

British Standard

## Testing concrete

Part 108. Method for making test cubes from fresh concrete

Essais du béton

Partie 108. Méthode de confection de cubes d'essai en béton frais

Prüfverfahren für Beton

Teil 108. Verfahren zur Herstellung von Probewürfeln aus Frischbeton

### Foreword

This Part of this British Standard, prepared under the direction of the Cement, Gypsum, Aggregates and Quarry Products Standards Committee, is a revision of 2.1, 2.2, 2.3, 2.4, 2.7 and 2.8 of BS 1881 : Part 3 : 1970. Together with Parts 109, 110, 111, 112 and 113, this Part of BS 1881 supersedes BS 1881 : Part 3 : 1970, which is withdrawn.

The dimensions and tolerances specified in this Part of this standard comply with ISO 1920.

Compliance with a British Standard does not of itself confer immunity from legal obligations.

### 1. scope

This Part of this British Standard describes a method for making test cubes of nominal sizes 100 mm and 150 mm out of fresh concrete. The method applies to plain and air-entrained concrete made with lightweight, normal weight and heavy aggregates having a nominal maximum size not exceeding 20 mm for 100 mm cubes and 40 mm for 150 mm cubes.

This method does not apply to aerated concrete, very stiff concrete, which cannot be compacted by vibration alone, and no-fines concrete.

NOTE. The titles of the publications referred to in this standard are listed on the inside back page.

### 2. Definitions

For the purposes of this Part of this British Standard, the definitions given in BS 5328 and BS 1881 : Part 101 apply.

### 3. Apparatus

#### 3.1 Mould

**3.1.1 Construction and assembly.** The sides of the mould shall be of ferrous metal (preferably cast iron or cast steel). The hardness of each internal face shall be at least 95 Rockwell (scale B) Hardness Value\* when determined in accordance with BS 891 : Part 1. The mould shall include a removable steel base plate. All parts of the mould shall be robust enough to prevent distortion. Before assembly for use, the joints between the sides of the mould and between them and the base plate shall be thinly coated with oil or grease to prevent loss of water. The parts of the mould when assembled shall be positively located and rigidly held together in such a manner as to prevent leakage from the mould. The internal faces of the assembled mould shall be thinly coated with release agent to prevent adhesion of the concrete.

The sides of the mould shall be clearly marked with a reference number or code to enable each concrete specimen to be identified when it is demoulded and the mould to be correctly re-assembled.

A mould shall be refurbished or discarded when any dimensional deviation exceeds twice the tolerances specified in 3.1.2.

**3.1.2 Tolerances** When assembled, the dimensions and internal faces of a new mould shall be accurate within the following limits.

(a) *Dimensions* The depth of the mould and the distance between the two pairs of opposite internal side faces, each based on the average of four symmetrically placed measurements, shall be the nominal size of  $100 \pm 0.15$  mm\*, or  $150 \pm 0.15$  mm\*.

\* The purchaser should note the need to accept the indentations on the faces of new moulds resulting from the hardness test.

† The base plate of a 150 mm mould should preferably have a thickness of at least 15 mm.

\*This tolerance should be considered in conjunction with those for flatness, squareness and parallelism.

(b) *Flatness* The flatness tolerance (see BS 308 : Part 3) for each internal side face shall be 0.03 mm wide.

That for the joint faces, for the bottom surface of the assembled mould sides and for the top surface of the base plate shall be 0.06 mm wide.

(c) *Squareness* The squareness tolerance (squareness 4 of BS 308 : Part 3) for each internal side face with respect to the bottom surface of the mould and the adjacent internal side faces as datum faces shall be 0.5 mm wide.

(d) *Parallelism*. The parallelism tolerance (parallelism 4 of BS 308 : Part 3) for the top surface of the mould with respect to the bottom surface of the mould as datum face shall be 1.0 mm wide.

(e) *Surface texture*. The surface texture of each internal side face shall not exceed  $3.2 \mu\text{m } R_a$ , when determined in accordance with BS 1134.

3.2 Scoop, approximately 100 mm wide.

3.3 *Compacting bar or vibrating hammer or table*.

A compacting bar made out of a steel bar weighing 1.8 kg, 300 mm long and having a ramming face 25 mm square, or a vibrating hammer or table suitable for compacting the concrete in accordance with 6.2 or 6.3.

3.4 *Plasterer's steel float*.

3.5 *Sampling tray*, 1.2 m x 1.2 m x 50 mm deep made from minimum 1.6 mm thick non-corrodible metal.

3.6 *Square mouthed shovel*, size 2 in accordance with BS 3388.

## 4. Sampling

Obtain the sample of fresh concrete by the procedure given in BS 1881 : Part 101. Commence making the cube as soon as possible after sampling.

## 5. Preparing the sample

Empty the sample from the container(s) on to the sampling tray. Ensure that no more than a light covering of slurry is left adhering to the container(s).

Thoroughly mix the sample by shovelling it to form a cone cure sampling tray and turning this over with the shovel to form a new cone, the operation being carried out three times. When forming the cones, deposit each shovelful of the material on the apex of the cone so that the portions which slide down the sides are distributed as evenly as possible and so that the centre of the cone is not displaced. Flatten the third cone by repeated vertical insertion of the shovel across the apex of the cone, lifting the shovel clear of the concrete after each insertion.

NOTE. The following modifications to the mixing procedures may be necessary when preparing samples of very high workability concrete (e.g. superplasticized concrete) for test.

(a) *Sampling tray*. The vertical lips on the edges of the tray may have to be larger to contain the sample without spillage during mixing.

(b) *Mixing the sample*. The coning procedure is not suitable for very high workability concrete and the following alternative method of mixing is recommended. Having poured the concrete on to the sampling tray, use the shovel to turn the concrete from the outside toward the centre, working progressively once round all sides of the sampling tray.

## 6. Procedure

6.1 *Filling the mould*. Place the mould on a rigid horizontal surface or on the vibrating table and fill with concrete in such a way as to remove as much entrapped air as possible (without significantly reducing the amount of

entrained air, if present) and to produce full compaction of the concrete with neither excessive segregation nor laitance. For this purpose, by means of the scoop, place the concrete in the mould in layers approximately 50 mm deep and compact each layer by using either the compacting bar or the vibrator in the manner described in 6.2 or 6.3. After the top layer has been compacted, smooth it level with the top of the mould, using the plasterer's float, and wipe clean the outside of the mould.

6.2 *Compacting with compacting bar*. When compacting each layer with the compacting bar, distribute the strokes of the compacting bar in a uniform manner over the cross-section of the mould, and ensure that the compacting bar does not penetrate significantly any previous layer nor forcibly strike the bottom of the mould when compacting the first layer. The number of strokes per layer required to produce full compaction will depend upon the workability of the concrete but in no case shall the concrete be subjected to less than 35 strokes per layer for 150 mm cubes or 25 strokes per layer for 100 mm cubes, except in the case of very high workability concrete. Record the number of strokes.

6.3 *Compacting with vibrator*. When compacting each layer by means of the hammer or vibrating table use applied vibration of the minimum duration necessary to achieve full compaction of the concrete. Over-vibration may cause excessive segregation and laitance or loss of entrained air, if present. The required duration of vibration will depend upon the workability of the concrete and the effectiveness of the vibrator and vibration shall cease as soon as the surface of the concrete becomes relatively smooth and has a glazed appearance. Record the duration of vibration.

## 7. Report

7.1 *General*. The report shall affirm that the cubes were made in accordance with this Part of this British Standard. The report shall state whether or not a certificate of sampling is available. If available, a copy of the certificate shall be provided.

7.2 *Information to be included in the test report*

7.2.1 *Mandatory information*. The following information shall be included in the test report:

- (a) date, time and place of sampling and sample identity number;
- (b) time and place of making cubes;
- (c) number and nominal size of cubes;
- (d) method of compaction (hand or vibration) including type of equipment used and the number of strokes of the compacting bar or duration of the vibration;
- (e) identification number or codes of cubes;
- (f) name of person making cubes;
- (g) certificate that the cubes were made in accordance with this Part of this standard.

7.2.2 *Optional information*. If requested the following information shall be included in the test report:

- (a) name of project and place where concrete used;
- (b) name of supplier and source of concrete;
- (c) date and time of production of concrete or delivery to site;
- (d) specification of concrete mix (e.g. strength grade);
- (e) workability of concrete;
- (f) air content of concrete (if air-entrained);
- (g) age(s) at which cubes are to be tested

## **Publications referred to**

- BS 308** Engineering drawing practice
  - Part 3 Geometrical tolerancing
- BS 891** Method for Rockwell hardness test
  - Part 1 Testing of metals
- BS 1134** Method for the assessment of surface texture
- BS 1881** Testing concrete
  - Part 101 Method of sampling fresh concrete on site
  - Part 109' Method for making test beams from fresh concrete
  - Part 110\* Method for making test cylinders from fresh concrete
  - Part 111\* Method of normal curing of test specimens (20 °C method)
  - Part 112\* Methods of accelerated curing of test cubes
  - Part 113\* Method for making and curing no-fines test cubes
- BS 3388** Forks, shovels and spades
- BS 5328** Methods for specifying concrete, including ready-mixed concrete
- ISO 1920\*** Concrete tests – Dimensions, tolerances and applicability of test specimens

\* Referred to in the foreword only.

# BS 1881 : Part 108 : 1983

This British Standard, having been prepared under the direction of the Cement, Gypsum, Aggregates and Quarry Products Standards Committee, was published under the authority of the Board of BSI and comes into effect on 29 July 1983.

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The following BSI references relate to the work on this standard:  
Committee reference CAB/4 Draft for comment 81/12319 DC

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## Committees responsible for this British Standard

This British Standard was published under the direction of the Cement, Gypsum, Aggregates and Quarry Products Standards Committee CAB/-. Its preparation was entrusted to Technical Committee CAB/4 upon which the following bodies were represented:

British Aggregate Construction Materials Industries  
British Precast Concrete Federation Ltd.  
British Ready Mixed Concrete Association  
Cement Admixtures Association  
Cement and Concrete Association  
Cement Makers' Federation  
Concrete Society Limited  
County Surveyors' Society  
Department of the Environment (Building Research Establishment)  
Department of the Environment (PSA)  
Department of the Environment (Transport and Road Research Laboratory)  
Department of Transport  
Electricity Supply Industry in England and Wales

Federation of Civil Engineering Contractors  
Greater London Council  
Institute of Concrete Technology  
Institution of Civil Engineers  
Institution of Highway Engineers  
Institution of Municipal Engineers  
Institution of Structural Engineers  
Institution of Water Engineers and Scientists  
National Federation of Building Trades Employers  
Royal Institute of British Architects  
Royal Institution of Chartered Surveyors  
Sand and Gravel Association Limited  
Society of Chemical Industry

The following bodies were also represented in the drafting of the standard, through subcommittees and panels:

British Civil Engineering Test Equipment Manufacturers' Association  
Coopted members

## Amendments issued since publication

Amd. No.	Date of issue	Text affected



**Amendment No. 1**  
**published and effective from 31 July 1989**  
**to BS 1881 : Part 108 : 1983**

**Testing concrete**  
**Part 108. Method for making test cubes**  
**from fresh concrete**

### Revised text

AMD 6106  
 July 1989

### Clause 3.1 Mould

Delete this clause and substitute the following.

#### 3.1 Mould

**3.1.1 Construction and assembly.** The sides of the mould shall be manufactured from ferrous metal having a hardness value of at least 90 Rockwell (scale B) when determined in accordance with BS 891. The mould shall include a removable ferrous metal base plate. All parts of the mould shall be robust enough to prevent distortion. Before assembly for use, the joints between the sides of the mould and between the sides and the base plate shall be thinly coated with oil or grease to prevent loss of water. The sides of the mould when assembled shall be positively located and the whole assembly rigidly held together in such a manner as to prevent leakage from the mould. The internal faces of the assembled mould shall be thinly coated with release agent to prevent adhesion of the concrete.

The sides of the mould shall be clearly marked before use with a reference code to enable each mould to be correctly assembled and, where appropriate, the cube to be marked for identification.

**3.1.2 Tolerances on dimensional deviations of new or refurbished moulds.** A new or refurbished mould shall be accurate within the following limits.

(a) *Dimensions.* The internal depth of the mould when assembled and the distance between the two pairs of opposite internal side faces, each based on the mean of four symmetrically arranged measurements, shall be either  $100 \pm 0.15$  mm or  $150 \pm 0.15$  mm.

(b) *Flatness.* Excluding any indentations resulting from the hardness test, the flatness tolerance (see BS 308 : Part 3) for each internal side face when assembled shall be 0.03 mm wide. The flatness tolerance for the joint faces, for the bottom surface of the assembled mould sides and for the top surface of the base plate shall be 0.06 mm wide.

NOTE. The flatness tolerances can be checked using a straight-edge complying with grade A of BS 5204 : Part 2 and feeler gauges complying with BS 957.

(c) *Squareness.* When assembled, the squareness tolerances (squareness 4 of BS 308 : Part 3) for each internal side face with respect to the adjacent internal side faces and top of the base plate as datum faces shall be 0.5 mm wide.

*blank*

(d) *Parallelism*. When assembled, the parallelism tolerance (parallelism 4 of BS 308 : Part 3) for the top surface of the mould with respect to the top surface of the base plate as datum face shall be 1.00 mm wide.

3.1.3 *Tolerances on dimensions and flatness of moulds in use*. A mould shall be refurbished or discarded when any dimensional deviation given in 3.1.2 exceeds twice the tolerance specified for a new mould.

NOTE. Compliance with the tolerances on dimensions and flatness applicable to moulds in use should be checked at least once a year and when there is any cause to suspect that the dimensions of the mould may not be within the specified limits.

The flatness of the side faces and the top surface of the base plate can be checked by using either:

(a) a straightedge complying with BS 5204 : Part 2, grade A and feeler gauges complying with BS 957; or

(b) an assembly comprising two fixed reference points and a central movable reference point, all three of which can be placed in contact with the surface. The central reference point should be linked to a calibrated dial gauge, complying with BS 907, which indicates the distance of the third point from the line joining the two fixed reference points.

Checks should be made on the joint faces of individual parts and in several directions on the sides of assembled moulds and on the base plate to ensure that the flatness is within the required tolerance in any direction.

If the dial gauge assembly is used, suitable spacings between the fixed reference points are 80 mm and 120 mm for 100 mm and 150 mm moulds respectively. In such cases, the flatness requirements of 0.06 mm for the internal side faces of moulds in use is equivalent to a deviation of the movable reference point from the straight line joining the two fixed reference points of 0.04 mm.

The corresponding value when checking the flatness of the joint faces or of the top surface of the base plate with a dial gauge assembly is 0.08 mm.

3.1.4 *Surface texture of internal side faces*. The surface texture of each internal side face shall not exceed 3.2  $\mu\text{m}$   $R_a$  when determined in accordance with BS 1134.

NOTE. The internal faces of moulds usually become smoother with use but the surfaces should be checked annually and at any time that the internal surfaces appear to have been roughened or damaged. (Accurate examples of different surface textures complying with BS 2634 : Part 1 permit tactile estimation of the surface texture.)'

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AMD 6105  
July 1989

Clause 3.3 Compacting bar or vibrating hammer or table

Delete this clause and substitute the following.

'3.3 *Compacting bar or vibrator*. Compacting bar made from iron or steel weighing  $1.8 \pm 0.1$  kg, at least 380 mm long and having a ramming face  $25.0 \pm 0.5$  mm square, or a vibrating hammer or table suitable for compacting the concrete in accordance with 6.2 or 6.3.'

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AMD 6105  
July 1989

Clause 3.5 Sampling tray

Delete this clause and substitute the following.

'3.5 *Sampling tray*, minimum dimensions 900 mm x 900 mm x 50 mm deep of rigid construction and made from a non-absorbent material not readily attacked by cement paste.'

*blank*



AMD 6105  
July 1989

Clause 4. Sampling

In line 2 after 'Part 101' insert 'or Part 125'.

AMD 6105  
July 1989

Clause 5. Preparing the sample

At the end of this clause insert the following.

'Caution. When cement is mixed with water, alkali is released. Take precautions to avoid dry cement entering the eyes, mouth and nose when mixing concrete. Prevent skin contact with wet cement or concrete by wearing suitable protective clothing. If cement or concrete enters the eye, immediately wash it out thoroughly with clean water and seek medical treatment without delay. Wash wet concrete off the skin immediately.'

AMD 6105  
July 1989

Publications referred to

Delete the entry for 891 and substitute the following.

'BS 891 Methods for hardness test (Rockwell method) and for verification of hardness testing machines (Rockwell method)

BS 907 Specification for dial gauges for linear measurement

BS 957 Specification for feeler gauges'

Under BS 1881 insert in order

'Part 125 Methods for mixing and sampling fresh concrete in the laboratory'.

After BS 1881 insert the following.

'BS 2634 Specification for roughness comparison specimens

Part 1 Specification for turned, ground, bored, milled, shaped and planed specimens'

After BS 3388 insert the following

'BS 5204 Specification for straightedges

Part 2 Steel or granite straightedges of rectangular section'

*blank*