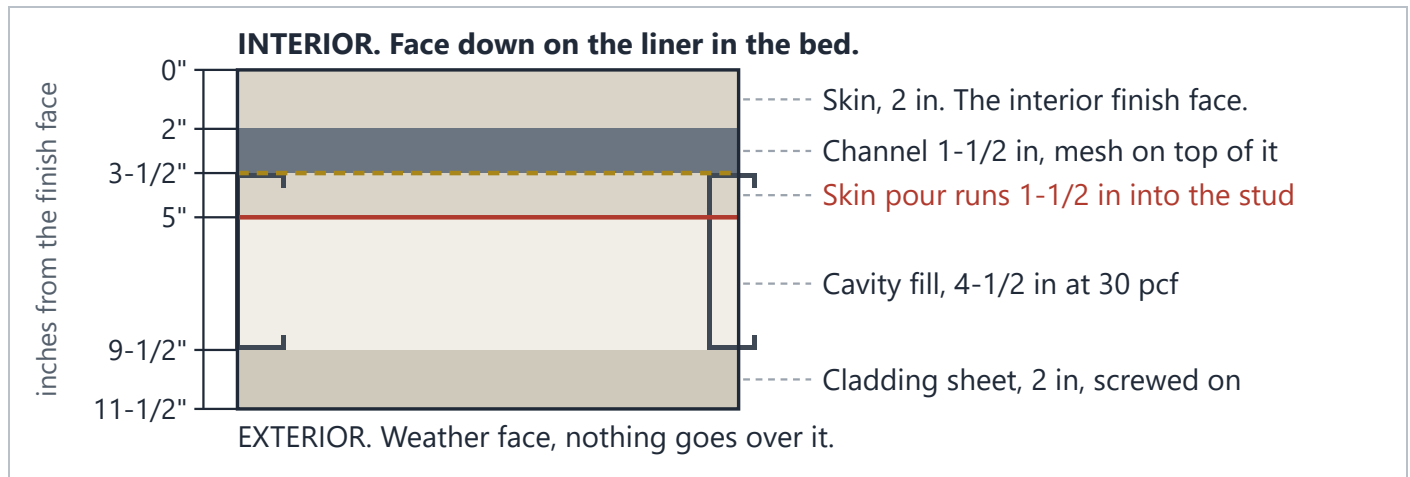


The skin pour

The finish layer is 2 in. The pour is 5 in. Those are two different numbers and this is the one a new hand gets wrong.

Why it is 5 in and not 2 in

2 in of skin, plus 1-1/2 in of channel and mesh zone, plus 1-1/2 in up into the studs, is 5 in. That last 1-1/2 in is the whole point. It is what locks the studs into the panel, so that what comes out of the bed is one piece instead of a slab with loose steel lying on it. Pour to 2 in and you have poured a paving slab.



The red line is the top of the skin pour at 5 in. Everything between the finish face and that line is filled in one placement, including 1-1/2 in up the web of every stud.

Placing it

- 1** Check the pre-pour line on the traveler is signed. If it is not signed, nothing goes in the slot.
- 2** Batch only to the approved mix design. No water added for workability, ever, and no proportion changed at the bed.
- 3** Move the concrete from the mixer to the bed and place it without segregation and without a free fall that breaks the foam structure.
- 4** Fill the slot to 5 in.
- 5** Place continuously within a slot. A cold joint inside a panel is a nonconformance, so do not start a slot you cannot finish.
- 6** Consolidate only by the method written on the approved mix design. Do not vibrate it the way you would vibrate normal concrete: that collapses the foam and changes the density.
- 7** Screed to the edge forms and finish the top face.

The skin pour (continued)

STOP

The top face of the pour becomes the cavity side of the wall. The face against the liner is the interior finish face of somebody's house and it is **not worked after the pour**. Do not trowel it, do not touch it, do not walk on it.

Density and cylinders, while you place

- Fresh density at the point of placement: the first placement of every batch, then at least every 30 minutes while placing continues. Recorded on QF-09 Daily batch and density log.
- Concrete temperature and ambient temperature at the same frequency, on QF-09 Daily batch and density log.
- 3 by 6 in cylinders cast from the same placing stream, by the same method as the panel. Mark every cylinder with the batch number, the date, the mix, and the bed and slot, **before the concrete sets**. Cover them and leave them protected for at least 24 hours. Recorded on QF-10 Cylinder cast and break log.
- Weather at placement on QF-09 Daily batch and density log.

NOT SETTLED YET

[PE TO SET: the acceptance band around 35 pcf, and the acceptable concrete temperature range.] [PE TO SET: the cylinder sampling frequency, per batch, per bed cycle, per day or per cubic yard.] [PE TO SET: the design compressive strength at 28 days. No cylinder has been cast or broken for this product and no strength value exists.] [KEN TO CONFIRM: the placing and consolidation method, once the mixer and the pump are chosen, written into the mix design.]

When the density goes out of band

A density reading outside the band **stops placement**. Tell the QC inspector. The scale, the water meter and the foam nozzle get checked. Every panel that got concrete from that batch is identified by serial number, tagged, and held. A nonconformance report QF-22 Nonconformance report is raised and the quality manager dispositions it in writing.

Weather

Concrete is not mixed or placed during freezing weather, during rain or snow, or over standing water, snow or ice. If the temperature is going below 32 F within 8 hours of placing, the cold weather mix is used, not the normal one. Above 100 F, the hot weather provisions apply.

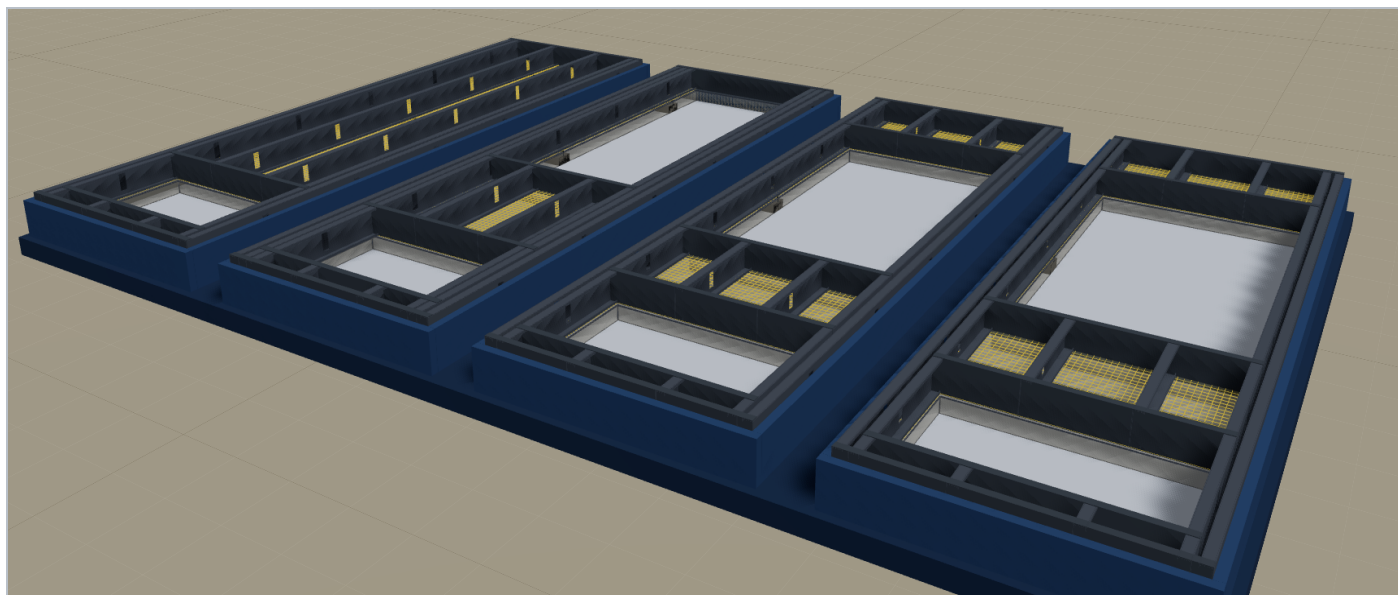
The skin pour (continued)

HOLD POINT

Pre-pour. Before any concrete goes in a slot, the QC inspector verifies the bed check, the steel, the mesh, the embedments and the inserts are all complete and signed, that the drawing on the floor is the current revision, and that the weather allows placing, and signs the pre-pour line on QF-13 Panel and unit traveler. **Concrete placed in a slot whose pre-pour line is unsigned makes every panel in that slot nonconforming**, because after the pour none of those checks can be made again. This hold is not waivable for production pressure.

SAFETY

Wet cellular concrete burns skin. It is strongly alkaline and the burn is slow, so it does not hurt while it is happening and you find out hours later. Gloves, long sleeves and eye protection for everyone in the placing crew. If it gets inside a boot or a glove, stop and wash it off. Do not let it sit against skin.



The bed filling slot by slot. The pour depth itself does not read in this view, which is why the section drawing above is the figure that matters on this sheet. Figure file: wall-02-skin-pour.png

THE RECORD YOU SIGN

QF-09 Daily batch and density log for every batch and every density and temperature reading. QF-10 Cylinder cast and break log for the cylinders. QF-12 Daily production log for the placement and finish. The pre-pour hold and the pour line on QF-13 Panel and unit traveler.