

Contents

Foreword	i
1. Introduction	1
2. Categories of surface quality	2
2.1 Requirements for classification	2
2.1.1 Requirements on the planning and tender	3
2.1.2 Requirements on the concrete surface	4
2.1.3 Requirements on the execution process on site and the use of formwork	5
2.2 Non-classifiable characteristics	8
2.2.1 Requirements on formwork	8
2.2.2 Requirements for concrete and casting	9
2.3 Description of the defined requirements for classification	9
2.3.1 Examples and illustrations for requirements on planning and tender	9
2.3.2 Examples and illustrations for requirements on the concrete surface	10
2.3.3 Requirements for the execution-process and the use of formwork	12
2.4 Description of requirements without classification	16
2.4.1 Requirements on the formwork	16
2.4.2 Requirements for the concrete and casting	20
3. Costing of visual concrete	21
3.1 A systematic approach to determining labour cost	21
3.1.1 Criteria for Costing	21
3.1.2 Calculation of Cost of Production	22
3.1.3 Determining item costs for visual concrete – checklist	23
3.1.4 Determining overhead costs for visual concrete	23
3.2 Costing	23
3.3 Visual concrete – Example of Preliminary Costing or Cost Estimate	24
3.4 Calculation of the total labour consumption rate for standard concrete	26
3.5 Calculation of the total labour consumption rate for visual concrete	26
3.5.1 Visual concrete with requirements EXP1	26
3.5.2 Visual concrete with requirements EXP3	29
3.6 Summary	31

4.	Construction project organisation and workflow	32
4.1	Construction project organisation	32
4.2	Workflow	34
4.2.1	Final Design	35
4.2.2	Execution drawings	35
4.2.3	Assisting award process	35
4.2.4	Concept of execution of structural visual concrete works	35
4.2.5	Execution Phase	35
5.	Influence of concrete characteristics on visual concrete surfaces	36
5.1	Important Concrete Characteristics	36
5.2	Influence of component materials	36
5.2.1	Aggregate	36
5.2.2	Cement	37
5.2.3	Additives	38
5.2.4	Water	38
5.2.5	Chemical admixtures	39
5.2.6	Pigments	39
5.3	Influences of mix design	40
5.3.1	Mix design procedure	40
5.3.2	Mix design of vibrated normal visual concrete	40
5.3.3	Mix design of self-compacting visual concrete	41
5.4	Fresh Concrete properties	41
5.5	Robustness	42
6.	Influence of execution on the surface quality	44
6.1	Structural design	44
6.2	Influence of placement of concrete	45
6.3	Effect of Compaction or Consolidation	46
6.4	Effect of formwork system and tightness	47
6.5	Effect of release agent and form removal	50
6.6	Effect of curing	52
6.7	Repair and "cosmetics"	53

7.	Methods of evaluation	54
7.1	General	54
7.2	Approach to evaluation	54
7.2.1	Limits of Visual Concrete	55
7.2.2	Dealing with cracks	55
7.3	Evaluation methods	56
7.3.1	Direct comparison	56
7.3.2	Comparison with image	56
7.3.3	Image analysis	57
8.	Annexes	58
	Annex A	58
A.1	Costing for slabs	58
A.2	Costing for walls	60
	Annex B	62
	Annex C - Challenges when photographing concrete surfaces	63
C.1	Colour of light	63
C.2	Light distribution	63
	References	65