



Standard Specification for Gypsum Plasters¹

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This standard has been approved for use by agencies of the Department of Defense.

1. Scope

1.1 This specification covers four gypsum plasters; gypsum mill-mixed plaster, gypsum neat plaster, gypsum wood fibered plaster and gypsum gauging plaster.

1.2 The values stated in either inch-pound or SI (metric) units are to be regarded separately as the standard. Within the text, the SI units are shown in brackets. The values stated in each system shall be used independently of the other. Values from the two systems shall not be combined. This paragraph does not apply to the appendix.

1.3 The text of this standard references notes and footnotes which 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 the test methods described in the appendix to this specification. *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 11 Terminology Relating to Gypsum and Related Building Materials and Systems²
- C 22 Specification for Gypsum²
- C 35 Specification for Inorganic Aggregates for Use in Gypsum Plaster²
- C 471M Test Methods for Chemical Analysis of Gypsum and Gypsum Products²
- C 472 Test Methods for Physical Testing of Gypsum, Gypsum Plasters, and Gypsum Concrete²
- C 778 Specification for Standard Sand²

¹ This specification is under the jurisdiction of ASTM Committee C11 on Gypsum and Related Building Materials and Systems and is the direct responsibility of Subcommittee C11.01 on Specifications and Test Methods for Gypsum Products.

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² *Annual Book of ASTM Standards*, Vol 04.01.

E 11 Specification for Wire-Cloth and Sieves for Testing Purposes³

3. Terminology

3.1 *Definitions*—Definitions shall be in accordance with Terminology C 11.

3.2 *Definitions of Terms Specific to This Standard:*

3.2.1 *gypsum gauging plaster for finish coat, n*—a calcined gypsum plaster designed to be mixed with lime putty for the finish coat.

3.2.2 *gypsum neat plaster, n*—calcined gypsum mixed at the mill with other ingredients to control working quality and setting time.

3.2.2.1 *Discussion*—Neat plaster is either fibered or unfibered. The addition of aggregate is required on the job.

3.2.3 *gypsum mill-mixed plaster, n*—calcined gypsum plaster, mixed at the mill with a mineral aggregate, designed to function as a base coat to receive various finish coats.

3.2.3.1 *Discussion*—Other materials are not prohibited from being added to control setting time and other desirable working properties.

3.2.4 *gypsum wood-fibered plaster, n*—A calcined gypsum plaster in which wood fiber is used as an aggregate.

4. Materials

4.1 *Calcined Gypsum*—Calcined gypsum shall be manufactured from gypsum meeting the requirements of Specification C 22.

4.2 *Vermiculite Aggregate*, Specification C 35.

4.3 *Perlite Aggregate*, Specification C 35.

4.4 *Sand Aggregate*, Specification C 35.

4.5 *Ottawa Sand*, Specification C 778 for 20–30 sand.

4.6 *Wood Fiber*, non staining wood fiber.

5. Composition

5.1 When tested in accordance with Test Methods C 471M, calcined gypsum shall contain no less than 66.0 weight % $\text{CaSO}_4 \cdot \frac{1}{2} \text{H}_2\text{O}$.

5.2 *Aggregate*—plasters shall contain a volume of aggregate not more than that shown in Table 1.

³ *Annual Book of ASTM Standards*, Vol 14.02.

TABLE 1 Composition and Physical Properties

Product	Aggregate Type	Composition, Aggregate per 100 lb of Plaster, not more than		Setting Time ^A hours	Compressive Strength ^B not less than	
		ft ³	m ³		psi	MPa
Mill-Mixed Plaster over Lath Base	Vermiculite	2	0.057	1½ to 8	450	3.1
	Perlite	2	0.057	1½ to 8	600	4.1
	Sand	2.5	0.071	1½ to 8	700	4.8
Mill-Mixed Plaster over Masonry	Vermiculite	3	0.085	1½ to 8	325	2.2
	Perlite	3	0.085	1½ to 8	400	2.8
	Sand	3	0.085	1½ to 8	400	2.8
Neat Plaster	none	2 to 16 ^C	750 ^D	5.2
Wood Fibered Plaster	none	1½ to 8	1200	8.3
Gauging Plaster	none	^E	1200	8.3

^A Setting time shall be not less than the shorter time shown nor more than the longer time shown.

^B Compressive strengths are as tested at the setting times specified in Test Methods C 472.

^C When mixed with 3 parts by weight of Ottawa sand.

^D When mixed with 2 parts by weight of Ottawa sand.

^E When not retarded, the setting time shall be not less than 20 nor more than 40 minutes and, when retarded, not less than 40 minutes.

NOTE 1—An approximation of the aggregate content may be made by using the test methods in the appendix. A more accurate method for determining sand in plaster is described in Test Methods C 471M. Test Methods C 471M requires that the original sand and plaster components be available separately.

6. Mechanical Properties

6.1 *Compressive Strength*—When tested in accordance with Test Methods C 472 the compressive strength shall be as specified in Table 1.

6.2 *Setting Time*—When tested in accordance with Test Methods C 472 using the Vicat method, the setting time shall be as specified in Table 1.

NOTE 2—*Setting Time*—Attention is directed to conditions affecting job set of gypsum plasters that are usually beyond the control of the producer. Materials added at the site of application such as water and aggregates affect job sets. In addition, the various bases with different absorptive values may affect job performance. The plaster may be retarded to provide a setting time of not more than 4 h. Setting times more than 2 h may result in lower compressive strengths.

6.3 *Fineness of Gauging Plaster for Finish Coat*—When tested in accordance with Test Method C 472 all shall pass a No. 14 [1.4 mm] sieve and not less than 60 % shall pass a No. 100 [150 μm] sieve.⁴

7. Sampling

7.1 At least 1 % of the packages, but not less than 5 packages, shall be sampled. Packages to be sampled shall be selected at random. Samples shall be taken both from the outer portion and the center of each package. The materials so obtained shall be thoroughly mixed to provide a composite sample of not less than 7 lb [3.2 kg]. This composite sample

shall be placed immediately in a clean, dry, airtight container for delivery to the laboratory.

8. Packaging and Package Marking

8.1 Gypsum plasters shall be dry and free of lumps, and shall be shipped in packages.

8.2 When shipped for resale, the following information shall be legibly marked on each package or on a tag of suitable size attached to the package:

- 8.2.1 Name of manufacturer or seller,
- 8.2.2 Brand, and
- 8.2.3 Net weight of the package.

9. Inspection

9.1 Inspection of the gypsum plaster shall be agreed upon between the purchaser and the supplier as part of the purchase agreement.

10. Rejection

10.1 Rejection of gypsum plaster that fails to conform to the requirements of this specification shall be reported to the producer or supplier promptly and in writing. The notice of rejection shall contain a statement documenting requirements of this specification.

11. Certification

11.1 When specified in the purchase agreement, a manufacturer's or supplier's report shall be furnished at the time of shipment certifying that the product is in compliance with this specification.

12. Keywords

12.1 aggregate; gauging plaster; gypsum plaster; mill-mixed plaster; neat plaster; plaster; wood fibered plaster

⁴ Detailed requirements for these sieves are given in Specification E 11.