protected steel wire or CRSI Class 2 stainless-steel bar supports.

2.4 CONCRETE MATERIALS

- A. Cementitious Material: Use the following cementitious materials, of the same type, brand, and source, throughout Project:
 1. Portland Cement: ASTM C 150, Type I. Supplement with the following:
 - a. Fly Ash: ASTM C 618, Class F.
- B. Normal-Weight Aggregates: ASTM C 33, Class 3M coarse aggregate or better, graded. Provide aggregates from a single source.
 1. Maximum Coarse-Aggregate Size:
 - a. Foundations: 1-1/2 inches nominal.
 - b. Slab on grade: 1 inch nominal.
 - c. Elevated Slab: 3/8 inch nominal.
 2. Fine Aggregate: Free of materials with deleterious reactivity to alkali in cement.

- C. Water: ASTM C 94 and potable.

2.5 ADMIXTURES

- A. Air-Entraining Admixture: ASTM C 260.
- B. Chemical Admixtures: Provide admixtures certified by manufacturer to be compatible with other admixtures and that will not contribute water-soluble chloride ions exceeding those permitted in hardened concrete. Do not use calcium chloride or admixtures containing calcium chloride.
 - 1. Water-Reducing Admixture: ASTM C 494, Type A.
 - 2. Retarding Admixture: ASTM C 494, Type B.
 - 3. Water-Reducing and Retarding Admixture: ASTM C 494, Type D.
 - 4. High-Range, Water-Reducing Admixture: ASTM C 494, Type F.
 - 5. High-Range, Water-Reducing and Retarding Admixture: ASTM C 494, Type G.
 - 6. Plasticizing and Retarding Admixture: ASTM C 1017, Type II.

2.6 WATERSTOPS

- A. Self-Expanding Butyl Strip Waterstops: Manufactured rectangular or trapezoidal strip, butyl rubber with sodium bentonite or other hydrophilic polymers, for adhesive bonding to concrete, 3/4 by 1 inch.
 - 1. Products: Subject to compliance with requirements, available products that may be incorporated into the Work include, but are not limited to, the following:
 - a. Carlisle Coatings & Waterproofing, Inc.; MiraSTOP.
 - b. CETCO; Volclay Waterstop-RX.
 - c. Concrete Sealants Inc.; Conseal CS-231.
 - d. Greenstreak; Swellstop.
 - e. Henry Company, Sealants Division; Hydro-Flex.
 - f. JP Specialties, Inc.; Earth Shield Type 20.

2.7 VAPOR RETARDERS

- A. Sheet Vapor Retarder: ASTM E 1745, Class A. Include manufacturer's recommended adhesive or pressure-sensitive tape.
 - 1. Products: Subject to compliance with requirements, available products that may be incorporated into the Work include, but are not limited to, the following:
 - a. Carlisle Coatings & Waterproofing, Inc.; Blackline 400.
 - b. Fortifiber Building Systems Group; Moistop Ultra 10.
 - c. Grace Construction Products, W. R. Grace & Co.; Florprufe 120.
 - d. Insulation Solutions, Inc.; Viper VaporCheck 10.
 - e. Meadows, W. R., Inc.; Perminator 10 mil.
 - f. Raven Industries Inc.; Vapor Block 10.
 - g. Stego Industries, LLC; Stego Wrap 10 mil Class A.

2.8 CURING MATERIALS

- A. Evaporation Retarder: Waterborne, monomolecular film forming, manufactured for application to fresh concrete.
 - 1. Products: Subject to compliance with requirements, available products that may be incorporated into the Work include, but are not limited to, the following:
 - a. Axim Italcementi Group, Inc.; CATEXOL CimFilm.
 - b. BASF Construction Chemicals - Building Systems; Confilm.
 - c. ChemMasters; SprayFilm.
 - d. Conspec by Dayton Superior; Aquafilm.
 - e. Dayton Superior Corporation; Sure Film (J-74).
 - f. Edoco by Dayton Superior; BurkeFilm.
 - g. Euclid Chemical Company (The), an RPM company; Eucobar.
 - h. Kaufman Products, Inc.; Vapor-Aid.
 - i. Lambert Corporation; LAMBCO Skin.
 - j. L&M Construction Chemicals, Inc.; E-CON.
 - k. Meadows, W. R., Inc.; EVAPRE.
 - l. Metalcrete Industries; Waterhold.
 - m. Nox-Crete Products Group; MONOFILM.
 - n. Sika Corporation; SikaFilm.
 - o. SpecChem, LLC; Spec Film.
 - p. Symons by Dayton Superior; Finishing Aid.
 - q. TK Products, Division of Sierra Corporation; TK-2120 TRI-FILM.
 - r. Unitex; PRO-FILM.
 - s. Vexcon Chemicals, Inc.; Certi-Vex Envio Set.
- B. Absorptive Cover: AASHTO M 182, Class 2, burlap cloth made from jute or kenaf, weighing approximately 9 oz./sq. yd. when dry.
- C. Moisture-Retaining Cover: ASTM C 171, polyethylene film or white burlap-polyethylene sheet.
- D. Water: Potable.

2.9 RELATED MATERIALS

- A. Expansion- and Isolation-Joint-Filler Strips: ASTM D 1751, asphalt-saturated cellulosic fiber.
- B. Semirigid Joint Filler: Two-component, semirigid 100 percent solids, epoxy resin with a Type A shore durometer hardness of 80 per ASTM D 2240.
- C. Bonding Agent: ASTM C 1059, Type II, non-redispersible, acrylic emulsion or styrene butadiene.
- D. Epoxy Bonding Adhesive: ASTM C 881, two-component epoxy resin, capable of humid curing and bonding to damp surfaces, of class suitable for application temperature and of grade to suit requirements, and as follows:
 - 1. Types IV and V, load bearing, for bonding hardened or freshly mixed concrete to hardened concrete.

2.10 REPAIR MATERIALS

- A. Repair Underlayment: Cement-based, polymer-modified, self-leveling product that can be applied in thicknesses from 1/8 inch and that can be feathered at edges to match adjacent floor elevations.
1. Cement Binder: ASTM C 150, portland cement or hydraulic or blended hydraulic cement as defined in ASTM C 219.
 2. Primer: Product of underlayment manufacturer recommended for substrate, conditions, and application.
 3. Aggregate: Well-graded, washed gravel, 1/8 to 1/4 inch or coarse sand as recommended by underlayment manufacturer.
 4. Compressive Strength: Not less than 4100 psi at 28 days when tested according to ASTM C 109.
- B. Repair Overlayment: Cement-based, polymer-modified, self-leveling product that can be applied in thicknesses from 1/4 inch and that can be filled in over a scarified surface to match adjacent floor elevations.
1. Cement Binder: ASTM C 150, portland cement or hydraulic or blended hydraulic cement as defined in ASTM C 219.
 2. Primer: Product of topping manufacturer recommended for substrate, conditions, and application.
 3. Aggregate: Well-graded, washed gravel, 1/8 to 1/4 inch or coarse sand as recommended by topping manufacturer.
 4. Compressive Strength: Not less than 5000 psi at 28 days when tested according to ASTM C 109.

2.11 CONCRETE MIXTURES, GENERAL

- A. Prepare design mixtures for each type and strength of concrete, proportioned on the basis of laboratory trial mixture or field test data, or both, according to ACI 301.
1. Use a qualified independent testing agency for preparing and reporting proposed mixture designs based on laboratory trial mixtures.
- B. Cementitious Materials: Limit percentage, by weight, of cementitious materials other than portland cement in concrete as follows:
1. Fly Ash: 25 percent.
- C. Limit water-soluble, chloride-ion content in hardened concrete to 0.06 percent by weight of cement.
- D. Admixtures: Use admixtures according to manufacturer's written instructions.
1. Use water-reducing high-range water-reducing or plasticizing admixture in concrete, as required, for placement and workability.
 2. Use water-reducing and retarding admixture when required by high temperatures, low humidity, or other adverse placement conditions.
 3. Use water-reducing admixture in pumped concrete, concrete for heavy-use industrial slabs and parking structure slabs, concrete required to be watertight, and concrete with a water-cementitious materials ratio below 0.50.

2.12 CONCRETE MIXTURES FOR BUILDING ELEMENTS

A. Footings: Proportion normal-weight concrete mixture as follows:

1. Minimum Compressive Strength: 4000 psi at 28 days.
2. Maximum Water-Cementitious Materials Ratio: 0.50.
3. Slump Limit: 5 inches, 8 inches for concrete with verified slump of 2 to 4 inches before adding high-range water-reducing admixture or plasticizing admixture, plus or minus 1 inch.
4. Air Content: 5.5 percent, plus or minus 1.5 percent at point of delivery for 1-1/2-inch nominal maximum aggregate size.

B. Slabs-on-Grade: Proportion normal-weight concrete mixture as follows:

1. Minimum Compressive Strength: 4000 psi at 28 days.
2. Slump Limit: 4 inches, plus or minus 1 inch.
3. Air Content: Do not allow air content of trowel-finished floors to exceed 3 percent.

C. Suspended Slabs: Proportion normal-weight concrete mixture as follows:

1. Minimum Compressive Strength: 4000 psi at 28 days.
2. Slump Limit: 4 inches, plus or minus 1 inch.
3. Air Content: Do not allow air content of trowel-finished floors to exceed 3 percent.

2.13 FABRICATING REINFORCEMENT

A. Fabricate steel reinforcement according to CRSI's "Manual of Standard Practice."

2.14 CONCRETE MIXING

A. Ready-Mixed Concrete: Measure, batch, mix, and deliver concrete according to ASTM C 94, and furnish batch ticket information.

1. When air temperature is between 85 and 90 deg F, reduce mixing and delivery time from 1-1/2 hours to 75 minutes; when air temperature is above 90 deg F, reduce mixing and delivery time to 60 minutes.

PART 3 - EXECUTION

3.1 FORMWORK

- A. Design, erect, shore, brace, and maintain formwork, according to ACI 301, to support vertical, lateral, static, and dynamic loads, and construction loads that might be applied, until structure can support such loads.
- B. Construct formwork so concrete members and structures are of size, shape, alignment, elevation, and position indicated, within tolerance limits of ACI 117.
- C. Limit concrete surface irregularities, designated by ACI 347 as abrupt or gradual, as follows:
 - 1. Class A, 1/8 inch for smooth-formed finished surfaces.
 - 2. Class C, 1/2 inch for rough-formed finished surfaces.
- D. Construct forms tight enough to prevent loss of concrete mortar.
- E. Fabricate forms for easy removal without hammering or prying against concrete surfaces. Provide crush or wrecking plates where stripping may damage cast concrete surfaces. Provide top forms for inclined surfaces steeper than 1.5 horizontal to 1 vertical.
 - 1. Install keyways, reglets, recesses, and the like, for easy removal.
 - 2. Do not use rust-stained steel form-facing material.
- F. Set edge forms, bulkheads, and intermediate screed strips for slabs to achieve required elevations and slopes in finished concrete surfaces. Provide and secure units to support screed strips; use strike-off templates or compacting-type screeds.
- G. Provide temporary openings for cleanouts and inspection ports where interior area of formwork is inaccessible. Close openings with panels tightly fitted to forms and securely braced to prevent loss of concrete mortar. Locate temporary openings in forms at inconspicuous locations.
- H. Chamfer exterior corners and edges of permanently exposed concrete.
- I. Form openings, chases, offsets, sinkages, keyways, reglets, blocking, screeds, and bulkheads required in the Work. Determine sizes and locations from trades providing such items.
- J. Clean forms and adjacent surfaces to receive concrete. Remove chips, wood, sawdust, dirt, and other debris just before placing concrete.
- K. Retighten forms and bracing before placing concrete, as required, to prevent mortar leaks and maintain proper alignment.
- L. Coat contact surfaces of forms with form-release agent, according to manufacturer's written instructions, before placing reinforcement.

3.2 EMBEDDED ITEMS

- A. Place and secure anchorage devices and other embedded items required for adjoining work that is attached to or supported by cast-in-place concrete. Use setting drawings, templates, diagrams, instructions, and directions furnished with items to be embedded.

1. Install anchor rods, accurately located, to elevations required and complying with tolerances in Section 7.5 of AISC's "Code of Standard Practice for Steel Buildings and Bridges."
2. Install reglets to receive waterproofing and to receive through-wall flashings in outer face of concrete frame at exterior walls, where flashing is shown at lintels, shelf angles, and other conditions.

3.3 REMOVING AND REUSING FORMS

- A. General: Formwork for sides of beams, walls, columns, and similar parts of the Work that does not support weight of concrete may be removed after cumulatively curing at not less than 50 deg F for 24 hours after placing concrete. Concrete has to be hard enough to not be damaged by form-removal operations and curing and protection operations need to be maintained.
 1. Leave formwork for beam soffits, joists, slabs, and other structural elements that supports weight of concrete in place until concrete has achieved at least 70 percent of its 28-day design compressive strength.
 2. Remove forms only if shores have been arranged to permit removal of forms without loosening or disturbing shores.
- B. Clean and repair surfaces of forms to be reused in the Work. Split, frayed, delaminated, or otherwise damaged form-facing material will not be acceptable for exposed surfaces. Apply new form-release agent.
- C. When forms are reused, clean surfaces, remove fins and laitance, and tighten to close joints. Align and secure joints to avoid offsets. Do not use patched forms for exposed concrete surfaces unless approved by Architect.

3.4 SHORES AND RESHORES

- A. Comply with ACI 318 and ACI 301 for design, installation, and removal of shoring and reshoring.
 1. Do not remove shoring or reshoring until measurement of slab tolerances is complete.
- B. In multistory construction, extend shoring or reshoring over a sufficient number of stories to distribute loads in such a manner that no floor or member will be excessively loaded or will induce tensile stress in concrete members without sufficient steel reinforcement.
- C. Plan sequence of removal of shores and reshore to avoid damage to concrete. Locate and provide adequate reshoring to support construction without excessive stress or deflection.

3.5 VAPOR RETARDERS

- A. Sheet Vapor Retarders: Place, protect, and repair sheet vapor retarder according to ASTM E 1643 and manufacturer's written instructions.
 1. Lap joints 6 inches and seal with manufacturer's recommended tape.

3.6 STEEL REINFORCEMENT

- A. General: Comply with CRSI's "Manual of Standard Practice" for placing reinforcement.
 - 1. Do not cut or puncture vapor retarder. Repair damage and reseal vapor retarder before placing concrete.
- B. Clean reinforcement of loose rust and mill scale, earth, ice, and other foreign materials that would reduce bond to concrete.
- C. Accurately position, support, and secure reinforcement against displacement. Locate and support reinforcement with bar supports to maintain minimum concrete cover. Do not tack weld crossing reinforcing bars.
 - 1. Weld reinforcing bars according to AWS D1.4, where indicated.
- D. Set wire ties with ends directed into concrete, not toward exposed concrete surfaces.
- E. Install welded wire reinforcement in longest practicable lengths on bar supports spaced to minimize sagging. Lap edges and ends of adjoining sheets at least one mesh spacing. Offset laps of adjoining sheet widths to prevent continuous laps in either direction. Lace overlaps with wire.

3.7 JOINTS

- A. General: Construct joints true to line with faces perpendicular to surface plane of concrete.
- B. Construction Joints: Install so strength and appearance of concrete are not impaired, at locations indicated or as approved by Architect.
 - 1. Place joints perpendicular to main reinforcement. Continue reinforcement across construction joints unless otherwise indicated. Do not continue reinforcement through sides of strip placements of floors and slabs.
 - 2. Form keyed joints as indicated. Embed keys at least 1-1/2 inches into concrete.
 - 3. Locate joints for beams, slabs, joists, and girders in the middle third of spans. Offset joints in girders a minimum distance of twice the beam width from a beam-girder intersection.
 - 4. Use a bonding agent at locations where fresh concrete is placed against hardened or partially hardened concrete surfaces.
 - 5. Use epoxy-bonding adhesive at locations where fresh concrete is placed against hardened or partially hardened concrete surfaces.
- C. Contraction Joints in Slabs-on-Grade: Form weakened-plane contraction joints, sectioning concrete into areas as indicated. Construct contraction joints for a depth equal to at least one-fourth of concrete thickness as follows:
 - 1. Sawed Joints: Form contraction joints with power saws equipped with shatterproof abrasive or diamond-rimmed blades. Cut 1/8-inch wide joints into concrete when cutting action will not tear, abrade, or otherwise damage surface and before concrete develops random contraction cracks.

- D. Isolation Joints in Slabs-on-Grade: After removing formwork, install joint-filler strips at slab junctions with vertical surfaces, such as column pedestals, foundation walls, grade beams, and other locations, as indicated.
 - 1. Extend joint-filler strips full width and depth of joint, terminating flush with finished concrete surface unless otherwise indicated.
 - 2. Terminate full-width joint-filler strips not less than 1/2 inch or more than 1 inch below finished concrete surface where joint sealants, specified in Division 07 Section "Joint Sealants," are indicated.
 - 3. Install joint-filler strips in lengths as long as practicable. Where more than one length is required, lace or clip sections together.
- E. Doweled Joints: Install dowel bars and support assemblies at joints where indicated. Lubricate or asphalt coat one-half of dowel length to prevent concrete bonding to one side of joint.

3.8 WATERSTOPS

- A. Self-Expanding Strip Waterstops: Install in construction joints and at other locations indicated, according to manufacturer's written instructions, adhesive bonding, mechanically fastening, and firmly pressing into place. Install in longest lengths practicable.

3.9 CONCRETE PLACEMENT

- A. Before placing concrete, verify that installation of formwork, reinforcement, and embedded items is complete and that required inspections have been performed.
- B. Do not add water to concrete during delivery, at Project site, or during placement unless approved by Architect.
- C. Deposit concrete continuously in one layer or in horizontal layers of such thickness that no new concrete will be placed on concrete that has hardened enough to cause seams or planes of weakness. If a section cannot be placed continuously, provide construction joints as indicated. Deposit concrete to avoid segregation.
 - 1. Deposit concrete in horizontal layers of depth to not exceed formwork design pressures and in a manner to avoid inclined construction joints.
 - 2. Consolidate placed concrete with mechanical vibrating equipment according to ACI 301.
 - 3. Do not use vibrators to transport concrete inside forms. Insert and withdraw vibrators vertically at uniformly spaced locations to rapidly penetrate placed layer and at least 6 inches into preceding layer. Do not insert vibrators into lower layers of concrete that have begun to lose plasticity. At each insertion, limit duration of vibration to time necessary to consolidate concrete and complete embedment of reinforcement and other embedded items without causing mixture constituents to segregate.
- D. Deposit and consolidate concrete for floors and slabs in a continuous operation, within limits of construction joints, until placement of a panel or section is complete.
 - 1. Consolidate concrete during placement operations so concrete is thoroughly worked around reinforcement and other embedded items and into corners.
 - 2. Maintain reinforcement in position on chairs during concrete placement.
 - 3. Screed slab surfaces with a straightedge and strike off to correct elevations.
 - 4. Slope surfaces uniformly to drains where required.

5. Begin initial floating using bull floats or darbies to form a uniform and open-textured surface plane, before excess bleedwater appears on the surface. Do not further disturb slab surfaces before starting finishing operations.
- E. Cold-Weather Placement: Comply with ACI 306.1 and as follows. Protect concrete work from physical damage or reduced strength that could be caused by frost, freezing actions, or low temperatures.
1. When average high and low temperature is expected to fall below 40 deg F for three successive days, maintain delivered concrete mixture temperature within the temperature range required by ACI 301.
 2. Do not use frozen materials or materials containing ice or snow. Do not place concrete on frozen subgrade or on subgrade containing frozen materials.
 3. Do not use calcium chloride, salt, or other materials containing antifreeze agents or chemical accelerators unless otherwise specified and approved in mixture designs.
- F. Hot-Weather Placement: Comply with ACI 301 and as follows:
1. Maintain concrete temperature below 90 deg F at time of placement. Chilled mixing water or chopped ice may be used to control temperature, provided water equivalent of ice is calculated to total amount of mixing water. Using liquid nitrogen to cool concrete is Contractor's option.
 2. Fog-spray forms, steel reinforcement, and subgrade just before placing concrete. Keep subgrade uniformly moist without standing water, soft spots, or dry areas.

3.10 FINISHING FORMED SURFACES

- A. Rough-Formed Finish: As-cast concrete texture imparted by form-facing material with tie holes and defects repaired and patched. Remove fins and other projections that exceed specified limits on formed-surface irregularities.
1. Apply to concrete surfaces not exposed to public view.
- B. Smooth-Formed Finish: As-cast concrete texture imparted by form-facing material, arranged in an orderly and symmetrical manner with a minimum of seams. Repair and patch tie holes and defects. Remove fins and other projections that exceed specified limits on formed-surface irregularities.
1. Apply to concrete surfaces exposed to public view, to receive a rubbed finish.
- C. Rubbed Finish: Apply the following to smooth-formed finished as-cast concrete where indicated:
1. Smooth-Rubbed Finish: Not later than one day after form removal, moisten concrete surfaces and rub with carborundum brick or another abrasive until producing a uniform color and texture. Do not apply cement grout other than that created by the rubbing process.
- D. Related Unformed Surfaces: At tops of walls, horizontal offsets, and similar unformed surfaces adjacent to formed surfaces, strike off smooth and finish with a texture matching adjacent formed surfaces. Continue final surface treatment of formed surfaces uniformly across adjacent unformed surfaces unless otherwise indicated.

3.11 FINISHING FLOORS AND SLABS

- A. General: Comply with ACI 302.1R recommendations for screeding, restraighening, and finishing operations for concrete surfaces. Do not wet concrete surfaces.
- B. Scratch Finish: While still plastic, texture concrete surface that has been screeded and bull-floated or darbied. Use stiff brushes, brooms, or rakes to produce a profile amplitude of 1/4 inch in one direction.
 - 1. Apply scratch finish to surfaces indicated.
- C. Float Finish: Consolidate surface with power-driven floats or by hand floating if area is small or inaccessible to power driven floats. Restraighten, cut down high spots, and fill low spots. Repeat float passes and restraighening until surface is left with a uniform, smooth, granular texture.
 - 1. Apply float finish to surfaces to receive trowel finish.
- D. Trowel Finish: After applying float finish, apply first troweling and consolidate concrete by hand or power-driven trowel. Continue troweling passes and restraighten until surface is free of trowel marks and uniform in texture and appearance. Grind smooth any surface defects that would telegraph through applied coatings or floor coverings.
 - 1. Apply a trowel finish to surfaces indicated, exposed to view or to be covered with resilient flooring, carpet, ceramic or quarry tile set over a cleavage membrane, paint, or another thin-film-finish coating system.
 - 2. Finish and measure surface so gap at any point between concrete surface and an unlevelled, freestanding, 10-ft. long straightedge resting on two high spots and placed anywhere on the surface does not exceed 1/8 inch.
- E. Trowel and Fine-Broom Finish: Apply a first trowel finish to surfaces indicated or where ceramic or quarry tile is to be installed by either thickset or thin-set method. While concrete is still plastic, slightly scarify surface with a fine broom.
 - 1. Comply with flatness and levelness tolerances for trowel-finished floor surfaces.
- F. Broom Finish: Apply a broom finish to exterior concrete platforms, steps, ramps, and elsewhere as indicated.
 - 1. Immediately after float finishing, slightly roughen trafficked surface by brooming with fiber-bristle broom perpendicular to main traffic route. Coordinate required final finish with Architect before application.

3.12 MISCELLANEOUS CONCRETE ITEMS

- A. Filling In: Fill in holes and openings left in concrete structures after work of other trades is in place unless otherwise indicated. Mix, place, and cure concrete, as specified, to blend with in-place construction. Provide other miscellaneous concrete filling indicated or required to complete the Work.

- B. Curbs: Provide monolithic finish to interior curbs by stripping forms while concrete is still green and by steel-troweling surfaces to a hard, dense finish with corners, intersections, and terminations slightly rounded.
- C. Equipment Bases and Foundations: Provide machine and equipment bases and foundations as shown on Drawings. Set anchor bolts for machines and equipment at correct elevations, complying with diagrams or templates from manufacturer furnishing machines and equipment.

3.13 CONCRETE PROTECTING AND CURING

- A. General: Protect freshly placed concrete from premature drying and excessive cold or hot temperatures. Comply with ACI 306.1 for cold-weather protection and ACI 301 for hot-weather protection during curing.
- B. Evaporation Retarder: Apply evaporation retarder to unformed concrete surfaces if hot, dry, or windy conditions cause moisture loss approaching 0.2 lb/sq. ft. x h before and during finishing operations. Apply according to manufacturer's written instructions after placing, screeding, and bull floating or darbying concrete, but before float finishing.
- C. Formed Surfaces: Cure formed concrete surfaces, including underside of beams, supported slabs, and other similar surfaces. If forms remain during curing period, moist cure after loosening forms. If removing forms before end of curing period, continue curing for the remainder of the curing period.
- D. Unformed Surfaces: Begin curing immediately after finishing concrete. Cure unformed surfaces, including floors and slabs, concrete floor toppings, and other surfaces.
- E. Cure concrete according to ACI 308.1, by one or a combination of the following methods:
 - 1. Moisture Curing: Keep surfaces continuously moist for not less than seven days with the following materials:
 - a. Water.
 - b. Continuous water-fog spray.
 - c. Absorptive cover, water saturated, and kept continuously wet. Cover concrete surfaces and edges with 12-inch lap over adjacent absorptive covers.
 - 2. Moisture-Retaining-Cover Curing: Cover concrete surfaces with moisture-retaining cover for curing concrete, placed in widest practicable width, with sides and ends lapped at least 12 inches, and sealed by waterproof tape or adhesive. Cure for not less than seven days. Immediately repair any holes or tears during curing period using cover material and waterproof tape.
 - a. Moisture cure or use moisture-retaining covers to cure all concrete slabs.

3.14 JOINT FILLING

- A. Prepare, clean, and install joint filler according to manufacturer's written instructions.
 - 1. Defer joint filling until concrete has aged at least one month. Do not fill joints until construction traffic has permanently ceased.

- B. Remove dirt, debris, saw cuttings, curing compounds, and sealers from joints; leave contact faces of joint clean and dry.
- C. Install semirigid joint filler full depth in saw-cut joints and at least 2 inches deep in formed joints. Overfill joint and trim joint filler flush with top of joint after hardening.

3.15 CONCRETE SURFACE REPAIRS

- A. Defective Concrete: Repair and patch defective areas when approved by Architect. Remove and replace concrete that cannot be repaired and patched to Architect's approval.
- B. Patching Mortar: Mix dry-pack patching mortar, consisting of one part portland cement to two and one-half parts fine aggregate passing a No. 16 sieve, using only enough water for handling and placing.
- C. Repairing Formed Surfaces: Surface defects include color and texture irregularities, cracks, spalls, air bubbles, honeycombs, rock pockets, fins and other projections on the surface, and stains and other discolorations that cannot be removed by cleaning.
 - 1. Immediately after form removal, cut out honeycombs, rock pockets, and voids more than 1/2 inch in any dimension to solid concrete. Limit cut depth to 3/4 inch. Make edges of cuts perpendicular to concrete surface. Clean, dampen with water, and brush-coat holes and voids with bonding agent. Fill and compact with patching mortar before bonding agent has dried. Fill form-tie voids with patching mortar or cone plugs secured in place with bonding agent.
 - 2. Repair defects on surfaces exposed to view by blending white portland cement and standard portland cement so that, when dry, patching mortar will match surrounding color. Patch a test area at inconspicuous locations to verify mixture and color match before proceeding with patching. Compact mortar in place and strike off slightly higher than surrounding surface.
 - 3. Repair defects on concealed formed surfaces that affect concrete's durability and structural performance as determined by Architect.
- D. Repairing Unformed Surfaces: Test unformed surfaces, such as floors and slabs, for finish and verify surface tolerances specified for each surface. Correct low and high areas. Test surfaces sloped to drain for trueness of slope and smoothness; use a sloped template.
 - 1. Repair finished surfaces containing defects. Surface defects include spalls, popouts, honeycombs, rock pockets, crazing and cracks in excess of 0.01 inch wide or that penetrate to reinforcement or completely through unreinforced sections regardless of width, and other objectionable conditions.
 - 2. After concrete has cured at least 14 days, correct high areas by grinding.
 - 3. Correct localized low areas during or immediately after completing surface finishing operations by cutting out low areas and replacing with patching mortar. Finish repaired areas to blend into adjacent concrete.
 - 4. Correct other low areas scheduled to receive floor coverings with a repair underlayment. Prepare, mix, and apply repair underlayment and primer according to manufacturer's written instructions to produce a smooth, uniform, plane, and level surface. Feather edges to match adjacent floor elevations.
 - 5. Correct other low areas scheduled to remain exposed with a repair topping. Cut out low areas to ensure a minimum repair topping depth of 1/4 inch to match adjacent floor elevations. Prepare, mix, and apply repair topping and primer according to

manufacturer's written instructions to produce a smooth, uniform, plane, and level surface.

6. Repair defective areas, except random cracks and single holes 1 inch or less in diameter, by cutting out and replacing with fresh concrete. Remove defective areas with clean, square cuts and expose steel reinforcement with at least a 3/4-inch clearance all around. Dampen concrete surfaces in contact with patching concrete and apply bonding agent. Mix patching concrete of same materials and mixture as original concrete except without coarse aggregate. Place, compact, and finish to blend with adjacent finished concrete. Cure in same manner as adjacent concrete.
 7. Repair random cracks and single holes 1 inch or less in diameter with patching mortar. Groove top of cracks and cut out holes to sound concrete and clean off dust, dirt, and loose particles. Dampen cleaned concrete surfaces and apply bonding agent. Place patching mortar before bonding agent has dried. Compact patching mortar and finish to match adjacent concrete. Keep patched area continuously moist for at least 72 hours.
- E. Perform structural repairs of concrete, subject to Architect's approval, using epoxy adhesive and patching mortar.
- F. Repair materials and installation not specified above may be used, subject to Architect's approval.

3.16 FIELD QUALITY CONTROL

- A. Testing and Inspecting: Engage a special inspector to perform field tests and inspections and prepare test reports.
- B. Inspections:
1. Steel reinforcement placement.
 2. Steel reinforcement welding.
 3. Headed bolts and studs.
 4. Verification of use of required design mixture.
 5. Concrete placement, including conveying and depositing.
 6. Curing procedures and maintenance of curing temperature.
 7. Verification of concrete strength before removal of shores and forms from beams and slabs.
- C. Concrete Tests: Testing of composite samples of fresh concrete obtained according to ASTM C 172 shall be performed according to the following requirements:
1. Testing Frequency: Obtain one composite sample for each day's pour of each concrete mixture exceeding 5 cu. yd., but less than 25 cu. yd., plus one set for each additional 50 cu. yd. or fraction thereof.
 - a. When frequency of testing will provide fewer than five compressive-strength tests for each concrete mixture, testing shall be conducted from at least five randomly selected batches or from each batch if fewer than five are used.

2. Slump: ASTM C 143; one test at point of placement for each composite sample, but not less than one test for each day's pour of each concrete mixture. Perform additional tests when concrete consistency appears to change.
3. Air Content: ASTM C 231, pressure method, for normal-weight concrete; ASTM C 173, volumetric method, for structural lightweight concrete; one test for each composite sample, but not less than one test for each day's pour of each concrete mixture.
4. Concrete Temperature: ASTM C 1064; one test hourly when air temperature is 40 deg F and below and when 80 deg F and above, and one test for each composite sample.
5. Unit Weight: ASTM C 567, fresh unit weight of structural lightweight concrete; one test for each composite sample, but not less than one test for each day's pour of each concrete mixture.
6. Compression Test Specimens: ASTM C 31.
 - a. Cast and laboratory cure two sets of two standard cylinder specimens for each composite sample.
7. Compressive-Strength Tests: ASTM C 39; test one set of two laboratory-cured specimens at 7 days and one set of two specimens at 28 days.
 - a. Test one set of two field-cured specimens at 7 days and one set of two specimens at 28 days.
 - b. A compressive-strength test shall be the average compressive strength from a set of two specimens obtained from same composite sample and tested at age indicated.
8. Strength of each concrete mixture will be satisfactory if every average of any three consecutive compressive-strength tests equals or exceeds specified compressive strength and no compressive-strength test value falls below specified compressive strength by more than 500 psi.
9. Test results shall be reported in writing to Architect, concrete manufacturer, and Contractor within 48 hours of testing. Reports of compressive-strength tests shall contain Project identification name and number, date of concrete placement, name of concrete testing and inspecting agency, location of concrete batch in Work, design compressive strength at 28 days, concrete mixture proportions and materials, compressive breaking strength, and type of break for both 7- and 28-day tests.
10. Nondestructive Testing: Impact hammer, sonoscope, or other nondestructive device may be permitted by Architect but will not be used as sole basis for approval or rejection of concrete.
11. Additional Tests: Testing and inspecting agency shall make additional tests of concrete when test results indicate that slump, air entrainment, compressive strengths, or other requirements have not been met, as directed by Architect. Testing and inspecting agency may conduct tests to determine adequacy of concrete by cored cylinders complying with ASTM C 42/C 42M or by other methods as directed by Architect.
12. Additional testing and inspecting, at Contractor's expense, will be performed to determine compliance of replaced or additional work with specified requirements.
13. Correct deficiencies in the Work that test reports and inspections indicate do not comply with the Contract Documents.

END OF SECTION 033000

SECTION 034713 - TILT-UP CONCRETE

PART 1 - GENERAL

1.1 RELATED DOCUMENTS

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 SUMMARY

- A. Section includes load-bearing, tilt-up concrete, including the following:
 - 1. Monolithic panels.
- B. Related Requirements:
 - 1. Division 03 Section "Architectural Concrete" for specially finished formed concrete.
 - 2. Division 07 Section "Sheet Metal Flashing and Trim" for flashing receivers and reglets.

1.3 DEFINITIONS

- A. Face-down Surface: Concealed surface of as-cast, tilt-up panel formed against the casting slab.
- B. Face-up Surface: Exposed upper surface of as-cast, tilt-up panel.
- C. Reveal: Projection of the coarse aggregate from the matrix after exposure.

1.4 PREINSTALLATION MEETINGS

- A. Preinstallation Conference: Conduct conference at Project site.
 - 1. Before submitting design mixes, review concrete design mixture and examine procedures for ensuring quality of concrete materials. Require representatives of each entity directly concerned with tilt-up concrete to attend, including the following:
 - a. Contractor's superintendent.
 - b. Independent testing agency responsible for concrete design mixtures.
 - c. Ready-mix concrete manufacturer.
 - d. Tilt-up concrete subcontractor.
 - 2. Review special inspection procedures; testing and inspecting agency procedures for field quality control; tilt-up concrete finishes and finishing; cold- and hot-weather concreting procedures; curing procedures; casting-slab construction, flatness and levelness, finish, and joint requirements; steel reinforcement installation; hoisting

and erection plans; measurement of fabrication and erection tolerances; tilt-up concrete repair procedures; and tilt-up concrete protection.

1.5 ACTION SUBMITTALS

- A. Product Data: For each type of product.
- B. Design Mixtures: For each concrete mixture. Submit alternate design mixtures when characteristics of materials, Project conditions, weather, test results, or other circumstances warrant adjustments.
- C. Shop Drawings: Detail fabrication and installation of tilt-up concrete units. Indicate panel locations, plans, elevations, dimensions, shapes, cross sections, and details of steel embedments.
 - 1. Include steel reinforcement, detailing fabrication, bending, and placing. Include material, grade, bar schedules, stirrup spacing, bent-bar diagrams, arrangement, and supports of concrete reinforcement.
 - 2. Include additional steel reinforcement to resist hoisting and erection stresses.
 - 3. Include locations and details of hoisting points and lifting devices for handling and erection.
 - 4. Include engineering analysis data of additional steel reinforcement and hoisting and erection details, signed and sealed by the qualified professional engineer responsible for their preparation.
 - 5. Indicate welded connections by AWS standard symbols. Detail cast-in inserts, connections, and joints, including accessories.

1.6 INFORMATIONAL SUBMITTALS

- A. Qualification Data: For Installer.
- B. Welding certificates.
- C. Material Certificates: For each of the following, signed by manufacturers:
 - 1. Cementitious materials.
 - 2. Admixtures.
 - 3. Steel reinforcement and accessories.
 - 4. Bond breakers.
 - 5. Curing compounds.
 - 6. Inserts and embedments.
- D. Material Test Reports: For the following, from a qualified testing agency, indicating compliance with requirements:
 - 1. Aggregates. Include service record data indicating absence of deleterious expansion of concrete due to alkali aggregate reactivity.
- E. Field quality-control reports.

1.7 QUALITY ASSURANCE

- A. **Manufacturer Qualifications:** A firm experienced in manufacturing ready-mixed concrete products and that complies with ASTM C 94/C 94M requirements for production facilities and equipment.
 - 1. Manufacturer certified according to NRMCA's "Certification of Ready Mixed Concrete Production Facilities."
- B. **Installer Qualifications:** A qualified installer who employs a supervisor on Project who is an ACI-certified Tilt-up Supervisor.
- C. **Testing Agency Qualifications:** An independent agency, qualified according to ASTM C 1077 and ASTM E 329 for testing indicated, as documented according to ASTM E 548.
 - 1. Personnel conducting field tests shall be qualified as ACI Concrete Field Testing Technician, Grade I, according to ACI CP-1 or an equivalent certification program.
 - 2. Personnel performing laboratory tests shall be an ACI-certified Concrete Strength Testing Technician and Concrete Laboratory Testing Technician - Grade I. Testing agency laboratory supervisor shall be an ACI-certified Concrete Laboratory Testing Technician - Grade II.
- D. **Welding Qualifications:** Qualify procedures and personnel according to the following:
 - 1. AWS D1, "Structural Welding Code - Steel."
 - 2. AWS D1.4, "Structural Welding Code - Reinforcing Steel."
- E. **Concrete Testing Service:** Engage a qualified independent testing agency to perform material evaluation tests and to design concrete mixtures.
- F. **Mockups:** Cast and erect tilt-up concrete panel mockups to demonstrate typical reveals, surface finishes, texture, color, and standard of workmanship.
 - 1. Build mockup panels in the location and of the size indicated or, if not indicated, as directed by Architect.
 - 2. In presence of Architect, damage part of an exposed surface for each finish, color, and texture required, and demonstrate materials and techniques proposed for repairs to match adjacent undamaged surfaces.
 - 3. Subject to compliance with requirements, approved mockups may become part of the completed Work if undisturbed at time of Substantial Completion.

PART 2 - PRODUCTS

2.1 TILT-UP CONCRETE

- A. Comply with ACI 301, "Specifications for Structural Concrete," Sections 1 through 5, unless modified by requirements in the Contract Documents.

- B. Source Limitations: Obtain each type or class of cementitious material of the same brand from the same manufacturer's plant, obtain aggregate from one source, and obtain admixtures from one source from a single manufacturer.

2.2 FORMS AND ACCESSORIES

- A. Forms: Metal, dressed lumber, or other approved materials that are nonreactive with concrete and that will provide continuous, true, and smooth concrete surfaces.
- B. Chamfer Strips: Wood, metal, PVC, or rubber strips, 3/4 by 3/4 inch.
- C. Form Liners: Units of face design, texture, arrangement, and configuration indicated. Furnish with manufacturer's recommended liquid-release agent that will not bond with, stain, or adversely affect concrete surfaces and will not impair subsequent surface treatments of concrete.
- D. Reveal Strips: Metal, PVC, rubber, straight dressed wood, or plywood; with sides kerfed.
- E. Sealer: Penetrating, clear, polyurethane wood form sealer formulated to reduce absorption of bleedwater and prevent migration of set-retarding chemicals from wood or plywood.

2.3 STEEL REINFORCEMENT

- A. Reinforcing Bars: ASTM A 615, Grade 60, deformed.
- B. Low-Alloy-Steel Reinforcing Bars: ASTM A 706, deformed.
- C. Plain-Steel Wire: ASTM A 82, as drawn.
- D. Plain-Steel Welded Wire Reinforcement: ASTM A 185, fabricated from as-drawn steel wire into flat sheets.
- E. Deformed-Steel Welded Wire Reinforcement: ASTM A 497, flat sheet.
- F. Bar Supports: Manufactured according to CRSI's "Manual of Standard Practice" of plastic or CRSI Class 1 plastic-protected steel wire or Class 2 stainless-steel wire.

2.4 CONCRETE MATERIALS

- A. Cementitious Material: Use the following cementitious materials, of the same type, brand, and source, throughout Project:
 - 1. Portland Cement: ASTM C 150, Type I. Supplement with the following:
 - a. Fly Ash: ASTM C 618, Class F.
- B. Coarse Aggregate: ASTM C 33, Class 4M coarse aggregate or better, graded. Provide aggregates from single source.

1. Maximum Coarse-Aggregate Size: 1 inch nominal.
- C. Fine Aggregate: ASTM C 33, manufactured or natural sand, from same source for Project, free of materials with deleterious reactivity to alkali in cement.
 - D. Water: ASTM C 94 and potable.

2.5 ADMIXTURES

- A. Air-Entraining Admixture: ASTM C 260.
- B. Chemical Admixtures: Provide admixtures certified by manufacturer to be compatible with other admixtures and that will not contribute water-soluble chloride ions exceeding those permitted in hardened concrete. Do not use calcium chloride or admixtures containing calcium chloride.
 1. Water-Reducing Admixture: ASTM C 494, Type A.
 2. Retarding Admixture: ASTM C 494, Type B.
 3. Water-Reducing and Retarding Admixture: ASTM C 494, Type D.
 4. High-Range, Water-Reducing Admixture: ASTM C 494, Type F.
 5. High-Range, Water-Reducing and Retarding Admixture: ASTM C 494, Type G.
 6. Plasticizing and Retarding Admixture: ASTM C 1017, Type II.

2.6 BOND BREAKERS

- A. Solvent-Borne, Membrane-Forming Bond breaker: Dissipating polymerized solution containing no oils, waxes, paraffins, or silicones, and compatible with casting-slab curing compound.
 1. Products: Subject to compliance with requirements, available products that may be incorporated into the Work include, but are not limited to, the following:
 - a. Dayton Superior Corporation; Conspec Tilt-Eez VOC or Edoco Super Bond breaker VOC.
 - b. Universal Building Products, Inc.; Unitilt VOC.

2.7 CURING MATERIALS

- A. Evaporation Retarder: Waterborne, monomolecular film forming; manufactured for application to fresh concrete.
- B. Absorptive Cover: AASHTO M 182, Class 2, burlap cloth made from jute or kenaf, weighing approximately 9 oz./sq. yd. when dry.
- C. Moisture-Retaining Cover: ASTM C 171, polyethylene film or white burlap-polyethylene sheet.
- D. Clear, Waterborne, Membrane-Forming Curing Compound: ASTM C 309, Type 1, Class B.

2.8 CONNECTION MATERIALS

- A. Embedded Metal Items and Loose Hardware: Materials for securing tilt-up concrete panels together and to supporting and adjacent construction are specified in Division 05 Section "Metal Fabrications."
- B. Loose Hardware: Materials for securing tilt-up concrete panels together and to supporting and adjacent construction are specified in Division 05 Section "Metal Fabrications."
- C. Carbon-Steel Shapes and Plates: ASTM A 36.
- D. Carbon-Steel Bolts and Studs: ASTM A 307, Grade A; carbon-steel, hex-head bolts and studs; carbon-steel nuts; and flat, unhardened steel washers.
- E. Unheaded Carbon-Steel Rods and Nuts: ASTM A 36, threaded rods with ASTM A 563, nuts.
- F. Welded Headed Studs: AWS D1.1, Type B headed studs, and cold-finished, carbon- steel bars.
- G. Low-Alloy-Steel Reinforcing Bars: ASTM A 706, deformed.
- H. Chord Bar Sleeves: Tubular sheathing, plastic or moisture-resistance-treated cardboard.
- I. Welding Electrodes: Comply with AWS standards.
- J. Hot-Dip Galvanized Finish: Apply zinc coating to steel connections by hot-dip process, complying with ASTM A 123 or ASTM A 153 as applicable.
 - 1. Zinc Repair Paint: SSPC-Paint 20.
- K. Shop-Primed Finish: Prepare surfaces of steel connections, except those surfaces to be embedded in concrete, according to requirements in SSPC-SP 3, and shop-apply primer according to SSPC-PA 1.
 - 1. Primer: MPI#79, "Alkyd Anti-Corrosive Metal Primer."

2.9 LIFTING INSERTS AND ACCESSORIES

- A. Furnish inserts, dowels, bolts, nuts, washers, and other items to be cast in panels for tilting and lifting.
 - 1. Manufacture inserts with feet of plastic, galvanized-steel wire, plastic-tipped steel wire, or stainless-steel-tipped steel wire.
- B. Furnish brace anchors and other accessories to be cast in panels and in casting slab for attaching bracing.
 - 1. Manufacture wall brace anchors and accessories with feet of galvanized-steel wire, plastic-tipped steel wire, or stainless-steel-tipped steel wire.

2. Manufacture floor brace anchors that will not penetrate vapor retarder under slab-on-grade.

2.10 BEARING PADS

- A. Elastomeric Pads: AASHTO M 251, plain, vulcanized, 100 percent polychloroprene (neoprene) elastomer, molded to size or cut from a molded sheet; Type A Shore durometer hardness of 50 to 70, ASTM D 2240; and minimum tensile strength 2250 psi, ASTM D 412.
- B. Random, Fiber-Reinforced Elastomeric Pads: Preformed, randomly oriented synthetic fibers set in elastomer with a Type A Shore durometer hardness of 70 to 90, ASTM D 2240.
- C. Cotton-Duck-Fabric-Reinforced Elastomeric Pads: Preformed, horizontally layered cotton-duck fabric bonded in elastomer with a Type A Shore durometer hardness of 80 to 100, ASTM D 2240.
- D. High-Density Plastic Strips: Multimonomer, nonleaching plastic.

2.11 GROUT

- A. Cement Grout: Portland cement, ASTM C 150, Type I; and clean, natural sand, ASTM C 404. Mix at ratio of 1 part cement to 2-1/2 parts sand, by volume, with minimum water required for placement and hydration.
- B. Nonmetallic, Nonshrink Grout: Premixed, nonmetallic, noncorrosive, nonstaining grout containing selected silica sands, portland cement, shrinkage-compensating agents, and plasticizing and water-reducing agents; complying with ASTM C 1107, of consistency suitable for application.

2.12 MISCELLANEOUS MATERIALS

- A. Chemical Surface Retarder: Water-soluble, liquid set retarder with color dye, for horizontal concrete surface application, capable of temporarily delaying final hardening of concrete to depth of reveal or etch required of specified finish.
- B. Form Retarder: Chemical liquid set retarder, for application on hardened horizontal concrete and capable of temporarily delaying final hardening of newly placed concrete to depth of reveal specified.
 1. Mold Release: Solution specially formulated by manufacturer for use under form retarder.
- C. Flashing Reglets: Open type having continuous groove not less than 1-1/8 inches deep by 3/16 inch wide at opening and sloped upward to 45 degrees. Temporarily fill or cover face openings of reglets to prevent intrusion of concrete or debris.
 1. Hot-Dip Galvanized-Steel Sheet: ASTM A 653/A 653M, G90 coating, not less than 0.0217 inch thick.

- D. Dovetail Anchor Slots: Hot-dip galvanized-steel sheet, not less than 0.0336 inch thick, with bent tab anchors. Temporarily fill or cover face opening of slots to prevent intrusion of concrete or debris.

2.13 REPAIR MATERIALS

- A. Bonding Agent: ASTM C 1059, Type II, nonredispersible, acrylic emulsion or styrene butadiene.
- B. Patching Mortar: Dry-pack mix consisting of 1 part portland cement to 2-1/2 parts fine aggregate passing No. 16 sieve, using only enough water for handling and placing.

2.14 CONCRETE MIXTURES

- A. Prepare design mixtures for each type and strength of concrete, proportioned on basis of laboratory trial mixture or field test data, or both, according to ACI 301.
 - 1. Use a qualified independent testing agency for preparing and reporting proposed concrete design mixtures based on laboratory trial mixtures.
- B. Proportion concrete mixture as follows:
 - 1. Minimum Compressive Strength: 4000 psi at 28 days.
 - 2. Maximum Water-Cementitious Materials Ratio: 0.45.
 - 3. Slump Limit: 4 inches plus or minus 1 inch.
 - 4. Air Content: 5-1/2 percent plus or minus 1.5 percent for 1-1/2-inch nominal maximum aggregate size at point of delivery.
- C. Limit water-soluble, chloride-ion content in hardened concrete to 0.06 percent by weight of cement.
- D. Admixtures: Use admixtures according to manufacturer's written instructions.
 - 1. Use high-range, water-reducing or plasticizing admixture in concrete, as required, for placement and workability.
 - 2. Use water-reducing and retarding admixture when required by high temperatures, low humidity, or other adverse placement conditions.

2.15 CONCRETE MIXING

- A. Ready-Mixed Concrete: Measure, batch, mix, and deliver concrete according to ASTM C 94, and furnish batch ticket information.
 - 1. When air temperature is above 90 deg F, reduce mixing and delivery time to 60 minutes.

- B. Project-Site-Produced Concrete: Measure, batch, and mix concrete according to ASTM C 94. Mix concrete materials in appropriate drum-type batch machine mixer.
 - 1. Provide a batch ticket for each batch discharged and used in the Work, indicating Project identification name and number, date, mix type, mix time, quantity, and amount of water added. Record panel locations where concrete is deposited.

PART 3 - EXECUTION

3.1 FORMS

- A. Construct and brace formwork so tilt-up concrete panels are of size, shape, alignment, elevation, and position indicated.
 - 1. Construct forms on slab-on-grade or on temporary casting slab, at Contractor's option.
 - 2. Provide for openings, offsets, recesses, reveals, rustications, reglets, and blockouts.
 - 3. Place form liners accurately to provide finished surface texture indicated. Provide solid backing and supports to maintain stability of liners during concreting. Coat form liner with form-release agent.
- B. Fabricate forms for easy removal without hammering or prying against concrete surfaces. Use kerfed inserts, such as those forming reglets, rustications, and recesses, for easy removal.
- C. Set edge forms for panels to achieve required panel thickness.
- D. Chamfer exposed corners and edges, unless otherwise indicated, using chamfer strips fabricated to produce uniform, smooth lines and tight edge joints.
- E. Coat contact surfaces of wood forms and chamfers with sealer before placing reinforcement.

3.2 BONDBREAKERS

- A. Uniformly and continuously apply two coats of bondbreaker to casting-slab surfaces by power spray or roller according to manufacturer's written instructions, before placing steel reinforcement. Recoat areas subjected to moisture before drying. Maintain continuity of coating until concrete placement.
- B. After placing steel reinforcement, touch up or recoat worn or damaged areas with bondbreaker. Do not splash or coat steel reinforcement and inserts.

3.3 FORM RETARDER

- A. Uniformly and continuously apply form retarder to slab surfaces by power spray, roller, or brush according to manufacturer's written instructions, before placing steel reinforcement.

Recoat areas subjected to moisture before drying. Maintain continuity of coating until concrete placement.

- 1. Uniformly apply mold release according to manufacturer's written instructions and allow it to dry before applying form retarder.

- B. After placing steel reinforcement, touch up or recoat worn or damaged areas with form retarder. Do not splash or coat steel reinforcement and inserts.

3.4 REINFORCEMENT AND INSERTS

- A. General: Comply with CRSI's "Manual of Standard Practice" for fabricating and placing reinforcement.
- B. Accurately position, support, and secure reinforcement against displacement. Locate and support reinforcement with bar supports to maintain minimum concrete cover.
 - 1. Field weld reinforcement according to AWS D1.4, where indicated.
 - 2. Do not tack-weld crossing reinforcing bars.
 - 3. Set wire ties so ends are directed into concrete, not toward exposed concrete surfaces.
- C. Install welded wire reinforcement in longest practicable lengths on bar supports spaced to minimize sagging. Lap edges and ends of adjoining sheets at least one mesh spacing. Offset laps of adjoining sheet widths to prevent continuous laps in either direction. Lace overlaps with wire.
- D. Accurately place and securely support embedded items, anchorages, inserts, cramps, retainers, bar chords and sleeves, and other items to be built into panels. Coordinate with other trades for installing cast-in items.

3.5 PANEL CASTING, GENERAL

- A. Comply with ACI 301 for handling, placing, and consolidating concrete.
- B. Maintain position of steel reinforcement, inserts, and anchors during concrete placement, consolidation, and finishing.
- C. Screed panel surfaces to correct level with a straightedge and strike off.
 - 1. Begin initial floating before excess moisture or bleedwater appears on the surface. Use bull floats or darbies to form a uniform and open-textured surface plane free of humps or hollows. Do not disturb panel surfaces before beginning finishing operations.
- D. Form chamfers at top edges of panel perimeters, openings, and similar locations not formed by chamfer strips unless otherwise indicated.
- E. Surface Defects: Limit visible surface defects to those permitted by TCA's "Tilt-up Concrete Association's Guideline Specifications" for Grade A, Architectural panel surfaces.

3.6 CASTING TOLERANCES

- A. Cast tilt-up concrete panels without exceeding the following tolerances:
1. Height and Width of Panels:
 - a. For Panels up to 20 Feet Tall: 1/4 inch wide.
 - b. For Panels 20 to 30 Feet Tall: 3/8 inch wide.
 - c. Each Additional 10 Feet in Excess of 30 Feet Tall: 1/8 inch wide.
 2. Thickness: 3/16 inch.
 3. Skew of Panel or Opening: Difference in length of diagonals of 1/8 inch per 72 inches with a maximum difference of 1/2 inch.
 4. Openings Cast into Panel:
 - a. Size of Opening: 1/4 inch.
 - b. Location of Centerline of Opening: 1/4 inch.
 5. Location and Placement of Embedded Items:
 - a. Inserts, Bolts, and Pipe Sleeves: 3/8 inch.
 - b. Lifting and Bracing Inserts: As required by manufacturer.
 - c. Lateral Placement of Weld Plate Embedments: 1 inch.
 - d. Tipping and Flushness of Weld Plate Embedments: 1/4 inch.
 6. Deviation of Steel Reinforcement Cover: Maintain minimum cover required by ACI 301.

3.7 FACE-UP FINISHES

- A. Float Finish: Consolidate surface of plastic concrete with power-driven floats or by hand floating. Restraighten and cut down high spots and fill low spots. Repeat float passes and restraighten until surface is left with a uniform, smooth, granular texture.
- B. Trowel Finish: After applying float finish, apply first trowel finish and consolidate plastic concrete by hand trowel or power-driven trowel. Continue troweling passes and restraighten until surface is free of trowel marks and is uniform in texture and appearance.

3.8 FACE-DOWN FINISHES

- A. Smooth, As-Cast Finish: Cast panel to produce a surface free of pockets, sand streaks, and honeycombs. Produce a surface appearance of uniform color and texture.

3.9 CONCRETE PROTECTING AND CURING

- A. Protect freshly placed concrete from premature drying and excessive cold or hot temperatures according to ACI 301.

1. Apply evaporation retarder in hot, dry, or windy weather to protect concrete from rapid moisture loss before and during finishing operations. Apply according to manufacturer's written instructions after screeding and bull floating concrete, but before float finishing.
- B. Begin curing immediately after finishing concrete. Cure by one or a combination of the following methods according to ACI 308.1:
1. Moisture Curing: Keep surfaces continuously moist for no fewer than seven days with the following materials:
 - a. Water.
 - b. Continuous water-fog spray.
 - c. Absorptive cover, water saturated and kept continuously wet. Cover concrete surfaces and edges with 12-inch lap over adjacent absorptive covers.
 2. Moisture-Retaining-Cover Curing: Cover concrete surfaces with moisture-retaining cover for curing concrete, placed in widest practicable width, with sides and ends lapped at least 12 inches, and sealed by waterproof tape or adhesive. Cure for no fewer than seven days. Immediately repair any holes or tears during curing period, using cover material and waterproof tape.
 3. Curing Compound: Apply uniformly in continuous operation by power spray or roller according to manufacturer's written instructions. Recoat areas subjected to heavy rainfall within three hours after initial application. Maintain continuity of coating and repair damage during curing period.

3.10 ERECTION

- A. Use erection equipment with care to prevent damage to floor slabs and panels.
- B. Lift, support, and erect panels only at designated lifting or supporting points indicated on Shop Drawings.
- C. Do not erect panels until 28-day compressive strength of concrete has been verified.
- D. Install tilt-up concrete panels level, plumb, square, and true. Place panels on leveled grout-setting pads or shims in correct position. Maintain joint width of 1/2 inch between panels.
 1. Install tilt-up concrete panels with face-down surfaces exposed to exterior of building.
- E. Temporarily brace and support panels securely in position against loads comparable in intensity to those for which structure was designed. Maintain braces and supports in place, undisturbed, until entire integrated supporting structure has been completed and permanent connections to panels are secured.
- F. Anchor panels in place and, if indicated, to one another.
 1. Weld steel connectors to steel supports and embedments indicated, complying with AWS D1.1.

- G. Solidly grout-fill gaps between foundation system and bottom of panels.

3.11 FIELD QUALITY CONTROL

- A. Testing and Inspecting: Engage a qualified special inspector to perform tests and inspections.
- B. Inspections:
 - 1. Steel reinforcement placement.
 - 2. Steel reinforcement welding.
 - 3. Headed bolts and studs.
 - 4. Verification of use of required design mixture.
 - 5. Concrete placement, including conveying and depositing.
 - 6. Curing procedures and maintenance of curing temperature.
 - 7. Verification of concrete strength before erection of tilt-up panels.
- C. Testing Services: Tests shall be performed according to ACI 301.
- D. Tilt-up concrete panels will be considered defective if they do not pass tests and inspections.
- E. Prepare test and inspection reports.

3.12 ERECTION TOLERANCES

- A. Install tilt-up concrete panels without exceeding the following erection tolerances:
 - 1. Joint Width Variation (Exterior Face): Without decreasing or increasing more than 50 percent from specified joint width, maintain joint width as follows:
 - a. For Panels up to 20 Feet Tall: 1/4 inch.
 - b. Each Additional 10 Feet in Excess of 20 Feet Tall: 1/8 inch.
 - 2. Joint Taper: Maximum 3/8 inch over length, but not greater than the following:
 - a. For Panels up to 20 Feet Tall: 1/4 inch.
 - b. Each Additional 10 Feet in Excess of 20 Feet Tall: 1/8 inch.
 - 3. Panel Alignment:
 - a. Alignment of Horizontal and Vertical Joints: 1/4 inch.
 - b. Offset in Exterior Face of Adjacent Panels: 1/4 inch.

3.13 FILLING AND REPAIRS

- A. Patch holes and voids left by erecting and bracing inserts on tilt-up panels and slabs-on-grade. Cut or chip edges of voids perpendicular to concrete surface. Fill blockouts where indicated.

1. Clean, dampen with water, and brush-coat holes, voids, and blockouts with bonding agent. Fill and compact with patching mortar of a stiff consistency before bonding agent has dried.
 2. Finish surfaces of fills and repairs to Architect's approval, with materials of same colors and textures as finishes on surrounding surfaces.
- B. Repair damaged galvanized-steel surfaces of connectors by cleaning and applying a coat of zinc repair paint.
- C. Repair damage to tilt-up panels and slabs-on-grade resulting from tilt-up work, as directed by Architect.
- D. Remove and replace tilt-up panels that do not comply with requirements in this Section.
- E. Demolish and remove temporary concrete casting slabs.

END OF SECTION 034713