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USACE / NAVFAC / AFCEA UFGS-03100A (February 2004)  
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Preparing Activity: USACE Superseding  
UFGS-03100A (May 1998)

UNIFIED FACILITIES GUIDE SPECIFICATIONS

References are in agreement with UMLR dated 25 June 2004

Latest change indicated by CHG tags

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SECTION TABLE OF CONTENTS

DIVISION 03 - CONCRETE

SECTION 03100A

STRUCTURAL CONCRETE FORMWORK

02/04

PART 1 GENERAL

- 1.1 REFERENCES
- 1.2 SUBMITTALS
- 1.3 DESIGN
- 1.4 STORAGE AND HANDLING

PART 2 PRODUCTS

- 2.1 FORM MATERIALS
  - 2.1.1 Forms For Class A and Class B Finish
  - 2.1.2 Forms For Class C Finish
  - 2.1.3 Forms For Class D Finish
  - 2.1.4 Retain-In-Place Metal Forms
  - 2.1.5 Pan-Form Units
  - 2.1.6 Form Ties
  - 2.1.7 Form Releasing Agents
  - 2.1.8 Fiber Voids
- 2.2 FIBER VOID RETAINERS
  - 2.2.1 Polystyrene Rigid Insulation
  - 2.2.2 Precast Concrete

PART 3 EXECUTION

- 3.1 INSTALLATION
  - 3.1.1 Formwork
  - 3.1.2 Fiber Voids
  - 3.1.3 Fiber Void Retainers
- 3.2 CHAMFERING
- 3.3 COATING
- 3.4 REMOVAL OF FORMS

-- End of Section Table of Contents --

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SECTION 03100A

STRUCTURAL CONCRETE FORMWORK  
02/04

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NOTE: This guide specification covers the requirements for formwork for cast-in-place concrete and will be used with Section 03300 CAST-IN-PLACE STRUCTURAL CONCRETE. Formwork for architectural cast-in-place concrete is specified in Section 03330 CAST-IN-PLACE ARCHITECTURAL CONCRETE.

Comments and suggestions on this guide specification are welcome and should be directed to the technical proponent of the specification. A listing of technical proponents, including their organization designation and telephone number, is on the Internet.

Recommended changes to a UFGS should be submitted as a Criteria Change Request (CCR).

Use of electronic communication is encouraged.

Brackets are used in the text to indicate designer choices or locations where text must be supplied by the designer.

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PART 1 GENERAL

1.1 REFERENCES

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NOTE: Issue (date) of references included in project specifications need not be more current than provided by the latest guide specification. Use of SpecsIntact automated reference checking is recommended for projects based on older guide specifications.

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The publications listed below form a part of this specification to the extent referenced. The publications are referred to within the text by the

basic designation only.

ACI INTERNATIONAL (ACI)

ACI 347 (2001) Guide to Formwork for Concrete

AMERICAN HARDBOARD ASSOCIATION (AHA)

AHA A135.4 (1995) Basic Hardboard

ASTM INTERNATIONAL (ASTM)

ASTM C 578 (2003a) Rigid, Cellular Polystyrene  
Thermal Insulation

U.S. DEPARTMENT OF COMMERCE (DOC)

PS1 (1995) Construction and Industrial Plywood  
(APA V995)

## 1.2 SUBMITTALS

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NOTE: Submittals must be limited to those necessary for adequate quality control. The importance of an item in the project should be one of the primary factors in determining if a submittal for the item should be required.

A "G" following a submittal item indicates that the submittal requires Government approval. Some submittals are already marked with a "G". Only delete an existing "G" if the submittal item is not complex and can be reviewed through the Contractor's Quality Control system. Only add a "G" if the submittal is sufficiently important or complex in context of the project.

For submittals requiring Government approval on Army projects, a code of up to three characters within the submittal tags may be used following the "G" designation to indicate the approving authority. Codes for Army projects using the Resident Management System (RMS) are: "AE" for Architect-Engineer; "DO" for District Office (Engineering Division or other organization in the District Office); "AO" for Area Office; "RO" for Resident Office; and "PO" for Project Office. Codes following the "G" typically are not used for Navy projects.

Submittal items not designated with a "G" are considered as being for information only for Army projects and for Contractor Quality Control approval for Navy projects.

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Government approval is required for submittals with a "G" designation; submittals not having a "G" designation are [for Contractor Quality Control

approval.][for information only. When used, a designation following the "G" designation identifies the office that will review the submittal for the Government.] The following shall be submitted in accordance with Section 01330 SUBMITTAL PROCEDURES:

#### SD-02 Shop Drawings

Formwork[; G][; G, [\_\_\_\_\_]]

Drawings showing details of formwork, including dimensions of fiber voids, joints, supports, studding and shoring, and sequence of form and shoring removal.

#### SD-03 Product Data

##### Design

Design analysis and calculations for form design and methodology used in the design.

##### Form Materials

Manufacturer's data including literature describing form materials, accessories, and form releasing agents.

##### Form Releasing Agents

Manufacturer's recommendation on method and rate of application of form releasing agents.

#### SD-04 Samples

Fiber Voids[; G][; G, [\_\_\_\_\_]]

One sample unit of fiber voids prior to installation of the voids.

#### SD-07 Certificates

##### Fiber Voids

Certificates attesting that fiber voids conform to the specified requirements.

### 1.3 DESIGN

Formwork shall be designed in accordance with methodology of ACI 347 for anticipated loads, lateral pressures, and stresses. Forms shall be capable of producing a surface which meets the requirements of the class of finish specified in Section 03300A CAST-IN-PLACE STRUCTURAL CONCRETE. Forms shall be capable of withstanding the pressures resulting from placement and vibration of concrete.

### 1.4 STORAGE AND HANDLING

Fiber voids shall be stored above ground level in a dry location. Fiber voids shall be kept dry until installed and overlaid with concrete.

## PART 2 PRODUCTS

### 2.1 FORM MATERIALS

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**NOTE: This paragraph should be edited to reflect project requirements. Description of classes of finish are contained in Section 03300 CAST-IN-PLACE STRUCTURAL CONCRETE.**  
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#### 2.1.1 Forms For Class A and Class B Finish

Forms for Class A and Class B finished surfaces shall be plywood panels conforming to PS1, Grade B-B concrete form panels, Class I or II. Other form materials or liners may be used provided the smoothness and appearance of concrete produced will be equivalent to that produced by the plywood concrete form panels. Forms for round columns shall be the prefabricated seamless type.

#### 2.1.2 Forms For Class C Finish

Forms for Class C finished surfaces shall be shiplap lumber; plywood conforming to PS1, Grade B-B concrete form panels, Class I or II; tempered concrete form hardboard conforming to AHA A135.4; other approved concrete form material; or steel, except that steel lining on wood sheathing shall not be used. Forms for round columns may have one vertical seam.

#### 2.1.3 Forms For Class D Finish

Forms for Class D finished surfaces, except where concrete is placed against earth, shall be wood or steel or other approved concrete form material.

#### 2.1.4 Retain-In-Place Metal Forms

Retain-in-place metal forms for concrete slabs and roofs shall be as specified in Section 05310 STEEL DECKS.

#### 2.1.5 Pan-Form Units

Pan-form units for one-way or two-way concrete joist and slab construction shall be factory-fabricated units of the approximate section indicated. Units shall consist of steel or molded fiberglass concrete form pans. Closure units shall be furnished as required.

#### 2.1.6 Form Ties

Form ties shall be factory-fabricated metal ties, shall be of the removable or internal disconnecting or snap-off type, and shall be of a design that will not permit form deflection and will not spall concrete upon removal. Solid backing shall be provided for each tie. Except where removable tie rods are used, ties shall not leave holes in the concrete surface less than 6 mm 1/4 inch nor more than 25 mm 1 inch deep and not more than 25 mm 1 inch in diameter. Removable tie rods shall be not more than 38 mm 1-1/2 inches in diameter.

#### 2.1.7 Form Releasing Agents

Form releasing agents shall be commercial formulations that will not bond with, stain or adversely affect concrete surfaces. Agents shall not impair subsequent treatment of concrete surfaces depending upon bond or adhesion nor impede the wetting of surfaces to be cured with water or curing compounds.

#### 2.1.8 Fiber Voids

Fiber voids shall be the product of a reputable manufacturer regularly engaged in the commercial production of fiber voids. The voids shall be constructed of double faced, corrugated fiberboard. The corrugated fiberboard shall be fabricated of [wet strength] [standard kraft] paper liners, impregnated with paraffin, and laminated with moisture resistant adhesive, and shall have a board strength of 20 kg per square centimeter 275 psi. Voids which are impregnated with paraffin after construction, in lieu of being constructed with paraffin impregnated fiberboard, are acceptable. Voids shall be designed to support not less than 4900 kg per square meter 1000 psf. To prevent separation during concrete placement fiber voids shall be assembled with steel or plastic banding at 1.22 m 4 feet on center maximum, or by adequate stapling or gluing as recommended by the manufacturer. Fiber voids placed under concrete slabs and that are 200 mm 8 inches in depth may be heavy duty "waffle box" type, constructed of paraffin impregnated corrugated fiberboard.

### 2.2 FIBER VOID RETAINERS

#### 2.2.1 Polystyrene Rigid Insulation

Polystyrene rigid insulation shall conform to ASTM C 578, Type V, VI, or VII, square edged. Size shall be 38 mm 1-1/2 inches thick by 400 mm 16 inches in height by 1 m 3 feet in length, unless otherwise indicated.

#### 2.2.2 Precast Concrete

Precast concrete units shall have a compressive strength of not less than 17 MPa 2500 psi, reinforced with 150 mm by 150 mm by W1.4 WWF 6 inch by 6 inch by W1.4 WWF wire mesh, and 300 mm (height) by 1 m (length) by 40 mm (thickness) 12 inches (height) by 3 feet (length) by 1-5/8 inches (thickness) in size unless indicated.

## PART 3 EXECUTION

### 3.1 INSTALLATION

#### 3.1.1 Formwork

Forms shall be mortar tight, properly aligned and adequately supported to produce concrete surfaces meeting the surface requirements specified in Section 03300A CAST-IN-PLACE STRUCTURAL CONCRETE and conforming to construction tolerance given in TABLE 1. Where concrete surfaces are to have a Class A or Class B finish, joints in form panels shall be arranged as approved. Where forms for continuous surfaces are placed in successive units, the forms shall fit over the completed surface to obtain accurate alignment of the surface and to prevent leakage of mortar. Forms shall not be reused if there is any evidence of surface wear and tear or defects which would impair the quality of the surface. Surfaces of forms to be reused shall be cleaned of mortar from previous concreting and of all other

foreign material before reuse. Form ties that are to be completely withdrawn shall be coated with a nonstaining bond breaker.

#### 3.1.2 Fiber Voids

Voids shall be placed on a smooth firm dry bed of suitable material, to avoid being displaced vertically, and shall be set tight, with no buckled cartons, in order that horizontal displacement cannot take place. Each section of void shall have its ends sealed by dipping in paraffin, with any additional cutting of voids at the jobsite to be field dipped in the same type of sealer, unless liners and flutes are completely impregnated with paraffin. Prior to placing reinforcement, the entire formed area for slabs shall be covered with a 1.22 x 2.44 m 4 x 8 feet minimum flat sheets of fiber void corrugated fiberboard. Joints shall be sealed with a moisture resistant tape having a minimum width of 75 mm 3 inches. If voids are destroyed or damaged and are not capable of supporting the design load, they shall be replaced prior to placing of concrete.

#### 3.1.3 Fiber Void Retainers

Fiber void retainers shall be installed, continuously, on both sides of fiber voids placed under grade beams in order to retain the cavity after the fiber voids biodegrade.

#### 3.2 CHAMFERING

Except as otherwise shown, external corners that will be exposed shall be chamfered, beveled, or rounded by moldings placed in the forms.

#### 3.3 COATING

Forms for Class A and Class B finished surfaces shall be coated with a form releasing agent before the form or reinforcement is placed in final position. The coating shall be used as recommended in the manufacturer's printed or written instructions. Forms for Class C and D finished surfaces may be wet with water in lieu of coating immediately before placing concrete, except that in cold weather with probable freezing temperatures, coating shall be mandatory. Surplus coating on form surfaces and coating on reinforcing steel and construction joints shall be removed before placing concrete.

#### 3.4 REMOVAL OF FORMS

Forms shall be removed preventing injury to the concrete and ensuring the complete safety of the structure. Formwork for columns, walls, side of beams and other parts not supporting the weight of concrete may be removed when the concrete has attained sufficient strength to resist damage from the removal operation but not before at least 24 hours has elapsed since concrete placement. Supporting forms and shores shall not be removed from beams, floors and walls until the structural units are strong enough to carry their own weight and any other construction or natural loads. Supporting forms or shores shall not be removed before the concrete strength has reached 70 percent of design strength, as determined by field cured cylinders or other approved methods. This strength shall be demonstrated by job-cured test specimens, and by a structural analysis considering the proposed loads in relation to these test strengths and the strength of forming and shoring system. The job-cured test specimens for form removal purposes shall be provided in numbers as directed and shall be in addition to those required for concrete quality control. The specimens

shall be removed from molds at the age of 24 hours and shall receive, insofar as possible, the same curing and protection as the structures they represent.

TABLE 1

TOLERANCES FOR FORMED SURFACES

1.	Variations from the plumb:	In any 3 m of length ----- 6 mm
a.	In the lines and surfaces of columns, piers, walls and in arises	Maximum for entire length -- 25 mm
b.	For exposed corner columns, control-joint grooves, and other conspicuous lines	In any 6 m of length ----- 6 mm Maximum for entire length 13 mm
2.	Variation from the level or from the grades indicated on the drawings:	In any 3 m of length ----- 6 mm In any bay or in any 6 m of length ----- 10 mm
a.	In slab soffits, ceilings beam soffits, and in arises, measured before removal of supporting shores	Maximum for entire length - 20 mm
b.	In exposed lintels, sills, parapets, horizontal grooves, and other conspicuous lines	In any bay or in any 6 m of length ----- 6 mm Maximum for entire length - 13 mm
3.	Variation of the linear building lines from established position in plan	In any 6 m ----- 13 mm Maximum ----- 25 mm
4.	Variation of distance between walls, columns, partitions	6 mm per 3 m of distance, but not more than 13 mm in any one bay, and not more than 25 mm total variation
5.	Variation in the sizes and locations of sleeves, floor openings, and wall opening	Minus ----- 6 mm Plus ----- 13 mm
6.	Variation in cross-sectional dimensions of columns and beams and in the thickness of slabs and walls	Minus ----- 6 mm Plus ----- 13 mm



TABLE 1

TOLERANCES FOR FORMED SURFACES

## 7. Footings:

- |    |                                 |  |
|----|---------------------------------|--|
| a. | Variation of dimensions in plan | Minus ----- 13 mm<br>Plus ----- 50 mm<br>when formed or plus 75 mm when placed against unformed excavation |
| b. | Misplacement of eccentricity    | 2 percent of the footing width in the direction of misplacement but not more than ----- 50 mm              |
| c. | Reduction in thickness          | Minus ----- 5 percent of specified thickness   |

## 8. Variation in steps:

- |    |                       |                                      |
|----|-----------------------|--------------------------------------|
|    |                       | Riser ----- 3 mm                     |
| a. | In a flight of stairs | Tread ----- 6 mm                     |
| b. | In consecutive steps  | Riser ----- 2 mm<br>Tread ----- 3 mm |

TABLE 1

TOLERANCES FOR FORMED SURFACES

- |    |  |  |
|----|--|--|
| 1. | Variations from the plumb:   | In any 10 feet of length ----- 1/4 inch  |
| a. | In the lines and surfaces of columns, piers, walls and in arises                                     | Maximum for entire length ----- 1 inch   |
| b. | For exposed corner columns, control-joint grooves, and other conspicuous lines                       | In any 20 feet of length ----- 1/4 inch<br>Maximum for entire length ----- 1/2 inch              |
| 2. | Variation from the level or from the grades indicated on the drawings:                               | In any 10 feet of length ----- 1/4 inch<br>In any bay or in any 20 feet of length ----- 3/8 inch |
| a. | In slab soffits, ceilings, beam soffits, and in arises, measured before removal of supporting shores | Maximum for entire length ----- 3/4 inch   |
| b. | In exposed lintels, sills, parapets,   | In any bay or in any 20 feet of length ----- 1/4 inch  |

TABLE 1

TOLERANCES FOR FORMED SURFACES

horizontal grooves, and other conspicuous lines	Maximum for entire length----- 1/2 inch
3. Variation of the linear building lines from established position in plan	In any 20 feet ----- 1/2 inch Maximum -----1 inch
4. Variation of distance between walls, columns, partitions	1/4 inch per 10 feet of distance, but not more than 1/2 inch in any one bay, and not more than 1 inch total variation
5. Variation in the sizes and locations of sleeves, floor openings, and wall opening	Minus ----- 1/4 inch Plus ----- 1/2 inch
6. Variation in cross-sectional dimensions of columns and beams and in the thickness of slabs and walls	Minus ----- 1/4 inch Plus ----- 1/2 inch
7. Footings:	
a. Variation of dimensions in plan	Minus ----- 1/2 inch Plus ----- 2 inches when formed or plus 3 inches when placed against unformed excavation
b. Misplacement of eccentricity	2 percent of the footing width in the direction of misplacement but not more than 2 inches
c. Reduction in thickness of specified thickness	Minus ----- 5 percent
8. Variation in steps:	Riser ----- 1/8 inch
a. In a flight of stairs	Tread ----- 1/4 inch
b. In consecutive steps	Riser ----- 1/16 inch Tread ----- 1/8 inch
-- End of Section --	