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Testing hardened concrete

Part 1: Shape, dimensions and other requirements for specimens and moulds

National foreword

This British Standard is the UK implementation of EN 12390-1:2021 and supersedes BS EN 12390-1:2012, which is withdrawn.

The UK participation in its preparation was entrusted to Technical Committee B/517/1, Concrete production and testing.

A list of organizations represented on this committee can be obtained on request to its committee manager.

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Published by BSI Standards Limited 2021

ISBN 978 0 539 05351 7

ICS 91.100.30

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This British Standard was published under the authority of the Standards Policy and Strategy Committee on 31 July 2021.

Amendments/corrigenda issued since publication

Date	Text affected
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EUROPEAN STANDARD

EN 12390-1

NORME EUROPÉENNE

EUROPÄISCHE NORM

July 2021

ICS 91.100.30

Supersedes EN 12390-1:2012

English Version

Testing hardened concrete - Part 1: Shape, dimensions
and other requirements for specimens and moulds

Essais pour béton durci - Partie 1 :
Forme, dimensions et autres exigences
aux éprouvettes et aux moules

Prüfung von Festbeton - Teil 1: Form, Maße und
andere Anforderungen für Probekörper und Formen

This European Standard was approved by CEN on 7 June 2021.

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European foreword

This document (EN 12390-1:2021) has been prepared by Technical Committee CEN/TC 104 "Concrete and related products", the secretariat of which is held by SN.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by January 2022, and conflicting national standards shall be withdrawn at the latest by January 2022.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. CEN shall not be held responsible for identifying any or all such patent rights.

This document supersedes [EN 12390-1:2012](#).

The following amendments have been made to the former edition:

- editorial revision;
- increases in the allowable tolerances for flatness of moulds and the dimensions of the specimens which reflect current industry practice.

This document is one of a series on testing concrete.

EN 12390, *Testing hardened concrete*, consists of the following parts:

- *Part 1: Shape, dimensions and other requirements for specimens and moulds;*
- *Part 2: Making and curing specimens for strength tests;*
- *Part 3: Compressive strength of test specimens;*
- *Part 4: Compressive strength – Specification for testing machines;*
- *Part 5: Flexural strength of test specimens;*
- *Part 6: Tensile splitting strength of test specimens;*
- *Part 7: Density of hardened concrete;*
- *Part 8: Depth of penetration of water under pressure;*
- *Part 10: Determination of the carbonation resistance of concrete at atmospheric levels of carbon dioxide;*
- *Part 11: Determination of the chloride resistance of concrete, unidirectional diffusion;*
- *Part 12: Determination of the potential carbonation resistance of concrete: Accelerated carbonation method;*
- *Part 13: Determination of secant modulus of elasticity in compression;*
- *Part 14: Semi-adiabatic method for the determination of heat released by concrete during its hardening process;*
- *Part 15: Adiabatic method for the determination of heat released by concrete during its hardening process;*
- *Part 16: Determination of shrinkage of concrete;*
- *Part 17: Determination of creep of concrete in compression;*
- *Part 18: Determination of the chloride migration coefficient (in preparation).*

This document recognizes alternative approaches towards obtaining test specimens of the correct sizes and shapes. The first is to use moulds whose lives are limited and to measure the specimens to ensure

conformity. The second is to cast specimens in calibrated metal moulds which meet tighter tolerances than for specimens. The use of calibrated moulds allows relaxation on the requirement for measuring the specimens.

[Annex A](#) gives the application of EN ISO 1101 to measuring the shapes of concrete test specimens and moulds.

[Annex B](#) gives a method to measure the flatness of specimens and moulds.

Any feedback and questions on this document should be directed to the users' national standards body. A complete listing of these bodies can be found on the CEN website.

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1 Scope

This document specifies the shapes, dimensions and tolerances of cast concrete test specimens in the form of cubes, cylinders and prisms, and of the moulds required to produce them.

NOTE The tolerances specified in this document are based on the needs of strength testing, but they can be applicable to tests for other properties.

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

EN ISO 1101, *Geometrical product specifications (GPS) - Geometrical tolerancing - Tolerances of form, orientation, location and run-out* (ISO 1101)

[EN 206](#), *Concrete - Specification, performance, production and conformity*

3 Terms and definitions

For the purposes of this document, the terms and definitions given in EN ISO 1101 and the following apply.

ISO and IEC maintain terminological databases for use in standardization at the following addresses:

- IEC Electropedia: available at <https://www.electropedia.org/>
- ISO Online browsing platform: available at <https://www.iso.org/obp>

3.1

nominal size

commonly used description of specimen size

3.2

designated size

specimen size in millimetres, selected and declared by the user of this standard from amongst the allowed range of nominal sizes

4 Shape, dimensions and tolerances of specimens

4.1 General

For application of EN ISO 1101 to the measurement of concrete test specimens and moulds in respect to flatness, perpendicularity and straightness, see [Annex A](#).

For each shape of test specimen, cube, cylinder and prism, the nominal size d ([Figures 1, 2 and 3](#)) should be chosen to be at least three and a half times the maximum aggregate size (D_{\max} according to [EN 206](#)) in the concrete.

4.2 Cubes

4.2.1 Nominal sizes

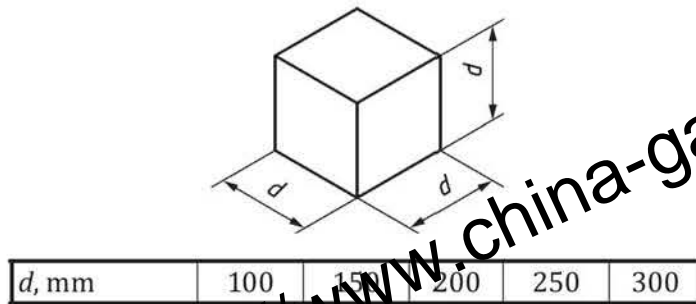


Figure 1 — Cube - nominal sizes

4.2.2 Designated sizes

Designated sizes may be selected within $\pm 10\%$ of the nominal size.

4.2.3 Tolerances

4.2.3.1 Between moulded surfaces the tolerance on the designated size (d) is 1,0 %.

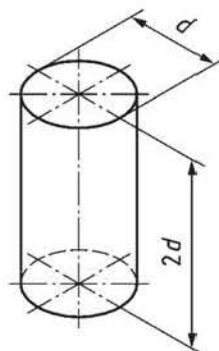
4.2.3.2 Between the top trowelled face and the moulded bottom face the tolerance on the designated size is 1,5 %.

4.2.3.3 The tolerance on the flatness of the potential load bearing surfaces is $0,000\ 6d$ mm (see [Annex B](#)).

4.2.3.4 The tolerance on the perpendicularity of the sides of the cube, with reference to the base, as cast, is 0,5 mm.

4.3 Cylinders

4.3.1 Nominal sizes



$d, \text{ mm}$	100	113 ^a	150	200	250	300
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Figure 2 — Cylinder - nominal size

4.3.2 Designated sizes

Designated sizes may be selected within $\pm 10\%$ of the nominal size.

4.3.3 Tolerances

4.3.3.1 The tolerance on the designated diameter (d) is 1,0 %.

4.3.3.2 The tolerance on the flatness of the load-bearing surface is $0,0006d$ mm (see [Annex B](#)).

4.3.3.3 The tolerance on the perpendicularity of the side, with reference to the end faces, is $0,007d$ mm.

4.3.3.4 The tolerance on the height ($2d$) is 5 %.

4.3.3.5 For specimens to be used for the tensile splitting strength test, the straightness tolerance on the generating line of the cylinder is 0,2 mm.

4.3.4 Applicability of tolerances

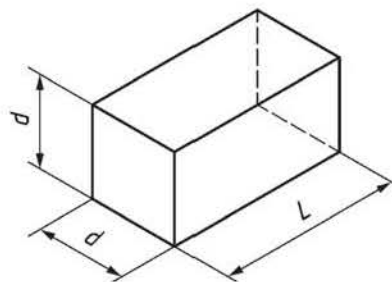
4.3.4.1 Specimens with moulded end faces, or with end faces adjusted by grinding, shall conform to [4.3.3](#).

4.3.4.2 Specimens with end faces adjusted using sulfur capping, high alumina cement capping, or similar capping shall conform to [4.3.3.1](#) before capping and to [4.3.3.2](#), [4.3.3.3](#) and [4.3.3.4](#) after capping.

4.3.4.3 Specimens with end faces adjusted using the sandbox method or similar methods shall conform to [4.3.3.1](#) and [4.3.3.4](#) before capping and to [4.3.3.3](#) after fixing the box(es).

4.4 Prisms

4.4.1 Nominal sizes



d , mm	70	100	150	200	250	300
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Figure 3 — Prism - nominal sizes

4.4.2 Designated sizes

Designated sizes (d) may be selected within $\pm 10\%$ of the nominal sizes.

4.4.3 Tolerances

4.4.3.1 Between moulded surfaces, the tolerance on the designated size (d) is 1,0 %.

4.4.3.2 Between the top trowelled face and the bottom moulded face, the tolerance on the designated size is 1,5 %.

4.4.3.3 The tolerance on the perpendicularity of the sides of the prism with reference to the base as cast, is 0,5 mm.

4.4.3.4 The tolerances on the straightness of the line on the surface to be in contact with the rollers in the flexural strength test is 0,3 mm.

4.4.3.5 For specimens to be used for the tensile splitting strength test, the straightness tolerance on the load bearing surface is 0,3 mm.

4.5 Measurement of dimensions and shape of specimens

4.5.1 Unless specimens have documentation to show that they had been made in calibrated moulds, they shall be measured or checked for conformity to [4.2](#), [4.3](#) or [4.4](#) as appropriate.

NOTE Go/no-go gauges or other suitable method can be used to check dimensions.

4.5.2 If specimens have documentation to show that they have been made in calibrated moulds, only the requirements of [4.2.3.1](#) and [4.2.3.2](#) or [4.3.3.1](#), [4.3.3.2](#) and [4.3.3.4](#) or [4.4.3.1](#), [4.4.3.2](#), for cubes, cylinder or prisms, respectively, shall be checked.

NOTE 1 Go/no-go gauges or other suitable method can be used to check dimensions.

NOTE 2 If a surface, calibrated with respect to flatness, is used to form the load bearing surface of cylinders, [4.3.3.2](#) need not be performed.

NOTE 3 Guidance on the measurement of flatness of load-bearing surfaces is given in [Annex B](#).

5 Moulds

5.1 General

Moulds shall be watertight and non-absorbent.

NOTE The joints of moulds can be coated with wax, oil or grease to achieve water-tightness.

Moulds, other than calibrated moulds in accordance with [5.2](#), may be made from any material which is suitable for producing concrete specimens.

5.2 Calibrated moulds

5.2.1 General

Calibrated moulds shall be made of steel or cast iron, which shall be the reference materials. If moulds are manufactured from other materials, in-use performance test data shall be available which demonstrates long-term equivalence with steel or cast iron calibrated moulds.

All parts of calibrated moulds shall be sufficiently robust to prevent distortion on assembly and in use.

The components of the mould, with the possible exception of the base plate, shall have identification marks.

5.2.2 Calibrated moulds for cubical specimens

5.2.2.1 Moulds shall be suitable for producing specimens conforming to [4.2](#).

5.2.2.2 The tolerance on the designated size (d) of an assembled mould is 0,5 %.

5.2.2.3 The tolerance on the flatness of the four side faces of the mould is $0,000\ 6d$ mm.

5.2.2.4 The tolerance on the flatness of the top surface of the baseplate of the moulds is $0,001d$ mm.

5.2.2.5 The tolerance on the perpendicularity of the sides of a mould with respect to the adjacent sides and of the sides in relation to the base is 0,5 mm.

NOTE If necessary, the flatness tolerance can be measured with the mould disassembled (see [Annex B](#)).

5.2.3 Calibrated moulds for cylindrical specimens

5.2.3.1 Moulds shall be suitable for producing specimens conforming to [4.3](#).

5.2.3.2 The tolerance on the designated diameter (d) and the designated height ($2d$) is 0,5 %.

5.2.3.3 The tolerance on the flatness of a base of a mould is $0,000\ 6d$ mm.

5.2.3.4 The tolerance on the perpendicularity of the side of a mould with respect to the base is 0,5 mm.

NOTE If necessary, the flatness tolerance can be measured with the mould disassembled (see [Annex B](#)).

5.2.4 Calibrated moulds for prismatic specimens

5.2.4.1 Moulds shall be suitable for producing specimens conforming to [4.4](#).

5.2.4.2 The tolerance on the designated depth and width (d) of an assembled mould is 0,5 %.

5.2.4.3 The tolerance on the flatness of the internal sides is $0,002d$ mm.

5.2.4.4 The tolerance on the flatness of the top surface of the baseplate of the mould is $0,004d$ mm.

5.2.4.5 For mould surfaces with dimensions exceeding 150 mm, the flatness tolerances in [5.2.4.3](#) and [5.2.4.4](#) shall apply over any 150 mm length.

5.2.4.6 The tolerance on the perpendicularity of the sides of a mould with respect to the base is 0,5 mm.

NOTE If necessary, the flatness tolerance can be measured with the mould disassembled (see [Annex B](#)).

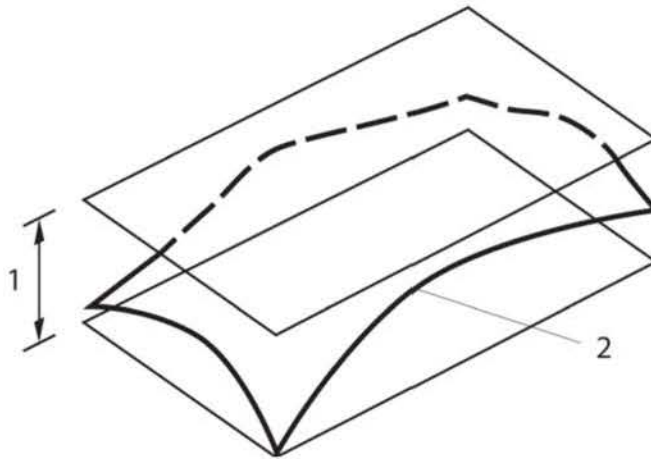
Annex A (normative)

Application of EN ISO 1101 to concrete test specimens and moulds

A.1 General

EN ISO 1101 describes the geometric tolerancing of drawings. Figures A.1, A.2 and A.3 show particular applications of the standard to the measurement of concrete test specimens and moulds.

A.2 Flatness

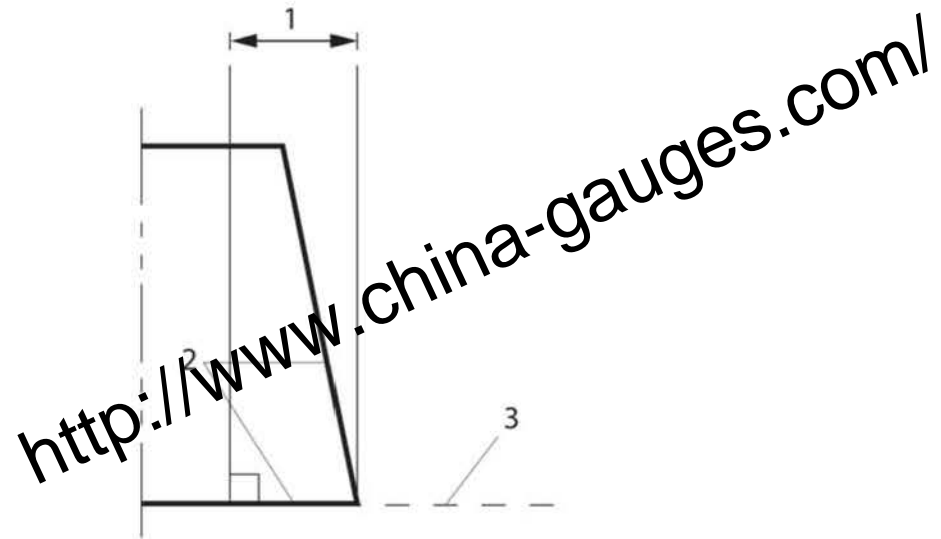


Key

- 1 flatness tolerance at any point across the face
- 2 surface to which flatness tolerance applies

Figure A.1 — Measurement of flatness

A.3 Perpendicularity

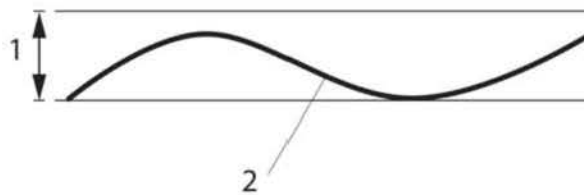


Key

- 1 perpendicularity tolerance
- 2 surfaces to which perpendicularity tolerance applies
- 3 adjacent surface as datum surface

Figure A.2 — Measurement of perpendicularity

A.4 Straightness



Key

- 1 straightness tolerance of the line on the load-bearing surface
- 2 line to which the straightness tolerance is applied

Figure A.3 — Measurement of straightness

Annex B (normative)

Assessment of flatness of specimens and moulds

For the purpose of this document, flatness shall be assessed by the measurement of straightness in four positions, as shown in [Figure B.1](#), for circular or rectilinear surfaces. Other methods giving at least the same degree of accuracy may be used.

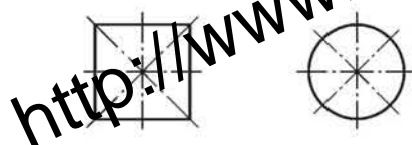


Figure B.1 — Measurement pattern for flatness of circular and rectilinear surfaces

The tolerance on straightness shall be equal to the tolerance on the flatness specified in [4.2](#), [4.3](#) or [4.4](#) as appropriate, for specimens, and in [5.2.2](#), [5.2.3](#) and [5.2.4](#), as appropriate, for moulds.

NOTE A steel straight-edge of rectangular section, and feeler gauges, with blades 0,03 mm to 1,00 mm thick, are considered suitable for this measurement, which characteristics could be defined on a national level.

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