

Instructions for casting small sample slabs

Storage and handling of membranes

- The membranes must be stored in a dry, warm space protected from sunlight.
- Handle the membranes so that there are no wrinkles or creases. Do not allow the membranes to become dirty, wet or fouled by oil.

Preliminary tests and trial castings

- The Technology Transfer Process needs to be carried out prior to starting to commercially use the Graphic Concrete™ method.
- The process includes trial castings using various concrete masses and membranes as well as learning how to use the membrane in production.
- This facilitates high-quality of Graphic Concrete™ and production efficiency.

Preparations

- Element production begins with cleaning the mould. The mould should have an even and clean surface; even the smallest irregularities on the mould surface (for example, marks left by a hammer) will be imprinted on the concrete surface.
- Crumbs between the mould surface and the membrane or blisters on the mould surface will be visible on the concrete surface.
- Use an industrial vacuum cleaner to remove all loose dust and sand particles. Do not use mould oil or release agents.

Setting the mould edges and building the mould

- Start by spreading a piece of membrane that is larger than the slab being cast on the mould table.
- Before setting the edges, press the membrane tightly against the surface of the mould table. As little air as possible should remain between the membrane and the table surface. You can also perform this procedure by using a soft brush or pulling the ends of the membrane to straighten it.
- Set the mould edges on the membrane and lock the mould table.

Casting and compacting the slab

- Use external vibration for compacting the slab in a normal manner. Use sufficient compacting time but keep it also as short as possible. Self-compacting concrete may also be used.

Exposing the Graphic Concrete™ pattern

- The membrane is removed and the sample slabs are pressure washed the following day.



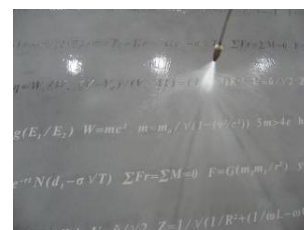
Keep membrane clean



Carry out tests



Clean table surface



Pressure wash