

SECTION 034500 - PRECAST ARCHITECTURAL CONCRETE

PART 1 - GENERAL

1.1 RELATED DOCUMENTS

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 SUMMARY

- A. This Section includes the following:
 - 1. Architectural precast concrete cladding units.
 - 2. Architectural precast stair units.

1.3 DEFINITION

- A. Design Reference Sample: Sample of approved architectural precast concrete color, finish and texture, preapproved by Architect.

1.4 PERFORMANCE REQUIREMENTS

- A. Structural Performance: Provide architectural precast concrete units and connections capable of withstanding the following design loads within limits and under conditions indicated:
 - 1. Loads: As indicated.
 - 2. Thermal Movements: Provide for in-plane thermal movements resulting from annual ambient temperature changes of 120 deg F.

1.5 ACTION SUBMITTALS

- A. Product Data: For each type of product indicated.
- B. LEED Submittals: Follow submittal requirements of Division 01 Section "Submittal Requirements" and provide product data on the LEED Materials Documentation Cover Sheet attached as an Appendix to Division 01 Section "Sustainable Design and LEED Requirements."
- C. Design Mixtures: For each precast concrete mixture. Include compressive strength and water-absorption tests.
- D. Shop Drawings: Detail fabrication and installation of architectural precast concrete units. Indicate locations, plans, elevations, dimensions, shapes, and cross sections of each unit. Indicate joints, reveals, and extent and location of each surface finish. Indicate details at building corners.

1. Indicate separate face and backup mixture locations and thicknesses.
 2. Indicate welded connections by AWS standard symbols. Detail loose and cast-in hardware and connections.
 3. Indicate locations, tolerances, and details of anchorage devices to be embedded in or attached to structure or other construction.
 4. Indicate locations, extent, and treatment of dry joints if two-stage casting is proposed.
 5. Include plans and elevations showing unit location and sequence of erection for special conditions.
 6. Indicate location of each architectural precast concrete unit by same identification mark placed on panel.
 7. Indicate relationship of architectural precast concrete units to adjacent materials.
 8. Design Modifications: If design modifications are proposed to meet performance requirements and field conditions, submit design calculations and Shop Drawings. Do not adversely affect the appearance, durability, or strength of units when modifying details or materials and maintain the general design concept.
 9. Comprehensive engineering analysis signed and sealed by the qualified professional engineer responsible for its preparation. Show governing panel types, connections, and types of reinforcement, including special reinforcement. Indicate location, type, magnitude, and direction of loads imposed on the building structural frame from architectural precast concrete.
- E. Samples: For each type of finish indicated on exposed surfaces of architectural precast concrete units, in sets of 3, illustrating full range of finish, color, and texture variations expected; approximately 12 by 12 by 2 inches.
1. When other faces of precast concrete unit are exposed, include Samples illustrating workmanship, color, and texture of backup concrete as well as facing concrete.
 2. Samples for each brick unit required, showing full range of color and texture expected. Include Sample showing color and texture of joint treatment.
 - a. Grout Samples for Initial Selection: Color charts consisting of actual sections of grout showing manufacturer's full range of colors.
 - b. Grout Samples for Verification: Showing color and texture of joint treatment.

1.6 INFORMATIONAL SUBMITTALS

- A. Welding certificates.
- B. Material Certificates: For the following items, signed by manufacturers:
 1. Cementitious materials.
 2. Reinforcing materials and prestressing tendons.
 3. Admixtures.
 4. Bearing pads.
- C. Material Test Reports: For aggregates.
- D. Source quality-control test reports.
- E. Field quality-control test reports.

1.7 QUALITY ASSURANCE

- A. Installer Qualifications: A precast concrete erector who has retained a "PCI-Certified Field Auditor" to conduct a field audit of a project in same category as this Project before erection of precast concrete and who can produce an Erectors' Post-Audit Declaration.
- B. Fabricator Qualifications: A firm that assumes responsibility for engineering architectural precast concrete units to comply with performance requirements. This responsibility includes preparation of Shop Drawings and comprehensive engineering analysis by a qualified professional engineer.
 - 1. Participates in PCI's plant certification program and is designated a PCI-certified plant for Group A, Category A1 - Architectural Cladding and Load Bearing Units or participates in APA's "Plant Certification Program for Production of Architectural Precast Concrete Products" and is designated an APA-certified plant.
- C. Testing Agency Qualifications: An independent testing agency qualified according to ASTM C 1077 and ASTM E 329 for testing indicated.
- D. Design Standards: Comply with ACI 318 and design recommendations of PCI MNL 120, "PCI Design Handbook - Precast and Prestressed Concrete," applicable to types of architectural precast concrete units indicated.
- E. Quality-Control Standard: For manufacturing procedures and testing requirements, quality-control recommendations, and dimensional tolerances for types of units required, comply with PCI MNL 117, "Manual for Quality Control for Plants and Production of Architectural Precast Concrete Products."
- F. Welding: Qualify procedures and personnel according to AWS D1.1/D.1.1M, "Structural Welding Code - Steel"; and AWS D1.4, "Structural Welding Code - Reinforcing Steel."
- G. Mockups: To be coordinated with exterior wall sample.

1.8 DELIVERY, STORAGE, AND HANDLING

- A. Deliver architectural precast concrete units in such quantities and at such times to limit unloading units temporarily on the ground.
- B. Support units during shipment on nonstaining shock-absorbing material.
- C. Store units with adequate dunnage and bracing and protect units to prevent contact with soil, to prevent staining, and to prevent cracking, distortion, warping or other physical damage.
- D. Place stored units so identification marks are clearly visible, and units can be inspected.
- E. Handle and transport units in a position consistent with their shape and design in order to avoid excessive stresses which would cause cracking or damage.
- F. Lift and support units only at designated points shown on Shop Drawings.

1.9 SEQUENCING

- A. Furnish loose connection hardware and anchorage items to be embedded in or attached to other construction without delaying the Work. Provide locations, setting diagrams, templates, instructions, and directions, as required, for installation.

PART 2 - PRODUCTS

2.1 MOLD MATERIALS

- A. Molds: Rigid, dimensionally stable, non-absorptive material, warp and buckle free, that will provide continuous and true precast concrete surfaces within fabrication tolerances indicated; nonreactive with concrete and suitable for producing required finishes.
 - 1. Mold-Release Agent: Commercially produced liquid-release agent that will not bond with, stain or adversely affect precast concrete surfaces and will not impair subsequent surface or joint treatments of precast concrete.
- B. Surface Retarder: Chemical set retarder, capable of temporarily delaying final hardening of newly placed concrete mixture to depth of reveal specified.

2.2 REINFORCING MATERIALS

- A. Recycled Content of Steel Products: Postconsumer recycled content plus one-half of preconsumer recycled content not less than 60 percent.
- B. Reinforcing Bars: ASTM A 615/A 615M, Grade 60, deformed.
- C. Plain-Steel Welded Wire Reinforcement: ASTM A 185, fabricated from as-drawn steel wire into flat sheets.
- D. Supports: Suspend reinforcement from back of mold or use bolsters, chairs, spacers, and other devices for spacing, supporting, and fastening reinforcing bars and welded wire reinforcement in place according to PCI MNL 117.

2.3 PRESTRESSING TENDONS

- A. Prestressing Strand: ASTM A 416/A 416M, Grade 270, uncoated, 7-wire, low-relaxation strand.
 - 1. Coat unbonded post-tensioning strand with corrosion inhibitor passing ASTM D 1743 and sheath with polypropylene tendon sheathing. Include anchorage devices and coupler assemblies.

2.4 CONCRETE MATERIALS

- A. Portland Cement: ASTM C 150, Type I or Type III, gray, unless otherwise indicated.

1. For surfaces exposed to view in finished structure, mix gray with white cement, of same type, brand, and mill source.
- B. Supplementary Cementitious Materials:
1. Fly Ash: ASTM C 618, Class C or F, with maximum loss on ignition of 3 percent.
 2. Metakaolin Admixture: ASTM C 618, Class N.
 3. Silica Fume Admixture: ASTM C 1240, with optional chemical and physical requirement.
 4. Ground Granulated Blast-Furnace Slag: ASTM C 989, Grade 100 or 120.
- C. Normal-Weight Aggregates: Except as modified by PCI MNL 117, ASTM C 33, with coarse aggregates complying with Class 5S. Stockpile fine and coarse aggregates for each type of exposed finish from a single source (pit or quarry) for Project.
1. Face-Mixture-Coarse Aggregates: Selected, hard, and durable; free of material that reacts with cement or causes staining; to match selected finish sample.
 - a. Gradation: Uniformly graded.
 2. Face-Mixture-Fine Aggregates: Selected, natural or manufactured sand of same material as coarse aggregate, unless otherwise approved by Architect.
- D. Lightweight Aggregates: Except as modified by PCI MNL 117, ASTM C 330, with absorption less than 11 percent.
- E. Coloring Admixture: ASTM C 979, synthetic or natural mineral-oxide pigments or colored water-reducing admixtures, temperature stable, and nonfading.
- F. Water: Potable; free from deleterious material that may affect color stability, setting, or strength of concrete and complying with chemical limits of PCI MNL 117.
- G. Air-Entraining Admixture: ASTM C 260, certified by manufacturer to be compatible with other required admixtures.
- H. Chemical Admixtures: Certified by manufacturer to be compatible with other admixtures and to not contain calcium chloride, or more than 0.15 percent chloride ions or other salts by weight of admixture.
1. Water-Reducing Admixtures: ASTM C 494/C 494M, Type A.
 2. Retarding Admixture: ASTM C 494/C 494M, Type B.
 3. Water-Reducing and Retarding Admixture: ASTM C 494/C 494M, Type D.
 4. Water-Reducing and Accelerating Admixture: ASTM C 494/C 494M, Type E.
 5. High-Range, Water-Reducing Admixture: ASTM C 494/C 494M, Type F.
 6. High-Range, Water-Reducing and Retarding Admixture: ASTM C 494/C 494M, Type G.
 7. Plasticizing and Retarding Admixture: ASTM C 1017/C 1017 M.

2.5 STEEL CONNECTION MATERIALS

- A. Carbon-Steel Shapes and Plates: ASTM A 36/A 36M.
- B. Carbon-Steel Plate: ASTM A 283/A 283M.
- C. Deformed-Steel Wire or Bar Anchors: ASTM A 496 or ASTM A 706/A 706M.
- D. Carbon-Steel Bolts and Studs: ASTM A 307, Grade A; carbon-steel, hex-head bolts and studs; carbon-steel nuts, ASTM A 563; and flat, unhardened steel washers, ASTM F 844.
- E. Zinc-Coated Finish: For exterior steel items and items indicated for galvanizing, apply zinc coating by hot-dip process according to ASTM A 123/A 123M or ASTM A 153/A 153M.
 - 1. For steel shapes, plates, and tubing to be galvanized, limit silicon content of steel to less than 0.03 percent or to between 0.15 and 0.25 percent or limit sum of silicon and 2.5 times phosphorous content to 0.09 percent.
 - 2. Galvanizing Repair Paint: High-zinc-dust-content paint with dry film containing not less than 94 percent zinc dust by weight, and complying with DOD-P-21035A or SSPC-Paint 20.
- F. Shop-Primed Finish: Prepare surfaces of nongalvanized steel items, except those surfaces to be embedded in concrete, according to requirements in SSPC-SP 3 and shop-apply lead- and chromate-free, rust-inhibitive primer, complying with performance requirements in MPI 79 [SSPC-Paint 25] according to SSPC-PA 1.
- G. Welding Electrodes: Comply with AWS standards.

2.6 BEARING PADS

- A. Provide one of the following bearing pads for architectural precast concrete units as recommended by precast fabricator for application:
 - 1. Elastomeric Pads: AASHTO M 251, plain, vulcanized, 100 percent polychloroprene (neoprene) elastomer, molded to size or cut from a molded sheet, Type A durometer hardness of 50 to 70, ASTM D 2240, minimum tensile strength 2250 psi, ASTM D 412.
 - 2. Random-Oriented, Fiber-Reinforced Elastomeric Pads: Preformed, randomly oriented synthetic fibers set in elastomer. Type A durometer hardness of 70 to 90, ASTM D 2240; capable of supporting a compressive stress of 3000 psi with no cracking, splitting, or delaminating in the internal portions of pad. Test one specimen for every 200 pads used in Project.
 - 3. Cotton-Duck-Fabric-Reinforced Elastomeric Pads: Preformed, horizontally layered cotton-duck fabric bonded to an elastomer; Type A durometer hardness of 80 to 100, ASTM D 2240; complying with AASHTO's "AASHTO Load and Resistance Factor Design (LRFD) Bridge Design Specifications, Division II, Section 18.10.2, or with MIL-C-882E.
 - 4. Frictionless Pads: Tetrafluoroethylene (Teflon), glass-fiber reinforced, bonded to stainless or mild-steel plate, of type required for in-service stress.
 - 5. High-Density Plastic: Multimonomer, nonleaching, plastic strip.

2.7 ACCESSORIES

- A. Precast Accessories: Provide clips, hangers, plastic or steel shims, and other accessories required to install architectural precast concrete units.

2.8 GROUT MATERIALS

- A. Nonmetallic, Nonshrink Grout: Premixed, nonmetallic, noncorrosive, nonstaining grout containing selected silica sands, portland cement, shrinkage-compensating agents, plasticizing and water-reducing agents, complying with ASTM C 1107, Grade A for drypack and Grades B and C for flowable grout and of consistency suitable for application within a 30-minute working time.

2.9 CONCRETE MIXTURES

- A. Prepare design mixtures for each type of precast concrete required.
 - 1. Limit use of fly ash and silica fume to 20 percent of portland cement by weight; limit metakaolin and silica fume to 10 percent of portland cement by weight.
- B. Design mixtures may be prepared by a qualified independent testing agency or by qualified precast plant personnel at architectural precast concrete fabricator's option.
- C. Limit water-soluble chloride ions to maximum percentage by weight of cement permitted by ACI 318 or PCI MNL 117 when tested according to ASTM C 1218/C 1218M.
- D. Normal-Weight Concrete Mixtures: Proportion full-depth mixture by either laboratory trial batch or field test data methods according to ACI 211.1, with materials to be used on Project, to provide normal-weight concrete with the following properties:
 - 1. Compressive Strength (28 Days): 5000 psi minimum.
 - 2. Maximum Water-Cementitious Materials Ratio: 0.45.
- E. Water Absorption: 6 percent by weight or 14 percent by volume, tested according to PCI MNL 117.
- F. Add air-entraining admixture at manufacturer's prescribed rate to result in concrete at point of placement having an air content complying with PCI MNL 117.
- G. When included in design mixtures, add other admixtures to concrete mixtures according to manufacturer's written instructions.

2.10 MOLD FABRICATION

- A. Molds: Accurately construct molds, mortar tight, of sufficient strength to withstand pressures due to concrete-placement operations and temperature changes and for prestressing and detensioning operations. Coat contact surfaces of molds with release agent before reinforcement is placed. Avoid contamination of reinforcement and prestressing tendons by release agent.

1. Place form liners accurately to provide finished surface texture indicated. Provide solid backing and supports to maintain stability of liners during concrete placement. Coat form liner with form-release agent.
- B. Maintain molds to provide completed architectural precast concrete units of shapes, lines, and dimensions indicated, within fabrication tolerances specified.
 1. Form joints are not permitted on faces exposed to view in the finished work.
 2. Edge and Corner Treatment: Uniformly chamfered.

2.11 FABRICATION

- A. Cast-in Anchors, Inserts, Plates, Angles, and Other Anchorage Hardware: Fabricate anchorage hardware with sufficient anchorage and embedment to comply with design requirements. Accurately position for attachment of loose hardware, and secure in place during precasting operations. Locate anchorage hardware where it does not affect position of main reinforcement or concrete placement.
 1. Weld-headed studs and deformed bar anchors used for anchorage according to AWS D1.1/D1.1M and AWS C5.4, "Recommended Practices for Stud Welding."
- B. Furnish loose hardware items including steel plates, clip angles, seat angles, anchors, dowels, cramps, hangers, and other hardware shapes for securing architectural precast concrete units to supporting and adjacent construction.
- C. Cast-in reglets, slots, holes, and other accessories in architectural precast concrete units as indicated on the Contract Drawings.
- D. Cast-in openings larger than 10 inches in any dimension. Do not drill or cut openings or prestressing strand without Architect's approval.
- E. Reinforcement: Comply with recommendations in PCI MNL 117 for fabricating, placing, and supporting reinforcement.
 1. Clean reinforcement of loose rust and mill scale, earth, and other materials that reduce or destroy the bond with concrete. When damage to epoxy-coated reinforcing exceeds limits specified in ASTM A 775/A 775M, repair with patching material compatible with coating material and epoxy coat bar ends after cutting.
 2. Accurately position, support, and secure reinforcement against displacement during concrete-placement and consolidation operations. Completely conceal support devices to prevent exposure on finished surfaces.
 3. Place reinforcement to maintain at least 3/4-inch minimum coverage. Arrange, space, and securely tie bars and bar supports to hold reinforcement in position while placing concrete. Direct wire tie ends away from finished, exposed concrete surfaces.
 4. Place reinforcing steel and prestressing strand to maintain at least 3/4-inch minimum concrete cover. Increase cover requirements for reinforcing steel to 1-1/2 inches when units are exposed to corrosive environment or severe exposure conditions. Arrange, space, and securely tie bars and bar supports to hold reinforcement in position while placing concrete. Direct wire tie ends away from finished, exposed concrete surfaces.

5. Install welded wire fabric in lengths as long as practicable. Lap adjoining pieces at least one full mesh spacing and wire tie laps, where required by design. Offset laps of adjoining widths to prevent continuous laps in either direction.
- F. Reinforce architectural precast concrete units to resist handling, transportation, and erection stresses.
- G. Prestress tendons for architectural precast concrete units by either pretensioning or post-tensioning methods. Comply with PCI MNL 117.
1. Delay detensioning or post-tensioning of precast, prestressed architectural concrete units until concrete has reached its indicated minimum design release compressive strength as established by test cylinders cured under same conditions as concrete.
 2. Detension pretensioned tendons either by gradually releasing tensioning jacks or by heat-cutting tendons, using a sequence and pattern to prevent shock or unbalanced loading.
 3. If concrete has been heat cured, detension while concrete is still warm and moist to avoid dimensional changes that may cause cracking or undesirable stresses.
 4. Protect strand ends and anchorages with bituminous, zinc-rich, or epoxy paint to avoid corrosion and possible rust spots.
- H. Comply with requirements in PCI MNL 117 and requirements in this Section for measuring, mixing, transporting, and placing concrete. After concrete batching, no additional water may be added.
- I. Place face mixture to a minimum thickness after consolidation of the greater of 1 inch or 1.5 times the maximum aggregate size, but not less than the minimum reinforcing cover specified.
- J. Place concrete in a continuous operation to prevent seams or planes of weakness from forming in precast concrete units.
1. Place backup concrete mixture to ensure bond with face-mixture concrete.
- K. Thoroughly consolidate placed concrete by internal and external vibration without dislocating or damaging reinforcement and built-in items, and minimize pour lines, honeycombing, or entrapped air on surfaces. Use equipment and procedures complying with PCI MNL 117.
1. Place self-consolidating concrete without vibration according to PCI TR-6, "Interim Guidelines for the Use of Self-Consolidating Concrete in Precast/Prestressed Concrete Institute Member Plants."
- L. Comply with PCI MNL 117 for hot- and cold-weather concrete placement.
- M. Identify pickup points of architectural precast concrete units and orientation in structure with permanent markings, complying with markings indicated on Shop Drawings. Imprint or permanently mark casting date on each architectural precast concrete unit on a surface that will not show in finished structure.
- N. Cure concrete, according to requirements in PCI MNL 117, by moisture retention without heat or by accelerated heat curing using low-pressure live steam or radiant heat and moisture. Cure units until compressive strength is high enough to ensure that stripping does not have an effect on performance or appearance of final product.

- O. Discard and replace architectural precast concrete units that do not comply with requirements, including structural, manufacturing tolerance, and appearance, unless repairs meet requirements in PCI MNL 117 and Architect's approval.

2.12 FABRICATION TOLERANCES

- A. Fabricate architectural precast concrete units straight and true to size and shape with exposed edges and corners precise and true so each finished panel complies with PCI MNL 117 product tolerances as well as position tolerances for cast-in items.
- B. Fabricate architectural precast concrete units straight and true to size and shape with exposed edges and corners precise and true so each finished panel complies with the following product tolerances:
 - 1. Overall Height and Width of Units, Measured at the Face Exposed to View: As follows:
 - a. 10 feet or under, plus or minus 1/8 inch.
 - b. 10 to 20 feet, plus 1/8 inch, minus 3/16 inch.
 - c. 20 to 40 feet, plus or minus 1/4 inch.
 - d. Each additional 10 feet, plus or minus 1/16 inch.
 - 2. Overall Height and Width of Units, Measured at the Face Not Exposed to View: As follows:
 - a. 10 feet or under, plus or minus 1/4 inch.
 - b. 10 to 20 feet, plus 1/4 inch, minus 3/8 inch.
 - c. 20 to 40 feet, plus or minus 3/8 inch.
 - d. Each additional 10 feet, plus or minus 1/8 inch.
 - 3. Total Thickness or Flange Thickness: Plus 1/4 inch, minus 1/8 inch.
 - 4. Variation from Square or Designated Skew (Difference in Length of the Two Diagonal Measurements): Plus or minus 1/8 inch per 72 inches or 1/2 inch total, whichever is greater.
 - 5. Difference in Relative Position of Adjacent Haunch Bearing Surfaces from Specified Relative Position: Plus or minus 1/4 inch.
 - 6. Bowing: Plus or minus L/360, maximum 1 inch.
 - 7. Local Smoothness: 1/4 inch per 10 feet.
 - 8. Warping: 1/16 inch per 12 inches of distance from nearest adjacent corner.
 - 9. Tipping and Flushness of Plates: Plus or minus 1/4 inch.
 - 10. Dimensions of Architectural Features and Rustications: Plus or minus 1/8 inch.
- C. Position Tolerances: For cast-in items measured from datum line location, as indicated on Shop Drawings.
 - 1. Weld Plates: Plus or minus 1 inch.
 - 2. Inserts: Plus or minus 1/2 inch.
 - 3. Handling Devices: Plus or minus 3 inches.
 - 4. Reinforcing Steel and Welded Wire Fabric: Plus or minus 1/4 inch where position has structural implications or affects concrete cover; otherwise, plus or minus 1/2 inch.
 - 5. Reinforcing Steel Extending out of Member: Plus or minus 1/2 inch of plan dimensions.

6. Tendons: Plus or minus 1/4 inch, vertical; plus or minus 1 inch, horizontal.
7. Location of Bearing Surface from End of Member: Plus or minus 1/4 inch.
8. Allowable Rotation of Plate, Channel Inserts, and Electrical Boxes: 2-degree rotation or 1/4 inch maximum over the full dimension of unit.

2.13 FINISHES

- A. Panel faces shall be free of joint marks, grain, and other obvious defects. Corners, including false joints shall be uniform, straight, and sharp. Finish exposed-face surfaces of architectural precast concrete units to match approved design reference sample and as follows:
 1. Design Reference Sample: **To be determined.**
 2. PCI's "Architectural Precast Concrete - Color and Texture Selection Guide," of plate numbers indicated.
 3. Abrasive-Blast Finish: Use abrasive grit, equipment, application techniques, and cleaning procedures to expose aggregate and surrounding matrix surfaces.
- B. Finish exposed top surfaces of architectural precast concrete units to match face-surface finish.
- C. Finish unexposed surfaces of architectural precast concrete units by float finish.

2.14 SOURCE QUALITY CONTROL

- A. Quality-Control Testing: Test and inspect precast concrete according to PCI MNL 117 requirements. If using self-consolidating concrete, also test and inspect according to PCI TR-6, "Interim Guidelines for the Use of Self-Consolidating Concrete in Precast/Prestressed Concrete Institute Member Plants."
- B. Strength of precast concrete units will be considered deficient if units fail to comply with ACI 318 requirements for concrete strength.
- C. Testing: If there is evidence that strength of precast concrete units may be deficient or may not comply with ACI 318 requirements, precaster will employ an independent testing agency to obtain, prepare, and test cores drilled from hardened concrete to determine compressive strength according to ASTM C 42/C 42M.
 1. A minimum of three representative cores will be taken from units of suspect strength, from locations directed by Architect.
 2. Cores will be tested in an air-dry condition.
 3. Strength of concrete for each series of 3 cores will be considered satisfactory if average compressive strength is equal to at least 85 percent of 28-day design compressive strength and no single core is less than 75 percent of 28-day design compressive strength.
 4. Test results will be made in writing on same day that tests are performed, with copies to Architect, Contractor, and precast concrete fabricator. Test reports will include the following:
 - a. Project identification name and number.
 - b. Date when tests were performed.
 - c. Name of precast concrete fabricator.

- d. Name of concrete testing agency.
 - e. Identification letter, name, and type of precast concrete unit(s) represented by core tests; design compressive strength; type of break; compressive strength at breaks, corrected for length-diameter ratio; and direction of applied load to core in relation to horizontal plane of concrete as placed.
- D. Patching: If core test results are satisfactory and precast concrete units comply with requirements, clean and dampen core holes and solidly fill with precast concrete mixture that has no coarse aggregate, and finish to match adjacent precast concrete surfaces.

PART 3 - EXECUTION

3.1 EXAMINATION

- A. Examine supporting structural frame or foundation and conditions for compliance with requirements for installation tolerances, true and level bearing surfaces, and other conditions affecting performance.
- B. Proceed with installation only after unsatisfactory conditions have been corrected.
- C. Do not install precast concrete units until supporting cast-in-place building structural framing has attained minimum allowable design compressive strength or supporting steel or other structure is complete.

3.2 INSTALLATION

- A. Install clips, hangers, bearing pads, and other accessories required for connecting architectural precast concrete units to supporting members and backup materials.
- B. Erect architectural precast concrete level, plumb, and square within specified allowable tolerances. Provide temporary supports and bracing as required to maintain position, stability, and alignment as units are being permanently connected.
 - 1. Install temporary steel or plastic spacing shims or bearing pads as precast concrete units are being erected. Tack weld steel shims to each other to prevent shims from separating.
 - 2. Maintain horizontal and vertical joint alignment and uniform joint width as erection progresses.
 - 3. Remove projecting lifting devices and grout fill voids within recessed lifting devices flush with surface of adjacent precast surfaces when recess is exposed.
 - 4. Unless otherwise indicated, maintain uniform joint widths of 3/4 inch.
- C. Connect architectural precast concrete units in position by bolting, welding, grouting, or as otherwise indicated on Shop Drawings. Remove temporary shims, wedges, and spacers as soon as practical after connecting and grouting are completed.
 - 1. Do not permit connections to disrupt continuity of roof flashing.
- D. Welding: Comply with applicable AWS D1.1/D1.1M and AWS D1.4 for welding, welding electrodes, appearance, quality of welds, and methods used in correcting welding work.

1. Protect architectural precast concrete units and bearing pads from damage by field welding or cutting operations, and provide noncombustible shields as required.
 2. Welds not specified shall be continuous fillet welds, using no less than the minimum fillet as specified by AWS.
 3. Clean weld-affected metal surfaces with chipping hammer followed by brushing, and apply a minimum 4.0-mil- thick coat of galvanized repair paint to galvanized surfaces according to ASTM A 780.
 4. Clean weld-affected metal surfaces with chipping hammer followed by brushing, and reprime damaged painted surfaces.
 5. Remove, reweld, or repair incomplete and defective welds.
- E. At bolted connections, use lock washers, tack welding, or other approved means to prevent loosening of nuts after final adjustment.
1. Where slotted connections are used, verify bolt position and tightness. For sliding connections, properly secure bolt but allow bolt to move within connection slot. For friction connections, apply specified bolt torque and check 25 percent of bolts at random by calibrated torque wrench.
- F. Grouting Connections: Grout connections where required or indicated. Retain grout in place until hard enough to support itself. Pack spaces with stiff grout material, tamping until voids are completely filled. Place grout to finish smooth, level, and plumb with adjacent concrete surfaces. Keep grouted joints damp for not less than 24 hours after initial set. Promptly remove grout material from exposed surfaces before it affects finishes or hardens.

3.3 ERECTION TOLERANCES

- A. Erect architectural precast concrete units level, plumb, square, true, and in alignment without exceeding the noncumulative erection tolerances of PCI MNL 117, Appendix I.
- B. Erect architectural precast concrete units level, plumb, square, and true, without exceeding the following noncumulative erection tolerances:
1. Plan Location from Building Grid Datum: Plus or minus 1/2 inch.
 2. Plan Location from Centerline of Steel: Plus or minus 1/2 inch.
 3. Top Elevation from Nominal Top Elevation: As follows:
 - a. Exposed Individual Panel: Plus or minus 1/4 inch.
 - b. Non-Exposed Individual Panel: Plus or minus 1/2 inch.
 - c. Exposed Panel Relative to Adjacent Panel: 1/4 inch.
 - d. Non-Exposed Panel Relative to Adjacent Panel: 1/2 inch.
 4. Support Elevation from Nominal Support Elevation: As follows:
 - a. Maximum Low: 1/2 inch.
 - b. Maximum High: 1/4 inch.
 5. Maximum Plumb Variation over the Lesser of Height of Structure or 100 Feet: 1 inch.
 6. Plumb in Any 10 Feet of Element Height: 1/4 inch.
 7. Maximum Jog in Alignment of Matching Edges: 1/4 inch.

PEARL PLACE 2

8. Joint Width (Governs over Joint Taper): Plus or minus 1/4 inch.
9. Maximum Joint Taper: 3/8 inch.
10. Joint Taper in 10 Feet: 1/4 inch.
11. Maximum Jog in Alignment of Matching Faces: 1/4 inch.
12. Differential Bowing or Camber, as Erected, between Adjacent Members of Same Design: 1/4 inch.
13. Opening Height between Spandrels: Plus or minus 1/4 inch.

3.4 REPAIRS

- A. Repair architectural precast concrete units if permitted by Architect. The Architect reserves the right to reject repaired units that do not comply with requirements.
- B. Mix patching materials and repair units so cured patches blend with color, texture, and uniformity of adjacent exposed surfaces and show no apparent line of demarcation between original and repaired work, when viewed in typical daylight illumination from a distance of 20 feet.
- C. Prepare and repair damaged galvanized coatings with galvanizing repair paint according to ASTM A 780.
- D. Wire brush, clean, and paint damaged prime-painted components with same type of shop primer.
- E. Remove and replace damaged architectural precast concrete units when repairs do not comply with requirements.

3.5 CLEANING

- A. Clean surfaces of precast concrete units exposed to view.
- B. Clean mortar, plaster, fireproofing, weld slag, and other deleterious material from concrete surfaces and adjacent materials immediately.
- C. Clean exposed surfaces of precast concrete units after erection and completion of joint treatment to remove weld marks, other markings, dirt, and stains.
 1. Perform cleaning procedures, if necessary, according to precast concrete fabricator's recommendations. Clean soiled precast concrete surfaces with detergent and water, using stiff fiber brushes and sponges, and rinse with clean water. Protect other work from staining or damage due to cleaning operations.
 2. Do not use cleaning materials or processes that could change the appearance of exposed concrete finishes or damage adjacent materials.

END OF SECTION 034500