



Designation: C94/C94M – 12

## Standard Specification for Ready-Mixed Concrete<sup>1</sup>

This standard is issued under the fixed designation C94/C94M; 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 ( $\epsilon$ ) indicates an editorial change since the last revision or reapproval.

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

### 1. Scope\*

1.1 This specification covers ready-mixed concrete as defined in 3.2.2. Requirements for quality of concrete shall be either as hereinafter specified or as specified by the purchaser. In any case where the requirements of the purchaser differ from these in this specification, the purchaser's specification shall govern. This specification does not cover the placement, consolidation, curing, or protection of the concrete after delivery to the purchaser.

1.2 The values stated in either SI units, shown in brackets, 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.

1.3 As used throughout this specification the manufacturer produces ready-mixed concrete. The purchaser buys ready-mixed concrete.

1.4 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.

1.5 *This standard does not purport to address all 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. (Warning—Fresh hydraulic cementitious mixtures are caustic and may cause chemical burns to skin and tissue upon prolonged use.)<sup>2</sup>*

<sup>1</sup> This specification is under the jurisdiction of ASTM Committee C09 on Concrete and Concrete Aggregates and is the direct responsibility of Subcommittee C09.40 on Ready-Mixed Concrete.

Current edition approved Feb. 1, 2012. Published March 2012. Originally approved in 1933. Last previous edition approved in 2011 as C94/C94M-11b. DOI: 10.1520/C0094\_C0094M-12.

<sup>2</sup> See Section on Safety Precautions, Manual of Aggregate and Concrete Testing, *Annual Book of ASTM Standards*, Vol. 04.02.

### 2. Referenced Documents

2.1 *ASTM Standards*:<sup>3</sup>

- C31/C31M Practice for Making and Curing Concrete Test Specimens in the Field
- C33/C33M Specification for Concrete Aggregates
- C39/C39M Test Method for Compressive Strength of Cylindrical Concrete Specimens
- C125 Terminology Relating to Concrete and Concrete Aggregates
- C138/C138M Test Method for Density (Unit Weight), Yield, and Air Content (Gravimetric) of Concrete
- C143/C143M Test Method for Slump of Hydraulic-Cement Concrete
- C150/C150M Specification for Portland Cement
- C172/C172M Practice for Sampling Freshly Mixed Concrete
- C173/C173M Test Method for Air Content of Freshly Mixed Concrete by the Volumetric Method
- C231/C231M Test Method for Air Content of Freshly Mixed Concrete by the Pressure Method
- C260/C260M Specification for Air-Entraining Admixtures for Concrete
- C330/C330M Specification for Lightweight Aggregates for Structural Concrete
- C494/C494M Specification for Chemical Admixtures for Concrete
- C567/C567M Test Method for Determining Density of Structural Lightweight Concrete
- C595/C595M Specification for Blended Hydraulic Cements
- C618 Specification for Coal Fly Ash and Raw or Calcined Natural Pozzolan for Use in Concrete
- C637 Specification for Aggregates for Radiation-Shielding Concrete

<sup>3</sup> For referenced ASTM standards, visit the ASTM website, [www.astm.org](http://www.astm.org), or contact ASTM Customer Service at [service@astm.org](mailto: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

- C989/C989M Specification for Slag Cement for Use in Concrete and Mortars
- C1017/C1017M Specification for Chemical Admixtures for Use in Producing Flowing Concrete
- C1064/C1064M Test Method for Temperature of Freshly Mixed Hydraulic-Cement Concrete
- C1077 Practice for Agencies Testing Concrete and Concrete Aggregates for Use in Construction and Criteria for Testing Agency Evaluation
- C1157/C1157M Performance Specification for Hydraulic Cement
- C1240 Specification for Silica Fume Used in Cementitious Mixtures
- C1602/C1602M Specification for Mixing Water Used in the Production of Hydraulic Cement Concrete
- C1611/C1611M Test Method for Slump Flow of Self-Consolidating Concrete
- 2.2 *ACI Documents*:<sup>4</sup>
  - 211.1 Standard Practice for Selecting Proportions for Normal, Heavyweight, and Mass Concrete
  - 211.2 Standard Practice for Selecting Proportions for Structural Lightweight Concrete
  - 301 Standard Specifications for Structural Concrete
  - 305R Guide to Hot Weather Concreting
  - 306R Guide to Cold Weather Concreting
  - 318 Building Code Requirements for Structural Concrete and Commentary

### 3. Terminology

#### 3.1 Definitions:

The terms used in this specification are defined in Terminology C125.

#### 3.2 Definitions of Terms Specific to This Standard:

3.2.1 *concrete, central-mixed, n*—ready-mixed concrete mixed completely in a stationary mixer.

3.2.2 *concrete, ready-mixed, n*—concrete manufactured and delivered to a purchaser in a fresh state.

3.2.3 *concrete, shrink-mixed, n*—ready-mixed concrete partially mixed in a stationary mixer with mixing completed in a truck mixer.

3.2.4 *concrete, truck-mixed, n*—ready-mixed concrete completely mixed in a truck mixer.

### 4. Basis of Purchase

4.1 The basis of purchase shall be a cubic yard or cubic metre of fresh concrete as discharged from the transportation unit.

4.2 The volume of fresh concrete in a given batch shall be determined from the total mass of the batch divided by the density of the concrete. The total mass of the batch shall be determined as the net mass of the concrete in the batch as delivered, including the total mixing water as defined in 9.3. The density shall be determined in accordance with Test Method C138/C138M. The yield shall be determined as the

<sup>4</sup> Available from American Concrete Institute (ACI), P.O. Box 9094, Farmington Hills, MI 48333-9094, <http://www.concrete.org>.

average of at least three measurements, one from each of three different transportation units sampled in accordance with Practice C172/C172M.

NOTE 1—It should be understood that the volume of hardened concrete may be, or appear to be, less than expected due to waste and spillage, over-excavation, spreading forms, some loss of entrained air, or settlement of wet mixtures, none of which are the responsibility of the producer.

### 5. Materials

5.1 In the absence of designated applicable materials specifications, the following materials specifications shall be used:

#### 5.2 Cementitious Materials

5.2.1 *Hydraulic Cement*—Hydraulic cement shall conform to Specification C150/C150M, Specification C595/C595M, or Specification C1157/C1157M.

5.2.2 *Supplementary Cementitious Materials*—Coal fly ash or natural pozzolans shall conform to Specification C618. Slag cement shall conform to Specification C989/C989M. Silica fume shall conform to Specification C1240.

5.3 *Aggregates*—Normal weight aggregates shall conform to Specification C33/C33M. Lightweight aggregates shall conform to Specification C330/C330M and heavyweight aggregates shall conform to Specification C637.

5.4 *Water*—Water shall conform to Specification C1602/C1602M.

5.5 *Air-Entraining Admixtures*—Air-entraining admixtures shall conform to Specification C260/C260M (Note 2).

5.6 *Chemical Admixtures*—Chemical admixtures shall conform to either Specification C494/C494M or C1017/C1017M as applicable (Note 2).

NOTE 2—In any given instance, the required dosage of air-entraining, accelerating, and retarding admixtures may vary. Therefore, a range of dosages should be allowed which will permit obtaining the desired effect.

NOTE 3—Interchanging kinds, characteristics, types, classes, or grades of the materials permitted in ready-mixed concrete may produce concrete of different properties.

### 6. Ordering Information

6.1 In the absence of designated applicable general specifications, the purchaser shall specify the following:

6.1.1 Designated size, or sizes, of coarse aggregate,

6.1.2 Slump, or slumps, desired at the point of delivery (see Section 7 for acceptable tolerances),

6.1.3 Slump flow, or flows, desired at the point of delivery (see Section 7 for acceptable tolerances),

6.1.4 When air-entrained concrete is specified, the air content of the samples taken at the point of discharge from the transportation unit (see Section 8 and Table 1 for the total air content and tolerances) (Note 4),

6.1.5 Which of Options A, B, or C shall be used as a basis for determining the proportions of the concrete to produce the required quality,

6.1.6 When structural lightweight concrete is specified, the mass per unit volume as wet mass, air-dry mass, or oven-dry mass (Note 5), and

6.1.7 If desired, any of the optional requirements of Table 2 in Specification C1602/C1602M.

**TABLE 1 Recommended Total Air Content for Air-Entrained Concrete<sup>A,B</sup>**

Exposure Condition <sup>C</sup>	Total Air Content, %						
	Nominal Maximum Sizes of Aggregate, in. [mm]						
	⅜ [9.5]	½ [12.5]	¾ [19.0]	1 [25.0]	1½ [37.5]	2 [50.0]	3 [75.0]
Mild	4.5	4.0	3.5	3.0	2.5	2.0	1.5
Moderate	6.0	5.5	5.0	4.5	4.5	4.0	3.5
Severe	7.5	7.0	6.0	6.0	5.5	5.0	4.5

<sup>A</sup> For air-entrained concrete, when specified.

<sup>B</sup> Unless exposure conditions dictate otherwise, it is permissible to reduce air contents recommended above by up to 1 % for concretes with specified compressive strength,  $f'_c$ , of 5000 psi [35 MPa] or above.

<sup>C</sup> For description of exposure conditions, refer to Standard Practice ACI 211.1, Section 6.3.3, with attention to accompanying footnotes.

6.2 If the type, kind, or class of cementitious materials in 5.2.1 and 5.2.2 are not designated by the purchaser, it is permitted to use cementitious materials in concrete mixtures that will satisfy the concrete properties and other requirements of the purchaser as ordered.

NOTE 4—In selecting the specified air content, the purchaser should consider the exposure conditions to which the concrete will be subjected. Air contents less than shown in Table 1 may not give the required resistance to freezing and thawing, which is the primary purpose of air-entrained concrete. Air contents higher than the levels shown may reduce strength without contributing any further improvement of durability.

NOTE 5—The mass per unit volume of fresh concrete, which is the only unit mass determinable at the time of delivery, is always higher than the air-dry or oven-dry mass. Definitions of, and methods for determining or calculating air-dry and oven-dry masses, are covered by Test Method C567/C567M.

### 6.3 Option A:

6.3.1 When the purchaser requires the manufacturer to assume full responsibility for the selection of the proportions for the concrete mixture (Note 6), the purchaser shall also specify the following:

6.3.1.1 Requirements for compressive strength as determined on samples taken from the transportation unit at the point of discharge evaluated in accordance with Section 18. The purchaser shall specify the requirements in terms of the compressive strength of standard specimens cured under standard laboratory conditions for moist curing (see Section 18). Unless otherwise specified the age at test shall be 28 days.

NOTE 6—The purchaser, in selecting requirements for which he assumes responsibility should give consideration to requirements for workability, placeability, durability, surface texture, and density, in addition to those for structural design. The purchaser is referred to Standard Practice ACI 211.1 and Standard Practice ACI 211.2 for the selection of proportions that will result in concrete suitable for various types of structures and conditions of exposure. The water-cement ratio of most structural lightweight concretes cannot be determined with sufficient accuracy for use as a specification basis.

6.3.2 At the request of the purchaser, the manufacturer shall, prior to the actual delivery of the concrete, furnish a statement to the purchaser, giving the dry masses of cement and saturated surface-dry-masses of fine and coarse aggregate and quantities, type, and name of admixtures (if any) and of water per cubic yard or cubic metre of concrete that will be used in the manufacture of each class of concrete ordered by the purchaser. He shall also furnish evidence satisfactory to the purchaser that the materials to be used and proportions selected will produce concrete of the quality specified.

### 6.4 Option B:

6.4.1 When the purchaser assumes responsibility for the proportioning of the concrete mixture, he shall also specify the following:

6.4.1.1 Cement content in pounds per cubic yard [kilograms per cubic metre] of concrete,

6.4.1.2 Maximum allowable water content in gallons per cubic yard [litres per cubic metre] of concrete, including surface moisture on the aggregates, but excluding water of absorption (Note 6), and

6.4.1.3 If admixtures are required, the type, name, and dosage to be used. The cement content shall not be reduced when admixtures are used under this option without the written approval of the purchaser.

6.4.2 At the request of the purchaser, the manufacturer shall, prior to the actual delivery of the concrete, furnish a statement to the purchaser giving the sources, densities, and sieve analyses of the aggregates and the dry masses of cement and saturated-surface-dry masses of fine and coarse aggregate and quantities, type and name of admixture (if any) and of water per cubic yard or cubic metre of concrete that will be used in the manufacture of each class of concrete ordered by the purchaser.

### 6.5 Option C:

6.5.1 When the purchaser requires the manufacturer to assume responsibility for the selection of the proportions for the concrete mixture with the minimum allowable cement content specified (Note 7), the purchaser shall also specify the following:

6.5.1.1 Required compressive strength as determined on samples taken from the transportation unit at the point of discharge evaluated in accordance with Section 18. The purchaser shall specify the requirements for strength in terms of tests of standard specimens cured under standard laboratory conditions for moist curing (see Section 18). Unless otherwise specified the age at test shall be 28 days.

6.5.1.2 Minimum cement content in pounds per cubic yard [kilograms per cubic metre] of concrete.

6.5.1.3 If admixtures are required, the type, name, and dosage to be used. The cement content shall not be reduced when admixtures are used.

NOTE 7—Option C can be distinctive and useful only if the designated minimum cement content is at about the same level that would ordinarily be required for the strength, aggregate size, and slump or slump flow specified. At the same time, it must be an amount that will be sufficient to ensure durability under expected service conditions, as well as satisfactory surface texture and density, in the event specified strength is attained with

it. For additional information refer to Standard Practice ACI 211.1 and Standard Practice 211.2 referred to in [Note 6](#).

6.5.2 At the request of the purchaser, the manufacturer shall, prior to the actual delivery of the concrete, furnish a statement to the purchaser, giving the dry masses of cement and saturated surface-dry masses of fine and coarse aggregate and quantities, type, and name of admixture (if any) and of water per cubic yard or cubic metre of concrete that will be used in the manufacture of each class of concrete ordered by the purchaser. He shall also furnish evidence satisfactory to the purchaser that the materials to be used and proportions selected will produce concrete of the quality specified. Whatever strengths are attained the quantity of cement used shall not be less than the minimum specified.

6.6 The proportions arrived at by Options A, B, or C for each class of concrete and approved for use in a project shall be assigned a designation to facilitate identification of each concrete mixture delivered to the project. This is the designation required in [14.1.7](#) and supplies information on concrete proportions when they are not given separately on each delivery ticket as outlined in [14.2](#). A certified copy of all proportions as established in Options A, B, or C shall be on file at the batch plant.

6.7 The purchaser shall ensure that the manufacturer is provided copies of all reports of tests performed on concrete samples taken to determine compliance with specification requirements. Reports shall be provided on a timely basis.

## 7. Tolerances in Slump or Slump Flow

7.1 Unless other tolerances are indicated by the purchaser, the following shall apply.

7.1.1 When slump is stated as a “maximum” or “not to exceed” requirement:

For Slump of:	Tolerance
3 in. [75 mm] or less	+0 and -1½ [40 mm]
More than 3 in. [75 mm]	+0 and -2½ [40 mm]

7.1.2 When slump is stated as a target or nominal slump:

Tolerances for Target or Nominal Slumps	
For Slump of:	Tolerance
2 in. [50 mm] and less	±½ in. [15 mm]
More than 2 through 4 in. [50 to 100 mm]	±1 in. [25 mm]
More than 4 in. [100 mm]	±1½ in. [40 mm]

NOTE 8—This option applies when slump is stated as a target slump or nominal slump. For other ways of stating slump, the tolerances should be indicated by the purchaser.

7.1.3 When the purchaser states a slump flow requirement for self-consolidating concrete:

Tolerances for Slump Flow	
For Slump Flow	Tolerance
Less than or equal to 22 in. [550 mm]	± 1 ½ in. [40 mm]
More than 22 in [550 mm]	± 2 ½ in. [65 mm]

7.1.4 The slump tolerances are applicable when water addition in accordance with [12.7](#) is permitted.

7.2 Concrete shall be available within the permissible range of slump or slump flow for a period of 30 min starting either on arrival at the job site or after the initial slump adjustment permitted in [12.7](#), whichever is later. The first and last ¼ yd<sup>3</sup> [¼ m<sup>3</sup>] discharged are exempt from this requirement. If the user is unprepared for discharge of the concrete from the vehicle, the producer shall not be responsible for the limitation of minimum slump or slump flow after 30 min have elapsed starting either on arrival of the vehicle at the prescribed destination or at the requested delivery time, whichever is later.

## 8. Air-Entrained Concrete

8.1 When air-entrained concrete is desired the purchaser shall specify the total air content of the concrete. See [Table 1](#) for recommended total air contents ([Note 2](#)).

8.2 The air content of air-entrained concrete when sampled from the transportation unit at the point of discharge shall be within a tolerance of ± 1.5 of the specified value.

8.3 When a preliminary sample taken within the time limits of [12.7](#) and prior to discharge for placement shows an air content below the specified level by more than the allowable tolerance in accordance with [8.2](#), the manufacturer may use additional air entraining admixture to achieve the desired air content level, followed by a minimum of 30 revolutions at mixing speed, so long as the revolution limit of [12.7](#) is not exceeded (see [Note 9](#)).

NOTE 9—Acceptance sampling and testing in accordance with Practice [C172/C172M](#) is not obviated by this provision.

## 9. Measuring Materials

9.1 Except as otherwise specifically permitted, cementitious materials shall be measured by mass. When supplementary cementitious materials are used in the concrete mixtures, the cumulative mass is permitted to be measured with hydraulic cement, but in a batch hopper and on a scale which is separate and distinct from those used for other materials. The mass of the hydraulic cement shall be measured before supplementary cementitious materials. When the quantity of cementitious material exceeds 30 % of the full capacity of the scale, the measured quantity of the hydraulic cement shall be within ± 1 % of the required mass, and the cumulative measured quantity of hydraulic cement plus supplementary cementitious materials shall also be within ± 1 % of the required cumulative mass at each intermediate weighing. For smaller batches to a minimum of 1 yd<sup>3</sup> [1 m<sup>3</sup>], the measured quantity of the hydraulic cement and the measured cumulative quantity of hydraulic cement plus supplementary cementitious materials used shall be not less than the required amount nor more than 4 % in excess. When the purchaser requires alternate methods of measuring cementitious materials, measurement methods and reporting shall be stated in the order (see [Note 10](#)).

NOTE 10—Cementitious materials in bags may be used when requested by the purchaser.

9.2 Aggregate shall be measured by mass. Batch mass measurements shall be based on dry materials and shall be the required mass of dry materials plus the total mass of moisture (both absorbed and surface) contained in the aggregate.

9.2.1 For aggregates measured in individual or cumulative weigh batchers, when the required intermediate or final mass is less than 30 % of the scale capacity the aggregate mass shall be within  $\pm 0.3$  % of scale capacity or within  $\pm 3$  % of the required mass, whichever is less.

9.2.2 When aggregates are measured in an individual weigh batcher and the required mass of aggregate is equal to or greater than 30 % of the scale capacity, the quantity of aggregate shall be within  $\pm 2$  % of the required mass. When aggregates are measured in a cumulative aggregate weigh batcher, and the required intermediate and final cumulative mass of aggregate components is equal to or greater than 30 % of the scale capacity, the quantity of aggregate at each successive weighing shall be within  $\pm 1$  % of the required mass.

NOTE 11—The batching accuracy limit of 0.3 % of scale capacity establishes a reasonable minimum weighing tolerance limit that is independent of the quantity of material being weighed. It generally governs for smaller batch quantities weighed in weigh batchers (scales).

9.3 Mixing water shall consist of water added to the batch, ice added to the batch, water occurring as surface moisture on the aggregates, and water introduced in the form of admixtures. The added water shall be measured by weight or volume to an accuracy of 1 % of the required total mixing water. Added ice shall be measured by weight. In the case of truck mixers, any wash water retained in the drum for use in the next batch of concrete shall be accurately measured; if this proves impractical or impossible the wash water shall be discharged prior to loading the next batch of concrete. Total water (including any wash water) shall be measured or weighed to an accuracy of  $\pm 3$  % of the specified total amount.

9.4 Chemical admixtures in powdered form shall be measured by mass. Liquid chemical admixtures shall be batched by mass or volume. Admixtures measured by either mass or volume, shall be batched with an accuracy of  $\pm 3$  % of the total amount required or plus or minus the amount or dosage required for 100 lb [50 kg] of hydraulic cement, whichever is greater.

NOTE 12—Admixture dispensers of the mechanical type capable of adjustment for variation of dosage, and of simple calibration, are recommended.

## 10. Batching Plant

10.1 Bins with adequate separate compartments shall be provided in the batching plant for fine and for each required size of coarse aggregate. Each bin compartment shall be designed and operated so as to discharge efficiently and freely, with minimum segregation, into the weighing hopper. Means of control shall be provided so that, as the quantity desired in the weighing hopper is approached, the material shall be shut off with precision. Weighing hoppers shall be constructed so as to eliminate accumulations of tare materials and to discharge fully.

10.2 Indicating devices shall be in full view and near enough to be read accurately by the operator while charging the hopper. The operator shall have convenient access to all controls.

10.3 Scales shall be considered accurate when at least one static load test within each quarter of the scale capacity can be shown to be within  $\pm 0.15$  % of the total capacity of the scale or 0.4 % of the net applied load, whichever is greater.

10.4 Adequate standard test weights shall be available for checking accuracy. All exposed fulcrums, clevises, and similar working parts of scales shall be kept clean. Beam scales shall be equipped with a balance indicator sensitive enough to show movement when a weight equal to 0.1 % of the nominal capacity of the scale is placed in the batch hopper. Pointer travel shall be a minimum of 5 % of the net-rated capacity of the largest weigh beam for underweight and 4 % for overweight.

10.5 The device for the measurement of the added water shall be capable of delivering to the batch the quantity required within the accuracy required in 9.3. The device shall be so arranged that the measurements will not be affected by variable pressures in the water supply line. Measuring tanks shall be equipped with outside taps and valves to provide for checking their calibration unless other means are provided for readily and accurately determining the amount of water in the tank.

NOTE 13—The scale accuracy limitations of the National Ready Mixed Concrete Association Plant Certification meet the requirements of this specification.

## 11. Mixers and Agitators

11.1 Mixers will be stationary mixers or truck mixers. Agitators will be truck mixers or truck agitators.

11.1.1 Stationary mixers shall be equipped with a metal plate or plates on which are plainly marked the mixing speed of the drum or paddles, and the maximum capacity in terms of the volume of mixed concrete. When used for the complete mixing of concrete, stationary mixers shall be equipped with an acceptable timing device that will not permit the batch to be discharged until the specified mixing time has elapsed.

11.1.2 Each truck mixer or agitator shall have attached thereto in a prominent place a metal plate or plates on which are plainly marked the gross volume of the drum, the capacity of the drum or container in terms of the volume of mixed concrete, and the minimum and maximum mixing speeds of rotation of the drum, blades, or paddles. When the concrete is truck mixed as described in 12.5, or shrink mixed as described in 12.4, the volume of mixed concrete shall not exceed 63 % of the total volume of the drum or container. When the concrete is central mixed as described in 12.3, the volume of concrete in the truck mixer or agitator shall not exceed 80 % of the total volume of the drum or container. Truck mixers and agitators shall be equipped with means to readily verify the number of revolutions of the drum, blades, or paddles.

11.2 All stationary and truck mixers shall be capable of combining the ingredients of the concrete within the specified time or the number of revolutions specified in 11.5, into a thoroughly mixed and uniform mass and of discharging the concrete so that not less than five of the six requirements shown in Table A1.1 shall have been met.

NOTE 14—The sequence or method of charging the mixer will have an important effect on the uniformity of the concrete.

11.3 The agitator shall be capable of maintaining the mixed concrete in a thoroughly mixed and uniform mass and of discharging the concrete with a satisfactory degree of uniformity as defined by **Annex A1**.

11.4 Slump tests of individual samples taken after discharge of approximately 15 % and 85 % of the load will provide a quick check of the probable degree of uniformity (**Note 15**). These two samples shall be obtained within an elapsed time of not more than 15 min. If these slumps differ more than that specified in **Annex A1**, the mixer or agitator shall not be used unless the condition is corrected, except as provided in **11.5**.

**NOTE 15**—No samples should be taken before 10 % or after 90 % of the batch has been discharged. Due to the difficulty of determining the actual quantity of concrete discharged, the intent is to provide samples that are representative of widely separated portions, but not the beginning and end of the load.

11.5 Use of the equipment is permitted when operation with a longer mixing time, a smaller load, or a more efficient charging sequence will permit the requirements of **Annex A1** to be met.

11.6 Mixers and agitators shall be examined or their mass determined as frequently as necessary to detect changes in condition due to accumulations of hardened concrete or mortar and examined to detect wear of blades. When such changes are extensive enough to affect the mixer performance, the proof-tests described in **Annex A1** shall be performed to show whether the correction of deficiencies is required.

## 12. Mixing and Delivery

12.1 Ready-mixed concrete shall be mixed and delivered to the point designated by the purchaser by means of one of the following combinations of operations:

12.1.1 *Central-Mixed Concrete.*

12.1.2 *Shrink-Mixed Concrete.*

12.1.3 *Truck-Mixed Concrete.*

12.2 Mixers and agitators shall be operated within the limits of capacity and speed of rotation designated by the manufacturer of the equipment.

12.3 *Central-Mixed Concrete*—Concrete that is mixed completely in a stationary mixer and transported to the point of delivery either in a truck agitator, or a truck mixer operating at agitating speed, or in nonagitating equipment approved by the purchaser and meeting the requirements of Section **13**, shall conform to the following: The mixing time shall be counted from the time all the solid materials are in the drum. The batch shall be so charged into the mixer that some water will enter in advance of the cement and aggregate, and all water shall be in the drum by the end of the first one fourth of the specified mixing time.

12.3.1 Where no mixer performance tests are made, the acceptable mixing time for mixers having capacities of 1 yd<sup>3</sup> [0.76 m<sup>3</sup>] or less shall be not less than 1 min. For mixers of greater capacity, this minimum shall be increased 15 s for each cubic yard [cubic metre] or fraction thereof of additional capacity (See **Note 16**).

**NOTE 16**—Stationary mixers of similar design bearing a Performance Rated plate of the Concrete Plant Manufacturers Bureau have been tested

for their ability to produce uniformly mixed concrete in accordance with **Annex A1** for low slump (< 2 in. [50 mm]) and normal slump (4–6 in. [100–150 mm]) concrete in a mixing time between 30 and 90 sec.

12.3.2 Where mixer performance tests have been made on given concrete mixtures in accordance with the testing program set forth in the following paragraphs, and the mixers have been charged to their rated capacity, the acceptable mixing time is permitted to be reduced for those particular circumstances to a point at which satisfactory mixing defined in **12.3.3** shall have been accomplished. When the mixing time is so reduced the maximum time of mixing shall not exceed this reduced time by more than 60 s for air-entrained concrete.

12.3.3 *Sampling for Uniformity Tests of Stationary Mixers*—Samples of concrete for comparative purposes shall be obtained immediately after arbitrarily designated mixing times, in accordance with one of the following procedures:

12.3.3.1 *Alternative Procedure 1*—The mixer shall be stopped, and the required samples removed by any suitable means from the concrete at approximately equal distances from the front and back of the drum, or

12.3.3.2 *Alternative Procedure 2*—As the mixer is being emptied, individual samples shall be taken after discharge of approximately 15 % and 85 % of the load. The method of sampling shall provide that the samples are representative of widely separated portions, but not from the very ends of the batch (**Note 15**).

12.3.3.3 The samples of concrete shall be tested in accordance with Section **18**, and differences in test results for the two samples shall not exceed those given in **Annex A1**. Mixer performance tests shall be repeated whenever the appearance of the concrete or the coarse aggregate content of samples selected as outlined in this section indicates that adequate mixing has not been accomplished.

12.4 *Shrink-Mixed Concrete*—Concrete that is first partially mixed in a stationary mixer, and then mixed completely in a truck mixer, shall conform to the following: The time of partial mixing shall be minimum required to intermingle the ingredients. After transfer to a truck mixer the amount of mixing at the designated mixing speed will be that necessary to meet the requirements for uniformity of concrete as indicated in **Annex A1**. Tests to confirm such performance shall be made in accordance with **12.3.3** and **12.3.3.3**. Additional turning of the mixer, if any, shall be at a designated agitating speed.

12.5 *Truck-Mixed Concrete*—Concrete that is completely mixed in a truck mixer, 70 to 100 revolutions at the mixing speed designated by the manufacturer to produce the uniformity of concrete indicated in **Annex A1** (see **Note 17**). Concrete uniformity tests shall be made in accordance with **12.5.1** and if requirements for uniformity of concrete indicated in **Annex A1** are not met with 100 revolutions of mixing, after all ingredients including water, are in the drum, that mixer shall not be used until the condition is corrected, except as provided in **11.5**. When satisfactory performance is found in one truck mixer, the performance of mixers of substantially the same design and condition of blades are permitted to be regarded as satisfactory. Additional revolutions of the mixer beyond the number found to produce the required uniformity of concrete shall be at a designated agitating speed.