



P-22083

## **SLIPFORM INSTRUCTION FOR CAISSON PRODUCTION**

### ***Web version manual***

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## **1. START OF SLIPFORMING**

- 1.1 Make note of concreting start time.**
- 1.2 Always make 15 cm layers.**
- 1.3 Check with rod when concrete starts to harden, normally after 4 - 5 hours.**
- 1.4 When you have 5 - 15 cm of hard concrete all around in slipform, make first lift.**
- 1.5 Check under slipform that it has lifted at all places.**
- 1.6 Check that the concrete is not too soft or has lifted with the slipform.**
- 1.7 Continue with normal lifts (read slipforming).**
- 1.8 Do not speed up lifting until you have enough hard concrete in slipform.**

## **2. SLIPFORMING SEQUENCE**

The lifting speed is to the major part set by these three points:

- 2.1 Is there enough hard concrete in slipform (min. 10 cm)?**
- 2.2 Is there enough fresh concrete in the slipform (max 25 empty)?**
- 2.3 Is the reinforcement in place?**

Normal lifting speed here is varying between one lift each 10 or 15 minutes. If conditions are optimal one to three five-minutes lifts can be added per hour. Because of the short setting time on the concrete we do not recommend intervals longer than 25 minutes. The lifters should be levelled at each 25 cm to be able to guide slipform.



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