

DIN CEN/TR 16369:2014-04 (E)

Use of control charts in the production of concrete; English version CEN/TR 16369:2012

Contents		Page
Foreword		4
Introduction		5
1	Scope	7
2	Symbols and abbreviations	7
3	Statistics for Concrete	8
3.1	Normal distribution of strength	8
3.2	Characteristic strength and target strength	8
3.3	Standard deviation	10
3.4	Setting the target strength	13
4	Simple Data Charts	14
5	Shewhart Charts	15
5.1	Introduction	15
5.2	Shewhart action criteria	16
5.2.1	Points beyond UCL or LCL	16
5.2.2	Points beyond UWL or LWL	16
5.2.3	Patterns within control limits	16
5.3	Control of standard deviation	16
5.4	Example Shewhart chart	16
5.5	Modified application of Shewhart control chart	17
6	CUSUM	19
6.1	Introduction	19
6.2	Controlling mean strength	22
6.3	Controlling standard deviation	22
6.4	Controlling correlation	23
6.5	Design of V-mask	24
6.6	Action following change	24
7	Multivariable and Multigrade Analysis	26
7.1	General	26
7.2	Multivariable	26
7.3	Multigrade	27
8	Speeding the Response of the System	28
8.1	Early age testing	28
8.2	Family of mixes concept	28
9	Guidance on Control Systems	30
9.1	Abnormal Results	30
9.2	Handling mixes outside the concrete family	30
9.3	Handling mixes not controlled by compressive strength requirements	31
9.4	Test rates	32
9.5	Action following change	33
10	EN 206-1 Conformity Rules for Compressive Strength	33

10.1	Basic requirements for conformity of compressive strength	33
10.2	Assessment period	34
10.3	Conformity rules for compressive strength	34
10.4	Achieving an AOQL of 5 % with CUSUM	36
10.5	Non-conformity	37
11	Implementing Control Systems	38
12	CUSUM Example	38
12.1	Reference mix and concrete family	38
12.2	Main relationship	39
12.3	Applying adjustments	40
12.4	CUSUM calculation	41
12.5	CUSUM action following change	45
12.6	Further data and a change in standard deviation	47
	Bibliography	51