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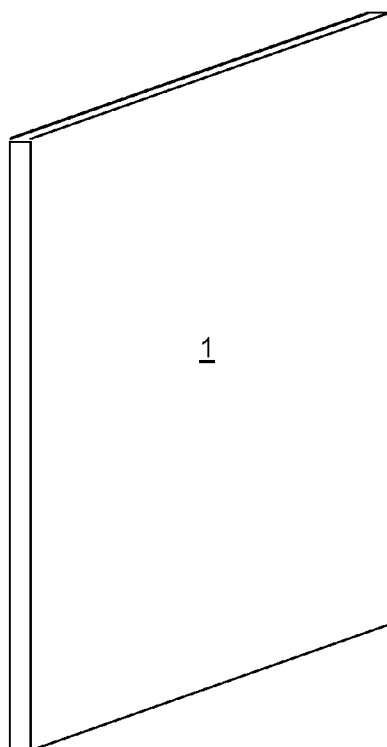
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[Continued on next page]

(54) Title: CEMENT BASED LAMINATED ARMOR PANELS

FIG. 1



(57) Abstract: A cementitious panel with ballistic and blast resistant properties having a core layer of ultra-high compressive strength composite and at least one skin layer. The panels can also be used in walls, ceiling and flooring panels which require high compressive strength for resistance to earthquakes and surfaces resistant to surface abuse such as in prison and other institutions. The panel core layer has a continuous cementitious phase resulting from the curing of an aqueous mixture, in the absence of silica flour, of inorganic cement binder, inorganic mineral filler having a particle size of about 150-450 microns, a pozzolanic mineral filler, polycarboxylate based superplasticizer, alkanolamine and acid or alkali metal acid salt; and water. The mixture may be uniformly reinforced with fiber added before curing. The cementitious core layer is then reinforced with the skin, such as fiber reinforced polymer, attached to at least one panel surface.



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## CEMENT BASED LAMINATED ARMOR PANELS

### CROSS REFERENCE TO RELATED APPLICATIONS

[001] This application claims the benefit of United States Provisional Application No. 61/033,264 filed March 3, 2008 incorporated herein by reference and is related to:

[002] United States Provisional Patent Application No. 61/033,240, entitled PROCESS FOR MANUFACTURING CEMENT BASED ARMOR PANELS, filed March 3, 2008;

[003] United States Provisional Patent Application No. 61/033,258, entitled CEMENT BASED ARMOR PANEL SYSTEM, filed March 3, 2008;

[004] United States Provisional Patent Application No. 61/033,212, entitled A SELF-LEVELING CEMENTITIOUS COMPOSITION WITH CONTROLLED RATE OF STRENGTH DEVELOPMENT AND ULTRA-HIGH COMPRESSIVE STRENGTH UPON HARDENING AND ARTICLES MADE FROM SAME, March 3, 2008;

[005] United States Patent Application No. 61/033,061, entitled TRANSPORTABLE MODULAR SYSTEM OF COMPONENTS FOR PHYSICAL PROTECTION, filed March 3, 2008; and

[006] United States Patent Application No. 61/033,059, entitled TRANSPORTABLE MODULAR FRAME FOR HOLDING PANELS FOR PHYSICAL PROTECTION, filed March 3, 2008;

### STATEMENT OF FEDERALLY SPONSORED RESEARCH

[007] The research work described here was supported under Cooperative Research and Development Agreement No. CRADA-05-GSL-04 between the Geotechnical and Structures Laboratory, Engineer Research & Development Center, U.S. Army Corps of Engineers and United States Gypsum Company.

[008] all herein incorporated by reference in their entirety.

## FIELD OF THE INVENTION

[009] This invention relates generally to an improved high-performance cement based armor panel with exceptional resistance to ballistic and blast loads having a unique fiber reinforced cementitious core composition with controlled strength development and a high performance skin-reinforcement attached to at least one surface of the cementitious core panel.

[0010] The cementitious core is made from an inorganic cementitious binder, typically hydraulic cement such as portland cement; an inorganic mineral filler, preferably silica sand of 150-450 micron median particle size and 0.80-1.50:1 weight ratio to the cementitious binder; a pozzolanic micro filler, preferably silica fume of average particle size of about 0.1 micron; about 0.75-2.5% by weight of the total composition of an organic based self-leveling chemical agent, based upon polycarboxylated chemistry, preferably polycarboxylated polyether (Superplasticizer), optional alkanolamine and acid or acid salt fluidity additives, fibers and water.

[0011] The mixture for forming the cementitious core is self leveling when mixed and develops significant strength after hardening. The cementitious core does not include silica flour, which has been found to produce a cementitious core composition which is too thick in consistency to be formed into a usable panel core with conventional production equipment.

[0012] The cementitious core composition is used in combination with a fiber reinforced skin material used to laminate at least one surface of the cementitious core of the panel. A variety of skins can be used to laminate the core of the cementitious armor panel. However, fiber reinforced polymer (FRP) laminates as skins are preferred. Fiberglass reinforced resin is the especially preferred FRP. The skin (S) is placed on the core (C) as a laminate of SC or SCS or SCSCS structural design.

[0013] Panels made with the improved cement composition have sufficient strength to resist blasts and ballistic impacts without or without steel fibers or steel reinforcement.

## BACKGROUND OF THE INVENTION

[0014] Fiber reinforced cementitious compositions containing hydraulic cement, inorganic mineral fillers and pozzolans as well as chemical additives like plasticizers and water dispersants have been used in the construction industry to form the interior and exterior walls of residential and/or commercial structures. However, a drawback of such conventional panels is that they do not have sufficient compressive strength to provide a high degree of resistance to ballistic and blast loads.

[0015] Current practice for producing ultra-high strength cementitious compositions relies upon efficient particle packing and extremely low water dosage for achieving ultra-high material strength. As a consequence of the raw materials utilized to achieve dense particle packing and the extremely low water usage in these compositions, the cementitious mixtures have extremely stiff rheological behavior with dough like consistency in the freshly mixed state. The stiff consistency makes these mixtures highly unworkable and extremely difficult to process in conventional manufacturing processes for making thin cement-based products and composites.

[0016] US Pat. No. 4158082 A to Belousofsky discloses a laminated cement based structure with a fiber glass skin that is impact resistant and may use Portland based cements.

[0017] US Pat. No. 4793892 to Miller discloses an apparatus for manufacturing a concrete panel with cement core and fiber glass facing utilizing Portland cement.

[0018] US Pat. No. 4948429 A to Arfaei discloses a cementitious composition containing portland cement, sand, fumed silica and a polyether .

[0019] US Pat. No. 5724783 to Mandish disclose a building panel and assembly system composed of Portland cement panel layers attached to a panel framework with multiple layers.

[0020] US Pat. No. 6119422 B1 to Clear discloses an impact resistant strong structural cementitious building panel with outer facing of fiberglass reinforcing mesh where the composite cementitious has an aggregate core with inner and outer faces of fiberglass mesh.

[0021] US Pat. No. 6176920 to Murphy disclose a method of method for constructing a cementitious panel of multiple layers utilizing a smoothing head, shearer and screeding process.

[0022] US Pat. No. 6309457 B1 Guerin et al. discloses a self-leveling cement composition that includes Portland cement, silica sand of maximum 10 mm size or 0-5 mm size, or a blend of 0-0.4 mm and 0-5 mm size; fine mineral aggregates such as fly ash or silica flour having dimensions of less than 200 microns, preferably less than 100 microns; a first plasticizer which is a water-soluble or water-dispersible organic compound containing at least one aminodi(alkenephosphonic) group; and a second water-soluble or water-dispersible plasticizer which is of the polycarboxylic acid type and contains polyether chains. Example 1 indicates a compressive strength in 28 days of 32 MPa (about 4600 psi).

[0023] US Pat. No. 6437027 to Isomura et al. discloses a cementitious composition containing portland cement, silica sand of less than 5mm size; and polycarboxylate polyether of 0.01-2.5 wt.%.

[0024] US Pat. No. 6,620,487 to Tonyan et al., incorporated herein by reference in its entirety, discloses a reinforced, lightweight, dimensionally stable structural cement panel (SCP's or SCP panels) capable of resisting shear loads when fastened to framing equal to or exceeding shear loads provided by plywood or oriented strand board panels. The panels employ a core of a continuous phase resulting from the curing of an aqueous mixture of calcium sulfate alpha hemihydrate, hydraulic cement, an active pozzolan and lime, the continuous

phase being reinforced with alkali-resistant glass fibers and containing ceramic microspheres, or a blend of ceramic and polymer microspheres, or being formed from an aqueous mixture having a weight ratio of water-to-reactive powder of 0.6/1 to 0.7/1 or a combination thereof. At least one outer surface of the panels may include a cured continuous phase reinforced with glass fibers and containing sufficient polymer spheres to improve nail ability or made with a water-to-reactive powders ratio to provide an effect similar to polymer spheres, or a combination thereof.

[0025] US Pat. No. 6849118 B2 to Kerkar et al. discloses a cementitious composition containing Portland cement, silica sand of 0 to 6 mm size; and polycarboxylate (ADVA® plasticizer).

[0026] US Pat. No. 6858074 B2 to Anderson et al. discloses a cementitious composition containing portland cement, silica sand, fumed silica, accelerator, retarder, and polycarboxylate high range water reducing dispersant.

[0027] US Pat. No. 6875801 B2 to Shendy et al. discloses a cementitious composition containing portland cement, sands, fumed silica and polycarboxylate of 0-2 wt %.

[0028] US Pat. No. 6942727 Daczko et al. discloses a high early strength cementitious member that includes Portland cement; fine aggregate such as silica sand, the fine aggregate are materials that almost entirely pass through a Number 4 sieve, coarse aggregate such as sand, the coarse aggregate are materials predominantly retained on a Number 4 sieve); silica fume pozzolan; 0.025-0.7% polycarboxylate dispersant which can be an polyether based on dry weight of cement; and structural synthetic fibers. The cementitious member can be used to make wall panels. The cementitious member can exhibit 24 hour compression strength greater than 10,000 psi; however these compositions do not contain a pozzolan.

[0029] US Pat. App. Pub. No. 2002/0004559 to Hirata et al. discloses a cementitious composition containing portland cement, sands, fumed silica and polyethers of more than 0.5% wt. e.g. 2 wt. %.

[0030] US Pat. App. Pub. No. 2004/0149174 to Farrington et al. discloses a cementitious composition containing portland cement, sands, fumed silica and polycarboxylate of 0.01-0.2 wt %.

[0031] US Pat. App. Pub. No. 2004/0198873 to Bury et al. discloses a cementitious composition containing portland cement, silica sand, fumed silica and polycarboxylate of 0.02- 2 wt %

[0032] US Pat. App. Pub. No. 2004/0211342 to Sprouts et al. discloses a cementitious composition containing portland cement, silica sand, fumed silica and polycarboxylate of 0.1- 2 wt %

[0033] US Pat. App. Pub. No. 2004/0231567 to Dulzer et al. discloses a cementitious composition containing portland cement, sand, fumed silica and polycarboxylate of 0.1- 10 wt % of the total dry cementitious binder.

[0034] US Pat. App. Pub. No. 2005/0139308 to Aldea disclose a system and method using a FRP reinforced cementitious material or composite that may include Portland cement, fly ash, silica fume, resins, sand, glass fibers, resins, water, accelerators, fillers, setting retardants, dispersing agents; involves multiple layers and toweling to smooth between layers; and may be used to strengthen structures against earthquakes and explosions. In Aldea, the layers are applied in situ by toweling and are not applied to form a free standing panel which can be attached to a frame. The structure made in Aldea has two concrete layers bonded to a fiberglass mat.

[0035] US Pat. App. Pub. No. 2005/0239924 to Lettkeman et al. discloses a cementitious composition containing portland cement, fine sands, fumed silica and polycarboxylate of 0.05 – 2.5 wt %.

[0036] US Pat. App. Pub. No. 2005/0274294 to Brower et al. discloses a cementitious composition containing portland cement, fine sands, fumed silica and polycarboxylate of 1-4% wt.

[0037] US Pat. App. Pub. No. 2006/0174572 to Tonyan et al., incorporated herein by reference, discloses non-combustible reinforced cementitious lightweight panels and metal frame system for shear walls.



[0038] US Pat. App. Pub. No. 2006/0281836 to Kerns et al. discloses a cementitious composition containing portland cement, fine sands, fumed silica and polycarboxylate.

[0039] US Pat. App. Pub. No. 2007/0125273 to Pinto discloses a cementitious composition containing portland cement, fine sands, fumed silica and polycarboxylate such as 1-2 wt. %.

[0040] US Pat. App. Pub. No. 2007/0175126 to Tonyan et al, incorporated herein by reference in its entirety, discloses a structural cementitious panel.

[0041] US Pat. App. Pub. No. 2007/0228612 A to Durst et al, incorporated herein by reference discloses blast resistant concrete also suitable for limiting penetration of ballistic fragments.

## SUMMARY OF THE INVENTION

[0042] The present invention relates to a laminate panel having a cementitious core made from a unique combination of inorganic and organic materials with specific size properties. This combination of inorganic and organic materials when mixed with water leads to excellent flow properties and self-leveling behavior in the freshly mixed stage. This combination of inorganic and organic materials when mixed with water also leads to ultra-high compressive strength of at least 10,000, 15,000 or 20,000 psi upon curing of the cementitious composition with controlled strength development after 28-day curing compared to the typical range of 3000-5000 psi obtained with typical full density normal strength concrete.

[0043] The present invention relates to a panel comprising a core having a continuous phase of a cementitious composition and a reinforcement layer on at least one side of the core. The primary ingredients of the core material are: 25-45 wt. % inorganic cementitious binder (for example Portland cement), 35-65 wt. % inorganic mineral filler (for example silica sand) having a particle size of about 150-450 microns, 5-15 wt. % pozzolanic micro filler (for example silica fume), 0.75-2.5 wt. % self-leveling chemical agent (for example carboxylated

polyether) and 6-12 wt. % water and an absence of silica flour. The composition may also have alkanolamine and acid (or acid salt) fluidity additives to extend the setting time for final cure.

[0044] The cementitious composition does not include silica flour, which has been found to produce a cementitious composition which is too thick in consistency to be formed into an extremely high strength panel core with conventional production equipment.

[0045] A further embodiment of the invention relates to addition of appropriate amounts of alkanolamine, e.g., triethanolamine (hereinafter "TEA") and acid or acid salt, e.g., tartaric acid, to the above described cementitious composition for the manufacture of blast resistant cementitious panels to modify fresh and hardened properties of the cementitious slurry for making panels. Typically the cementitious mixtures have Portland cement and silica fume as cementing components at a relative weight ratio of 0.85:0.15 and silica sand as filler at a weight ratio of 1.05:1.00 relative to the cementing components.

[0046] Water was used at a weight ratio of 0.22:1.00 relative to the cementing components. The triethanolamine and tartaric acid are added to control mixture fluidity, with a typical dosage of TEA of about 0.045% by weight, based upon the weight of Portland cement and a typical dosage of tartaric acid of less than about 0.040% by weight based upon the total cementing components. In addition, a Superplasticizer can be added. However, an advantage of the invention is that it permits use of reduced amounts of Superplasticizer.

[0047] Fiber reinforcement may be dispersed through the continuous phase. The fiber reinforced cementitious armor panel has ultra-high compressive strength for withstanding ballistic and blast loads which can range up to at least about 10,000 psi. These cementitious panels may have uses other than as blast resistant panels due to their high strength. Typical reinforcing fibers are alkali resistant glass fibers. Panels can be designed with less strength and lighter weight for use, for example, in construction in earthquake zones.

[0048] The laminate skin surface is on one or both sides of the cementitious core. A variety of skins can be used to laminate the core of the cementitious armor panel. However, fiber reinforced polymer (FRP) laminates as skins are preferred. Fiberglass reinforced resins such as woven fiberglass reinforced polyester, polyethylene, polypropylene are especially preferred FRP. The skin (S) is placed on the core (C) as a laminate of SC or SCS or SCSCS structural design.

[0049] The skin may be applied to one or more sides of the panel or completely cover the panel, e.g., a rectangular panel could be covered on both sides and all four edges. Further, the elastic material for covering the panels may be of the type described in US patent application publication no. US 2009-0004430 A1, US patent application no. 11/819,340 reinforced Elastomeric Configuration Tailored to Meet a User's Requirements for Protecting a Structure and a Structure Comprised Thereof, filed June 27, 2007, incorporated herein by reference. Methods for applying the elastomeric material to the panel are also provided in US patent application publication no. US 2009-0004430 A1, US patent application no. 11/819,340. Other FRPs are also suitable for use with structures of the present invention.

[0050] The present product overcomes the above described deficiencies of the current cementitious materials used to make ultra-high strength cementitious materials and provides a cementitious binder material that is self-leveling in its freshly mixed state and extremely strong upon hardening.

[0051] The invention allows for the self-leveling properties of the cementitious composition for easy formation of panels without the need for increased water that would have to be removed.

[0052] The self leveling behavior of the freshly mixed cementitious material is defined herein as the characteristic property that allows the material to flow and seek horizontal level without the aid of external vibration or energy. Prior art attempts to achieve self leveling have required the use of excess water in the mixtures, which have produced unacceptable composite material with very low compressive strength performance.

[0053] The cementitious armor panel may be attached to at least one side of a frame structure, such as a metal frame.

[0054] In an embodiment of the invention, one or more cementitious panels are mounted on to the frame by use of fasteners such as “Z” clips or “H” clips wherein the cementitious panels are laid into a channel formed by the fasteners which are attached on one side to the metal frame. The cementitious panels are mounted on at least one surface of the metal frame.

[0055] As previously discussed, there is a need for building panels that are capable of replacing currently available cementitious panels which suffer from the following deficiencies: poor flow properties, a requirement for significant amounts of water to be self leveling and when made into cementitious panels, have insufficient compressive strength to resist ballistic and blast loads, inferior toughness performance, and poor handleability during installation.

[0056] All percentages and ratios are by weight unless otherwise indicated.

## BRIEF DESCRIPTION OF THE DRAWINGS

[0057] FIG. 1 is a diagram of a perspective view of an embodiment of the cementitious fiber reinforced panel of the present invention.

[0058] FIG. 1A shows a side view of the panel of FIG. 1 further provided with a sheet of reinforcing material, such that the panel of FIG. 1 forms a core of cementitious fiber reinforced and the sheet of reinforcing material forms a cladding.

[0059] FIG. 1B shows a side view of a multi-layer panel comprising two cementitious panels of FIG. 1 acting as two cores provided with a sheet of reinforcing material between two opposed inner surfaces of the two cores and sheets of reinforcing material respectively on two opposed outer surfaces of the two cores.

[0060] FIG. 2 is a schematic diagram of an appropriate apparatus for performing the present process for producing the cementitious armor panel of the invention.

[0061] FIG. 3 is a graph of temperature rise for mixes from Example 8 containing varying amounts of tartaric acid.

[0062] FIG. 4 is a graph of compressive strength gain for mixes of Example 8 containing varying amounts of tartaric acid.

[0063] FIG. 5 is a graph of slump loss for mixes of Example 9 containing varying amounts of tartaric acid and constant amounts of Superplasticizer and triethanolamine.

[0064] FIG. 6 is a graph of temperature rise behavior for mixes of Example 9 containing varying amounts of tartaric acid and constant amounts of Superplasticizer and triethanolamine.

[0065] FIG. 7 is a graph of compressive strength gain for mixes of Example 9 containing varying amounts of tartaric acid and constant amounts of Superplasticizer and triethanolamine.

[0066] FIG. 8 is a graph of slump loss for mixes of Example 10 containing varying amounts of Superplasticizer at constant amounts of TEA and tartaric acid.

[0067] FIG. 9 is a graph of temperature rise behavior for mixes of Example 10 containing varying amounts of Superplasticizer at constant amounts of TEA and tartaric acid.

[0068] FIG. 10 is a graph of compressive strength gain for mixes of Example 10 containing varying amounts of Superplasticizer at constant amounts of TEA and tartaric acid.

[0069] FIG. 11 is a graph of slump loss for mixes of Example 11 containing varying amounts of tartaric acid and constant amounts of Superplasticizer and TEA.

[0070] FIG. 12 is a graph of temperature rise behavior for mixes of Example 11 containing varying amounts of tartaric acid and constant amounts of Superplasticizer and TEA.

[0071] FIG. 13 is a graph of compressive strength gain for mixes of Example 11 containing varying amounts of tartaric acid and constant amounts of Superplasticizer and TEA.

[0072] FIG. 14 is a graph of the ballistic velocity attenuation versus cementitious panel density for standard steel reinforced cementitious armor panels compared to cementitious armor panels of the invention.

[0073] FIG. 15 is a graph of the ballistic velocity attenuation versus cementitious panel density for two, three and four panels of panels which have a laminated fiber reinforced plastic skin layer facing compared to panel without a fiber reinforced plastic skin layer facing.

[0074] FIG. 16 is a graph showing the slump of mixes of Example 13.

[0075] FIG. 17 shows the slump loss for Mix 1 of Example 13.

[0076] FIG. 18 shows set times (initial and final) measured for these mixes of Example 13 using Gillmore needles.

[0077] FIG. 19 is a graph of the ballistic velocity attenuation versus areal density for a cementitious armor panel of the present invention (no laminate) compared to that of a structural cementitious panel.

## DETAILED DESCRIPTION OF THE EMBODIMENTS

### [0078] A. THE PANEL

[0079] The present invention relates to a fiber reinforced, dimensionally stable cementitious board panel. FIG. 1 shows a perspective view of a panel 1 of the invention.

[0080] FIG. 1A shows a side view of the panel 1 of FIG. 1 further provided with sheets of reinforcing material 2 on opposed outer surfaces of the cementitious

panel 1. Thus, the panel 1 of FIG. 1 forms the fiber reinforced cementitious core and the sheets 2 of reinforcing material form a cladding on opposed sides of the core. Typical reinforcing sheet materials include fiber reinforced polymer (FRP) or other material as described by United States Provisional Patent Application No. 61/033,264, entitled CEMENT BASED LAMINATED ARMOR PANELS, filed March 3, 2008 and herein incorporated by reference in its entirety.

[0081] Typically the FRP skin layer is adhesively attached to both surfaces of the cementitious core. For example, the fiber reinforced skin may be laminated to the surface of the core with an epoxy adhesive.

[0082] FIG. 1B shows a side view of a multi-layer panel comprising two cementitious panels 1 of FIG. 1 acting as two cores provided with a sheet of reinforcing material between two opposed inner surfaces of two cores and sheets of reinforcing material respectively on two opposed outer surfaces of the two cores.

[0083] The principal starting materials used to make panels of the invention are inorganic cementitious binder, e.g., hydraulic cement such as Portland cement; inorganic mineral filler such as the preferred silica sand, pozzolanic micro filler such as fumed silica, a self-leveling agent selected from polycarboxylate based compound particularly polyethers and water and reinforcing fibers such as glass fibers and any optional additives added to the cementitious slurry before the slurry is formed into a mat.

[0084] The panel includes a continuous phase resulting from the curing of an aqueous mixture of cementitious composition and reinforcing fibers, e.g. fiberglass fibers, the panel comprising, 25-45 weight % inorganic cement binder, 35-65 weight % inorganic mineral filler of 150-450 microns, 5-15 weight % pozzolanic filler and 0.75-2.5 weight % polycarboxylate based self leveling agent and 6-12 % water.

[0085] Optionally the aqueous mixture includes about 0.005 to 0.500 % by weight of the cement binder of triethanolamine and optionally about 0.10 to 1.80 % by weight of the cement components of tartaric acid.

[0086] Panels of the invention typically include a continuous phase of cementitious material in which the reinforcing fibers are substantially uniformly distributed. In the panel of FIG. 1 the continuous phase results from the curing of an aqueous mixture of the cementitious material and reinforcing fibers.

## B. FORMULATION

[0087] The components used to make the panels of the invention are described in more detail below.

[0088] Typical weight proportions of ingredients of one embodiment of the self-leveling, ultra-high compression strength cementitious compositions of the invention are shown in TABLE 1. The inorganic cementitious binder (hydraulic cement) and pozzolanic micro filler together are known as dry reactive powder.

[0089] TABLE 1

Ingredient Class	Preferred Ingredient	Typical Range min. (wt. % of total composition including water)	Typical Range max. (wt. % of total composition including water)	Typical formulation (wt. % of total composition including water)
Inorganic cementitious binder	Portland cement	25.0	45.0	37.0
Inorganic mineral filler 150-450 micron median particle size	silica sand	35.0	65.0	45.7
Pozzolanic micro filler	silica fume average particle size of about 0.1 micron	5.0	15.0	6.5



Organic based self-leveling chemical agent (Superplasticizer)	Poly-carboxylate-based chemical admixture	0.75	4.5	1.3
Water		6.0	12.0	9.6

[0090] The proportions of the dry composition ingredients which include the inorganic cementitious binder and pozzolanic micro filler, hereinafter also referred to as the dry reactive powder, and the inorganic mineral filler are shown in TABLE 1A.

[0091] TABLE 1A – Formulation on dry basis

Ingredients	Preferred Ingredient	Minimum typical wt. % (dry basis)	Maximum typical wt. % (dry basis)	Typical formulation wt. % (dry Basis)
Inorganic Hydraulic Cement (binder)	Portland Cement	25.0	55.0	41.5
Inorganic Mineral Filler (150-450 micrometers median particle size)	Silica sand	30.0	60.0	51.2
Pozzolanic Micro Filler	Silica Fume	2.0	15.0	7.3
Note: Inorganic hydraulic cement and pozzolanic micro filler combined together are termed Dry Reactive Powder.				

[0092] Pozzolan Micro Filler

[0093] Pozzolan materials are defined in ASTM C618-97 as “siliceous or siliceous and aluminous materials which in themselves possess little or no cementitious value, but will, in finely divided form and in the presence of moisture, chemically react with calcium hydroxide at ordinary temperatures to form compounds possessing cementitious properties.” One often used Pozzolan material is silica fume, finely divided amorphous silica which is the product of silicon metal and ferro-silicon alloy manufacture. Characteristically, it has high silica content and low alumina content.

[0094] Pozzolan material typically has the median particle size listed in TABLE 2

[0095] TABLE 2

<b>Pozzolan Filler</b> <b>For example, Silica Fume, Metakaolin,</b> <b>Volcanic Ash, Pumice</b>	
Median Particle Size (microns)	Range Type
≤ 50	Broad
≤ 10	Preferred
≤ 1.0	More Preferred
≤ 0.1	Most Preferred

[0096] In one embodiment of the invention, silica fume, finely divided amorphous silica which is the product of the reaction of a silicon metal and ferro-silicon alloy manufacture, is the preferred pozzolan micro filler. The average particle size of the silica fume particles is extremely small, i.e. about 0.1 microns, or almost one hundred times smaller than the average particle size of the Portland cement grains. In the broadest embodiment, the mean particle size of the pozzolan material should be less than about 50 microns, with a typical particle size of 10 microns or less and more typically a mean particle size of 1.0 microns or less. In a preferred embodiment the mean particle size of the pozzolan material is 0.1 microns or less, which has been

found to provide optimal particle packing, pozzolanic reaction and compressive strength development. The addition of inorganic, pozzolanic micro filler in the composition serves two critical functions in the composition.

[0097] The fine particle size of pozzolanic micro fillers plays a critical role in filling the empty spaces of varying sizes between the larger particles present in the mixture. Without these filler particles, these empty spaces would either be unfilled, forming air voids or become filled with water. The voids will ultimately lead to a reduction in both the density and compressive strength of the final material. The micro fillers filling these spaces lead to a significantly denser microstructure and enhance material compressive strength performance.

[0098] The silica fume pozzolanic filler also reacts with calcium hydroxide produced as a result of the hydration of the Portland cement. The reaction results in the formation of calcium silicate hydrate, which is a durable and extremely strong bonding material that enhances the strength and durability of the hardened cement based composition.

[0099] Various natural and man-made materials have been referred to as having pozzolanic properties, including pumice, perlite, diatomaceous earth, tuff, trass, metakaolin, microsilica, ground granulated blast furnace slag, and fly ash. While silica fume is a particularly convenient pozzolan for use in the panels of the invention, other pozzolanic materials may be used. In contrast to silica fume, metakaolin, ground granulated blast furnace slag, and pulverized fly ash have a much lower silica content and large amounts of alumina, but can be effective pozzolanic materials. When silica fume is used, it will constitute about 5 to 20 wt.%, preferably 10 to 15 wt.%, of the reactive powders (examples of reactive powders: hydraulic cement only; blends of hydraulic cement and pozzolan; or blends of hydraulic cement, calcium sulfate alpha hemihydrate, pozzolan, and lime). If other pozzolans are substituted, the amounts used will be chosen to provide chemical performance similar to silica fume.

[00100] Silica fume is quite distinct from other fine particle inorganic mineral fillers such as silica flour defined in CAS Number 87347-84-0 as silicone dioxide made by grinding pure silica sand to a very fine powder. Silica flour is commonly used as cheap filler in concrete compositions and plastics.

[00101] Silica fume defined by CAS Number 67256-35-3, is made by a very different way by reacting silicon tetrachloride in an oxy-hydrogen flame that has an excess of oxygen. The resulting solid is a very light, fluffy, pourable pozzolanic material which has been used in cement compositions to improve compression strength, bond strength and abrasion resistance.

[00102] The ratio of the pozzolanic micro filler to the inorganic cementitious binder has been found to be broadly useful in the range of 0.05 to 0.30, e.g. 5 parts to 30 parts by weight pozzolanic filler to 95 to 70 parts by weight cement binder. A more preferred ratio has been found to be 0.10 to 0.25 and the most preferred ratio of 0.15 to 0.20 has been found to give optimal for self-leveling performance, packing efficiency, pozzolanic reaction and controlled compressive strength development in the final cured composition. TABLE 2C lists ranges of Pozzolanic Filler / Inorganic Hydraulic Cement Ratios.

[00103] TABLE 2A

<b>Pozzolanic Filler / Inorganic Hydraulic Cement Weight Ratio</b>	
Ratio	Preference Type
0.05 to 0.30	Preferred
0.10 to 0.25	More Preferred
0.15 to 0.20	Most Preferred

[00104] Inorganic Cementitious Binder (Inorganic Hydraulic Cement)

[00105] The preferred inorganic cementitious binders are selected from the various classes of Portland cements, with the commercially available ones with coarser particle size being most preferred in the instant composition. The Blaine fineness of the Portland cement used in the cementitious compositions of this invention typically ranges between 2000 to 6000 cm<sup>2</sup>/gram.

[00106] It has been found that the relatively lower water demand of the Portland cements with coarser particle size results in mixtures with higher material density and enhanced material compressive strength performance.

[00107] Inorganic Mineral Filler

[00108] The preferred inorganic mineral filler are silica sands that have particular particle size distributions as described further below. These fillers have several extremely important functions in the composition of the invention.

[00109] Dimensional stability of the final product made with the cementitious composition of this invention is significantly enhanced with the use of the inorganic mineral filler. Pure portland cement compositions tend to be highly dimensionally unstable under varying hydro-thermal conditions. Mineral fillers such as silica sands help to improve the dimensional stability of the material without sacrificing the materials mechanical performance.

[00110] Pure portland cement compositions are extremely prone to shrinkage and associated development of cracks due to restrained plastic shrinkage of the material as it undergoes hardening. The effect of restrained plastic shrinkage becomes even more severe for compositions containing very low water content, particularly in the presence of pozzolanic materials like silica fume. Silica sand has been found to play an important role in controlling, and in some cases eliminating, development of cracks due to restrained plastic shrinkage.

[00111] Proper selection of particle size range of the inorganic mineral filler has been found to be instrumental in providing a denser particle packing to the cementitious mixture of this invention. A denser packing leads to less intrinsic flaws in the final material and this in turn, ultimately enhances the mechanical performance and compressive strength of the composite material.

[00112] The particle size of the inorganic mineral filler and the total amount of the filler used in the cementitious mixture has been found to contribute significantly to the self-leveling properties of the mixture. It has been

found that if the inorganic mineral filler has an average particle size that is very fine, the material will have poor flow properties with no self-leveling behavior. Additionally, it has been found that if the amount of the inorganic mineral filler is too high i.e. reaches a critical limit; the mineral will also have poor flow properties and no self-leveling behavior.

[00113] A particle size distribution of the inorganic filler that has been found to lead to self-leveling properties and ultra-high compressive strength performance is shown in TABLE 2B.

[00114] TABLE 2B

Inorganic filler particle size in microns	% Finer
1000	100
600	90-100
300	40-90
150	10-40
50	Less than 10

[00115] The inorganic mineral filler content of the composition found to provide self-leveling behavior to the final composition is described by the weight ratio of inorganic filler to cementitious material within the range of 0.80 to 1.50:1.0 on a dry basis.

[00116] The median particle size of the inorganic mineral filler in the composition of the invention should be in the range of 150 to 450 microns, more typically in the range of 200 to 400 microns and preferably in the range of 250 to 350 microns. When a median particle size in the range of about 250 to about 350 microns is used, the composition has been found to exhibit optimal self-leveling behavior, plastic shrinkage cracking control, efficient particle packing and optimum compressive strength development. Typical inorganic mineral filler has the median particle size listed in TABLE 2C.

[00117] TABLE 2C

<b>Inorganic Mineral Filler For example, Silica Sand, Zirconia Sand, Alumina Sand</b>	
Median Particle Size	Range Type
150 - 450 microns	Preferred
200 - 400 microns	More Preferred
250 - 350 microns	Most Preferred

[00118] Another parameter that has been found to provide optimal results is the ratio of the inorganic mineral filler, e.g., silica sand, to dry reactive powder (the combined weight of the inorganic cement binder and the pozzolanic micro filler reactive powders). Good results are obtained at ratios of from about 0.75 to 1.50: 1.0 with more preferred results being at ratios of 0.80 to 1.20: 1.0 and optimum self leveling, efficient particle packing and compressive strength development being achieved at ratios of 0.90 to 1.10:1.0, e.g., 90 to 110 parts by weight of inorganic mineral filler such as silica sand to 100 parts of combined cementitious binder and pozzolanic filler. TABLE 2D lists ranges for Inorganic Mineral Filler/Dry Reactive Powder Ratios.

[00119] TABLE 2D

<b>Inorganic Mineral Filler/Dry Reactive Powder Weight Ratio</b>	
Ratio	Preference Type
0.75 to 1.50	Preferred
0.80 to 1.20	More Preferred
0.90 to 1.10	Most Preferred
Note: Inorganic hydraulic cement and pozzolanic micro filler combined together are termed Dry Reactive Powder.	

[00120] Water

[00121] Typically the weight ratio of water to the inorganic cementitious binder and pozzolanic filler dry reactive powder is maintained at 0.35 or less, with a typical ratio being below about 0.25 to 0.30:1.0 and optimum particle packing and compressive strength being achieved at water to reactive powder

ratios of 0.20:1.0 or less. TABLE 2E lists ranges for Water / Dry Reactive Powder Ratio.

[00122] TABLE 2E

<b>Water / Dry Reactive Powders Ratio</b>	
Preferred Ratio	Range Type
$\leq 0.35$	Maximum water/dry reactive powders ratio
$\leq 0.30$	Preferred
$\leq 0.25$	More Preferred
$\leq 0.20$	Most Preferred
Note: Inorganic hydraulic cement and pozzolanic micro filler combined together are termed Dry Reactive Powder.	

[00123] Self-Leveling Agent - Superplasticizer

[00124] Organic admixtures based on polycarboxylate chemistry have been found to be exclusively effective self-leveling agents in the composition of the invention and provide the required fluidity and flow properties for development of long term compressive strength of the cured cementitious armor panel.

[00125] Polycarboxylate based compositions have been found to be effective when used in an amount of from about 0.25 to 5.00 % by weight, and more typically 0.50 to 3.0% by weight of the cementitious material on a dry basis. Amounts at levels below about 0.25% do not provide any significant improvement in fluidity and flow properties of the cementitious material. Use of levels of the polycarboxylate based Superplasticizer above about 5.0% by weight, causes a significant adverse impact upon the long term development of compressive strength. TABLE 2F lists ranges for superplasticizer.



[00126] TABLE 2F

<b>Superplasticizer Polycarboxylate polyethers</b>	
Dosage Range	Range Type
0.25 to 5.00 wt% of dry reactive powders	Broad Range
0.50 to 3.00 wt% of dry reactive powders	Preferred Range
0.75 to 1.50 wt% of dry reactive powders	More Preferred Range
1.00 to 1.25 wt% of dry reactive powders	Most Preferred Range
Note: Inorganic hydraulic cement and pozzolanic micro filler combined together are termed Dry Reactive Powder.	

[00127] When the polycarboxylate superplasticizer is used in the specified dosages in admixture with the other components of the cementitious composition of the invention, self-leveling cementitious compositions are obtained.

[00128] Typically, the polycarboxylate superplasticizer can be reduced to about 0.75 to 1.50% by wt. of dry reactive powders and down to about 1.0 to 1.25% by wt. of the of dry reactive powders while still giving the desired period of fluidity and long term compressive strength development when alkanolamines, e.g. TEA, and acid additives, e.g. tartaric acid, are used within the amounts specified in the present invention.

[00129] The term polycarboxylate based self-leveling agent used throughout this specification refers to polymers with a carbon backbone with pendant side chains, wherein at least a portion of the side chains are attached to the backbone through a carboxyl group or an ether group. Examples of these polycarboxylate compositions can be found in US Patent 6,942,727 B2 at Col. 4, lines 16-32, which is incorporated herein by reference. Polycarboxylate dispersants are very effective in dispersing and reducing the water content in hydraulic cements. These dispersants or Superplasticizers operate by surrounding a particle to be dispersed, and then repulsion forces between each polymer chain keeps the particles apart and more fluid.

[00130] The polycarboxylate agent used in the cementitious composition may include but is not limited to dispersants or water reducers sold under the trademarks GLENIUM 3030NS, GLENIUM 3200 HES, GLENIUM 3000NS (Master Builders Inc., Cleveland, Ohio), ADVA (W. R. Grace Inc., Columbia, Md.), VISCOCRETE (Sika, Stockholm, Sweden), and SUPERFLUX (Axim Concrete Technologies Inc., Middlebranch, Ohio). Two examples of commercially available polycarboxylated polyether compositions that have provided good results in this invention are Adva® Cast and Adva® Cast 500, commercially available from W.R. Grace, Columbia, MD.

[00131] Alkanolamine and Acid / Acid Salt

[00132] As mentioned above, alkanolamine, e.g., triethanolamine (TEA) and acid or acid salt, e.g., tartaric acid, may be added to control the fluidity of the cementitious composition. The addition of about 0.005 % to about 0.500 % TEA by weight of cementitious material, more typically 0.010% to about 0.250 % by weight, more preferably 0.020% to 0.100 wt % and most preferred about 0.025 to 0.075 % by weight of dry reactive powder allows the use of a lower amount of leveling agent Superplasticizer. For example, addition of alkanolamine and acid/acid salt permits using only about one-third of the amount otherwise used while obtaining the desired rate of development of compressive strength of the panel.

[00133] Moreover, addition of alkanolamine and acid/acid salt delays the period of curing to allow for handling and finishing of the cementitious armor panel. This also allows the cementitious composition to have a longer period to handle the panel between the time the panel hardens enough to be handled and be sanded for final finishing before the cementitious composition reaches its fully hardened final panel form. At amounts less than about 0.005%, the curing time is too fast and there is no improvement in the development of long term compressive strength of the panel.

[00134] When more than 0.500% of TEA is used, the cure is too fast for improving the period of handling and the compressive strength does not develop over a sufficient period of time to give compressive strength levels of more than about 10,000 psi, for example from 15,000 psi or 20,000 psi to 25,000 to 30,000 psi for effective blast and ballistic resistance.

[00135] TABLE 2G lists ranges for alkanolamines. Examples of suitable alkanolamines for use in embodiments of the present invention include one or more of monoethanolamine, diethanolamine and triethanolamine.

[00136] TABLE 2G

<b>Alkanolamines</b> <b>For example, Triethanolamine, Diethanolamine, Monoethanolamine</b>	
Dosage Range	Range Type
0.005 to 0.500 wt% of dry reactive powder	Broad Range
0.010 to 0.250 wt% of dry reactive powder	Preferred Range
0.020 to 0.100 wt% of dry reactive powder	More Preferred Range
0.025 to 0.075 wt% of dry reactive powder	Most Preferred Range
Note: Inorganic hydraulic cement and pozzolanic micro filler combined together are termed Dry Reactive Powder.	

[00137] The use of acids, for example, tartaric acid, or acid salts (alkali-metal salts), in combination with the above-discussed alkanolamines, has been found to be effective in reducing the amount of Superplasticizer needed for fluidity and flow properties. It also improves development of compressive strength gain over time at levels of from about 0.10 to about 1.80 % by weight of the cementitious material, with typical use being within the range of about 0.20 to 1.20 % and preferred ranges being from about 0.30% to 0.80% by weight and the more preferred amount being from about 0.40% to 0.60 % by weight. When tartaric acid is used below about 0.10%, there is no improvement in the development of compressive strength or any reduction in the amount of Superplasticizer required giving the required fluidity and flow properties of the cementitious material. At levels above about 1.8% by wt., the long term development of compressive strength is degraded to levels below the

compressive strength required for use as an effective cementitious armor panel.

[00138] Other examples of suitable acid / acid salt additives for improving fluidity include, but are not limited to, citric acid, potassium tartarate, sodium tartarate, sodium-potassium tartarate, and sodium citrate.

[00139] TABLE 2H lists ranges for acids and acid salts that may be employed in embodiments of the present invention.

[00140] TABLE 2H

<b>Acids and Acid-Salts:</b>	
<b>Tartaric Acid, Potassium Tartarate, Sodium Tartarate, Sodium-Potassium Tartarate, Citric Acid, Sodium Citrate</b>	
Dosage Range	Range Type
0.10 to 1.80 wt% of dry reactive powder	Broad Range
0.20 to 1.20 wt% of dry reactive powder	Preferred Range
0.30 to 0.80 wt% of dry reactive powder	More Preferred Range
0.40 to 0.60 wt% of dry reactive powder	Most Preferred Range
Note: Inorganic hydraulic cement and pozzolanic micro filler combined together are termed Dry Reactive Powder.	

[00141] Reinforcing Fibers

[00142] The cementitious armor panels of the invention typically include reinforcing fibers, e.g., glass fibers or steel fibers. However, products without reinforcing fibers also come within the present invention.

[00143] The cementitious armor panel is typically reinforced with one or more layers of loose chopped glass fibers embedded into the cementitious layers as the panel is made from cementitious slurry deposited on the forming line, as described in detail below. The glass fibers are chopped to a length of about 0.5 in (1.3 cm) to about 1.5 in (3.8 cm) in length. The glass fibers are monofilaments having a diameter of about 5 to 25 microns (micrometers), typically about 10 – 15 microns (micrometers).

[00144] The cementitious armor panels are uniformly reinforced with glass fibers in an amount of about 0.5 % to about 6% by volume of the overall composite material composition, more typically about 3 % to about 3.5 volume %, before it is cured to a final cementitious armor panel. The total cementitious composition means the total inorganic binder, inorganic mineral filler, pozzolanic filler, self-leveling agent, and additives like retarders and accelerators. Thus for 100 cubic feet of total composition, there is 0.5 to 6 cubic feet of fibers. The cementitious armor panels are also 0.5-6 volume % of the total wet composition used to make a composite article as well as the composite article itself.

[00145] Alkali-resistant glass fibers (AR glass fibers), such as Nippon Electric Glass (NEG) 350Y can be use when alkali resistance is important. Such fibers have been found to provide superior bonding strength to the matrix and are, thus, preferred for panels of the invention. The glass fibers are monofilaments that have a diameter from about 5 to 25 microns (micrometers) and typically about 10 to 15 microns (micrometers). The filaments generally are combined into 100 filament strands, which may be bundled into rovings containing about 50 strands. The strands or rovings will generally be chopped into suitable filaments and bundles of filaments, for example, about 0.25 to 3 inches (6.3 to 76 mm) long, preferably 0.5 to 1.5 inches (13 to 38 mm), more preferably 1 to 1.5 inches (25 to 38 mm).

[00146] It is also possible to include other fibers in the cementitious armor panels of the invention in place of some or all of the preferred glass fibers. Such other fibers may be one or more members of the group consisting of cellulosic fibers, such as paper fibers; polymer fibers, for example polyvinyl alcohol, polypropylene, polyethylene, high density polyethylene, polyacrylonitrile, polyamide, polyimide and/or aramid fibers. Carbon fibers and metal fibers such as steel fibers can also be used to reinforce the cementitious armor panels, although glass fibers have provided cementitious armor panels with excellent blast resistance and ballistic impact properties.

[00147] Additional Optional Additives

[00148] Other known additives for use in cementitious compositions, such as air entrainment additives, surfactants, accelerators, retarders, and additional plasticizers can also be used. In particular, water reducing agents such as polynaphthalene sulfonates, ligno-sulfonates and melamine-sulfonates may be added to the continuous phase and will function as secondary plasticizers in combination with the polycarboxylate based Superplasticizer

[00149] High Performance Skin-Reinforcement

[00150] The fiber-reinforced, cementitious core of the armor panels is strengthened by means of a high-performance, skin reinforcement bonded to one or both surfaces of the cementitious core. The skin reinforcement may be made of a variety of high performance reinforcement material such as fiber reinforced polymer laminates (FRP), thin metal laminates, composite FRP-metal laminates, open-weave mesh, closed-weave mesh, etc. The skin reinforcement is attached to the cementitious core by means of a bonding agent. For example, adhesives may be used to bond skins to the core. Typical suitable adhesives are urethanes (hot melt and room temperature), epoxies and other polymer adhesives. The skin may be applied to one or more sides of the panel or completely cover the panel, e.g., a rectangular panel could be covered on both sides and all four edges.

[00151] Alternatively, the skin reinforcement may be embedded in the cementitious core, thus avoiding the need for a bonding agent.

[00152] The elastic material for covering the panels may be of the type described in US patent application publication no. US 2009-0004430 A1, US patent application no. 11/819,340 reinforced Elastomeric Configuration Tailored to Meet a User's Requirements for Protecting a Structure and a Structure Comprised Thereof, filed June 27, 2007, incorporated herein by reference. Methods for applying the elastomeric material to the panel are also provided in US patent application publication no. US 2009-0004430 A1, US patent

application no. 11/819,340. Other FRPs are also suitable for use with structures of the present invention.

[00153] Fiber reinforced polymer laminates such as fiberglass reinforced polyester resin, fiberglass reinforced polyethylene and fiberglass reinforced polypropylene resins are typically used with a Kemlite ArmorTuf® woven fiberglass reinforced polyester resin laminate available from Crane Composites, Inc., being preferred. The FRP laminates may comprise reinforcing fibers embedded in a polymeric resin in either continuous form, discontinuous form, or a combination of both.

[00154] A variety of fibers may be used as reinforcement in the FRP laminate. Including such preferred fibers as glass fibers, aramid fibers, Kevlar® fibers, and metal fibers such as steel fibers.

[00155] After final set in the form of a fiber reinforced cementitious panel with a high performance skin-reinforcement attached to at least one surface of the cementitious core, as described below, the panel exhibits the desirable blast resistance and dimensional stability of the cementitious composite material.

[00156] C. BRIEF DESCRIPTION OF MAKING A PANEL OF THE PRESENT INVENTION

[00157] Forming

[00158] The cementitious panel is formed on a forming line by first depositing a layer of chopped fiber such as AR- glass fibers on a carrier on a porous conveyor belt followed by depositing a layer of the cementitious slurry over the layer of chopped fiber and then depositing a second layer of chopped fiber and then passing the layers through an embedment device to embed the randomly glass fibers into the cementitious slurry layer. The steps are then repeated a second time to accumulate a second layer to produce a cementitious panel of approximately 0.50 in. thickness. A third layer of cement slurry only is deposited on the top surface of the panel and immediately leveled

by a screed plate to provide a relatively smooth top surface of the product panel.

[00159] CURING

[00160] The resulting panels are then stored on a flat surface and cured at ambient temperature and humidity conditions for an initial period of between 8 and 72 hours after wet forming (casting). The panels are then wetted and wrapped in plastic to prevent loss of moisture. The wrapped panels are cured at 140°F (60°C) for 7 days.

[00161] FINISHING (Surfacing)

[00162] Surfacing machinery is used to gauge the panels to a thickness of about 0.50 in. (1.3 cm) e.g., 53 in. and to provide a smooth surface on the top and bottom surfaces of the panel.

[00163] CUTTING

[00164] The panels are cut to the desired size by use of conventional cutting methods such as dry sawing or waterjet cutting.

[00165] D. DETAILED DESCRIPTION OF A PRODUCTION LINE  
PROCES FOR MAKING A CEMENTITIOUS PANEL CORE  
COMPOSITION OF THE INVENTION

[00166] Referring now to FIG. 2, a cementitious armor panel production line is diagrammatically shown and is generally designated 10. The production line 10 includes a support frame or forming table 12 having a plurality of legs 13 or other supports. Included on the support frame 12 is a moving carrier 14, such as an endless rubber-like conveyor belt with a smooth, water-impervious surface, however porous surfaces are contemplated. As is well known in the art, the support frame 12 may be made of at least one table-like segment, which may include designated legs 13 or other support structure. The support frame 12 also includes a main drive roll 16 at a distal end 18 of the frame, and an idler roll 20 at a proximal end 22 of the frame. Also, at least one belt tracking



and/or tensioning device 24 is typically provided for maintaining a desired tension and positioning of the carrier 14 upon the rolls 16, 20. In this embodiment, the panels are produced continuously as the moving carrier proceeds in a direction "T" from the proximal end 22 to the distal end 18.

[00167] In this embodiment, a web 26 of Kraft paper, release paper, or a plastic carrier, for supporting a slurry prior to setting, may be provided and laid upon the carrier 14 to protect it and/or keep it clean.

[00168] However, it is also contemplated that, rather than the continuous web 26, individual sheets (not shown) of a relatively rigid material, e.g., sheets of polymer plastic, may be placed on the carrier 14.

[00169] It is also contemplated that the cementitious armor panels produced by the present line 10 are formed directly upon the carrier 14. In the latter situation, at least one belt washing unit 28 is provided. The carrier 14 is moved along the support frame 12 by a combination of motors, pulleys, belts or chains which drive the main drive roll 16 as is known in the art. It is contemplated that the speed of the carrier 14 may vary to suit the product being made.

#### [00170] CHOPPER

[00171] In this embodiment of the present invention, cementitious armor panel production is initiated by depositing a layer of loose, chopped glass fibers 30 of about 0.5 in. to about 1.5 in. (1.3 to 3.8 cm) in length and about 5 to about 25 micrometers in diameter, and typically 10-15 micrometers in diameter, upon a plastic carrier on the web 26. A variety of fiber depositing and chopping devices are contemplated by the present line 10. For example, a typical system employs a rack 31 holding several spools 32 of fiberglass cord, from each of which a length or string 34 of fiber is fed to a chopping station or apparatus, also referred to as a chopper 36. Typically a number of strands of fiberglass are fed at each of the chopper stations.

[00172] The chopper 36 includes a rotating bladed roll 38 from which project radially extending blades 40 extending transversely across the width of the carrier 14, and which is disposed in close, contacting, rotating relationship with an anvil roll 42. In the preferred embodiment, the bladed roll 38 and the anvil roll 42 are disposed in relatively close relationship such that the rotation of the bladed roll 38 also rotates the anvil roll 42, however the reverse is also contemplated. Also, the anvil roll 42 is preferably covered with a resilient support material against which the blades 40 chop the cords 34 into segments. The spacing of the blades 40 on the roll 38 determines the length of the chopped fibers. As is seen in FIG. 2, the chopper 36 is disposed above the carrier 14 near the proximal end 22 to maximize the productive use of the length of the production line 10. As the fiber strands 34 are chopped, the fibers fall loosely upon the carrier web 26.

[00173] SLURRY MIXER

[00174] The present production line 10 includes a slurry feed station or slurry feeder or slurry headbox, generally designated 44 and a source of slurry, which in this embodiment is a wet mixer 47. The slurry feeder 44 receives a supply of slurry 46 from the wet mixer 47 for depositing the slurry 46 on chopped fibers on the carrier web 26.

[00175] SLURRY FEED APPARATUS

[00176] Referring now to FIG. 2, as mentioned above, the present slurry feed apparatus, also referred to as slurry feed station, slurry feeder or slurry headbox, generally designated 44 receives a supply of slurry 46 from the wet mixer 47.

[00177] The preferred slurry feeder 44 includes a main metering roll 48 disposed transversely to the direction of travel "T" of the carrier 14. A companion or back up roll 50 is disposed in close, parallel, rotational

relationship to the metering roll 48. Slurry 46 is deposited in a nip 52 between the two rolls 48, 50.

[00178] The slurry feeder 44 also has a gate 132 mounted to sidewalls 54 of the slurry feed apparatus 44 to be mounted adjacent to the surface of the metering roll 48 to form a nip therebetween. The gate 132 is above the metering roll 48 so that the nip is between the gate 132 and an upper portion of the roll 48. The rolls 48, 50 and gate 132 are disposed in sufficiently close relationship that the nip between roll 48 and gate 132 retains a supply of the slurry 46, at the same time the rolls 48, 50 rotate relative to each other. The gate 132 is provided with a vibrator (not shown). The metering roll 48 rotates from the nip 52 to the nip between roll 48 and gate 132.

[00179] The gate 132 may be centered over the metering roll 48 or slightly upstream of centered over the metering roll 48.

[00180] While other sizes are contemplated, typically the metering roll 48 has a larger diameter than the companion roll 50.

[00181] Also, typically one of the rolls 48, 50 has a smooth, stainless steel exterior, and the other, preferably the companion roll 50, has a resilient, non-stick material covering its exterior.

[00182] The vibrating gate 132 helps to prevent significant build-up of slurry 46 on the gate 132 and controls the thickness of the slurry 46 deposited on the metering roll 48. The vibrating gate 132 can easily be removed from the wall mounts for cleaning and maintenance. A more detailed description of the vibrating gate can be found in co-pending Application No. 11/555,655 of November 1, 2006, incorporated herein by reference in its entirety.

[00183] Typically the slurry feeder 44 has a pair of relatively rigid sidewalls 54 (one shown), preferably made of, or coated with non-stick material such as TEFLON® material or the like. The sidewalls 54 prevent slurry 46 poured into the nip 52 from escaping out the sides of the slurry feeder 44. The sidewalls 54, preferably secured to the support frame 12 (FIG. 2), are disposed in close relationship to ends of the rolls 48, 50 to retain the slurry 46. However, the

sidewalls 54 are not excessively close to ends of the rolls to interfere with roll rotation.

[00184] An important feature of the present invention is that the slurry feeder 44 deposits an even layer of the slurry 46 of relatively controlled thickness upon the moving carrier web 26. Suitable layer thicknesses range from about 0.16 inch or 0.25 inch. However, with two layers preferred in the Cementitious armor panel produced by the production line 10, and a suitable panel being approximately 0.5 inch, an especially preferred slurry layer thickness is in the range of 0.25 inch. However, for a target panel forming thickness is about 0.53 inches, the standard layer thickness is typically closer to about 0.265 inches at each of the two forming stations.

[00185] Thus, the relative distance between the vibrating gate 132 and the main metering roll 48 may be adjusted to vary the thickness of the slurry 46 deposited.

[00186] To ensure a uniform disposition of the slurry 46 across the entire web 26, the slurry 46 is delivered to the slurry feeder 44 through a hose 56 or similar conduit having a first end in fluid communication with the outlet of the slurry mixer or reservoir 47. A second end of the hose 56 is connected to a laterally reciprocating, cable driven, fluid-powered dispenser of the type well known in the art. Slurry flowing from the hose 56 is thus poured into the feeder 44 in a laterally reciprocating motion to fill a reservoir defined by the rolls 48, 50 and the sidewalls 54 of the slurry feeder 44.

[00187] Rotation of the metering roll 48 draws a layer of slurry 46 from the reservoir defined by the rolls 48, 50 and the sidewalls 54 of the slurry feeder 44.

[00188] Another feature of the present feeder apparatus 44 is that the main metering roll 48 and the companion roll 50 are both driven in the same direction which minimizes the opportunities for premature setting of slurry on the respective moving outer surfaces. A drive system (not shown), including a fluid-powered, electric or other suitable motor is connected to the main metering roll

48 or the companion roll 50 for driving the roll(s) in the same direction, which is clockwise when viewed in FIG. 2. As is well known in the art, either one of the rolls 48, 50 may be driven, and the other roll may be connected via pulleys, belts, chain and sprockets, gears or other known power transmission technology to maintain a positive and common rotational relationship.

[00189] As the slurry 46 on the outer surface of the roll 48 moves toward the moving carrier web 26, it is important that all of the slurry be deposited on the web, and not travel back upward toward the nip 52. Such upward travel would facilitate premature setting of the slurry 46 on the rolls 48, 50 and would interfere with the smooth movement of slurry from the reservoir 57 to the carrier web 26.

[00190] To assist in preventing this upward travel, the slurry feeder 44 has a doctor blade 134 located between the main metering roll 48 and the carrier web 26. The doctor blade 134 ensures the slurry 46 uniformly covers the fiberglass fiber layer upon the carrier web 26 and does not proceed back up toward the nip 52 and the feeder reservoir 57. The doctor blade 134 also helps keep the main metering roll 50 free of prematurely setting slurry 46.

[00191] The doctor blade 134 removes the slurry from the surface of the metering roll 48 like the wire used in the process of US Patent No. 6,986,812 to Dubey et al. The doctor blade 134 also serves to collect the slurry 46 in a uniform layer or curtain and downwardly directs the slurry 46 in the direction of the movement of the web to a point about 1.0 to 1.5 inches (2.54 to 3.81 cm.) over the fiberglass layer on the web to uniformly cover the fiberglass layer with the slurry 46. This is particularly important where thinner slurries are used to cover the fiberglass layer, since thinner slurries have a tendency to drip over wires.

[00192] PROCESSING DOWNSTREAM OF THE SLURRY FEED  
APPARATUS

[00193] Referring again to FIG. 2, the other operational components of the Cementitious armor panel production line will be described briefly, but they are described in more detail in the following documents:

[00194] United States Patent No. 6,986,812, to Dubey et al. entitled SLURRY FEED APPARATUS FOR FIBER-REINFORCED STRUCTURAL CEMENTITIOUS PANEL PRODUCTION, herein incorporated by reference in its entirety; and

[00195] the following co-pending, commonly assigned, United States patent applications all herein incorporated by reference in their entirety:

[00196] United States Patent Application Publication No. 2005/0064164 A1 to Dubey et al., application no. 10/666,294, entitled, MULTI-LAYER PROCESS AND APPARATUS FOR PRODUCING HIGH STRENGTH FIBER-REINFORCED STRUCTURAL CEMENTITIOUS PANELS;

[00197] United States Patent Application Publication No. 2005/0064055 A1 to Porter, application no. 10/665,541, entitled EMBEDMENT DEVICE FOR FIBER-ENHANCED SLURRY;

[00198] United States Patent Application No. 11/555,655, entitled METHOD FOR WET MIXING CEMENTITIOUS SLURRY FOR FIBER-REINFORCED STRUCTURAL CEMENT PANELS, filed November 1, 2006;

[00199] United States Patent Application No. 11/555,658, entitled APPARATUS AND METHOD FOR WET MIXING CEMENTITIOUS SLURRY FOR FIBER-REINFORCED STRUCTURAL CEMENT PANELS, filed November 1, 2006;

[00200] United States Patent Application No. 11/555,661, entitled PANEL SMOOTHING PROCESS AND APPARATUS FOR FORMING A SMOOTH CONTINUOUS SURFACE ON FIBER-REINFORCED STRUCTURAL CEMENT PANELS, filed November 1, 2006;

[00201] United States Patent Application No. 11/555,665 entitled WET SLURRY THICKNESS GAUGE AND METHOD FOR USE OF SAME, filed November 1, 2006;

[00202] United States Patent Application Publication No. 2007/0110970 A1 to Dubey, application no. 11/591,793, entitled MULTI-LAYER PROCESS AND APPARATUS FOR PRODUCING HIGH STRENGTH FIBER-REINFORCED STRUCTURAL CEMENTITIOUS PANELS WITH ENHANCED FIBER CONTENT, filed November 1, 2006;

[00203] United States Patent Application Publication No. 2007/0110838 A1 to Porter et al., application no. 11/591,957, entitled EMBEDMENT ROLL DEVICE, filed November 1, 2006.

[00204] EMBEDMENT DEVICE

[00205] A variety of embedment devices are contemplated, including, but not limited to sheep's foot rollers and the like. However, in the present embodiment the embedment device 70 includes at least a pair of generally parallel shafts 76 mounted transversely to the direction of travel of the carrier web 14 on the frame 12. Each shaft 76 is provided with a plurality of relatively large diameter disks 74 which are axially separated by a distance of about 0.1 to about 0.25 inch (0.25 to 0.63 cm) e.g. 0.15 inch (0.38 cm) from each other on the shaft by small diameter disks (not shown), wherein the longer and smaller disks are located on the same axis.

[00206] During cementitious armor panel production, the shafts 76 and the disks 74 rotate together about the longitudinal axis of the shaft 76. As is well known in the art, either one or both of the shafts 76 may be powered. If only one shaft 76 is powered, the other may be driven by belts, chains, gear drives or other known power transmission technologies to maintain a corresponding direction and speed to the driven shaft. The respective disks 74 of the adjacent, preferably parallel shafts 76 overlap and are intermeshed with each other for creating a "kneading" or "massaging" action in the slurry, which embeds the

previously deposited fibers 68. In addition, the close, intermeshed and rotating relationship of the disks 74 prevents the buildup of slurry 46 on the disks, and in effect creates a "self-cleaning" action which significantly reduces production line downtime due to premature setting of clumps of slurry.

[00207] The intermeshed relationship of the disks 74 on the shafts 76 includes a closely adjacent disposition of opposing peripheries of the small diameter spacer disks (not shown) and the relatively large diameter main disks 74, which also facilitates the self-cleaning action. As the disks 74 rotate relative to each other in close proximity (but preferably in the same direction), it is difficult for particles of slurry to become caught in the apparatus and prematurely set. By providing two sets of disks 74 which are laterally offset relative to each other, the slurry 46 is subjected to multiple acts of disruption, creating a "kneading" action which further embeds the fibers 68 in the slurry 46.

[00208] An embodiment of embedment device 70 suitable for use in production line 10 is disclosed in greater detail in co-pending United States Patent Application No. 10/665,541, filed September 18, 2003, published as US 2005/0064055, and entitled EMBEDMENT DEVICE FOR FIBER-ENHANCED SLURRY, and incorporated herein by reference in its entirety.

#### [00209] APPLYING ADDITIONAL LAYERS

[00210] Once the fiber 68 has been embedded, a first layer 77 of the panel 92 is complete. In a preferred embodiment, the height or thickness of the first layer 77 is in the approximate range of 0.25 to 0.27 inches. This range has been found to provide the desired strength and rigidity when combined with like layers in a cementitious armor panel.

[00211] To build a structural cementitious panel of desired thickness, additional layers are typically added. To that end, a second slurry feeder 78, substantially identical to the feeder 44, is provided in operational relationship to the moving carrier 14, and is disposed for deposition of an additional layer 80 of the slurry 46 upon the existing layer 77.



[00212] Next, an additional chopper 82, substantially identical to the choppers 36 and 66, is provided in operational relationship to the frame 12 to deposit a third layer of fibers 68 provided from a rack (not shown) constructed and disposed relative to the frame 12 in similar fashion to the rack 31. The fibers 68 are deposited upon the slurry layer 80 and are embedded using a second embedment device 86. Similar in construction and arrangement to the embedment device 70, the second embedment device 86 is mounted slightly higher relative to the moving carrier web 14 so that the first layer 77 is not disturbed. In this manner, the second layer 80 of slurry and embedded fibers is created.

[00213] Referring now to FIG. 2, with each successive layer of settable slurry and fibers, an additional slurry feeder station 78 followed by a fiber chopper 82 and an embedment device 86 is provided on the production line 10. In the preferred embodiment, two total layers topped by a final slurry layer are provided to form the cementitious armor panel.

[00214] A final layer of slurry is deposited over the layer 80 in a third slurry feeder station 78 to produce the final additional layer 88 which is passed through a screed bar 146 to smooth the top surface of the slurry to produce a uniform layer 98 with a nominal thickness of about 0.5 inches, before the slurry is cut to length (typically 8 foot lengths) using cutter blade 98.

[00215] An important feature of the present invention is that the panel has multiple layers which will upon setting, form an integral, fiber-reinforced mass. Provided that the presence and placement of fibers in each layer are controlled by and maintained within certain desired parameters as is disclosed and described herein, it will be virtually impossible to delaminate the panel 92 produced by the present process.

#### [00216] FORMING AND SMOOTHING AND CUTTING

[00217] Upon the disposition of the two layers of fiber-embedded settable slurry as described above, a forming device such as a screed bar as mentioned

above is provided to the frame 12 to shape an upper surface 96 of the panel 92.

[00218] However, forming devices which scrape away excess thickness of cementitious armor panel material are not desired. Example of forming devices which are not employed include such as spring-loaded or vibrating plates or vibrating leveling screeds designed to conform the panel to suit desired dimensional characteristics are not used with cementitious armor panel material since they scrape away excess thickness of cementitious armor panel material. Such devices would not effectively scrape away or flatten the panel surface. They would cause the fiberglass to begin to roll up and mar the surface of the panel instead of flattening and smoothing it.

[00219] In particular, the production line 10 may include a smoothing device, also termed a screed bar 146, provided to the frame 12 to gently smooth an upper surface 96 of the panel 92. By applying vibration to the slurry 46, the smoothing screed bar 146 facilitates the distribution of the fibers 30, 68 throughout the panel 92, and provides a more uniform upper surface 96.

[00220] At this point, the layers of slurry have begun to set, and the respective panels 92 are separated from each other by a cutting device 98, which in a typical embodiment is a water jet cutter. Other cutting devices, including moving blades, are considered suitable for this operation, provided they can create suitably sharp edges in the present panel composition. The cutting device 98 is disposed relative to the line 10 and the frame 12 so that panels are produced having a desired length, typically 8 ft. lengths. Since the speed of the carrier web 14 is relatively slow, the cutting device 98 may be mounted to cut perpendicularly to the direction of travel of the web 14 in 8 ft. lengths. The panels are then allowed to dry during an 8-72 hour period after the slurry is wet cast i.e. after it leaves the screed bar.

[00221] The production line 10 includes sufficient fiber chopping stations 36, 66 slurry feeder stations 44, 78 and embedment devices 70, 86 to produce at least two layers. Additional layers may be created by repetition of stations as described above in relation to the production line 10.

[00222] To obtain a cementitious armor panel with both faces or sides smooth, both upper and lower faces of the 4 ft. x 8 ft. panels are sanded and are then optionally sawed to a desired size typically from about 2 x 2 feet up to about 4 x 8 feet, e.g., 2.5 x 4 foot panels, for subsequent processing and packaging.

[00223] Controlled Rate of Compressive Strength Development

[00224] Typically the cementitious composition is cured to achieve a controlled rate of compressive strength development. Desirably achieved is an ultra-high strength cementitious composite material with up to 5-day compressive strength of preferably less than 4000 psi, more preferably less than 3000 psi, and most preferably less than 2000 psi, and 28-day and later age compressive strength in excess of 20,000 psi.

[00225] For example some desirable rates of controlled compressive strength development are listed in TABLE 2I.

[00226] TABLE 2I

<b>Controlled Rate of Compressive Strength Development</b>	
Rate of Compressive Strength Development	Preference Type
An ultra-high strength cementitious composite material with 1-day compressive strength of preferably less than 4000 psi, more preferably less than 3000 psi, and most preferably less than 2000 psi, and 28-day and later age compressive strength in excess of 20,000 psi	Preferred
An ultra-high strength cementitious composite material with 2-day compressive strength of preferably less than 4000 psi, more preferably less than 3000 psi, and most preferably less than 2000 psi, and 28-day and later age compressive strength in excess of 20,000 psi	More Preferred than the Previous
An ultra-high strength cementitious composite material with 3-day compressive strength of preferably less than 4000 psi, more preferably less than 3000 psi, and most preferably less than 2000 psi, and 28-day and later age compressive strength in excess of 20,000 psi	More Preferred than the Previous
An ultra-high strength cementitious composite material with 4-day compressive strength of preferably less than 4000 psi, more preferably less than 3000 psi, and most preferably less than 2000 psi, and 28-day and later age compressive strength in excess of 20,000 psi	More Preferred than the Previous
An ultra-high strength cementitious composite material with 5-day compressive strength of preferably less than 4000 psi, more preferably less than 3000 psi, and most preferably less than 2000 psi, and 28-day and later age compressive strength in excess of 20,000 psi	Most Preferred

[00227] Applying Skins

[00228] After sufficient curing, the cut panels are coated with an adhesive, typically in nip rollers, and then the reinforcing skin is placed on the top surface of the panel and then run through another pair of nip rollers to laminate the skin reinforcing layer to the cementitious core. The panel is then turned and the laminating procedure repeated for the other side of the panel.

[00229] In one embodiment, the cementitious panels would be sanded and then the adhesive and fiber reinforced polymer skin layer would be applied to the still wet cementitious core and then the cementitious panel with the FRP skin would be run under a screed bar or roller.

[00230] Typical Uses of the Invention

[00231] Select embodiments of the present invention are suitable for fabricating inexpensive structural panels, such as thin concrete armor panels that may be used for vehicles as well as fixed structures. Structural armor panels may be formed or extruded to a thickness heretofore impractical because of the improved toughness and strength of embodiments of the present invention. For example, panels may be produced in size and thickness to accommodate man-portability. These man-portable panels may be configured for attaching to a structural framework to resist penetration of small arms fire and mitigate blast and fragmentation effects.

[00232] Military forces use a variety of protective materials ranging from soil cover to expensive, high-performance, lightweight ballistic ceramics. An embodiment of the present invention, configured appropriately, offers an inexpensive solution for force protection in addition to man-portable products. Applications for embodiments of the present invention include but are not limited to the military and government applications: very high performance concrete incorporated in inexpensive ballistic armor; light weight structural shapes such as plates, channels, pipes, tubes, I- and WF-sections; connectors; protective construction; blast-resistant panels; fragmenting munitions protection; vehicle up-armoring; forced entry resistant structural elements and the like.

[00233] For commercial users: building construction products, such as roofing tiles, wall panels, floor tiles, and the like; lightweight structural shapes such as plates, channels, pipes, tubes, I- and WF-sections; hurricane and tornado resistant structural elements, forced entry resistant structural elements, and the like.

[00234] EXAMPLES:

[00235] The flow properties and self-leveling behavior of the cementitious compositions of this invention were characterized using the slump test. The slump test used in the following experiments utilizes a hollow cylinder 5.08 cm. (2 inches) in diameter and 10.16 cm. (4 in.) in length kept vertically on a smooth plastic surface. The cylinder is filled up to the top with the cementitious mixture followed by striking off the top surface to remove the excess slurry mixture. The cylinder is then gently lifted up vertically to allow the slurry to come out from the bottom and spread on the plastic surface to form a circular patty. The diameter of the patty is then measured and recorded as the slump of the material. Compositions with good flow behavior yield a larger slump value.

[00236] To make use of conventional, high-efficiency manufacturing methods for producing cement-based products, it is desirable that the cementitious slurries with a slump value of less than 12.7 cm (5 in.) since slurries with slump values greater than 12.7 cm (5.0 in.) are extremely difficult to handle and process using the conventional manufacturing methods.

[00237] The influence of various raw material variables on the flow properties and self-leveling behavior was determined using the slump test in the examples described below.

[00238] Example 1

[00239] Slump was measured by pouring slurry into a 2 inch diameter cylinder that is 4 inches tall (open on each end and placed on end on a flat smooth surface) and screeding the top of the slurry off. This provides a set volume of slurry for every test. Then the cylinder was immediately lifted and

the slurry rushed out the open bottom end of the cylinder. This act formed a circular “patty” of slurry. The diameter of this patty is measured in inches and recorded. More fluid slurry will typically result in a larger diameter patty.

[00240] TABLE 3 shows the influence of silica sand content as the inorganic mineral filler on slump of the cementitious mixtures. The other raw materials in the various mixtures were held constant. As the results show, the slump of the cementitious mixtures decreases with an increase in the silica sand content in the mixture.

[00241] Typical formulations for the mixtures in TABLE 3 through 7 are shown in the above discussed TABLE 1.

[00242] TABLE 3

Mixture Identification	Inorganic Mineral Filler Content as Silica Sand*	Slump Inches (cm)
Mix 1	1.82	3 in. (7.6 cm)
Mix 2	1.35	5 in. (12.7 cm)
Mix 3	0.85	7 in. (17.8 cm)
* Silica sand content expressed as a weight ratio with respect to the total cementitious materials, where the inorganic cementitious binder (Portland cement) and pozzolanic micro filler (silica fume) are considered as cementitious materials in the composition. For example, for Mix 1, 1.82 parts by weight of silica sand is present for each 1 part by weight of combined inorganic cementitious binder and pozzolanic filler.		

[00243] Example 2

[00244] TABLE 4 shows the influence of the particle size of silica sand on slump of the cementitious mixtures. Two types of silica sand were used, the first with a median particle size of about 200 microns and the second with a median particle size of about 10 microns. The other raw materials were maintained constant. As shown in the table, the slump of the cementitious mixtures decreased significantly with the use of finer silica sand in the composition.

[00245] TABLE 4

Mixture	Inorganic Mineral Filler Type	Slump in inches (cm)
Mix 4	Coarse Silica Sand with 200 microns median particle size <sup>1</sup>	7 in. (17.8 cm)
Mix 5	Fine Silica Sand with 10 microns median particle size <sup>2</sup>	2 in. (5.1 cm)
<sup>1</sup> Coarse silica sand – US Silica F-55 unground silica		
<sup>2</sup> Fine silica sand – US Silica MIN-U-SIL 40 ground silica		

[00246] Example 3

[00247] TABLE 5 shows the influence of silica fume pozzolanic micro filler content on the slump of the cementitious mixture with all other raw materials maintained constant. It can be observed that the slump of the cementitious mixtures decreases with an increase in the content of silica fume in the mixture.

[00248] TABLE 5

Mixture	Silica Fume Content <sup>1</sup>	Slump in inches (cm)
Mix 6	15 %	9.5 in. (22.8)
Mix 7	25%	6 in. (15.2)
Mix 8	35 %	3 in. (7.6)
<sup>1</sup> Silica Fume content expressed as a weight % of total cementitious materials, where Portland cement and Silica sand are considered as cementitious materials in the mixture. For example, Mix 6 contains 15 parts by weight silica fume and 85 parts by weight combined portland cement and silica sand.		

[00249] Example 4

[00250] TABLE 6 shows the influence of self-leveling agent on slump of the cementitious mixture. Two types of chemical admixtures were used, polycarboxylate and polynaphthalene-sulfonate chemistry based compounds, with the others materials remaining constant. The slump of the mixture



containing polycarboxylate chemistry based admixtures was significantly higher than the mixtures containing the polynaphthalene-sulfonate based additive.

[00251] TABLE 6

Mixture	Self-leveling Agent (wt. % of total portland cement and silica fume)	Self-leveling Agent Content (wt. % of total portland cement and silica fume)	Slump in inches (cm)
Mix 9	Adva® Cast polycarboxylate (W.R.Grace, Columbia, MD)	3.0	6.75 in. (17.1)
Mix 10	DILOFLO GW 40 <sup>2</sup> Polynaphthalene-Sulfonate (Geo Specialty Chemicals, Horsham, PA 19044)	3.0	3.0 in. (7.6)

[00252] For example, for Mix 9, 3.0 parts by weight of self-leveling agent is present for each 100 parts by weight total portland cement and silica fume.

[00253] Example 5

[00254] TABLE 7 shows the influence of the content of polycarboxylate self-leveling agent content on the slump values for mixtures that are otherwise the same. It can be seen that the slump increase with the increase of the amount of agent used in the mixture.

[00255] TABLE 7

Mixture	Content of Adva Cast® polycarboxylate (wt.% of total portland cement and silica fume)	Slump in inches (cm)
Mix 11	1.0	3.0 (7.6)
Mix 12	2.0	6.75 in (17.1)
Mix 13	3.0	9.0 in (22.9)

[00256] Example 6

[00257] TABLE 8 shows the compressive strength of the self-leveling cementitious compositions of the invention. It can be observed that these mixtures yield ultra-high compressive strengths, typically in excess of 20,000 psi.

[00258] Slump was measured by filling a 4 in. tall by 2 in. diameter brass cylinder with the mixture, screeding the top edge of the cylinder to remove excess material, vertically lifting the cylinder within 5 seconds to allow the slurry to spread out and measuring the diameter of the formed slurry patty. Compressive strength was determined on 2 in. cubes in accordance with the test method in ASTM C 109. Slump loss and compressive strength gain were measured over a period of up to 7 hours and up to 7 days, respectively. The compressive strength of these mixtures was also evaluated under accelerated curing conditions with 7-day old samples being submerged in water at 140°F (60°C) followed by 4 days drying in a ventilated oven at 175°F (79.4°C) followed by cooling and testing

[00259] TABLE 8

Ingredient	Results	Mix 14 06/17/05 (wt %)	Mix 15 01/24/06 (wt %)	Mix 16 03/10/06 (wt %)	Mix 17 04/04/06 (wt %)
Portland Cement Type 1 Inorganic Cementitious Binder		37.0	37.6	37.0	37.0
Silica Fume Pozzolanic micro filler		6.5	6.6	6.5	6.5
Silica Sand <sup>1</sup> (coarse silica sand-US Silica F-55 unground silica) inorganic mineral filler		45.7	46.5	45.7	45.7
Polycarboxylate polyether Adva Cast 500® self leveling chemical agent		2.2	2.2	1.5	1.3
Water		8.7	7.1	9.3	9.6
	Slump inches (cm)	8.0	8.0	8.0	8.0
	Compressive Strength in psi (MPa)	20990 (144.7 MPa)	20119 (138.7 MPa)	20963 (144.5 MPa)	21026 (145 MPa)

[00260] Example 7

[00261] Fiber reinforced cement-based panels were manufactured using the self-leveling cementitious composition of the invention with alkali-resistant glass fibers using a Spray-up method.

[00262] In the Spray-up method, the slurry may be combined with the glass fibers in several ways, with the objective of obtaining a uniform mixture. The glass fibers typically will be in the form of rovings that are chopped into short lengths. In a preferred embodiment, the slurry and chopped glass fibers are concurrently sprayed into a panel mold. Preferably, spraying is done in a number of passes to produce thin layers, preferably up to about 0.25 inches thick, which are built up into a uniform panel having no particular pattern and with a thickness of  $\frac{1}{4}$  to 1 inch. For example, in one application, a 3 x 5 ft. panel was made with six passes of the spray in the length and width directions. As each layer is deposited, a roller may be used to assure that the slurry and the glass fibers achieve intimate contact. The layers may be leveled with a screed bar or other suitable means after the rolling step.

[00263] Typically, compressed air will be used to atomize the slurry. As it emerges from the spray nozzle, the slurry mixes with glass fibers that have been cut from a roving by chopper mechanism mounted on the spray gun. The uniform mixture of slurry and glass fibers is deposited in the panel mold as described above.

[00264] The nominal thickness of the manufactured panels was  $\frac{1}{2}$  inch and the volume fraction of glass fibers in the panels was 3%. TABLE 9 shows the flexural performance of the fiber-reinforced, self-leveling, ultra-high strength cementitious compositions. The formulation of TABLE 9 is Mix 17 of TABLE 8. The modulus of elasticity of the panels exceeded 5000 ksi, which is almost twice the modulus of elasticity of the full density normal strength concrete material. The flexural strength of the fiber reinforced panels was in excess of 3000 psi. The ASTM C1325 test method was used for modulus and the ASTM C947 test method was used for flexural strength.

[00265] TABLE 9

Ingredients	Formulation Mix (Wt. %)	Test	Results
Portland Cement Type 1	37.0		
Silica Fume	6.5		
Silica Sand (coarse silica sand- US Silica F-55 unground silica)	45.7		
Adva Cast 500® Polycarboxylate Leveling Agent	1.3		
Water	9.6		
		Modulus of Elasticity (ksi)	5140 ksi
		Flexural Strength (psi)	3105 psi

## [00266] Examples With Triethanolamine (TEA) And Tartaric Acid

[00267] The following examples are provided to illustrate the benefits of using admixtures of a preferred alkanolamine, triethanolamine and a preferred acid, tartaric acid at appropriate dosages. All mixtures contain Portland cement and silica fume as cementing components at a relative weight ratio of 0.85 to 0.15 and silica sand as filler at a weight ratio of 1.05 to 1.00 relative to the cementing components. Water was used at a weight ratio of 0.22 to 1.00 relative to the cementing components. The specified chemical admixtures of a carboxylated polyether superplasticizer, triethanolamine (TEA 99 Low Free Grade (LFG) 85% TEA and 15% water) and tartaric acid were added in the

amounts listed in the following examples to control mixture fluidity, set time and strength gain.

[00268] All of the ingredients were pre-conditioned in sealed plastic bags at 75-80°F for at least 24 hours prior to mixing in a Hobart mixer at high speed to achieve uniform dispersion. The temperature rise in the mixtures was measured by use of thermocouples embedded into 350 g. samples of each mixture and connected to a data acquisition system. Initial and final set times were determined using Gilmore needles in accordance with the method in ASTM C 266.

[00269] Slump and compressive strength were determined in accordance with the test methods described above in Example 6.

[00270] Example 8

[00271] Three mixes were prepared in accordance with the above procedure using the superplasticizer at 3% by weight of the cementing components to control mix fluidity and tartaric acid at levels of 0% (control), 0.15% and 0.30% by weight of the cementing components. No TEA was added to the sample mixes. The slump of the mixes was determined to be 7.5 in. (19.1 cm) for the control, 10.3 in. (26.2 cm) for the mix containing 0.15 % tartaric acid and 10.8 in. (27.4 cm) for the mix containing 0.30% tartaric acid.

[00272] FIG. 3 shows the temperature rise behavior of the mixes during the first 30 hours after casting. FIG. 3 shows the mixes with added tartaric acid did not exhibit setting during the first 24 hours compared to the control mix which set in about 10 hours.

[00273] FIG. 4 shows the compressive strength gains for up to 7 days. FIG. 4 shows the mixes with tartaric acid had a slower rate of compression strength gain in the first several days after mixing compared to the control, but at 7 days, the 0.15% and 0.30% tartaric acid mixes achieve higher strengths (19346 psi and 23759 psi, respectively ) compared to the control (19065 psi).

[00274] Example 9

[00275] In this example, the combined effects of addition of both tartaric acid and TEA were evaluated. All of the mixes contained cementing components, water and superplasticizer in the proportions in Example 8 and TEA was added to all mixes at 0.045% by weight of the Portland cement. Tartaric acid was at 0%, 0.30% and 0.40% by weight of the cementing components. The slump of the mixes was measured to be 5.9 inches (15.0 cm), 9.9 in. (25.1 cm), and 9.3 inches (23.6 cm) for the control and the 0.30% and 0.40% tartaric acid samples, respectively. The slump loss for these mixes was measured and is shown in FIG. 5. FIG. 5 shows the addition of tartaric acid to the TEA resulted in extended fluidity of the mix over 2-3 additional hours, followed by a sharp drop in fluidity at around 2 hours for the 0.30% tartaric acid mix and 3 to 3.5 hours for the 0.40% tartaric acid mix, followed by setting.

[00276] This extended period of workability compared to the control allows sufficient time for panels to be formed and cut in a forming line, while setting immediately after slump loss of 3-4 hours allows for transportation and handling of the panels after forming without sagging. The mix without tartaric acid experienced rapid slump loss within the first half hour after mixing and remained in a thick plastic state until it set at around 10-11 hours.

[00277] FIG. 6 shows the temperature rise behavior of the three mixes in the first 30 hours after casting. This shows the relatively faster set of the mixes containing tartaric acid.

[00278] FIG. 7 shows compressive strength gain of the tested mixes over the first 2-3 days after mixing. The tartaric acid mixes exhibited slower strength gains, which allows more time for finishing the panels. At 7 days, both tartaric acid mixes attained about 10% higher strength than the control mix. The accelerated strength for the 0%, 0.30% and 0.40% tartaric acid mixes was 22549, 22847 and 20418 psi, respectively.

[00279] Example 10

[00280] Mixes were prepared using cement components and water in proportions similar to those in Examples 8 and 9. Tartaric acid was added at 0.40% by weight of cementing components and TEA was added at 0.045% by weight of Portland cement. The amount of superplasticizer (SP) was varied at 1%, 2% and 3% by weight of the cementing components. The resulting slump of the mixes was 8.8 in. (22.4 cm), 9 inches (22.9 cm), and 10.3 inches (26.2 cm), respectively for the 1%, 2% and 3% SP mixes. For proper workability of the slurry, slump is preferably in the range of 5-7 inches (12.7-17.8 cm). Thus the level of SP can be reduced to 1%, i.e. only one-third its originally amount in the other composition embodiments when tartaric acid is added to the mix in the test amounts.

[00281] FIG. 8 shows the slump losses for the mixes. The mix with 1% SP maintained its fluidity for about 20 min., followed by a rapid drop in slump and eventual set at around 2.5 hours. The mixes containing more SP maintained fluidity for a longer period, but their slump also rapidly dropped followed by setting of the mix.

[00282] FIG. 9 shows the temperature behavior of these mixes during the first 30 hours after casting, with retardation of temperature increasing with higher levels of SP.

[00283] FIG. 10 shows compressive strength gain of these mixes, with no measurable difference noted among the mixes. The accelerated strength was 26145 psi, 25714 psi and 19096 psi respectively, for the 1%, 2% and 3% SP mixes.

[00284] An ultra-high strength cementitious composite material with 1-day compressive strength of preferably less than 4000 psi, more preferably less than 3000 psi, and most preferably less than 2000 psi, and 28-day and later age compressive strength in excess of 20,000 psi to 30,000 psi meets the requirements for rate of controlled compressive strength gain, and with a most



preferred rate of controlled compressive strength gain wherein the cementitious composite materials has with up to 5-days with compressive strength of less than 4000 psi and most preferably less than 2000 psi after 5 days and a 28-day and later age compressive strength of at least 10,000 psi and preferably in excess of 15,000 psi, more preferably in excess of 20,000 psi and more preferably in excess of 25,000 to 30,000 psi.

[00285]        Example 11

[00286]        Mixes containing cementing components and water in proportions similar to described in Examples 8-10 were made with 1.5% by weight SP based upon the weight of cementing components and TEA at a level of 0.045 % by weight of Portland cement. Tartaric acid content was varied at 0.40 %, 0.80% and 2.0% by weight of the cementing component. The slump of the mixes was measured as 8.8 inches (22.4 cm), 8.9 inches (22.6 cm), and 7.8 inches (19.8 cm) for the 0.40%, 0.80% and 2.0% tartaric acid mixes, respectively.

[00287]        FIG. 11 shows the slump loss behavior of these mixes. FIG. 12 shows the temperature rise. As shown in FIGS. 11 and 12, mixes with tartaric acid contents above 0.80% remained plastic and did not set within the first 24 hours.

[00288]        FIG. 13 shows the compressive strength gain of these mixes, where mixes with 0.80 % and 2.0 % tartaric acid had a much lower rate of strength gain. This is marginally suitable from the perspective of handling and finishing, especially in the first few hours after forming. The accelerated strength was 26478 psi, 24543 psi, and 1057 psi for the mixes with 0.40%, 0.80% and 2.0% tartaric acid, respectively. The mix with 2.0% tartaric acid does not have acceptable strength gain.

[00289]        Example 12

[00290] A preferred embodiment of the armor panel of the present invention is shown in FIG. 1, with a high-density, ultra-high strength cementitious core reinforced with discrete alkali-resistant glass fibers and a thin laminate composed of continuous glass fibers embedded in a resin and adhesively bonded to both surfaces of the cementitious core with an adhesive such as polyurethane adhesive.

[00291] Half inch thick, ultra-high strength cementitious core panels reinforced with alkali-resistant glass fibers were manufactured in accordance with the above examples using a continuous process. The nominal volume fraction of the fibers in the panel was 3.0%. The manufactured panels were sanded smooth and glass fiber reinforced polymer (FRP) laminates were bonded to both cementitious surfaces using polyurethane adhesive. The panels were tested in flexure under a third-point loading test over a span of 24 inches. The panels were tested in flexural performance of the panels subjected to different conditioning regimes. The results are shown in TABLE 10.

[00292] TABLE 10

Sample Conditioning	Sample Orientation	AMOE (ksi)	MOR (psi)	Max. Deflection (in.)
Dry	Face Up	3402	8445	1.50
Dry	Face Down	3962	10703	1.44
7-Days in 200°F Ventilation Oven + Cool to Room Temp.	Face Up	3516	9780	2.41
7-Days in 200°F Ventilation Oven + Cool to Room Temp.	Face Down	3573	12493	2.69

[00293] As shown above in TABLE 10, the panels achieved excellent flexural strength performance exceeding 8000 psi in all cases.

[00294] Cementitious armor panels were prepared in accordance with the present invention using the formulation in TABLE 11 for testing for velocity

attenuation of a projectile striking individual panels or a group of panels stacked together.

[00295] TABLE 11

Ingredient	Weight %
Portland Cement Type 1	37.6
Silica Fume	6.6
Silica Sand	46.5
Adva® Cast 500 Superplasticizer	2.2
Water	7.1
AR-Glass Fibers (NEG H-103)	3.0
Fraction % by Volume	

[00296] FIG. 14 shows a graph of Areal density versus velocity attenuation of a standard size projectile striking an individual cementitious armor panel or a group of panels stacked together. Areal density is mass per unit of area of the tested panel. FIG. 14 represents velocity attenuation for unfaced panels of the invention (using glass reinforcement) compared to unfaced panels with steel fiber. So FIG. 14 represents a comparison of the very high density cementitious material of the invention with glass fiber to standard density cementitious material with steel fiber. As shown in the graph in FIG. 14, the armor cementitious core panels of TABLE 11 of the present invention, even without the reinforcing FRP laminate reinforcing skin on its surfaces, provided better velocity attenuation than conventional steel fiber reinforced cementitious armor panel.

[00297] FIG. 15 represents velocity attenuation for faced panels of the invention (using glass reinforcement) compared to unfaced panels of the invention (using glass reinforcement). So FIG. 15 represents a comparison using faces or not using faces with panels of the invention. The data as presented demonstrates the impact of the addition of faces on the panel with respect to velocity attenuation. The graph in FIG. 15 shows velocity attenuation

of a projectile striking two, three and four cementitious armor panels of the formulation of TABLE 11 having a fiber reinforced skin layer of Kemlite ArmorTuf® woven glass fiber reinforced polyester laminate on both surface of the cementitious core panel compared to a similar number of stacked cementitious core panels having the same cementitious core structure but which do not have a fiber reinforced facing layer. This demonstrates the significant improvement in percent velocity attenuation achieved with the faced panels compared to the panels without the facing layer, particularly when multiple panels are used.

### Example 13

[00298] This example highlights the relative importance between SP and tartaric acid in imparting fluidity and self-leveling behavior to the formulation. Five mixes were evaluated with cementing components and water at proportions similar to those in previous examples, and with SP and tartaric acid at the contents shown in TABLE 12:

[00299]

<b>TABLE 12</b>		
<b>Mix</b>	<b>SP (% by wt. cementing components)</b>	<b>Tartaric acid (% by wt. cementing components)</b>
1	1.7	0.40
2	0.9	0.40
3	0.0	0.40
4	0.0	0.80
5	0.0	2.00

[00300] TEA was used in all mixes at a rate of 0.045% by weight of Portland cement. The slump of these mixes is shown in FIG. 16. It is seen here that despite the enhanced fluidity offered by the addition of tartaric acid to the mixes, this additive alone is not sufficient for proper fluidity and workability of the mix. Without SP, stiff, non-flowable mixes were produced. FIG. 17 shows the slump loss for Mix 1 which behaved in a similar manner to mixes

described in previous examples. Set times (initial and final) were also measured for these mixes using Gillmore needles. These results are shown in FIG. 18, where it is seen that beyond a tartaric acid content of 0.80%, setting of the mixes was significantly delayed (as also shown in the previous example).

#### Example 14

[00301] FIG. 19 shows a comparison of a cementitious armor panel of the present invention (no laminate) with a structural cementitious panel available from United Stages Gypsum Company and made according to US Patent Application Publication no. 2006/0174572 to Tonyan et al. (also no laminate) incorporated herein by reference. FIG. 19 represents unfaced panels of the invention (using glass reinforcement) compared to unfaced structural cementitious panels (using glass reinforcement). This is a comparison of the very high strength, high density core composition compared to a lower density core, with the lower density core that has a compressive strength in the range of 2000-3000 psi, and a density in the range of 70-80 pcf. FIG. 19 represents the impact of the high density, high strength core (with glass reinforcement) compared to a standard strength core (with glass reinforcement) on velocity attenuation.

[00302] While particular embodiments of the present invention have been shown and described, it will be appreciated by those skilled in the art that changes and modifications may be made thereto without departing from the invention in its broader aspects and as set forth in the following claims.

We claim:

1. A fiber reinforced, cementitious armor panel comprising:  
a cementitious core comprising a continuous phase resulting from the curing of an aqueous mixture of  
25-45 weight % inorganic cement binder,  
an absence of silica flour,  
35-65 weight % inorganic mineral filler having a particle size of about 150-450 microns,  
5-15 weight % pozzolanic filler having a median particle size of less than or equal to 50 microns,  
0.25-5.0 weight % polycarboxylate based self-leveling agent, and  
6-12 weight % water, and  
a skin layer attached to at least one surface of the cured continuous phase.
2. The panel of claim 1, wherein the cementitious core comprises reinforcing fiber in an amount of about 0.5-6.0 % by volume of the cementitious core uniformly distributed within the continuous phase before the continuous phase is cured.
3. The panel of claim 1, wherein the cementitious panel has a compressive strength of at least about 10,000 psi when cured.
4. The panel of claim 1, wherein the cementitious panel has a compressive strength of at least about 15,000 psi when cured.
5. The panel of claim 1, wherein the aqueous mixture comprises an alkanolamine in an amount of about 0.005 wt.% to about 0.500 wt.% by weight of the cement binder, and an acid or acid salt in an amount of

about 0.10 wt. % to about 1.80 wt.% by weight of the combined weight of the cement binder and pozzolanic filler.

6. The panel of claim 4, wherein the aqueous mixture comprises triethanolamine and tartaric acid.
7. The panel of claim 1, wherein the skin layer is a fiberglass reinforced plastic.
8. The panel of claim 1, wherein the skin layer is a fiberglass reinforced polyester.
9. The panel of claim 1, wherein the inorganic cement binder is Portland cement.
10. The panel of claim 1, wherein the compressive strength after 1 day curing is less than about 2000 to 4000 psi and the compressive strength develops to more than about 20,000 psi after curing for 28 days.
11. The panel of claim 2, wherein the reinforcing fibers are selected from the group consisting of glass fibers, metal fibers, polymer fibers and mixtures thereof.
12. The panel of claim 2, wherein the reinforcing fiber is glass fibers.
13. The panel of claim 1, wherein the weight ratio of pozzolanic filler to inorganic cement binder is about 0.05 to 0.30:1.0.
14. The panel of claim 1, wherein the weight ratio of inorganic mineral filler to the combined weight of inorganic cement binder and pozzolanic filler is about 0.75:1.0 to about 1.50:1.0.

15. The panel of claim 1, wherein the weight ratio of water to the combined weight of the inorganic cement binder and pozzolanic filler dry reactive powders is less than or equal to about 0.35:1.0.
16. The panel of claim 1, wherein the weight ratio of pozzolanic filler to inorganic cement binder is about 0.15 to about 0.20:1.0; the weight ration of inorganic mineral filler to the combined weight of inorganic cement binder and pozzolanic filler is about 0.90 to 1.10:1.0; and the weight ratio of water to the combined weight of the inorganic cement binder and pozzolanic filler dry reactive powders in the continuous phase is less than or equal to about 0.20:1.0.
17. The panel of claim 1, wherein the particle size of the inorganic filler is about 250 to about 350 microns.
18. The panel of claim 1, wherein the median particle size of the pozzolanic filler is less than about 0.1 microns.
19. The panel of claim 1, wherein the polycarboxylate based self-leveling agent is polycarboxylate polyether.
20. The panel of claim 1, wherein the pozzolanic filler is silica fume.
21. The panel of claim 1 wherein the inorganic mineral filler is silica sand.
22. The panel of claim 1, wherein the continuous phase comprises 0.75-2.5 weight % polycarboxylate polyether self-leveling agent.
23. The panel of claim 1, wherein the polycarboxylate polyether is present in an amount of about 0.75-1.0 weight %.



24. The panel of claim 2, wherein the glass fiber in the continuous phase of the cementitious core is present in about 3.0 to 3.5 % by volume of the continuous phase.
25. The panel of claim 1, wherein the alkanolamine is triethanolamine present in an amount of about 0.025 to about 0.075% by weight and the acid is tartaric acid and is present in an amount of about 0.40% to about 0.60% by weight based upon the weight of the cement components.
26. The panel of claim 1, wherein the pozzolanic filler is silica fume.
27. The panel of claim 1, wherein the polycarboxylate agent is an ether and is present in an amount of about 0.75% – 1.50 % by wt. of the cementitious mixture on a dry basis.
28. The panel of claim 1, wherein the polycarboxylate agent is present in an amount of about 1.00% - 1.25% by weight of the cementitious mixture on a dry basis.
29. The panel of claim 1, wherein the panel has been sanded and cut to size before said skin layer is attached to the surface of the panel.
30. The panel of claim 1, wherein the skin layer is a fiber reinforced polymer and adhesively laminated to the surface of the cementitious core.
31. The panel of claim 1, wherein the skin layer is a glass fiber reinforced polymer containing about 0.5 % to about 6% glass fibers by volume of the skin layer.
32. The panel of claim 31, wherein the glass fiber reinforced polymer is a woven fiber glass reinforced polyester.

33. The panel of claim 1, wherein the reinforcing skin layer is mechanically fastened to the cementitious core.
34. The panel of claim 1, wherein the skin layer is laminated to the surface of the core with an epoxy adhesive.
35. The panel of claim 1, wherein the pozzolanic mineral filler is silica fume.
36. The panel of claim 1, wherein at least one said skin layer is between opposed surfaces of two adjacent core layers.

FIG. 1

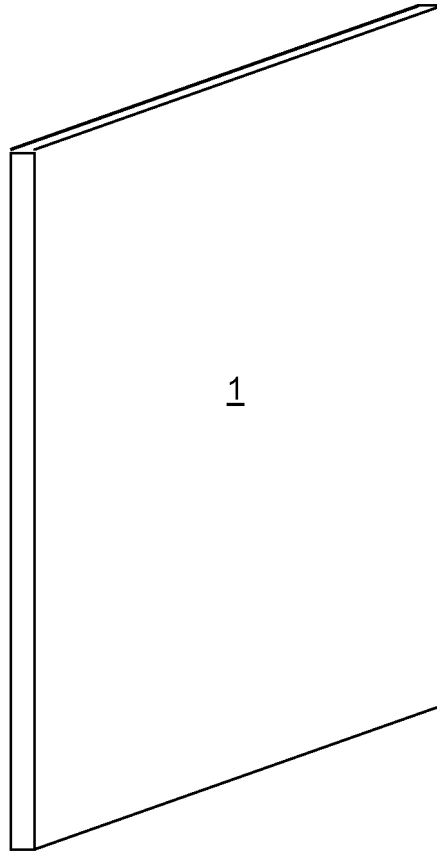


FIG. 1A

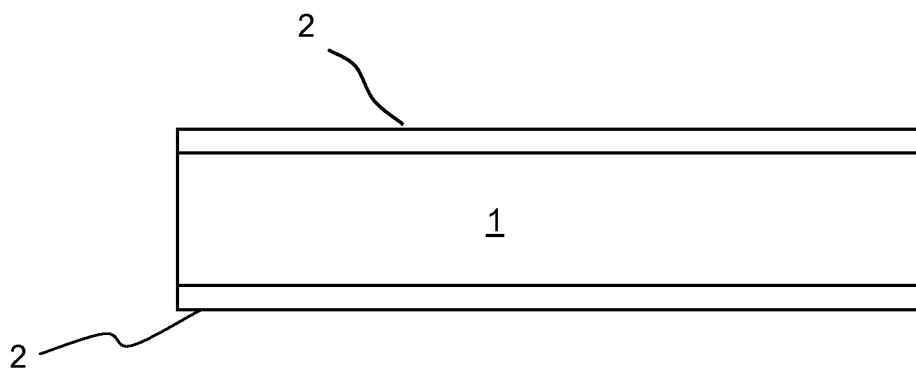


FIG. 1B

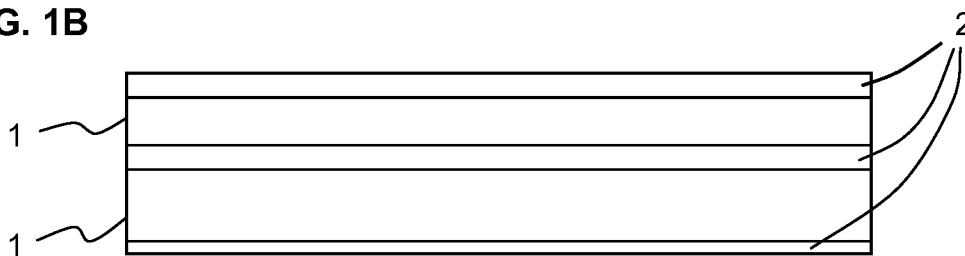


FIG. 2

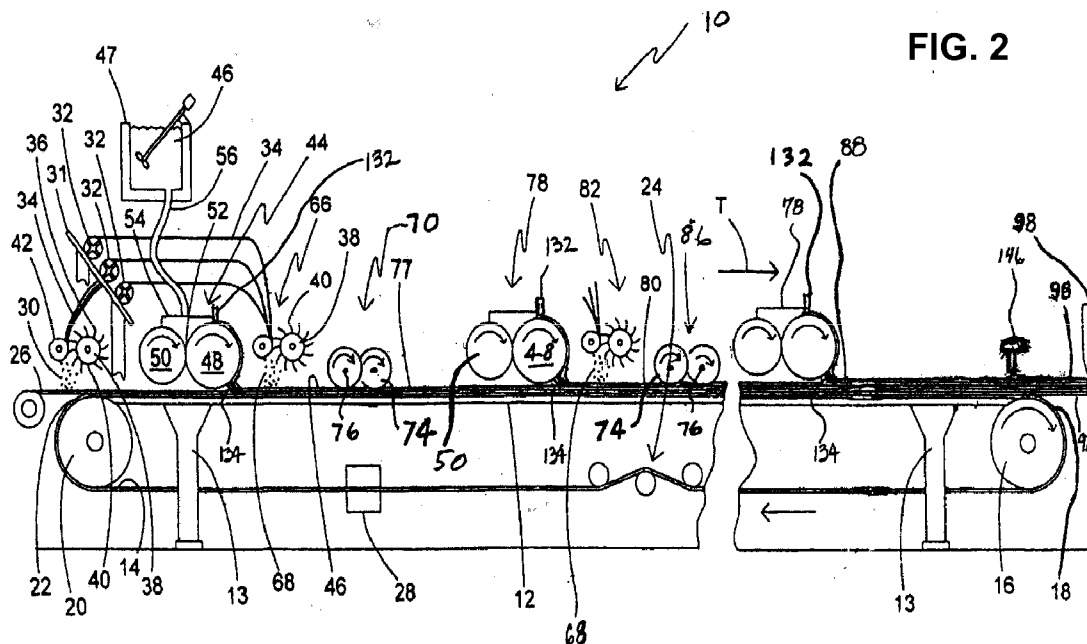


FIG. 3

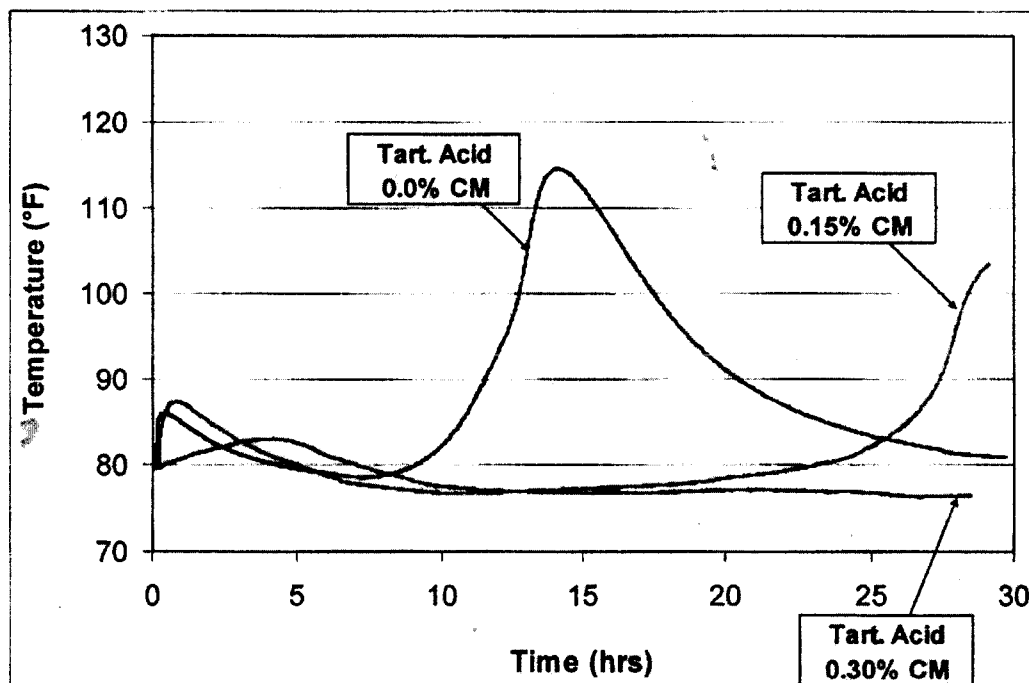


FIG. 4

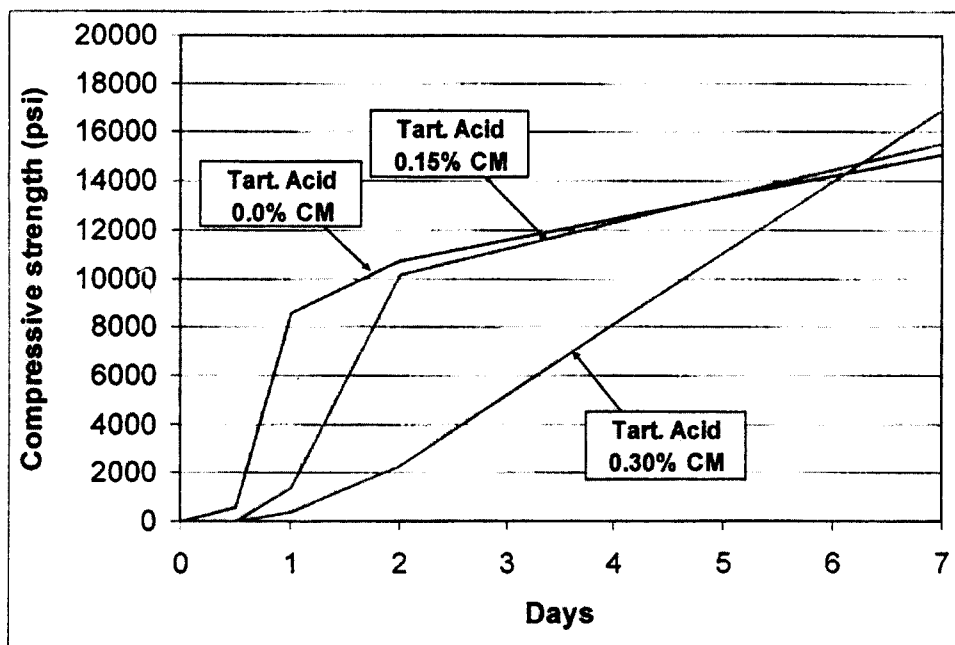


FIG. 5

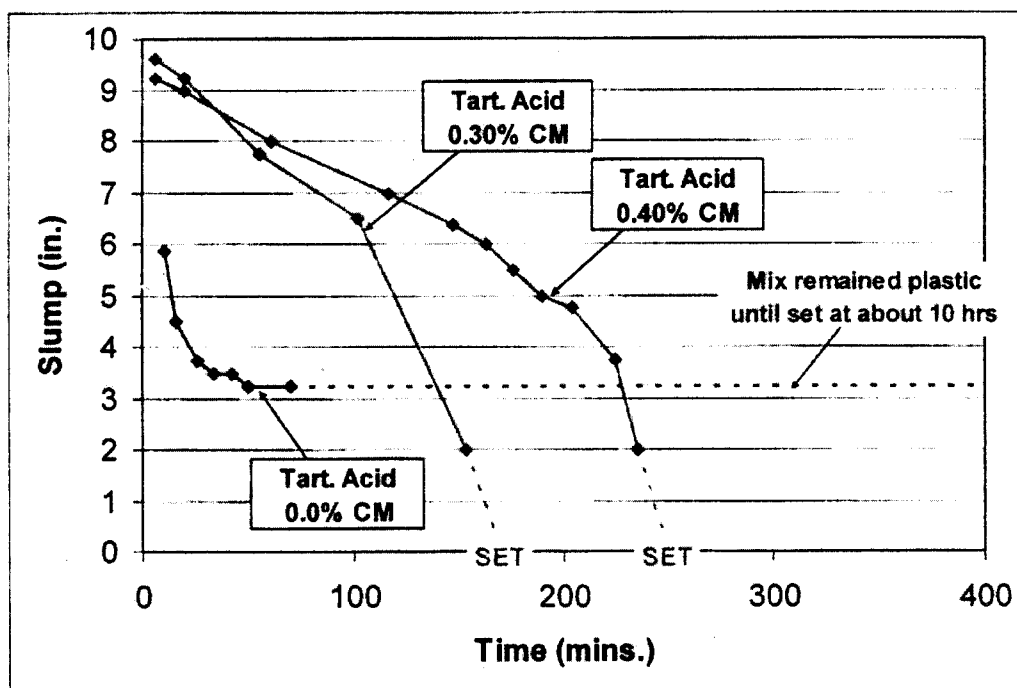


FIG. 6

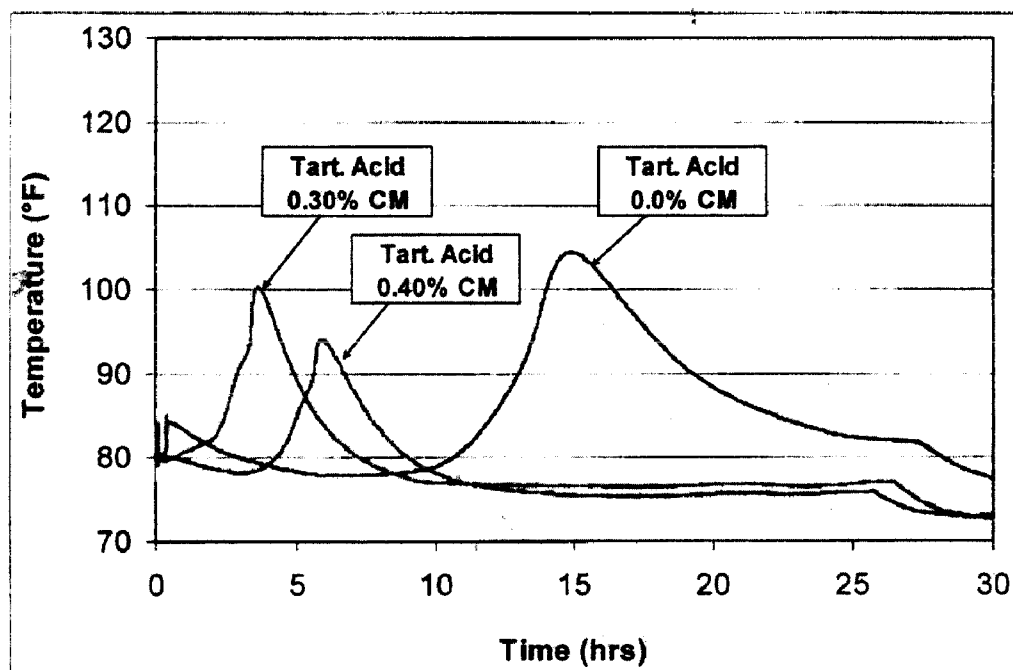


FIG. 7

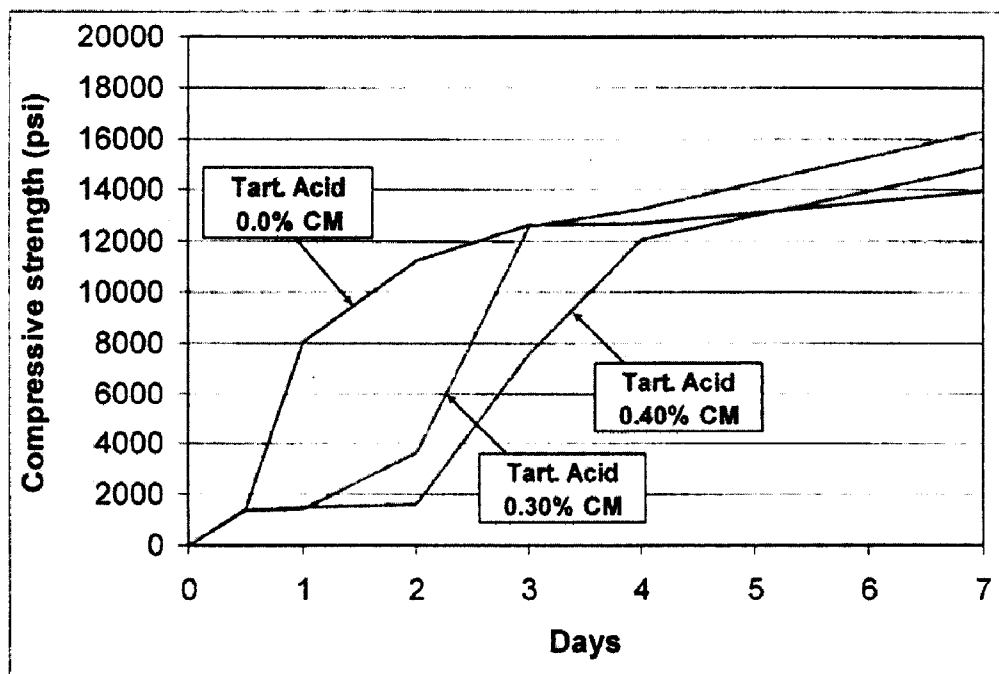


FIG. 8

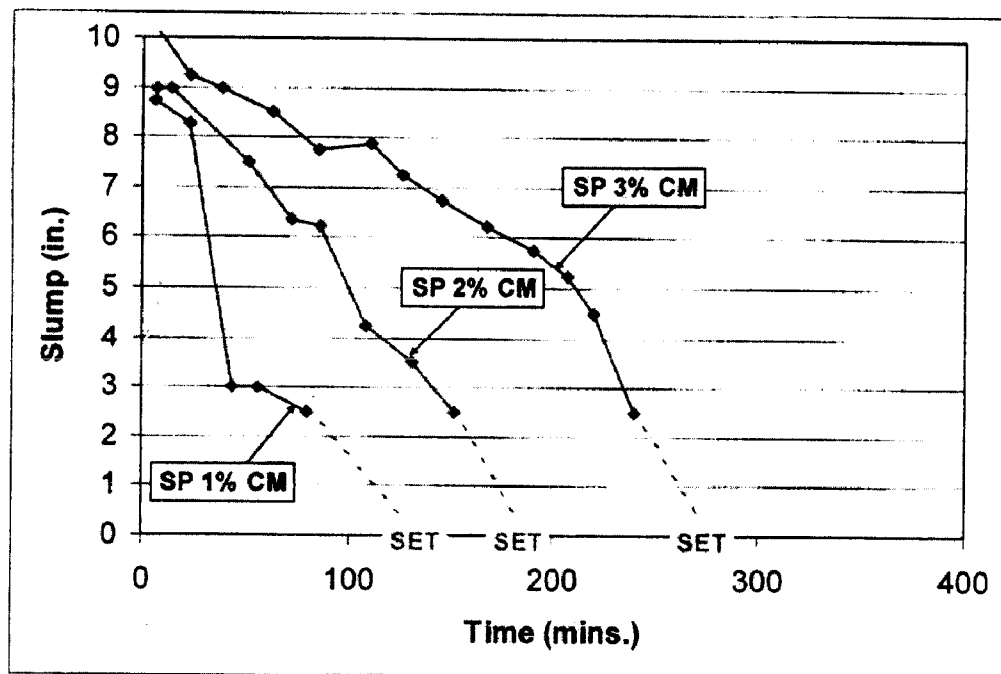


FIG. 9

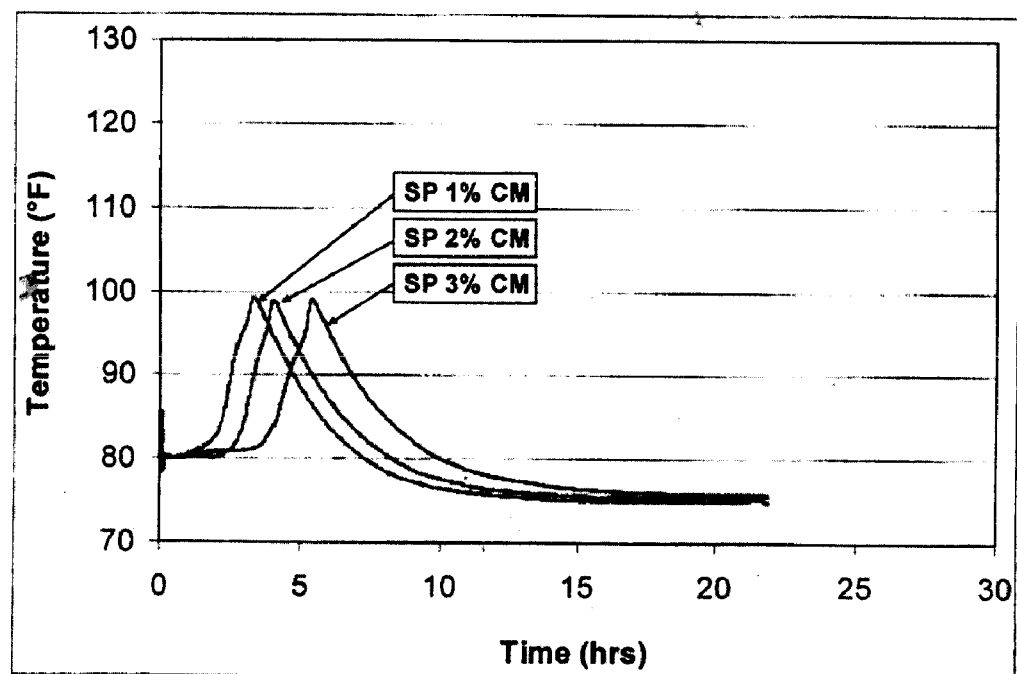


FIG. 10

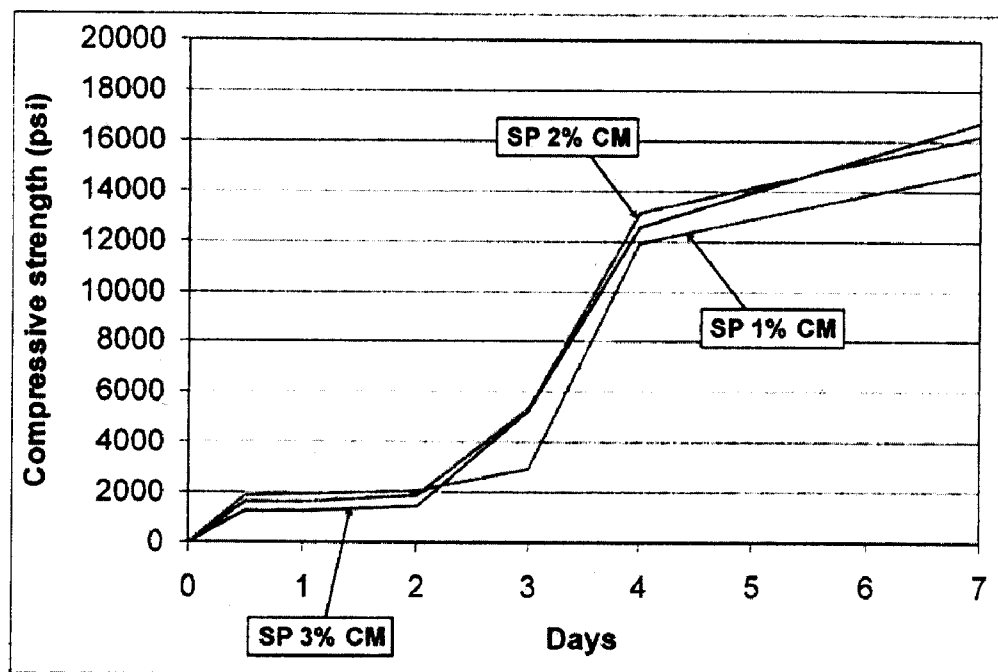


FIG. 11

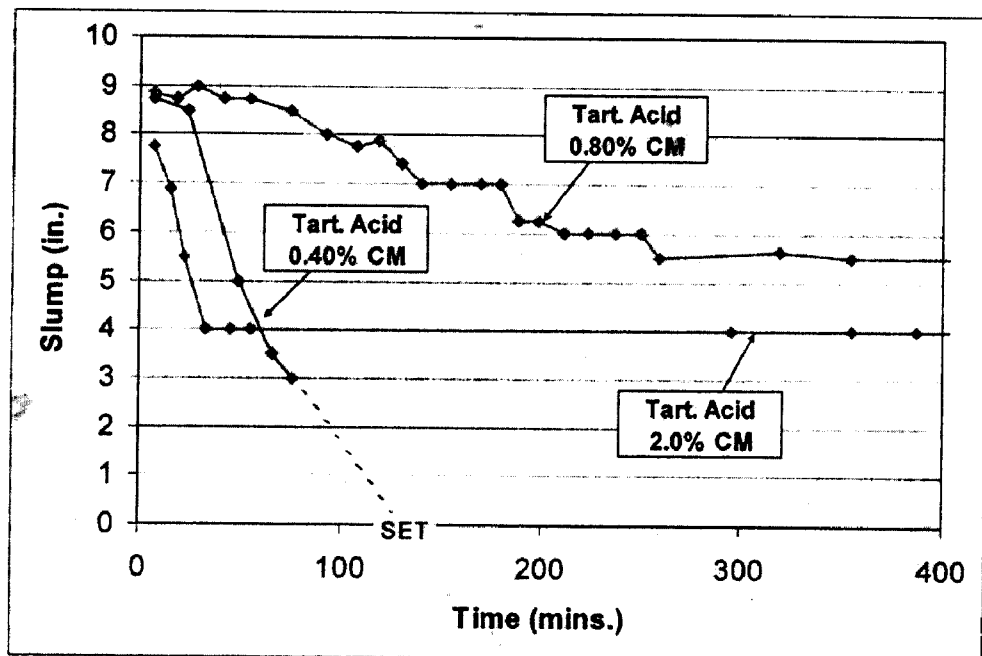




FIG. 12

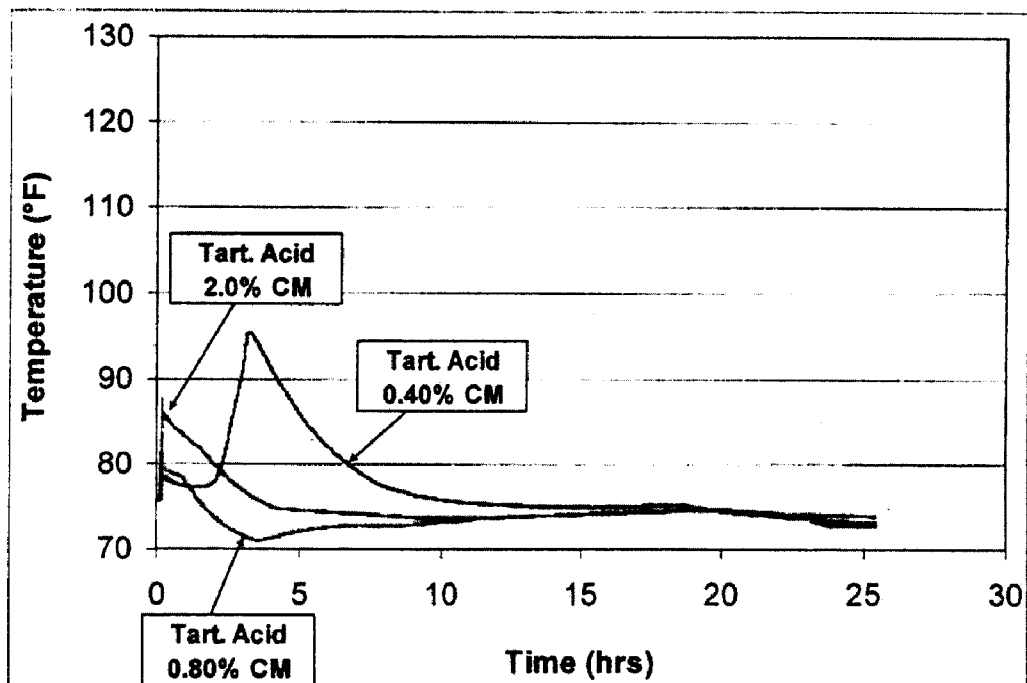


FIG. 13

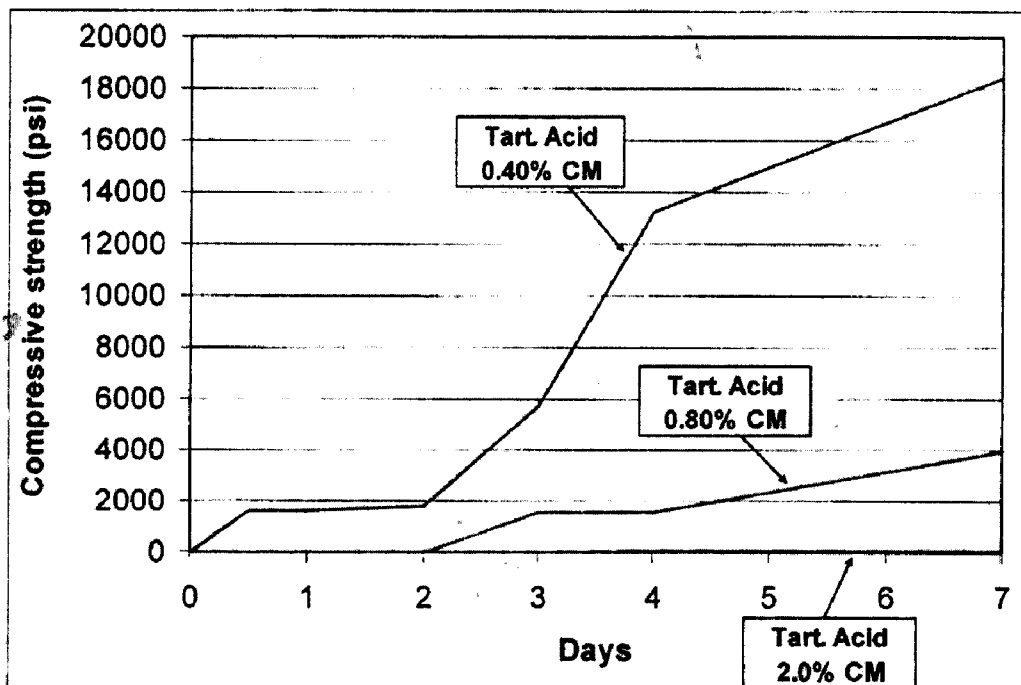


FIG. 14

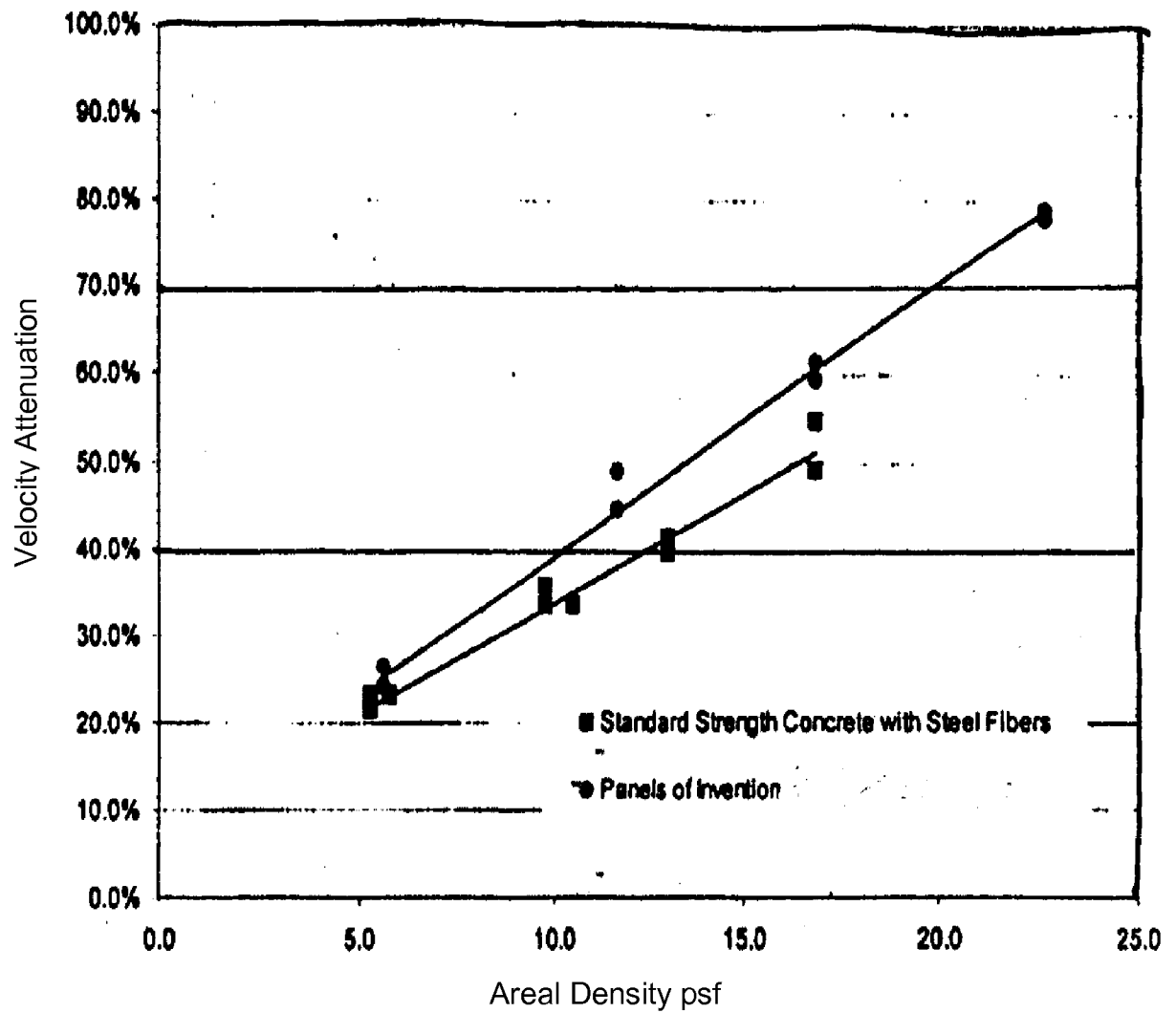
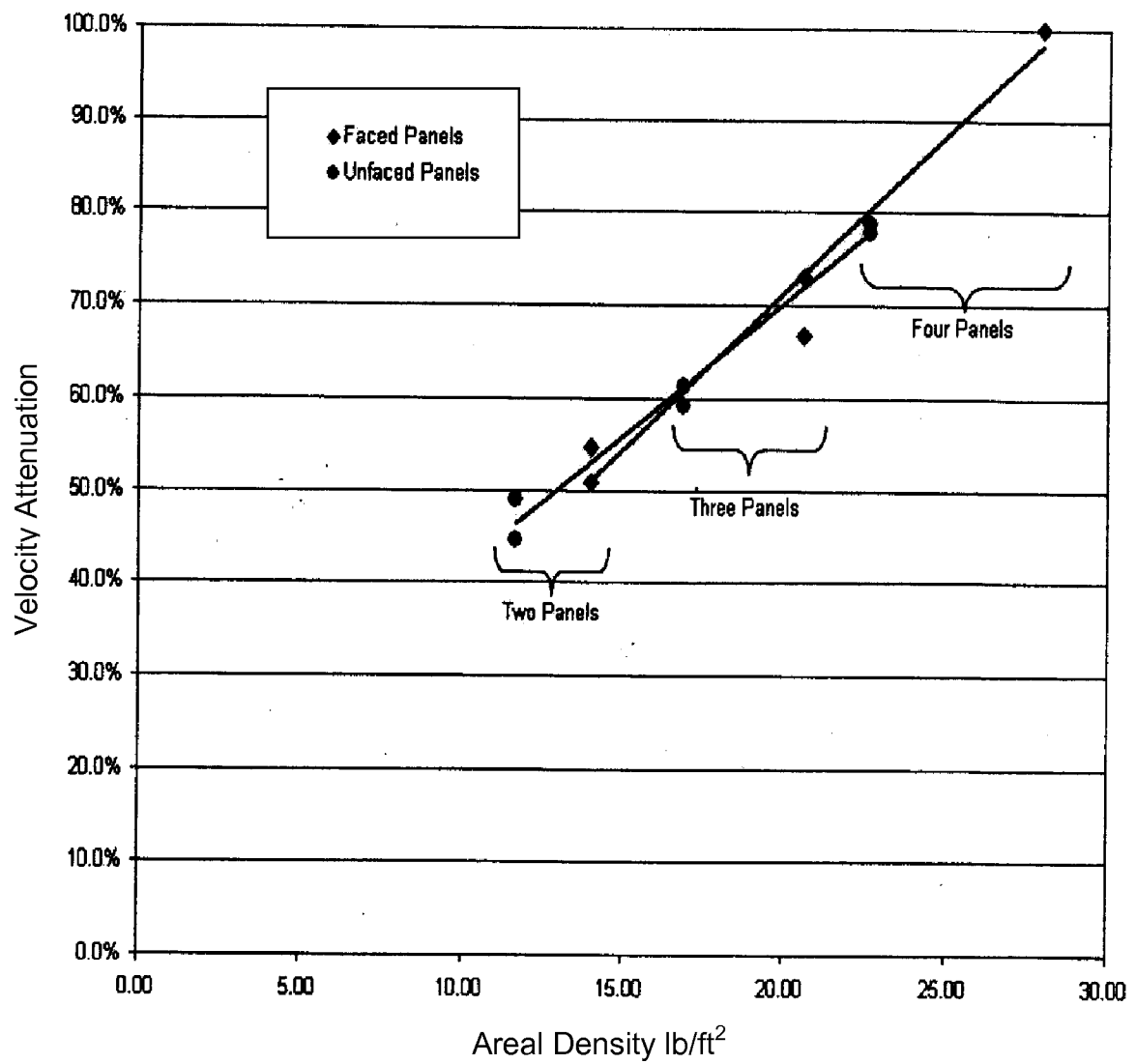
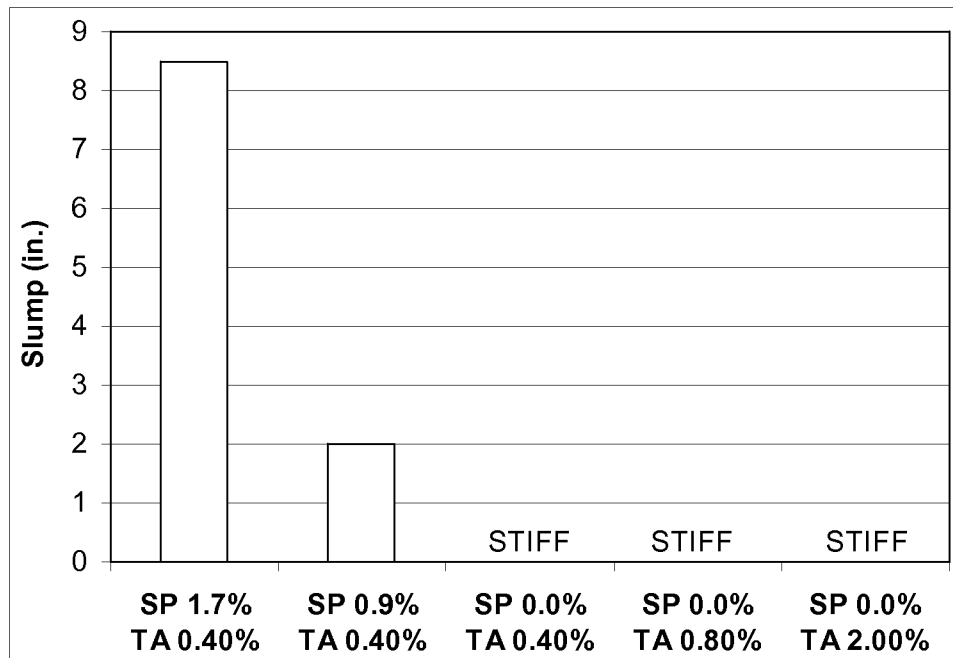


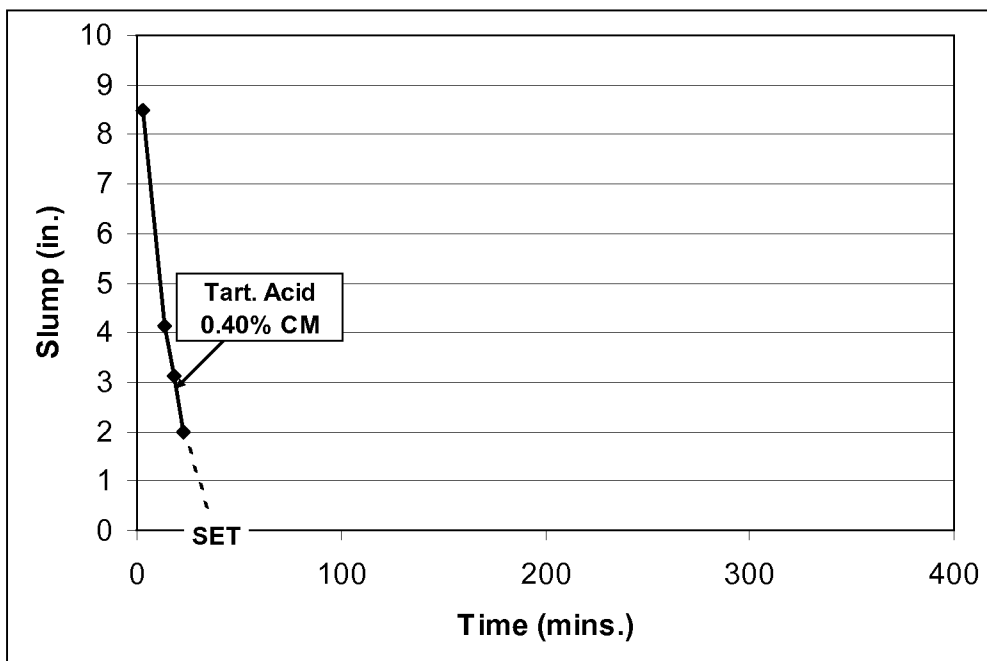
FIG. 15



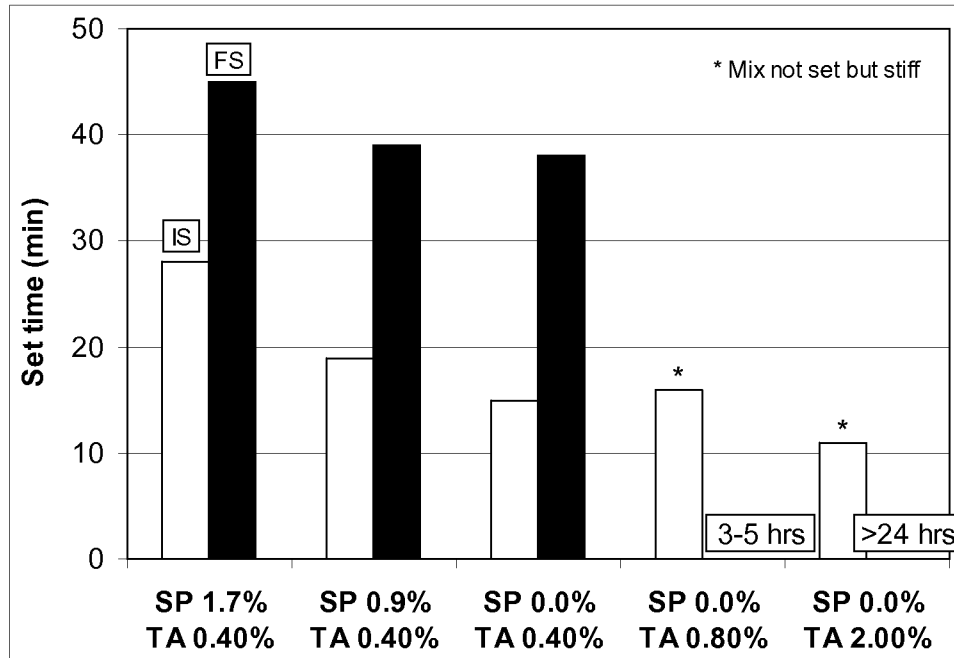
**FIG. 16 – Slump of mixes at varying SP and tartaric acid content.**



**FIG. 17 – Slump loss of Mix 1. (SP at 1.7% by wt. of cementing components, TEA at 0.045% by wt. of Portland cement)**



**FIG. 18 – Set time of mixes at varying SP and tartaric acid content (IS = Initial Set. FS = Final Set)**



**FIG. 19**

