

Table of Contents

Chapter 1 - Introduction		
1.1	A Brief Overview of the Product.	2
1.2	The Size of the Industry.	6
1.3	The Cause and effect of Abrasion.	6
1.4	Motivation for this Research.	7
1.4.1	The problems facing the industry may be summarised as follows	7
1.5	Aim	8
1.6	Objectives	8
1.6.1	Objective 1 - Improving the mix design.	9
1.6.2	Objective 2 - Recommending an abrasion test	11
1.6.3	Objective 3 - Classification of abrasion	11
1.6.4	Objective 4 - "Calibrating" the abrasion test and mix designs relative to actual. wear on site	12
1.6.5	Objective 5 – Abrasion resistance quality assurance	12
1.6.6	Objective 6 – Recommending changes to compressive strength test	12
1.7	Summary	13
Chapter 2 - Background		
2.1	Preview of Chapter	2
2.2	The Evolution of Cbp – from Ancient Stones to Precisely Shaped Concrete.	2
2.3	Survey of Cbp's Most Important Attributes	5
2.3.1	Economic Advantages	4
2.3.2	The waterproofing aspect of cbp	6
2.3.3	The structural Aspect of Cbp	8
2.3.4	Aesthetics	9
2.3.5	Abrasion Resistance	12
2.4	Survey of Current Research Undertaken into Abrasion Resistance of Cbp	14
2.4.1	Northern Hemisphere	15
2.4.2	Southern Hemisphere	20
2.5	South Africa	23
2.5.1	Problematic Compressive Strength Criteria	23
2.5.2	Selection of abrasion tests	24
2.5.3	Other Abrasion Tests	26
2.5.4	The Test Programme	26
2.6	Summary of Concluding Remarks	27
Chapter 3 - Manufacturing Controls and Procedure		
3.1	Introduction	2
3.2	Good Practice in Cbp Manufacture	2
3.2.1	Type of Material	2
3.2.2	Mix Proportions	2
3.2.3	Dosing and Mixing	2
3.2.4	Machine settings	3
3.2.5	Curing and packaging	3
3.3	Procedure Followed in the Production of 'BC100' cbp specimens	3
3.3.1	Storage of raw materials	5
3.3.2	Weighing	5
3.3.3	Loading	5
3.3.4	Mixing	6
3.3.5	Filling and moulding	6
3.3.6	Initial curing and storage	7
3.3.7	Marking and packaging	7
3.3.8	Storage and final curing	7

3.3.9	Despatch	8
3.4	Summary and Conclusion	8
Chapter 4 - Laboratory Testing		
4.1	Introduction	2
4.1.1	Age at testing.	3
4.1.2	Organisation of chapter.	4
4.2	Compressive Strength to SABS 1058 – 1985.	4
4.3	Compressive Strength to ASTM C140.	5
4.4	Compressive Strength to MA20-1986.	7
4.5	Tensile Splitting to ISO 4108.	8
4.6	Abrasion Resistance to Wire Brush Method.	10
4.6.1	"Wire-dial" method.	12
4.6.2	"Wire-vern" method.	13
4.6.3	"Wire-clay" method.	13
4.7	Abrasion Resistance to ASTM C418.	14
4.8	Abrasion Resistance to MA20 (or MA20SA).	18
4.9	Water Absorption to ASTM C140 and Dry Density to ASTM C642.	23
4.10	Initial Surface Absorption Test to SABS 0164 (ISAT).	23
4.11	Water Content.	24
4.11.1	Drying at 100 ^o C.	26
4.11.2	Firing at 1000 ^o C.	26
4.11.3	Sugar method.	26
4.11.4	Calcium carbide method.	27
4.12	Conclusion	28
Chapter 5 - Site Testing		
5.1	Introduction	2
5.2	Paving at Westgate	2
5.3	Estimation of Wear	6
5.3.1	Visual interpretation – photographs.	6
5.3.1.1	Experimental Procedure	7
5.3.2	Depth Gauge Measurements.	11
5.3.2.1	Experimental Procedure	12
5.3.3	Syringe method -abrasion expressed in terms of volume.	14
5.3.3.1	Description of Test	14
5.3.3.2	Apparatus	14
5.3.3.3	Site Measurements	14
5.3.4	Determination of Mass Loss	16
5.3.4.1	Experimental Procedure	16
5.4	Summary	17
Chapter 6 - The Effects of Water Content, Binder Content and Binder Type on the Strength of Cbp		
6.1	Introduction	2
6.2	Water Content.	6
6.2.1	Conductivity Meter.	6
6.2.2	Calcium Carbide.	7
6.2.3	Drying at 100 ^o C.	7
6.2.4	Firing at 1000 ^o C.	7
6.2.5	Sugar Method.	8
6.3	Density	9
6.3.1	The influence of density on compressive strength.	10
6.3.2	The influence of density on tensile splitting strength (tss).	15
6.3.3	The influence of density on abrasion resistance.	18
6.4	Binder Content.	24

6.4.1	The Influence of Binder Content on Compressive Strength	24
6.4.2	The Influence of Binder Content on Tensile Splitting Strength.	27
6.4.3	The Influence of Binder Content on Abrasion Resistance	29
6.4.3.1	Relative Sensitivity of the three abrasion test	31
6.4.4.	The Combined Influence of Binder Content and Moisture Content on Abrasion Resistance	32
6.4.3.2	Observation and Discussion	31
6.4.4	The Combined Influence of Binder Content and Moisture Content on Abrasion Resistance	32
6.5	Binder Type.	32
6.5.1	The influence of binder type on compressive strength.	35
6.5.2	The influence of binder type on tensile splitting strength.	38
6.5.3	The influence of binder type on the abrasion resistance.	39
6.6	Summary and Conclusions.	43
6.6.1	Water content.	43
6.6.2	Binder content.	43
6.6.3	Binder type.	45
6.6.4	Relative importance of water content, binder content, and binder type.	45
6.7	Practical Implications for the Industry.	47
Chapter 7 - Compressive Strength Tests		
7.1	Introduction	2
7.1.1	Preview of Chapter	2
7.1.2	Relationship and Correlation between Abrasion Resistance and Compressive Strength	2
7.1.3	Rationale for Compression Testing	3
7.1.4	Scope for Testing	4
7.2	Relative Performance of the Three Tests	6
7.2.1	Mean Quality	6
7.2.2	Relationship between compressive strength tests.	7
7.3	Differences in the Three Compression Tests	10
7.3.1	Aspect Ratio	10
7.3.2	The Area used in the Calculation.	11
7.3.3	Specified compressive strength	12
7.3.4	Soaking	12
7.3.5	Capping	13
7.3.6	Summary of differences	14
7.4	Coefficients of variation	16
7.5	Revision of SABS 1058.	16
7.5.1	Aspect ratio correction.	16
7.5.2	Gross plan area.	16
7.5.3	Dry testing.	17
7.5.4	Higher limits.	17
7.6	Summary, Conclusion and Recommendations	19
Chapter 8 - Classification of Abrasion		
8.1	The Need for a Classification.	2
8.2	Degrees of Abrasion.	3
8.2.1	Zero Degree Abrasion.	6
8.2.2	First-Degree Abrasion.	12
8.2.3	Second-Degree Abrasion.	18
8.2.4	Third-Degree Abrasion.	24
8.2.5	Fourth-Degree Abrasion.	29
8.2.6	Acceptable distribution of degrees of wear.	35
8.3	Binder Strength.	36
8.3.1	Weak binders.	36

8.3.2.	Strong Binders.	36
8.4	Measurement of Abrasion.	37
8.4.1.	Depth gauge method.	37
8.4.2.	Syringe method.	37
8.4.3.	Calibration of depth gauge and syringe methods.	37
8.4.4.	Interpretation of wear in terms of mvd (figure 8.50).	39
8.4.5.	Interpretation of wear in terms of mcd (figure 8.50).	41
8.5	Classification of Cbp in terms of Degrees of Abrasion.	43
8.5.1.	Interpretation of classification.	43
8.5.2	This classification will be useful to:.	45
8.6	CMA Abrasion Programme.	46
8.7	Abrasion in Other Surfaces.	48
8.8	Summary and Conclusion.	51
Chapter 9 - Critical Evaluation of MA20 Abrasion Test		
9.1	Introduction	2
9.2	Description of Test.	2
9.3	Historical Background.	3
9.4	Wear Mechanism of MA20 Abrasion Test.	5
9.4.1	Rolling	5
9.4.2	Impact	8
9.4.3	Sliding	9
9.4.4	Attack on Aggregate/Paste Bond	10
9.5	Expression of MA20 Laboratory results in September 1987.	12
9.5.1	Expressing MA20 results as a function of depth.	12
9.5.2	Expressing MA20 as a function of volume.	18
9.5.2.1	Advantages of Expressing Abrasion Wear as a Function of Volume	20
9.5.2.2	A theoretical model of wear in terms of volume	21
9.5.3	Sectional Conclusion	22
9.6	Abrasion Indices.	23
9.6.1	I_{MA20} - the Official MA20 Index	23
9.6.2	I_{INT} - the Integer Index	24
9.6.3	The n_{log} index	25
9.6.4	n_{vol} - an index based on the slope of the V versus P graph	30
9.6.5	P_{5000} - an index based on the abraded depth of the groove	31
9.6.6	V_{5000} - an index based on the abraded volume of the groove	31
9.6.7	Critical evaluation of the abrasion indices	32
9.7	The Variability of the MA20 Test.	39
9.7.1	Mean of five samples.	39
9.7.2	Misalignment	39
9.7.3	Worn bearings.	40
9.7.4	Secondary factors.	41
9.7.5	Discussion	41
9.8	Limiting Criteria.	43
9.9	MA20SA specification.	43
9.9.1	Soaking	43
9.9.2	Number of balls.	43
9.9.3	Construction of Bearing.	44
9.9.4	Heavier apparatus.	44
9.9.5	Better guide system.	45
9.9.6	Different fastening system.	45
9.9.7	Depth of penetration.	45
9.9.8	Hardness of bearings	45
9.9.9	CMA20 Tests.	45

9.10	Strengths and Weaknesses of MA20 Abrasion Test	46
9.10.1	Fast	46
9.10.2	Severe	46
9.10.3	Surface test.	46
9.10.4	Capital expenditure.	47
9.10.5	Portable.	47
9.10.6	Similar to existing tests.	47
9.10.7	Economic.	48
9.10.8	Reproducibility	48
9.10.9	Sensitivity	48
9.10.10	Aggregate component.	49
9.11	Summary, Conclusion and Recommendation	50
Chapter 10 - Critical Evaluation of Wire-brush Abrasion Test		
10.1	Background, Introduction, and Overview	2
10.2	Historical Background.	2
10.3	Description of Test.	5
10.4	Wear Mechanisms of Wire-brush Abrasion Test.	6
10.4.1	Shearing of Squat Asperities	6
10.4.2	Shearing or Snapping-off of Tall Asperities	7
10.4.3	Aggregate loss	8
10.4.4	Crushing	9
10.4.5	What other Authors say	9
10.4.6	Typical Applications	9
10.4.7	Sectional Conclusion	10
10.5	Results of Laboratory Tests September 1987.	11
10.5.1	Results of wire-dial readings.	11
10.5.2	Results of wire-vern method.	14
10.5.3	Results of wire-clay method.	14
10.6	Abrasion Indices.	15
10.6.1	Wire-dial index.	15
10.6.2	Wire-vern index.	16
10.6.3	Wire-clay index.	16
10.6.4	Critical evaluation of indices.	16
10.7	Limiting Criteria.	21
10.8	The Variability of the Wire-brush Test.	22
10.8.1	Type of brush.	22
10.8.2	Age of brush.	22
10.8.3	Measurement of depth.	23
10.9	Strengths and Weaknesses of Wire-brush Test.	24
10.9.1	Fast	24
10.9.2	Moderately severe.	24
10.9.3	Capital outlay.	24
10.9.4	Portable	24
10.9.5	Cost of abrasive.	24
10.9.6	Unique test.	25
Chapter 11 - Critical Evaluation of ASTM C418 Abrasion Test		
11.1	Introduction and Overview	1
11.2	Historical review.	3
11.3	Description of the Test.	4
11.3.1	Test procedure and apparatus.	4
11.3.2	Abrasion Index.	5

11.3.3	Limiting Criteria.	5
11.4	Wear Mechanism of ASTM C418 Abrasion Test	6
11.5	Results of Laboratory Tests done in Sept. 1987	9
11.6	Variability	10
11.6.1	Correlation of ASTM C418 with compressive strength results.	10
11.7	Strengths and Weaknesses of ASTM C418 Abrasion Test	13
11.7.1	Relatively slow.	13
11.7.2	Very severe.	13
11.7.3	Capital expenditure.	13
11.7.4	Portable	13
11.7.5	Cost of Abrasive.	13
11.7.6	Standard test.	14
11.7.7	Reproducibility	14
11.7.8	Sensitivity.	14
11.7.9	Simulation of wear effects.	15
11.7.10	Effect of Aggregate size	15
11.7.11	Surface measurement	16
11.8	Summary and Conclusion.	17
Chapter 12 - Comparison of Abrasion Tests		
12.1	Introduction	2
12.2	Critical Comparison of the Three Abrasion Tests.	2
12.2.1	Age of test.	4
12.2.2	International stature.	5
12.2.3	Capital expenditure.	6
12.2.4	Cost of abrasive.	7
12.2.5	Cost of Labour.	8
12.2.6	Simplicity	9
12.2.7	Limiting criteria.	9
12.2.8	Surface information from wear-duration curves.	10
12.2.9	Simulation of appearance.	11
12.2.10	Simulation of 'crushing'.	13
12.2.11	Simulation of 'shearing' .	13
12.2.12	Wear with respect to volume.	14
12.2.13	Sensitivity	19
12.2.14	Correlation with respect to compressive strength.	21
12.2.15	Wear with respect to depth.	21
12.2.16	Severity	22
12.2.17	Surface measurement.	22
12.2.18	Compatibility – Lab Testing.	23
12.2.19	Compatibility in-situ Testing.	23
12.2.20	Repeatability	24
12.2.21	Reproducibility	28
12.2.22	Aggregate hardness.	29
12.2.23	Abrasive obtainability.	30
12.2.24	Relationship with in-situ wear.	31
12.3	Conclusion and Recommendations.	32
Chapter 13 - Water Absorption in Cbp		
13.1	Introduction	2
13.1.1	Literature survey	2
13.1.2	Scope and rationale	3
13.2	Description of Tests	4
13.2.1	ASTM C140	4
13.2.2	SABS 0164.	4
13.3	Laboratory Test Results - 1987	5

13.3.1	Relationship between absorption and density.	7
13.3.2	Correlation of water absorption with density and compressive strength	10
13.3.3	Correlation of water absorption with abrasion resistance.	13
13.3.4	Relationship between water absorption and water content.	17
13.3.4.1	Water absorption to ASTM C140	19
13.3.4.2	Initial surface absorption to SABS 0164	20
13.4	Strengths and Weaknesses of Water Absorption Tests	21
13.5	Conclusion	22
Chapter 14 - Correlation of Mix Designs and Laboratory Tests with Wear on Site		
14.1	Introduction and Overview.	2
14.2	6-year wear at Westgate.	4
14.2.1	Mean visible depth vs mean crater depth at 5½ years.	4
14.2.2	A Visual Appreciation of Abrasion Wear at 5½ years.	7
14.2.3	Relationship between wear in the sidewalk and bus lane - at 6-years	9
14.2.4	Degrees of abrasion	10
14.3	Degree of Correlation between Laboratory Tests and Measured Wear.	12
14.4	Relationship Between Surface Tests and Wear for Individual Mix Designs.	22
14.4.1	The effect of variations in binder content on the mvd considering each of the three mix designs (mix 1, mix 2, mix 3) individually and collectively.	22
14.4.2	Limiting criteria for the three abrasion tests, considering mixes 1, 2 and 3 (same binder type).	31
14.4.3	The effect of variations in binder type on the mvd, considering each of the five mix designs individually	36
14.5	The MA20SA Test.	45
14.6	Design Graphs.	45
14.6.1	How to read and interpret the monograms	46
14.7	Summary and Conclusion.	51
Chapter 15 - Designing for Improved Abrasion Resistance		
15.1	Introduction and Overview.	2
15.2	Limitations of Design Graphs.	2
15.2.1	Inconsistent indices for 28 day MA20SA test.	2
15.2.2	Limited number of design graphs	5
15.2.3	The local manufacturing environment.	5
15.2.4	Abrasion Test	6
15.3	Mix Design Selection Chart.	7
15.3.1	Overview	7
15.3.2	Interpretation of Table 15.2	7
15.3.3	Explanatory notes on table 15.2	7
15.3.3.1	Water content.	9
15.3.3.2	Binder content.	9
15.3.3.3	Binder type.	9
15.3.3.4	Aggregate	10
15.3.3.5	Curing and process control.	10
15.3.4	Limitations	10
15.4	Local and National Limits for Abrasion Test.	11
15.5	Design Approach and Quality Assurance.	14
15.5.1	Traffic loadings.	14
15.5.2	Degree of abrasion.	14
15.5.3	Selection of Manufacturer	14

15.5.4	Mix design selection.	15
15.5.5	Manufacturing controls	16
15.5.6	Testing of newly de-moulded pavers	16
15.5.6.1	Density measurements	16
15.5.6.2	Finger test	17
15.5.6.3	Papenfus's penetrometer	17
15.5.6.4	24 Hour testing	18
15.5.7	Curing	18
15.5.8	Verification	18
15.5.9	Despatch	19
15.5.10	Flowchart	19
15.6	Summary and Conclusion	24
Chapter 16 - Summary, Conclusion and Recommendations		
16.1	Introduction	2
16.2	Review of Objectives	3
16.2.1	Objective 1 – to Improve the mix designs from which the blocks are made	3
16.2.2	Objective 2 – To recommend an abrasion test to ensure that standards are maintained	4
16.2.3	Objective 3 – To Classify abrasion wear in terms of quantifiable 'degrees of abrasion'. To classify cbp applications in terms of these degrees of abrasion (chapter 8.)	5
16.2.4	Objective 4 – 'Calibrating'. (a) Correlating the results of the 28 day abrasion tests (done in the laboratory in 1987) with the observed six year wear on site (recorded in 1993). Establishing limiting criteria for the tests. (b) 'Calibration' of mix designs in terms of six year site abrasion	5
16.2.5	Objective 5 - Recommending an overall abrasion resistance quality assurance programme	6
16.2.6	Objective 6 – Highlighting shortcomings in the compressive strength test method as described in SABS 1058, and recommending suitable changes (chapter 7).	7
16.3	Recommendations for further work.	8
16.3.1	The effect of aggregate on abrasion resistance.	8
16.3.2	The effect of curing on abrasion resistance.	9
16.3.3	The effect of surface hardeners.	9
16.3.4	Determination of Mass Loss.	9
16.4	Ongoing CMA Research	11
16.4.1	Limiting criteria.	11
16.4.2	Tests on old pavers.	11
16.4.3	Tests on clay pavers.	11
16.4.4	Masonique concrete pavers.	12
16.4.5	CMA abrasion wear test sites.	12
16.4.6	Further CMA abrasion wear test site.	13
16.4.7	Sectional Conclusion	13
16.5	Closing Remarks	14