



Standard Practice for Making Roller-Compacted Concrete in Cylinder Molds Using a Vibrating Table¹

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1. Scope

1.1 This practice covers procedures for making cylindrical test specimens from concrete when the standard procedures of rodding and internal vibration, as described in Practice C 31, are not practicable. This practice is applicable to freshly mixed concrete, prepared in the laboratory and the field, having a nominal maximum size aggregate of 50 mm (2 in.) or less. If the nominal maximum size aggregate is larger than 2 in., the practice is applicable only when performed on the fraction passing the 50-mm (2-in.) sieve with the larger aggregate being removed in accordance with Practice C 172. This practice, intended for use in testing roller-compacted concrete, may be applicable to testing other types of concrete such as cement-treated aggregate and mixtures similar to soil-cement.

1.2 Two methods are provided for making concrete cylinders using a vibrating table:

1.2.1 Method A is a procedure for making test specimens in steel reusable molds attached to a vibrating table.

1.2.2 Method B is a procedure for making test specimens in single-use plastic molds that have been inserted into a metal sleeve attached to a vibrating table.

1.3 The values stated in inch-pound units are to be regarded as the standard. The values given in parentheses are for information purposes only.

1.4 *This standard does not purport to address all of 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.*

2. Referenced Documents

2.1 ASTM Standards:

C 31 Practice for Making and Curing Concrete Test Specimens in the Field²

C 39 Test Method for Compressive Strength of Cylindrical Concrete Specimens²

C 172 Practice for Sampling Freshly Mixed Concrete²

C 192 Practice for Making and Curing Concrete Test Specimens in the Laboratory²

C 470 Specification for Molds for Forming Concrete Test Cylinders Vertically²

C 496 Test Method for Splitting Tensile Strength of Cylindrical Concrete Specimens²

C 1170 Test Methods for Consistency and Density of Roller-Compacted Concrete Using a Vibrating Table²

E 11 Specification for Wire-Cloth Sieves for Testing Purposes³

2.2 *ACI Reports and Standards:*
207.5R-88 Report on Roller-Compacted Concrete⁴

211.3-75 (R 1988) Practice for Selecting Proportions for No-Slump Concrete⁴

2.3 *Bureau of Reclamation Test Procedure:*

USBR 4906-86 Casting No-Slump Concrete in Cylinder Molds Using Vibratory Table⁵

3. Summary of Practice

3.1 This practice describes methods for making cylindrical concrete test specimens using a vibrating table. Test specimens are made in cylindrical molds that are attached to the vibrating table under a 20-lb (9.1-kg) surcharge to facilitate consolidation.

4. Significance and Use

4.1 This practice is intended to be used for stiff to extremely dry concrete mixtures commonly used in roller-compacted concrete construction. This practice is used instead of rodding or internal vibration, which cannot properly consolidate concrete of this consistency (Note 1).

NOTE 1—Further description of this concrete consistency is given in ACI 207.5R-88 and 211.3-75 (R 1988). The consistency of concrete may be determined in accordance with Test Method C 1170.

5. Apparatus

5.1 Molds:

5.1.1 *Type A Mold*—A cylindrical mold conforming to the

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² *Annual Book of ASTM Standards*, Vol 04.02.

³ *Annual Book of ASTM Standards*, 14.02.

⁴ *ACI Manual of Concrete Practice, Part 1, Materials and General Properties of Concrete*, 1988, American Concrete Institute, P.O. Box 19150, Detroit, MI 48219.

⁵ "Guidelines for Designing and Constructing Roller-Compacted Concrete Dams," *ACER Technical Memorandum No. 8*, Bureau of Reclamation, Denver, CO, Appendix A, 1987.

requirements of Specification C 470 for 6-in. (152-mm) diameter by 12-in. (305-mm) high reusable molds. Molds shall be made of steel or other hard metal not readily attacked by the cement paste. Aluminum molds shall not be used. Molds shall be equipped with permanently affixed metal slotted brackets on the baseplate so the molds can be rigidly clamped to a vibrating table. The top rim of the mold shall be smooth, plane, and parallel to the bottom of the mold. The bottom of the mold shall provide a watertight seal.

5.1.2 *Type B Mold*—A single-use plastic, cylindrical mold 6 in. (152 mm) in diameter and 12 in. (305 mm) in height. The mold specifications shall conform to Specification C 470 for single-use plastic molds.

5.1.2.1 *Mold Sleeve*—A Type B cylindrical mold shall be inserted into a rigid cylindrical sleeve with a bottom baseplate that is clamped to the vibrating table. The mold sleeve shall be made of steel or other hard metal that does not react with concrete containing portland or other hydraulic cement. The sleeve shall be capable of firmly and vertically holding the plastic mold in place without deformation and shall be slotted vertically with adjustable clamps for tightening around the mold. The sleeve shall be hinged so that it can be opened to remove the mold (Fig. 1) and shall also have permanently affixed slotted metal brackets so the sleeve may be rigidly clamped to the vibrating table. The mold sleeve shall have a minimum wall thickness of 1/8 in. (3.2 mm), and a minimum baseplate thickness of 1/4 in. (6.4 mm). The inside diameter of the mold sleeve shall be 1/8 ± 1/16 in. (3.2 ± 1.6 mm) larger than the outside diameter of the Type B mold and have a height 1/2 to 1/4 in. (12.8 ± 6.4 mm) less than the height of the Type B mold.

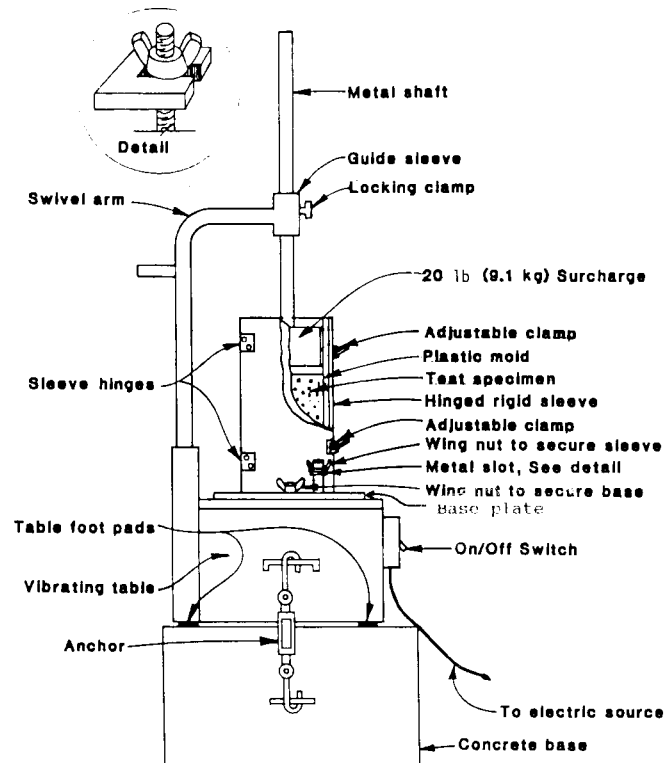


FIG. 1 Vibrating Table—Cylinder Preparation (Type B Mold)

5.2 *Vebe Vibrating Table*—A vibrating table with a 3/4-in. (19-mm) thick steel deck with dimensions of approximately 15 in. (381 mm) in length, 10 1/4 in. (260 mm) in width, and 12 in. (305 mm) in height. The vibrating table shall be constructed in such a manner as to prevent flexing of the table during operation. The table deck shall be activated by an electromechanical vibrator. The total mass of the vibrator and table shall be approximately 210 lb (95 kg). The table shall be level and clamped to a concrete floor or base slab that has sufficient mass to prevent displacement of the apparatus during specimen preparation (Note 2).

NOTE 2—The recommended vibrating table for these procedures is the Vebe vibrating table.⁶ Testing to date has been performed using this apparatus. An alternative vibrating table may be substituted for the Vebe apparatus provided it meets the specifications for the sinusoidal vibration given in 7.1.

5.3 *Swivel Arm and Guide Sleeve*—A metal guide sleeve with a clamp assembly or other suitable holding device mounted on a swivel arm. The swivel arm and guide sleeve must be capable of holding a metal shaft attached to a 20-lb (9.1-kg) cylindrical mass in a position perpendicular to the vibrating surface and allowing the shaft to slide freely when the clamp is released. The swivel arm must be capable of maintaining the guide sleeve in a locked position directly over the center of the specimens to be vibrated. The swivel arm shall also be capable of being rotated away from the center of the table (Note 3).

NOTE 3—The Vebe vibrating table comes equipped with the swivel arm and guide sleeve.

5.4 *Surcharge*—A cylindrical steel mass with a metal shaft at least 18 in. (457 mm) in length and 5/8 ± 1/16 in. (16 ± 2 mm) in diameter attached perpendicularly to and embedded in the center of the mass. The shaft shall slide through the guide sleeve without binding. The surcharge shall have a diameter of 5 3/4 ± 1/8 in. (146 ± 3 mm). The surcharge assembly shall have a mass of 20 ± 0.5 lb (9.1 ± 0.25 kg) including the mass of the metal shaft (Fig. 1). If the surcharge is to be hand held, the length of the shaft may be reduced to about 12 in. (305 mm) and fabricated with a “T” or “D” handle for gripping the surcharge shaft to avoid slipping.

5.5 *Sieve*—A 50-mm (2-in.) sieve conforming to Specification E 11.

5.6 *Small Tools*—Trowels, square-ended shovel and hand scoops, steel trowel, wooden float, wrench, tamping rod, and flashlight as required.

6. Sampling

6.1 Samples of fresh concrete shall be obtained in accordance with Practice C 172.

6.2 Concrete samples shall have a nominal maximum size aggregate of 50 mm (2 in.) or less. If the concrete has aggregate larger than 50 mm (2 in.), samples shall be obtained by wet sieving over a 50-mm (2-in.) sieve in accordance with Practice C 172.

⁶ The Vebe vibrating table, including cylindrical mold and guide sleeves, is manufactured by SoilTest, 86 Albrecht Drive, P.O. Box 8004, Lake Bluff, IL 60044-9902.

6.3 Concrete test specimens shall be made within 45 min after the completion of mixing concrete unless otherwise stipulated.

7. Calibration and Standardization

7.1 The vibrating table shall produce a sinusoidal vibratory motion with a frequency of at least 3600 ± 100 vibrations per min (60 ± 1.67 Hz) and a double amplitude of vibration of 0.0170 ± 0.0030 in. (0.43 ± 0.08 mm) when a 60.0- \pm 2.5-lb (27.2- \pm 1.1-kg) surcharge is rigidly bolted to the center of the table.

7.1.1 Determine the frequency and double amplitude⁷ of the vibrating table under simulated test conditions prior to initial use and annually thereafter. A vibrating reed tachometer should be used to check the frequency of vibration.

7.2 Recalibrate the vibrating table after any event (including repairs) that might affect its operation, or whenever test results are questionable.

8. Technical Precautions

8.1 When obtaining samples, ensure that the samples are representative of the material being sampled.

8.2 Concrete with stiff to extremely dry consistency is highly susceptible to segregation during handling. To minimize segregation, use care in obtaining samples and during transporting, remixing, and testing of the concrete.

8.3 After at least every three months of continued use, inspect and clean the underside of the vibrating table top of any hardened concrete or cement paste which may interfere with free movement of the table top.

9. Procedure

9.1 Method A—Type A Molds:

9.1.1 Coat Type A molds with a suitable lubricant or bond breaker prior to casting the test specimens to facilitate removal from the mold.

9.1.2 Place the mold on the vibrating table, and center the surcharge so that the edges of the plastic plate do not touch the walls of the mold. Lower the surcharge into the mold to check for proper clearance. Attach the mold to the vibrating table, and firmly tighten the wing nuts. Move the surcharge away from the mold.

9.1.3 Place enough concrete in the mold so that the mold will be filled to one-third of its volume after consolidation [approximately 9.5 lb (4.3 kg)]. A tamping rod may be used to distribute the loose concrete as it is added. During filling, use square-ended shovels and scoops to obtain representative samples, and handle the concrete in such a manner that larger sized coarse aggregate particles do not separate from the mortar.

9.1.4 Move the surcharge over the center of the mold, release the guide sleeve clamp, and place the surcharge gently on the loose concrete. The surcharge shall be able to vertically slide free without binding on the guide sleeve.

9.1.5 If the surcharge cannot be centered in the mold without binding on the inside wall of the mold, place the surcharge directly onto the specimen in the mold without use of the guide sleeve, and hold the surcharge shaft perpendicular to the top of the table. Hold the surcharge shaft manually while vibrating the specimen. Do not apply any additional hand pressure to the surcharge when manually holding the surcharge.

9.1.6 Start the vibrator table, and allow the concrete to consolidate under the surcharge. Using a flashlight, observe the concrete in the annular space between the edge of the surcharge and the inside wall of the mold. As the concrete consolidates, mortar will fill in the annular space between the outer edge of the surcharge and the inside mold wall. Observe the mortar until it forms a ring around the total perimeter of the surcharge. When the mortar ring forms completely around the surcharge, stop the vibrator. If the wing nuts loosen while casting the specimen, retighten the wing nuts, then continue vibrating to ensure complete consolidation of the specimen.

9.1.7 If a rock pocket prevents the mortar ring from forming at one small location, even though it has formed in all other locations, the vibrator can be stopped and another layer of concrete added. If a significant portion of the mortar ring does not form, this indicates the concrete may have insufficient mortar due to either improper sampling, segregation, or improper mixture proportioning. In these instances, the concrete specimen should be visually inspected after stripping from the mold, and a decision then made whether to accept or reject the specimen.

9.1.8 Repeat the procedure in 9.1.3 through 9.1.7 for the second lift of concrete, filling the mold to approximately two-thirds of its volume. For the third lift, overfill the mold by mounding the concrete above the top of the mold. Again, place the surcharge on the loose concrete and consolidate. If the surcharge consolidates concrete below the top level of the mold, turn off the vibrating table. Place additional concrete in the mold so that, when consolidated, the concrete will be about $\frac{1}{8}$ in. (3 mm) above the top of the mold. Continue vibrating, and slide the surcharge back and forth across the top of the mold until the compacted concrete is level with the top of the mold. This replaces strikeoff with a float since stiff concrete cannot be easily floated. Do not allow the surcharge to remain in one position when the concrete is being finished because this can cause aggregates to be forced down and mortar to be forced out of the mold resulting in a nonrepresentative test specimen. After the surface has been screeded with the surcharge, vibrate the specimen for 4 ± 1 s without the surcharge to fill in minor surface tears unless damage to the specimen by large-amplitude oscillations of the vibrator is anticipated.

9.1.8.1 When making test specimens using an alternative vibrating table, it may not be possible to vibrate the specimen without a surcharge. This is due to the disturbance of the compacted specimen when large-amplitude, low-frequency oscillations occur after the vibrator has been turned off. If this occurs, keep the surcharge in place until the vibrating table has completely stopped.

9.1.9 Remove the mold with the consolidated specimen

⁷ "Suggested Method for the Calibration of Vibrating Tables for Maximum Index Density Testing," *ASTM Geotechnical Journal*, Vol 2, No. 3, p. 152, September 1979.

from the vibrating table, and finish the top surface of the specimen with a steel trowel or wooden float. Avoid dislodging aggregate particles from the surface when using a wooden float.

9.2 Method B—Type B Molds:

Make concrete test specimens in Type B molds in accordance with 9.1. Prior to making test specimens, insert a Type B mold into the metal sleeve ensuring a close fit but not deforming the plastic mold. A sleeve assembly made from an existing steel cylindrical mold is shown in Fig. 1. Rigidly clamp the entire assembly to the vibrating table, and make the test specimen in accordance with procedures in 9.1.2 through 9.1.9.

10. Curing

10.1 Unless otherwise specified, all specimens shall be cured in accordance with the sections on curing in Practice C 192 or Practice C 31, whichever is applicable. Specimens tested for compressive strength and splitting tensile strength shall be in accordance with Methods C 39 and Test Method C 496, respectively.

11. Keywords

11.1 concrete; cylinder preparation; roller-compacted concrete

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