



Designation: **C563—18 C563 – 18a**

Standard Guide for Approximation of Optimum SO₃ in Hydraulic Cement¹

This standard is issued under the fixed designation C563; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ε) indicates an editorial change since the last revision or reapproval.

1. Scope*

1.1 This guide describes the determination of approximate optimum SO₃ for maximum performance as a result of substituting calcium sulfate for a portion of the cement.

1.2 This guide refers to the sulfur trioxide (SO₃) content of the cement only. Slag cements and occasionally other hydraulic cements can contain sulfide or other forms of sulfur. The determination of SO₃ content by rapid methods may include these other forms, and may therefore produce a significant error. If a significant error occurs, analyze the cement for SO₃ content using the reference test method of Test Methods **C114** for sulfur trioxide.

1.3 Values stated as SI units are to be regarded as standard.

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, health, and environmental practices and determine the applicability of regulatory limitations prior to use.*

1.5 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

2. Referenced Documents

2.1 *ASTM Standards:*²

C39/C39M Test Method for Compressive Strength of Cylindrical Concrete Specimens

C78/C78M Test Method for Flexural Strength of Concrete (Using Simple Beam with Third-Point Loading)

C109/C109M Test Method for Compressive Strength of Hydraulic Cement Mortars (Using 2-in. or [50-mm] Cube Specimens)

C114 Test Methods for Chemical Analysis of Hydraulic Cement

C150/C150M Specification for Portland Cement

C192/C192M Practice for Making and Curing Concrete Test Specimens in the Laboratory

C204 Test Methods for Fineness of Hydraulic Cement by Air-Permeability Apparatus

C305 Practice for Mechanical Mixing of Hydraulic Cement Pastes and Mortars of Plastic Consistency

C430 Test Method for Fineness of Hydraulic Cement by the 45-μm (No. 325) Sieve

C465 Specification for Processing Additions for Use in the Manufacture of Hydraulic Cements

C471M Test Methods for Chemical Analysis of Gypsum and Gypsum Products (Metric)

C595/C595M Specification for Blended Hydraulic Cements

C596 Test Method for Drying Shrinkage of Mortar Containing Hydraulic Cement

C1157/C1157M Performance Specification for Hydraulic Cement

C1437 Test Method for Flow of Hydraulic Cement Mortar

C1679 Practice for Measuring Hydration Kinetics of Hydraulic Cementitious Mixtures Using Isothermal Calorimetry

C1702 Test Method for Measurement of Heat of Hydration of Hydraulic Cementitious Materials Using Isothermal Conduction Calorimetry

3. Significance and Use

3.1 The purpose of this guide is to estimate the SO₃ content for a hydraulic cement that gives maximum performance. The value obtained is one way to establish an appropriate level of sulfate in the manufacture of cements specified in Specifications **C150/C150M**, **C595/C595M**, and **C1157/C1157M**.

¹ This guide is under the jurisdiction of ASTM Committee **C01** on Cement and is the direct responsibility of Subcommittee **C01.28** on Sulfate Content. Current edition approved Oct. 15, 2018; Dec. 1, 2018. Published October 2018; March 2019. Originally approved in 1965. Last previous edition approved in 2017 as **C563—17**; **C563 – 18**. DOI: 10.1520/C0563-18; 10.1520/C0563-18A.

² 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

3.2 The SO₃ content of a cement giving maximum performance is different at different ages, with different performance criteria and with different materials such supplementary cementitious materials and chemical admixtures. A manufacturer can choose the performance criteria to determine optimum SO₃ content. This optimum SO₃ content may be a compromise between different ages and different performance criteria.

NOTE 1—Typically, the optimum SO₃ content is higher the later the age.

3.3 This guide indicates optimum SO₃ content for cement, optionally in presence of supplementary cementitious materials and admixtures. Several alternate methods are allowed: compressive strength of concrete or mortar, heat of hydration of paste or mortar, and drying shrinkage of mortar.

3.4 It should not be assumed that the optimum SO₃ estimated in this guide is the same SO₃ content for optimum performance of a concrete prepared in the field using the same materials. The optimum SO₃ is influenced by parameters such as ambient and fresh concrete temperature, admixtures, and supplementary cementitious materials.

3.5 The guide is applicable to cements specified in Specifications **C150/C150M**, **C595/C595M**, and **C1157/C1157M**.

4. Apparatus

4.1 Use the apparatus as specified in Test Methods **C109/C109M**, **C192/C192M**, **C596**, or **C1702**.

5. Materials

5.1 *Calcium Sulfate*—Use calcium sulfate for addition to the cement that is either a high-grade natural gypsum having an SO₃ content of at least 46 %, or the calcium sulfate from the source used for the intended plant production. Grind the calcium sulfate to 100 % passing the 75-µm (No. 200) sieve, and at least 800 m²/kg Blaine fineness (Test Method **C204**). If the SO₃ content of the calcium sulfate is unknown, analyze it in accordance with Test Methods **C471M**.

NOTE 2—The calcium sulfate source can impact the optimum sulfate result due in part to differences in surface area and form of the calcium sulfate (for example, gypsum, calcium sulfate hemi-hydrate, or anhydrous calcium sulfate). Temperatures in cement finish mills during production can reach levels to partially or completely change the form of calcium sulfate in cement, while laboratory grinding of calcium sulfate may alter its reactivity through increased fineness and partial change of the form of the calcium sulfate. Different clinkers may react differently to the effect of sulfate forms. In particular, if the dissolution rate of sulfate during cement hydration is at any time lower than the sulfate consumption rate of the aluminates, the sulfate in solution may become temporarily depleted, resulting in elevated aluminate reactivity and significant reductions in alite reactivity. Elevated aluminate reactivity may lead to loss of workability and admixture performance as well as reduced rate of strength development and setting behavior that has a relatively low degree of repeatability and reproducibility. On the other hand, if the dissolution rate of sulfate before placing of concrete is higher than the sulfate consumption rate of the aluminates, precipitation of secondary gypsum may cause loss of workability and false set.

5.2 *Cement*—Make cements of different sulfate levels at a single production site. Make the cements so that the amount of calcium sulfate added, and the subsequent dilution effects, are the only difference in constituent materials.

5.2.1 Grind samples to a fineness within 13 m²/kg of the other samples when tested in accordance with Test Method **C204**. Since calcium sulfate sources are typically softer than clinker, an adjustment of 10 m²/kg for every 1 % calcium sulfate addition is permitted, as shown in **Eq 1**.

$$F_{A,X} = F_{M,X} - \frac{10 \cdot (\text{SO}_{3,X} - \text{SO}_{3,\text{median}})}{\text{SO}_{3,\text{CS}}/100} \quad (1)$$

where:

- SO_{3,CS} = percentage of SO₃ in the calcium sulfate,
- SO_{3,median} = SO₃ percentage of the sample with the median SO₃ of the samples tested,
- SO_{3,X} = SO₃ percentage of cement sample X,
- F_{M,X} = measured fineness of cement sample X, and
- F_{A,X} = adjusted fineness of cement sample X.

NOTE 3—Differences in the mill conditions between samples of different sulfate levels should be minimized. For this reason samples are normally taken during the same production campaign. Strategies should be employed to minimize the differences in fineness of the clinker when taking samples, such as targeting a specific sieve size range and adjusting around that target within reasonable tolerances. Since calcium sulfate is softer, and thus easier to grind than clinker, increases in calcium sulfate content will elevate the fineness of the cement without a change in the grinding energy or the fineness of the clinker.

NOTE 4—As an example, consider the case of one cement sample with an SO₃ content of 2.7 % and a fineness of 380 m²/kg, which is the sample with the median SO₃ content, and another sample with an SO₃ content of 3.7 % and a fineness of 405 m²/kg. The second sample has a 1.0% higher SO₃ content, or 2.2 % more calcium sulfate addition, assuming the calcium sulfate was 45 % SO₃. The adjusted cement fineness of the second sample would be reduced by 22 m²/kg (10 × 2.2) to 383 m²/kg by using **Eq 1** as shown in **Eq 2**. This value of 383 m²/kg is within 13 m²/kg of the fineness of 380 m²/kg, and thus is acceptable for testing.

$$F_{A,X} = 405 - \frac{10 \cdot (3.7 - 2.7)}{\frac{45}{100}} = 383 \text{ m}^2/\text{kg} \quad (2)$$

5.2.2 Determine the percentage of the following analytes by Test Method **C114** for each cement tested: silicon dioxide (SiO₂), aluminum oxide (Al₂O₃), ferric oxide (Fe₂O₃), calcium oxide (CaO), magnesium oxide (MgO), sulfur trioxide (SO₃), loss on

ignition, insoluble residue, sodium oxide (Na₂O), and potassium oxide (K₂O). Calculate the potential percentages of the following compounds for portland cements according to Specification **C150/C150M**: tricalcium silicate, dicalcium silicate, tricalcium aluminate, and tetracalcium aluminoferrite. When applicable, report the amount of limestone and Specification **C465** inorganic processing additions according to Specification **C150/C150M**. Determine the fineness of each cement tested according to Test Methods **C204** and **C430**.

NOTE 5—The amount of material retained on the 45- μ m sieve has been used as an indication of the clinker fineness. When high efficiency separators are used, the amount retained on a 20- μ m sieve has also been used as an indicator of clinker fineness.

6. Procedure

6.1 *Sulfate Levels to Test*—Test at least five different sulfate levels.

6.1.1 SO₃ contents are to be at least 0.20 % different unless more than five different SO₃ contents are being tested. The maximum and minimum SO₃ content of the blended samples must differ by at least 2.0 % SO₃ content.

NOTE 6—The same mixture design and materials shall be used when comparing different SO₃ contents. Use one or more of the following test methods to evaluate the performance:

6.1.1.1 When adding calcium sulfate it is considered as part of the mass of cement for proportioning.

6.1.1.2 Use the following equation to calculate the total SO₃ in the blended sample of cement and calcium sulfate:

$$SO_{3-Total} = \frac{M_{calcium\ sulfate}}{M_{calcium\ sulfate} + M_{cement}} \times SO_{3-calcium\ sulfate} + \frac{M_{cement}}{M_{calcium\ sulfate} + M_{cement}} \times SO_{3-cement} \quad (3)$$

where:

$M_{calcium\ sulfate}$ = the mass of the calcium sulfate,
 M_{cement} = the mass of the cement,
 $SO_{3-calcium\ sulfate}$ = the percent by mass of SO₃ in the calcium sulfate, and
 $SO_{3-cement}$ = the percent by mass of the SO₃ in the cement.

NOTE 7—As an example, consider the case of a cement with a SO₃ content of 2.7 % and calcium sulfate with SO₃ content of 45 % where 594 g of cement are mixed with 6 g calcium sulfate. The total SO₃ of the blend of cement and calcium sulfate would be 3.1 % as shown in equation Eq 4 below:

$$SO_{3-Total} = \frac{6}{6+594} \times 45 \% + \frac{594}{6+594} \times 2.7 \% = 3.1 \% \quad (4)$$

NOTE 8—More sulfate levels may be tested to help improve the precision of the interpretation of the results. Extremely high and low sulfate levels can give results that deviate from the typical peak behavior which may need to be treated as outliers when using a mathematical fitting procedure.

6.2 The same mixture design and materials shall be used when comparing different SO₃ contents. Use one or more of the following test methods to evaluate the performance:

6.2.1 *Mortar compressive strength*—Determine mortar compressive strength at each sulfate level at the age of 24 \pm ¼ h, 3 days \pm 1 h, or 7 days \pm 3 h in accordance with Test Method **C109/C109M** except as follows:

6.2.1.1 When mixing in accordance with the “Procedure for Mixing Mortars” section of Practice **C305**, add the calcium sulfate to the water, unless the calcium sulfate addition has been previously ground and mixed with the cement; then start the mixer and mix at slow speed (140 \pm 5 rpm) for 15 s; then stop the mixer and add the cement to the water; then start the mixer and mix at slow speed (140 \pm 5 rpm) for 30 s.

6.2.1.2 Use the amount of mixing water to produce a flow of 110 \pm 5 to 115 % for one of the mixtures using 25 drops of the table as determined in the section on Procedures in Test Method **C1437**. Use that same amount of water (constant w/cm) for each mixture with different sulfate levels.

NOTE 9—The mixture with the median sulfate level or lowest sulfate level is often used to determine the water content.

6.2.2 *Heat of hydration*—Determine heat of hydration at each sulfate level at the desired ages in accordance with Test Method **C1702** except as follows:

6.2.2.1 If making calcium sulfate powder additions to an industrially produced cement sample, add the cement and calcium sulfate powder directly into the calorimetry sample vial and dry mix the solids inside the calorimetry sample vial to ensure that the calcium sulfate is blended with the cement prior to water addition. If using industrially-produced cement samples with the calcium sulfate additions already interground, follow the procedure for Test Method **C1702** Method A or B except as follows. Alternatively, produce a mortar as described **6.2.1**.

6.2.2.2 Additions of other materials typically used in concrete, such as supplementary cementitious materials and chemical admixtures, can be used, provided that the content of supplementary cementitious materials, chemical admixtures, or both are kept the same for each different mixture.

6.2.2.3 When testing with mortars use the same sand content for each different mixture.

6.2.2.4 Testing at temperatures besides 23°C is allowed. Use the same temperature for each different mixture.

NOTE 10—Experience shows that mixing cement paste externally and transferring a subset of paste or mortar to the sample vial generates higher variability because of increased variability of the masses of cement and calcium sulfate transferred from the external mixing vial to the sample vial. If using cement paste with additions of calcium sulfate powder not already interground in the cement, it is recommended to weigh and mix all materials

inside the sample vial without removing any material from the sample vial after mixing.

NOTE 11—Blending of two industrially produced cement samples as described in 5.2, produced within the same day with a low and a high SO₃ content to obtain a series of sub samples with varying SO₃ contents, is known to give good results, provided that the clinker fineness and the clinker reactivity are similar. Alternatively, the addition of calcium sulfate powder to a single industrial cement sample allows for testing the effect of different sulfate forms and may yield a less variable approximate optimum sulfate level as the sulfate level is the only parameter that varies in the test.

6.2.2.5 Any thermal power measured prior to the minimum at point (B) observed prior to the onset of the main hydration peak (C), Fig. 1, shall be excluded from the calculated heat of hydration.

NOTE 12—Experience shows that optimum SO₃ estimated at a given age using isothermal conduction calorimetry with cement paste is similar to the optimum SO₃ estimated using compressive strength of mortar in Standard Guide C1679. The early heat measurements before the minimum B, Fig. 1, are typically subject to high levels of variability and influenced by relatively small differences in calorimeter and material temperatures, and are therefore excluded.

6.2.2.6 *Composition of Test Mixture*—Adjust the mass of solids and water as needed to obtain a suitable mix size, with the optional addition of sand and other materials typically used in concrete. Ensure that the total masses of cement and cement plus calcium sulfate differ by no more than 5 % within a given test series. Weigh or determine volumetrically a fixed and sufficient amount of water to completely wet and easily mix each individual mixture.

6.2.2.7 Use the same mixing method for all samples to be compared.

NOTE 13—Several paste mixing methods are known to give suitable results, including: Internal mixing using a disposable impeller left inside the sample vial after mixing; external mixing using a disposable spoon left inside the sample vial after mixing; external mixing using vibration or ultrasound contacting the outside of the sample vial, external mechanical mixing of paste or mortar which is then added to the sample vial. However, better reproducibility can be achieved when the mixing is done within the calorimeter sample vial, as error due to different sampling from a separate mixing bowl to sample vial is avoided, and mixing temperature conditions are easier to control within the sample vial.

6.2.2.8 *Test Duration*—Continue collecting calorimetry data for the period over which sulfate optimization is desired to be achieved.

NOTE 14—Generally optimum SO₃ levels are found to be higher when the degree of cement hydration is higher. Accordingly it is useful to perform this test for several days so that the change in optimum with a cement from a particular clinker source and sulfate source and form can be better understood.

6.2.2.9 Calculate the heat of hydration normalized per gram of cement (any calcium sulfate addition is considered as part of the cement) as described in the section on Calculation in Test Method C1702 with the following exceptions:

(1) Plot the thermal power per gram of cement as a function of time. Determine the time at which the minimum B, Fig. 1, occurs for each sample

(2) Remove all such data points before the minimum B, Fig. 1, at the time of onset of the main hydration peak before calculating the heat of hydration normalized per gram cement.

NOTE 15—It is important to use the same time for the minimum for all the samples to be compared, rather than adjusting the time for slight variations between samples. If the range of times of observed minima for the samples tested exceed 20 min, reliability of the test is suspect.

6.2.2.10 Report the mixture proportions used, including type and amount of calcium sulfate used, mixing regime employed, and the test temperature in the calorimeter.

6.2.3 *Concrete Strength*—Prepare all material according to Practice C192/C192M except as follows:

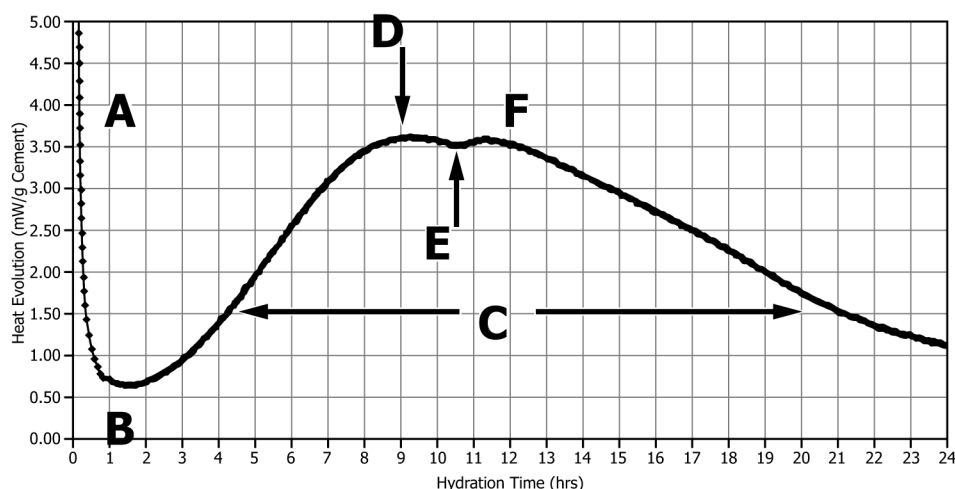


FIG. 1 (A) initial thermal power by dissolution of cement and initial cement hydration; (B) dormant period associated with very low thermal power indicating slow and well-controlled hydration; (C) main hydration peak associated mainly with hydration reactions contributing to setting and early strength development, with maximum at (D); and (E) sulfate depletion point, followed by (F) accelerated calcium aluminate activity. In this example the approximate time of onset of the main hydration peak is 1 h 45 min.

6.2.3.1 Add the calcium sulfate to the water, unless the calcium sulfate addition has been previously ground and mixed with the cement.

6.2.3.2 When applicable, determine compressive strength according to Test Method **C39/C39M**. When applicable, determine flexural strength according to Test Method **C78/C78M**.

6.2.3.3 Testing at concrete and curing temperatures other than specified is allowed. Use the same material temperature (all mixtures within 10°C range) and the same curing temperature (all curing temperatures within 4°C range) for each of the different mixtures

6.2.4 *Drying Shrinkage of Mortar*—Prepare all material according to Practice **C596** except as follows:

6.2.4.1 When mixing in accordance with the section on Procedure for Mixing Mortars of Practice **C305**, add the calcium sulfate to the water, unless the calcium sulfate addition has been previously ground and mixed with the cement; then start the mixer and mix at slow speed (140 ± 5 rpm) for 15 s; then stop the mixer and add the cement to the water; then start the mixer and mix at slow speed (140 ± 5 rpm) for 30 s.

6.2.4.2 ~~Instead of using~~ Use the amount of mixing water sufficient to produce a flow of 110 ± 5, ~~use the amount of mixing water to produce a flow of 110 ± 5~~ 105 to 115 % for one of the mixtures using 25 drops of the table as determined in the section on Procedures in Test Method **C1437**. Use that same amount of water (constant w/cm) for each mixture with different sulfate levels.

NOTE 16—The mixture with the median sulfate level or lowest sulfate level is often used to determine the water content.

7. Interpretation of Results

7.1 Approximate the SO₃ content which gives the maximum performance by one of the following methods:

NOTE 17—In the case of strength and heat of hydration measurements maximum performance is normally defined as maximum strength or heat of hydration. In the case drying shrinkage maximum performance is normally defined as minimum drying shrinkage.

NOTE 18—See the appendix for an example of how this interpretation is done for each method described below. Depending on which method is chosen the results may differ.

7.1.1 *Visual Fit*—Plot the performance level versus SO₃ content and interpolate the sulfate level at the peak.

7.1.2 *Least Squares Parabolic Fit*.

7.1.2.1 Determine the equation of a least squares fit according to follow equation:

$$\text{Performance Level} = a(\text{SO}_3)^2 + b\text{SO}_3 + c$$

where *a*, *b*, and *c* are fitting coefficients.

NOTE 19—Spreadsheet and graphing programs have the capability to calculate the least squares parabolic fit.

7.1.2.2 Approximate the optimum SO₃ by calculating vertex of the parabolic least squares fit from the following equation:

$$\text{Optimum SO}_3 \text{ approximation} = -b/(2a)$$

where *a* and *b* are coefficients of the parabolic least squares fit.

7.1.3 *Asymmetric Fit*—In cases where the performance level versus SO₃ is skewed to the right or left of the peak a fit using an asymmetric distribution function may provide a better fit than parabolic fit.

NOTE 20—Mathematical and statistics software programs are useful in doing such fits.

NOTE 21—The sulfate level for the maximum performance may ~~or may be~~ not the same SO₃ content that one of the tests was conducted at or it may be between two of the SO₃ levels that the tests were conducted at.

8. Retest

8.1 If the approximate optimum sulfate level is greater or lower than all the SO₃ contents tested, then test at additional sulfate levels until at least one SO₃ content is greater than or less than approximate optimum SO₃ content. Repeat the interpretation of results in Section 7 and report on that final set of results.

9. Report

9.1 Report the method(s) and ages used to determine performance

9.2 Report any variations in the method(s) from the standard

9.3 Report of the approximate optimum SO₃ value as required.

9.4 Report if calcium sulfate was added to the cement samples to achieve various levels of SO₃.

9.5 Report the results of chemical and physical analysis, as required by 5.2.2, for the cement sample(s) used.

10. Keywords

10.1 blended hydraulic cement; calcium sulfate; cement; compressive strength; gypsum; hydraulic cement; optimum sulfate content (of cement); portland cement; strength (of cement); sulfate content (of cement)

APPENDIXES

X1. PROCESS CONTROL OF SO₃ IN HYDRAULIC CEMENT PRODUCTION USING ISOTHERMAL CONDUCTION CALORIMETRY

X1.1 Definition of Terms Used in this Appendix

X1.1.1 *sulfate depletion point, n*—the onset of accelerated calcium aluminate activity that for a portland cement may take place after the main hydration peak, arrow “E” in Fig. 1.

X1.2 Procedure for Determining Target Elapsed Time

X1.2.1 Complete estimation of optimum sulfate using heat of hydration measurements as defined in 6.2.2.

X1.2.1.1 For each different heat of hydration test identify the time elapsed from the maximum thermal power of the main hydration peak, arrow “D” in Fig. 1, to the sulfate depletion point, arrow “E” in Fig. 1 which is “E_t-D_t”. This is done using the thermal power per gram of cement as a function of time data. In cases where the sulfate depletion point cannot be resolved at the sulfate level shown by the heat of hydration testing to be near optimum, the procedure in this appendix does not apply.

NOTE X1.1—The sulfate depletion point is normally only visible for cements close to and above the optimum SO₃ content. Mathematical methods are useful in locating the sulfate depletion point by finding the local minimum of the heat flow (arrow “E” in Fig. 1) located after the maximum of the main hydration peak (arrow “D” in Fig. 1) and before the heat flow has decreased to 1/3 of the maximum of the main hydration peak. One mathematical method is to use the mathematical derivative of the heat flow curve to more easily determine the time at the different peaks of interest. Experience shows that it is often desirable to low-pass filter the heat flow curve in order to reduce the impact of instrument-specific noise prior to analyzing the curve for the local minimum. As a precaution always visually confirm the software-generated location of the sulfate depletion point prior to reporting. Use of admixtures and/or SCMs in this test can have the effect of moving the sulfate depletion point to earlier times, and make it harder to determine.

X1.2.1.2 Using each of the heat of hydration tests determine the E_t-D_t that corresponds to the optimum sulfate level for heat of hydration, E_t-D_t Target. The sulfate level for the maximum heat of hydration may or may be not the SO₃ content that one of the tests was conducted at and interpolation between measured SO₃ contents may be able to provide a better estimate.

X1.3 Verification Tests in Process Control

X1.3.1 Collect representative samples and perform heat of hydration testing without sulfate addition at the same temperature that the optimum sulfate was determined in X1.2.1. Continue tests for 24 h or until the cement hydration has proceeded past the sulfate depletion point, otherwise following Test Method C1702.

X1.3.2 Plot the thermal power per gram of cement as a function of time and identify the time elapsed from the maximum thermal power of the main hydration peak to the sulfate depletion point (E_t-D_t).

X1.3.3 If E_t-D_t differs significantly from the time that corresponds to the mixture at or closest to the optimum SO₃ content in X1.2 then adjustments to the process may be made to bring the E_t-D_t closer to the E_t-D_t Target or an investigation into the cause for the shift from the E_t-D_t Target may be initiated.

NOTE X1.2—Adjustments to the process frequently involve changing the calcium sulfate dosing to the cement mill, but may also involve changes to milling temperature targets to change the reactivity of calcium sulfate in the cement, changes to the calcium sulfate source added to the mill, adjustments to clinker chemistry, cement fineness, or others.