DATE RELEASED: 23/08/2013

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**Quality Control Document 0811CCQC**

QC Requirements of Concrete Canvas

1. **SPACER FABRIC REQUIREMENTS**

|  |  |  |
| --- | --- | --- |
| **TYPE** | **THICKNESS (mm)** | **TOLERANCE** |
| CC5- 16 GAUGE | 5.10 | ± 0.40 |
| CC5- 12 GAUGE | 5.10 | ± 0.40 |
| CC8 | 8.00 | ± 0.40 |
| CC13 | 12.50 | ± 0.40 |

1. **DIMENSIONS REQUIREMENTS**
   1. Length

|  |  |  |
| --- | --- | --- |
|  | **Min Length**  **(m)** | **Max Length**  **(m)** |
| **CC5** | 196 | 210 |
| **CC8** | 111 | 119 |
| **CC13** | 71 | 76 |

* 1. Width

|  |  |  |  |
| --- | --- | --- | --- |
|  | **Min Width**  **(m)** | **Max Width**  **(m)** | **Tolerance included**  **± (%)** |
| **CC5** | 1000 | 1070 | 3.8% |
| **CC8** | 1070 | 1133 | 2.9% |
| **CC13** | 1070 | 1133 | 2.9% |

1. **WEIGHT OF CONCRETE CANVAS**

|  |  |  |  |
| --- | --- | --- | --- |
|  | **Min Weight**  **(kg/m2)** | **Max Weight**  **(kg/m2)** | **Tolerance included**  **± (%)** |
| **CC5** | 6.3 | 7.7 | 10.0% |
| **CC8** | 10.6 | 12.2 | 7.0% |
| **CC13** | 18 | 20 | 5.3% |

1. **STRENGTH REQUIRMENTS**

|  |  |  |  |  |
| --- | --- | --- | --- | --- |
| **Cloth category** | **Min. Strength** | | **Range of average QC results (2010)** | |
| [N] | MPa | [N] | MPa |
| CC4 | 15 | 3.5 | 18 – 39 | 4.1 – 6.8 |
| CC8 | 59 | 3.5 | 59 – 88 | 3.8 – 6.7 |
| CC13 | 200 | 4.4 | 200 - 250 | 4.9 - 6.4 |

1. **SETTING TIME REQUIRMENTS**
   1. Un-accelerated blend. Results for average temperature of 20°C.

|  |  |  |
| --- | --- | --- |
|  | **USUAL RANGE [min./hours]** | **LIMITS [min./hours]** |
| **INITIAL SET [min.]** | 270 – 420 [4:30 – 7:00] | >180 [3:00] |
| **FINAL SET [min.]** | 300 – 510 [5:00 – 8:30] | <540 [9:00] |

* 1. Accelerated blend. Results for average temperature of 20°C

|  |  |  |
| --- | --- | --- |
|  | **USUAL RANGE [min./hours]** | **LIMITS [min./hours]** |
| **INITIAL SET [min.]** | 80 - 180 [1:20 – 3:00] | >80 [1:20] |
| **FINAL SET [min.]** | 130 - 270 [2:10 – 4:30] | <300 [5:00] |