



Designation: ~~C1328/C1328M – 19~~ C1328/C1328M – 23

Standard Specification for Plastic (Stucco) Cement¹

This standard is issued under the fixed designation C1328/C1328M; 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 specification covers two types of plastic cement for use in portland cement-based plasters for exterior (stucco) and interior application.

1.2 *Units*—The values stated in either SI units or inch-pound units are to be regarded separately as standard. The values stated in each system may not be exact equivalents; therefore, each system shall be used independently of the other. Combining values from the two systems may result in non-conformance with the standard. Values in SI units shall be obtained by measurement in SI units or by appropriate conversion, using the Rules for Conversion and Rounding given in Standard [IEEE/ASTM SI 10](#), of measurements made in other units. Values are stated in only SI units when inch-pound units are not used in practice.

1.3 The text of this standard refers to notes and footnotes that provide explanatory material. These notes and footnotes (excluding those in tables and figures) shall not be considered as requirements of the standard.

1.4 The following safety hazards caveat pertains only to Sections ~~1413~~ and ~~1514~~. *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. (Warning—Fresh hydraulic cementitious mixtures are caustic and may cause chemical burns to skin and tissue upon prolonged exposure. Warning—Fresh hydraulic cementitious mixtures are caustic and may cause chemical burns to skin and tissue upon prolonged exposure.)*²

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:³

- [C109/C109M Test Method for Compressive Strength of Hydraulic Cement Mortars \(Using 2-in. or \[50 mm\] Cube Specimens\)](#)
- ~~[C151 Test Method for Autoclave Expansion of Hydraulic Cement](#)~~
- ~~[C183/C183M Practice for Sampling and the Amount of Testing of Hydraulic Cement](#)~~
- [C185 Test Method for Air Content of Hydraulic Cement Mortar](#)
- [C187 Test Method for Amount of Water Required for Normal Consistency of Hydraulic Cement Paste](#)
- [C188 Test Method for Density of Hydraulic Cement](#)
- [C219 Terminology Relating to Hydraulic and Other Inorganic Cements](#)

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² *Annual Book of ASTM Standards*, Vol 04.01. See the section on Safety Precautions in the Manual of Cement Testing.

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

*A Summary of Changes section appears at the end of this standard

- C266 Test Method for Time of Setting of Hydraulic-Cement Paste by Gillmore Needles
- 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
- C511 Specification for Mixing Rooms, Moist Cabinets, Moist Rooms, and Water Storage Tanks Used in the Testing of Hydraulic Cements and Concretes
- C778 Specification for Standard Sand
- C926 Specification for Application of Portland Cement-Based Plaster
- C1506 Test Method for Water Retention of Hydraulic Cement-Based Mortars and Plasters
- IEEE/ASTM SI 10 Standard for Use of the International System of Units (SI) (the Modernized Metric System)

3. Terminology

- 3.1 *Definitions*—Terms used in this specification are defined in Terminology C219 and Specification C926.
- 3.2 *Definitions of Terms Specific to This Standard:*

3.2.1 *plastic cement, n*—a hydraulic cement, primarily used in portland cement-based plastering construction, consisting of a mixture of portland or blended hydraulic cement and plasticizing materials (such as limestone or hydrated or hydraulic lime), together with other materials introduced to enhance one or more properties such as setting time, workability, water retention, and durability.

3.2.1.1 Discussion—

The term “plastic” does not refer to the inclusion of one or more organic components in the cement. The cement is predominantly inorganic in chemical composition. The term “plastic” refers to the ability of the cement to impart to the plaster a high degree of workability, and for the plaster to remain workable or plastic for a period of time so that, after initial application and floating on the wall, it can be reworked to obtain both densification and desired texture.

4. Physical Properties

4.1 Plastic cement shall conform to the applicable requirements prescribed in Table 1.

5. Sampling

5.1 At the option of the purchaser, the cement shall be sampled and tested to verify compliance with this specification, sampling and testing shall be performed in accordance with Practice C183/C183M.

5.2 Practice C183/C183M is not designed for manufacturing quality control and is not required for manufacturer’s certification.

6. Temperature and Humidity

6.1 The temperature and relative humidity of the air in the vicinity of the mixing slab and dry materials, molds, base plates, and mixing bowl shall conform to the requirements of Test Method C109/C109M.

TABLE 1 Physical Requirements

Plastic Cement Type	S	M
Fineness, residue on a 45 μm (No. 325) sieve, max, %	24	24
Fineness, residue on a 45 μm (No. 325) sieve, max, %	24	24
Autoclave expansion, max, %	1.0	1.0
Time of setting, Gillmore method:		
Initial set, minutes, not less than	90	90
Initial set, minutes, not more than	1000	1000
Compressive strength (average of three cubes):		
The compressive strength of mortar cubes, composed of 1 part cement and 3 parts blended sand (half graded standard sand and half standard 20–30 sand) by volume, prepared and tested in accordance with this specification, shall be equal to or higher than the values specified for the ages indicated below:		
7 days, MPa [psi]	9.0 [1300]	12.4 [1800]
28 days, MPa [psi]	14.5 [2100]	20.0 [2900]
Air content of mortar:		
Min, volume%	8	8
Max, volume %	20	20
Water retention value, min, %, of original flow	70	70

6.2 The moist cabinet or moist room shall conform to the requirements of Specification **C511**.

7. Fineness

7.1 Determine the residue on the ~~45- μ m~~45 μ m (No. 325) sieve in accordance with Test Method **C430**.

8. Normal Consistency

8.1 Determine normal consistency by the Vicat apparatus in accordance with Test Method **C187**.

9. Autoclave Expansion

~~9.1 Determine the autoclave expansion in accordance with Test Method **C151**. After molding, store the bars in the moist cabinet or room for 48 h \pm 30 min before removal from the molds for measurement and testing in the autoclave. Calculate the difference in length of the test specimen before and after autoclaving to the nearest 0.01 % of the effective gage length, and report as the autoclave expansion of the plastic cement.~~

9. Time of Setting

9.1 Determine the time of setting by the Gillmore needle method in accordance with Test Method **C266**.

10. Density

10.1 Determine the density of the plastic cement in accordance with Test Method **C188**, using kerosine as the liquid. Use the density so determined in the calculation of the air content of the plaster.

11. Blended Sand

11.1 The sand shall be a blend of equal parts by weight of graded standard sand and standard 20–30 sand conforming to Specification **C778**.

12. Preparation of Plaster

12.1 *Proportions for Plaster*—Plaster for air entrainment, compressive strength, and water retention tests shall be proportioned to contain ~~1620 g~~1620 g of sand and a mass of plastic (stucco) cement, in grams, as indicated in **Table 2**. The sand shall consist of ~~810 g~~810 g of graded standard sand and ~~810 g~~810 g of 20–30 standard sand. The quantity of water, measured in millilitres, shall be such as to produce a flow of 110 ± 5 , as determined by Test Method **C109/C109M**.

12.2 *Mixing of Plasters*—Mix the plaster in accordance with Practice **C305**.

12.3 *Determination of Flow*—Determine the flow in accordance with Test Method **C109/C109M**.

13. Air Entrainment

13.1 *Procedure*—If the plaster has the correct flow, use a separate portion of the plaster for the determination of entrained air. Determine the mass of ~~400 mL~~400 mL of plaster in accordance with Test Method **C185**.

13.2 *Calculation*—Calculate the air content of the plaster, and report it to the nearest 1 % as follows:

TABLE 2 Cement in Laboratory Batch of Plaster

Plastic (Stucco) Cement Type	Mass of Cement, g
S	510
M	540