

Batch Plant Instruction Manual

PercoCrete™ uses very little water. To aid in the mixing, transporting and to increase the ease of unloading of this unique pervious concrete please the closely adhere to these basic rules.

Truck Choice, mixing and transport instructions

1. Use only mix trucks with **clean and unworn fins**. If the fins are not clean or they are worn, PercoCrete will not unload as fast. Unclean and worn fins will also increase the chance of creating cement balls which are difficult to place and finish. If care is taken each 7 – 10 yard load should unload in 20 – 25 minutes.
2. Always **rinse and empty the drum** thoroughly before every load!
3. **Mixing drum speed must be 75% of maximum (or less)** to reduce balling.
4. **When in-transit dead roll the drum.** To prevent roller damage- use **.25 RPM**.

Batch plant operator loading instructions

5. Make sure **no water is in the mix truck before loading**. Always confirm each truck is rinsed and emptied prior to loading. **Never batch used materials on top of PercoCrete™** even if the truck was already hauling PercoCrete™.
6. **Water content of the mix is critical.** For that reason each load must be adjusted for free water in the aggregates. Total water in the mix design must not be exceeded. Please note that if your “Moisture probe” has not been recently calibrated it may not accurately register the correct moisture. To be certain **manually test the moisture content** in the aggregate prior to loading the first truck. We suggest batching the first truck in at least two batches. Ask the certified installer (who should be present during batching of the first load) to **visually check the first batch** to confirm if the mix looks correct. **WARNING: DO NO USE HOT WATER** with PercoCrete!
7. To reduce balling, **mix all the water with 50% or more of the aggregate** before introducing the cement and Perco Bond.
8. As additional protection from balling, have 2 pieces of 2’ 2x4 Trex decking on hand. Place these Trex boards into the mixer to break up balls if necessary.
9. Feather cement & Perco Bond into load with second half of the aggregate.
10. **Mix no more than 3 minutes.** This is important to reduce balling.
11. If central mixer is used, the mixer truck drum should be on **slow revolutions** when receiving mix, fast enough to prevent the chute from plugging but slow as possible to prevent balls caused by over mixing. Let material “fall” in the drum, not spin.

Site inspection and discharge of mix

12. **Site check is done by certified installer.** They will use “Hand compressing and bouncing” to see if material holds together for one to two bounces. If it falls apart immediately, add more water; if it is glistening, there's probably more water than you want. In that case, make sure the applicator is aware of this so he is careful not to over compact. The best case is the material has a dull sheen after hand compaction and holds together after one to two bounces. When adding water, set drum at slow revs to allow material to fall inside the drum.
13. **Do not attempt pouring PercoCrete™ “up hill”.** Downhill discharge is essential because PercoCrete™ will not discharge uphill and balls will be created while you try.