

Title: High Surface Area Inducers For Cementitious
Aggregates Production

5

FIELD

[0003] Embodiments disclosed herein relate to a method for producing granular material or aggregates from concrete or other hydratable cementitious compositions, and more particularly to the use of an aggregate-forming inducer that provides a surface
10 anchoring site for cement paste to bond/adhere to, such as shredded paper, cardboard, glass or polymer fibers, and the like to so produce the granular material or aggregates.

BACKGROUND

[0004] In the U.S., approximately 4% of concrete is returned to
15 the ready mix plant due to several reasons, including not meeting specifications, over-ordering (e.g., the amount ordered exceeded the amount used for the job), job site issues resulting in delayed pour beyond the plastic life of the concrete, etc. Regardless of the reason for the return, the ready mix producer
20 generally has to treat the returned concrete to facilitate reuse, recycle or discard it as industrial waste. For example, re-claimers may be used to recycle sand and aggregate. If managed correctly, the treatment water also can be used to manufacture fresh (unset) concrete.

[0005] It is known to produce aggregate particles from cement compositions, including concrete and residual or returned concrete. Such aggregate materials could be used to replace a portion of typical aggregates (e.g., sand, stone) in a different
5 batch of concrete or for other construction purposes, such as roadbed material.

[0006] Such aggregates have been produced by methods which involve adding flash setting accelerators and super-absorbent polymers to fresh unset cement compositions and blending this
10 mixture until granular materials were formed. Super-absorbent polymers (SAPs) are polymers that are capable of retaining large amounts of water in comparison to their weight. When SAPs come into contact with water, the water molecules diffuse into the void space inside the polymer network, hydrating the polymer
15 chains, and achieving a high swelling ratio which is the ratio of the weight of the swollen SAPs to the dried SAPs. The swelling ratio is determined by the degree of branching and cross-linking, the chemical structure of the monomers that make up the SAPs network and external factors such as pH, ionic
20 concentration of the solution and the temperature.

[0007] Methods for producing aggregates from non-hardened cement compositions are also known, in particular from concrete or residual concrete, which comprises adding (a) a water-absorbing agent and (b) a crystallization deactivator to a non-
25 hardened cement composition and mixing until a granular material

was formed. The method allows unneeded residues of still liquid concrete to be converted into a practical product, which could then be reused to produce new concrete compositions.

[0008] Similarly, there are methods for producing aggregates
5 from "unsettled" cementitious mixtures which comprise the steps
of (a) adding at least one "pelletizing" agent to the unsettled
cementitious mixture, (b) mixing constantly the mixture of step
(a) in a mixer to produce pellets, (c) discharging the pellets
obtained in step (b) and (d) drying the pellets formed in step
10 (c). The pelletizing agent is selected from the group consisting
of cellulose, chitosan, collagen, polyacrylamide and co-polymers
of polyacrylamide and polyacrylics, polyamines,
polyvinylalcohols, polysaccharides, lactic acid, methacrylic
acid, methacrylate, hydroxyethyl, ethylene glycol, ethylene
15 oxide, acrylic acid, inorganic flocculants, and inorganic
coagulants. This method avoids using a flash setting accelerator
while using a relatively high dosage of super-absorbent polymer.

[0009] The terms "paste," "mortar," and "concrete" are terms of
art: pastes are mixtures composed of a hydratable cementitious
20 binder (usually, but not exclusively, Portland cement, masonry
cement, or mortar cement, and may also include limestone,
hydrated lime, fly ash, blast furnace Slag, and Silica fume or
other materials commonly included in Such cements) and water;
mortars are pastes additionally including fine aggregate (e.g.,
25 Sand); and concretes are mortars additionally including coarse

aggregate (e.g., gravel, Stones). In case the concrete is spray applied, the concrete is called shotcrete. For example, a cementitious composition may be formed by mixing required amounts of certain materials, e.g., hydratable cementitious binder, water, and fine and/or coarse aggregate, as may be desired, with high surface area materials such as shredded paper or fibers as described herein.

[0010] As a still further example, the use of a polymer encapsulated in a water-soluble bag, wherein the polymer, when released from the bag during mixing, absorbs water in the concrete and forms a gel structure around some of the fine aggregates contained in the concrete is known, thereby forming a granular material that could be used as road bed material.

[0011] It would be desirable to provide a method for producing granular material or aggregates from fresh concrete, shotcrete or other fluid hydratable cementitious compositions, such as residual or returned concrete or shotcrete, in an efficient and inexpensive manner, such that, for example, the granular material or aggregate can be put in stock piles, or reused in concrete, e.g., a batch of fresh or unset concrete different from the one from which the granular material or aggregates are produced. It also would be desirable to obtain granular material or aggregates resulting from this method, and use such material as aggregates. Also, producing granular material in accordance with embodiments disclosed herein is beneficial to avoid buildup

of material on the sides, blades and chute, for example, of a concrete mixing drum that sometimes occurs with the use of set accelerators and other additives, and to quickly treat and discharge material from the truck or leaving the treated the
5 material inside the truck and batch fresh concrete on top of it, minimizing total processing time.

SUMMARY

[0012] In departing from the prior art approaches to forming aggregates which are based on the use of "superabsorbent"
10 polymers or "pelletizing" chemical compounds, the present inventors made the surprising discovery that adding additional surface area to a concrete mix by using materials with high specific surface areas can provide the ability to form aggregates within cements, concretes, and other cementitious
15 materials, such as residual or returned concrete. This can be accomplished with or without the use of a set accelerator. Moreover, the aggregate-inducing material used in accordance with embodiments disclosed herein has the advantage that residual material remaining in the concrete truck or other
20 vessel where it is mixed with the cementitious material does not alter the properties of the next batch of concrete added to the truck or vessel. Accordingly, methods disclosed herein enable the recycling of concrete by transforming the same into aggregates that then can be added into one or more different

batches of concrete, for example. The batches of concrete to which the formed aggregates are added may themselves contain aggregates.

[0013] Embodiments disclosed herein are also believed to
5 overcome the high unpredictability in the characteristics of the aggregate material, because the use of the high surface area materials decreases the workability and rheology of concrete materials, facilitating the formation of aggregate particles.

[0014] In certain embodiments, granular or aggregate material
10 is produced from fresh concrete by the addition of a formulation comprising a granular or aggregate-forming inducer. In some embodiments, the aggregate-forming inducer provides a surface anchoring site for cement paste to bond/adhere to. In some embodiments, the aggregate-forming inducer comprises a fiber
15 having an elongated body with a length to equivalent diameter ratio of at least 10, more preferable at least 50, wherein the equivalent diameter is defined by ACI 544.5R-10, Section 2.2-Definitions, diameter of a circle having an area equal to the average cross sectional area of a fiber. In some embodiments,
20 the aggregate-forming inducer, when added to concrete or cementitious material, introduces additional anchoring surface area for cement paste between 275 and 50,000 square meters per cubic meter of concrete, preferably between 500 and 10,000 square meters per cubic meter of concrete, most preferably
25 between 1,000 and 5,000 square meters per cubic meter of

concrete. In some embodiments, the aggregate-forming inducer is a water-absorbing component that exhibits a high capacity to absorb water per unit weight of water-absorbing material. In certain embodiments, the formulation is devoid of a set
5 accelerator. In certain embodiments, the formulation is devoid of a water-absorbing component. In certain embodiments, the formulation is devoid of both a set accelerator and a water-absorbing component. In some embodiments, the aggregate-forming inducer is news print. In some embodiments, the news print is
10 post-consumer newsprint. In some embodiments, the news print is untreated; e.g., it is not rendered hydrophobic. In some embodiments, the news print is or has been mechanically shredded and/or cut into small pieces similar to the shredding of paper documents with conventional shredders. The pieces can be as
15 small as one millimeter or less. The degree of shredding can be characterized by the particle size distribution measured using sieve analysis. Typically, shredded materials will pass through a sieve size of less than 20 mesh (0.841mm). Retention of material starts at 20 mesh or greater (0.841mm or less).

20 [0015] In some embodiments, an aggregate-forming inducer that is an additive or admixture is provided that, when added to fresh or plastic concrete, converts the concrete to granular material that can be reused. In some embodiments, the aggregate-forming inducer is provided in a container or housing, such as
25 a paper bag.

[0016] Without being limited to any particular theory, it is believed that the aggregate-forming inducer, when introduced into the plastic mix, introduces more surface area for the cement paste/mortar to adhere to. As a consequence, there is less
5 paste to form a continuous network to adhere aggregate. As a result, the workability and rheology of the concrete mix is significantly reduced as measured using the slump cone test, ASTM C143/C143M, Standard Test Method for Slump of Hydraulic-Cement Concrete. The net result is the conversion of the plastic
10 material to a granular form.

[0017] In some embodiments, the resulting granular material obtained by the methods disclosed herein is used as aggregate in fresh concrete, replacing up to (but not limited) about 60% of conventional aggregates, for example. In some embodiments,
15 the granular material is added to concrete in amounts between 100-1600 lbs/yd³, more preferably between 178 and 710 lbs/yd³ of cementitious material.

[0018] In certain embodiments, a method for producing aggregate particles from cementitious compositions is provided, the method
20 comprising: combining a cementitious composition and at least one aggregate-forming inducer, wherein the at least one aggregate-forming inducer has a specific surface area of at least 10 square meters per kilogram; and mixing said cementitious composition with said aggregate-forming inducer
25 until the mixed components form granular material.

[0019] In some embodiments, the cementitious composition is residual or returned concrete. In some embodiments, the cementitious composition is a cementitious paste fraction separate from residual or returned concrete.

5 [0020] In some embodiments, the at least one aggregate-forming inducer is chosen from paper, cardboard, corrugated cardboard, cartons, corrugated cartons, crepe paper, news print, kraft paper, wall paper, wax paper, silk paper; shredded currencies removed from circulation (US and Foreign); wood fibers; glass
10 fibers; shredded textiles; cotton fibers; hemp; mineral fiber chosen from wollastonite, mica, rock wool, slag wool, and graphite; polyolefin fibers; polyvinyl alcohol (PVA); carbon fibers; nylon; para-aramid synthetic fiber; polyester fibers, natural fibers chosen from sisal fibers, cotton, flax, jute,
15 coconut husks, protein-based fibers, banana, pineapple, wool, mohair and silk; shredded polystyrene, shredded PET; and mixtures of any of the foregoing.

[0021] In a first exemplary embodiment, a method for producing aggregate particles from cementitious compositions is disclosed,
20 the method comprising: combining in a vessel a cementitious composition and at least one aggregate-forming inducer that provides a surface anchoring site for cement paste to bond/adhere to, wherein the at least one aggregate-forming inducer comprises a fiber having an elongated body with a length
25 to equivalent diameter ratio of at least 10 and that when added

to concrete, introduces anchoring surface area for said cementitious composition between 275 and 50,000 square meters per cubic meter of cementitious composition.

[0022] In a second exemplary embodiment, which can be based on
5 any of the other exemplary embodiments, the fiber has an elongated body with a length to equivalent diameter ratio of at least 50.

[0023] In a third exemplary embodiment, which can be based on any of the other exemplary embodiments, the anchoring surface
10 area is between 500 and 10,000 square meters per cubic meter of cementitious composition.

[0024] In a fourth second exemplary embodiment, which can be based on any of the other exemplary embodiments, the anchoring surface area is between 1,000 and 5,000 square meters per cubic
15 meter of cementitious composition.

[0025] In a fifth exemplary embodiment, which can be based on any of the other exemplary embodiments, the vessel is the drum of a concrete mixing truck.

[0026] In a sixth exemplary embodiment, which can be based on
20 any of the other exemplary embodiments, the time needed to combine the at least one aggregate-forming inducer and the cementitious composition and convert the resulting mix to a

granular material is 1 to 10 minutes per cubic yard of cementitious composition.

[0027] In a seventh exemplary embodiment, which can be based on any of the other exemplary embodiments, the aggregate-forming inducer does not negatively impact subsequent concrete mixes with regard to its plastic and hardened properties chosen from air entrainment, unit weight, slump, set time and strength.

[0028] In an eighth exemplary embodiment, which can be based on any of the other exemplary embodiments, the cementitious composition is residual or returned concrete.

[0029] In a ninth exemplary embodiment, which can be based on any of the other exemplary embodiments, the cementitious composition is a cementitious paste fraction (e.g., devoid of aggregate) separate from residual or returned concrete.

[0030] In a tenth exemplary embodiment, which can be based on any of the other exemplary embodiments, the at least one aggregate-forming inducer is chosen from shredded and/or cut paper, cardboard, corrugated cardboard, cartons, corrugated cartons, crepe paper, news print, kraft paper, wall paper, wax paper, silk paper; shredded currencies removed from circulation (US and Foreign); wood fibers; glass fibers; shredded textiles; cotton fibers; hemp; mineral fiber chosen from wollastonite, mica, rock wool, slag wool, and graphite; polyolefin fibers; polyvinyl alcohol (PVA); carbon fibers; nylon; para-aramid

synthetic fiber; polyester fibers, natural fibers chosen from sisal fibers, cotton, flax, jute, coconut husks, protein-based fibers, banana, pineapple, wool, mohair and silk; shredded polystyrene, shredded PET; and mixtures of any of the foregoing.

- 5 [0031] In a first aspect of the tenth exemplary embodiment, the polyolefin fibers are polypropylene fibers, polyethylene fibers or blends thereof.

[0032] In a second aspect of the tenth exemplary embodiment, the polyolefin fibers are polypropylene fibers, polyethylene
10 fibers or blends thereof having a length between 1 mm and 60 mm.

[0033] In a third aspect of the tenth exemplary embodiment, the polyolefin fibers are polypropylene fibers, polyethylene fibers or blends thereof have a surface area per unit weight between 100 and 400 square meters per kilogram.

- 15 [0034] In a fourth aspect of the tenth exemplary embodiment, the polyolefin fibers are polypropylene fibers, polyethylene fibers or blends thereof have a surface area per unit weight between 200 and 250 square meters per kilogram.

[0035] In an eleventh exemplary embodiment, which can be based
20 on any of the other exemplary embodiments, said aggregate-forming inducer is news print.

[0036] In a first aspect of the eleventh exemplary embodiment, the news print is shredded and/or cut.

[0037] In a second aspect of the eleventh exemplary embodiment, the news print is shredded and has a surface area per unit weight between 10 and 500 square meters per kilogram.

[0038] In a third aspect of the eleventh exemplary embodiment,
5 the news print is shredded and has a surface area per unit weight between 15 and 300 square meters per kilogram.

[0039] In a twelfth exemplary embodiment, which can be based on any of the other exemplary embodiments, the cementitious composition is returned concrete in a delivery truck mixer-drum,
10 and the at least one aggregate-forming inducer is shredded newsprint.

[0040] In a thirteenth exemplary embodiment, which can be based on any of the other exemplary embodiments, an admixture chosen from one or more set accelerators, set retarders, water
15 reducers, rheology modifiers chosen from clay, super absorbent polymers and thickeners, corrosion inhibitors, shrinkage reducing admixtures, colorants, air entrainers, air detrainers, and combinations thereof.

[0041] In a first aspect of the thirteenth exemplary embodiment,
20 wherein said set accelerator is aluminum sulfate, aluminum trihydrate, calcium nitrate, calcium nitrite, calcium chloride, sodium nitrate, thiocyanate or mixtures thereof.

[0042] In a fourteenth exemplary embodiment, which can be based on any of the other exemplary embodiments, a super absorbent polymer chosen from sodium polyacrylate and polyacrylic acid is added.

5 [0043] In a fifteenth exemplary embodiment, which can be based on any of the previous other exemplary embodiments, aggregate particles formed by the method of the first exemplary embodiment are disclosed.

[0044] In a sixteenth exemplary embodiment, which can be based
10 on any of the other exemplary embodiments, a packaged admixture is disclosed, the admixture comprising an aggregate-forming inducer comprising a fiber having an elongated body with a length to equivalent diameter ratio of at least 10 and that when added to concrete and an admixture chosen from one or more of set
15 accelerators, set retarders and rheology modifiers.

[0045] In a first aspect of the sixteenth exemplary embodiment, the fiber has an elongated body with a length to equivalent diameter ratio of at least 50.

[0046] In a seventeenth exemplary embodiment, which can be based
20 on any of the other exemplary embodiments, a single-use container consisting essentially of one or more aggregate-forming inducers having an elongated body with a length to equivalent diameter ratio of at least 10 is disclosed.

[0047] In a first aspect of the seventeenth exemplary embodiment, the one or more aggregate-forming inducers is news print.

[0048] In a second aspect of the seventeenth exemplary
5 embodiment, the container is a paper bag.

[0049] In a third aspect of the seventeenth exemplary embodiment, the container is a water soluble bag.

[0050] In a fourth aspect of the seventeenth embodiment, the container is a pulpable bag.

10 [0051] In a fifth aspect of the seventeenth embodiment, the container is a plastic bag.

[0052] In a sixth aspect of the seventeenth embodiment, the container is a wrap covering the side of a cylinder.

[0053] In an eighteenth exemplary embodiment, which can be based
15 on any of the other exemplary embodiments, a method for producing aggregate particles from cementitious compositions is disclosed, comprising: combining a cementitious composition and a formulation consisting essentially of at least one aggregate-forming inducer, wherein the at least one aggregate-forming
20 inducer when added to said cementitious composition introduces surface area between 275 and 50,000 square meters per cubic meter of cementitious composition, and mixing said cementitious

composition with said formulation until the mixed components form granular material.

[0054] In a nineteenth exemplary embodiment, which can be based on any of the other exemplary embodiments, the formulation is
5 combined with said cementitious material with a conveyor belt, a pneumatic system, a blower or a dispenser.

[0055] In a twentieth exemplary embodiment, which can be based on any of the other exemplary embodiments, the aggregate-forming inducer, when added to the cementitious composition, introduces
10 surface area between 500 to 10,000 square meters per meter of cementitious composition.

[0056] In a first aspect of the twentieth embodiment, the aggregate-forming inducer, when added to the cementitious composition, introduces surface area between 1,000 to 5,000
15 square meters per meter of cementitious composition.

[0057] In a twenty-first exemplary embodiment, which can be based on any of the other exemplary embodiments, a cementitious composition is disclosed, comprising a paste portion and aggregate formed by the method of the first exemplary
20 embodiment.

[0058] Further advantages and benefits are further described in detail hereinafter.

BRIEF DESCRIPTION OF DRAWINGS

[0059] Benefits and features of the embodiments disclosed herein may be more readily appreciated when the following written description of exemplary embodiments is considered in conjunction with the drawings, as described in the ensuing
5 paragraphs.

[0060] FIG. 1 is a digital photograph of shredded post-consumer news print (at 1.0x, graduated scale is in units of 1 mm) used as an aggregate-forming inducer in accordance with embodiments disclosed herein;

10 [0061] FIG. 2 is a digital photograph of shredded post-consumer news print (at 1.6x, graduated scale is in units of 1 mm) used as an aggregate-forming inducer in accordance with embodiments disclosed herein;

[0062] FIG. 3 is a digital photograph of shredded post-consumer
15 news print (at 4.0x, graduated scale is in units of 1 mm) used as an aggregate-forming inducer in accordance with embodiments disclosed herein;

[0063] FIG. 4 is digital photograph of aggregate produced in Sample #6 of Table 1, in accordance with embodiments disclosed
20 herein;

[0064] FIG. 5 is digital photograph of aggregate produced in Sample #9 of Table 1, accordance with embodiments disclosed herein; and

[0065] FIG. 6 is digital photograph of aggregate produced in Sample #11 of Table 1, in accordance with embodiments disclosed herein.

[0066] DETAILED DESCRIPTION OF EXEMPLARY EMBODIMENTS

5 [0067] The singular forms "a," "an," and "the" include plural referents unless the context clearly dictates otherwise.

[0068] As used in the specification, various devices and parts may be described as "comprising" other components. The terms "comprise(s)," "include(s)," "having," "has," "can,"
10 "contain(s)," and variants thereof, as used herein, are intended to be open-ended transitional phrases, terms, or words that do not preclude the possibility of additional components.

[0069] The terms "concrete" or "shotcrete" typically refer to a mixture of cement (which often contains supplementary
15 cementitious materials such as limestone, fly ash, granulated blast furnace slag and other pozzolanic materials) and aggregates (e.g., fine aggregate such as sand, coarse aggregate such as gravel) and optionally one or more chemical admixtures (e.g., plasticizers for increasing workability, set
20 accelerators, set retarders, air entrainers, air detrainers, plastic shrinkage reducing admixtures, corrosion inhibitors (for rebar) for modifying concrete in its plastic or hardened state. Concrete is considered to be hydratable material in that the addition of water into the mixture of cement and aggregates
25 initiates a hardening reaction.

[0070] The term "cement" includes hydratable cement such as Portland cement which is produced by pulverizing clinker consisting of hydraulic calcium silicates, aluminates and aluminoferrites, and one or more forms of calcium sulfate (e.g.,
5 gypsum) as an interground additive. Typically, Portland cement is combined with one or more supplemental cementitious materials, such as fly ash, granulated blast furnace slag, limestone, natural pozzolans, or mixtures thereof, and provided as a blend, all of which binds aggregates together to make
10 concrete.

[0071] The term "cementitious" may be used herein to refer to materials that comprise Portland cement, CSA cement or which otherwise function as a binder to hold together fine aggregates (e.g., sand) and coarse aggregates (e.g., crushed gravel, stone)
15 which are used for constituting concrete. The cementitious compositions may be formed by mixing required amounts of certain materials, e.g., hydratable cement, water, and fine and/or coarse aggregate, as may be applicable to make the particular cement composition being formed.

20 [0072] In the concrete industry, the term "aggregate" typically means and refers to sand and/or stone particles, typically having average size of 0.5 to 50 mm. Aggregates may also comprise calciferous, siliceous or siliceous limestone minerals. Such aggregates may be of either the "natural" type (e.g.,
25 derived from glacial, alluvial, or marine deposits which are typically weathered such that the particles have smooth

surfaces) or may be of the "manufactured" type, which are made using mechanical crushers or grinding devices. Coarse aggregate stone particles are typically grouped into various size fractions as described for instance in ASTM C33/C33M-18. As the
5 size fraction used is controlled by various factors, including, but not limited to, the space between reinforcing bars in a proposed construction, aggregate size is often important in concrete mix designs.

[0073] As used herein, the term "aggregate" is used as well to
10 refer to cement or concrete particles made through exemplary processes disclosed herein which involve mixing with cement, concrete, mortar, other cementitious materials, or combinations thereof, an aggregate-forming inducer which may be a high surface area material such as post-consumer newsprint.

15 [0074] As used herein, the phrase "consisting essentially of" limits the scope of a claim to the specified materials or steps and those that do not materially affect the basic and novel characteristics of the claimed subject matter. The term permits the inclusion of substances which do not materially affect the
20 basic and novel characteristics of the composition, formulation or method under consideration. Accordingly, the expressions "consists essentially of" or "consisting essentially of" mean that the recited embodiment, feature, component, etc. must be present and that other embodiments, features, components, etc.,
25 may be present provided the presence thereof does not materially

affect the performance, character or effect of the recited embodiment, feature, component, etc. The presence of impurities or a small amount of a material that has no material effect on a composition is permitted. Also, the intentional inclusion of
5 small amounts of one or more non-recited components that otherwise have no material effect on the character or performance of a composition is still included within the definition of "consisting essentially of". For example, a formulation consisting essentially of an aggregate-forming
10 inducer in accordance with embodiments disclosed herein contains no superabsorbent polymer or set accelerator. Similarly, for example, a method consisting essentially of combining a cementitious composition and at least one aggregate-forming inducer, and mixing the cementitious composition with the
15 aggregate-forming inducer until the mixed components form granular material, includes no steps of adding or otherwise involving a superabsorbent polymer or set accelerator to form the aggregate.

[0075] In some embodiments, an aggregate-forming inducer that
20 is an additive or admixture is provided that, when added to and mixed with fresh or plastic concrete, converts the concrete to granular material that can be reused in a different batch of concrete or other cementitious material. In some embodiments, the resulting granular material then may be used as aggregate
25 in fresh (e.g., unset) concrete. The components may be mixed

directly in a conventional cement mixing truck or by other suitable mixing equipment.

[0076] The resulting granular material may be used as a substitute for conventional aggregate, such as course aggregate.

5 It can totally replace the aggregate, or can replace only a portion thereof, such as 10%, 20%, 40% ,60% or greater.

[0077] An exemplary method for producing aggregate materials from cement or concrete, comprises: combining a cementitious composition and at least one aggregate-forming inducer in a
10 vessel, wherein the at least one aggregate-forming inducer is characterized by having a specific surface area of at least 10 square meters per kilogram; and adding (e.g., blending, mixing or otherwise interdispersing) these components together until the additional surface area added to the mix is 400 square meters
15 or greater; wherein mixed components form aggregate particles. In some embodiments the vessel is the rotatable drum of a concrete mixing truck. In some embodiments, the components may be added to the cement or concrete in a drum of a concrete mixing truck while the concrete drum is slowly turning. After all the
20 components are added to the mix, the rotation rate of the drum may be set to between 10 and 15 rpm and mixed for approximately 3 minutes. In some embodiments, the material may then discharged to form a pile, for example. The method may be carried out under a variety of environmental conditions. In fact, the method
25 is independent of environmental conditions. The method may be

carried out within or under normal operating conditions or constraints for concrete. In some embodiments the method may be carried out wherein the vessel is a rotatable concrete mixer drum mounted on a concrete ready-mix delivery vehicle, and
5 further wherein concrete within the mixer drum is monitored by an automated slump monitoring system to ensure that the aggregate-forming inducer becomes uniformly mixed within concrete contained within the mixer drum. In some embodiments, the material may not be discharged to form a pile, but left in
10 the mixing vessel and fresh concrete may be batched on top of it, for example.

[0078] Other vessels in which the aggregate-forming inducer and cementitious material are combined and mixed may be used, including vats, mixers, etc.

15 [0079] Certain embodiments relate to the material obtained by the methods disclosed herein. An exemplary additive formulation for introducing into cement or concrete to produce aggregate particles may comprise an aggregate-forming inducer that is a water absorbing component having a high water absorption rate
20 ratio. For example, there's a range of water absorption rate or capacity for a host of different materials. Soil, for example will typically have a range of water absorption capacity between 0.3 and 0.6 grams/gram of soil. Super absorbent polymers (SAP) will have a water absorption capacity between 50 and 200
25 grams/gram of SAP. Both materials can be used to convert plastic

concrete to a granular form, the only important difference being the amounts necessary. The formulation may include one or more other ingredients, such as set accelerators and/or set retarders.

5 [0080] Suitable aggregate-forming inducers include cellulose fibers such as shredded and/or cut paper, cardboard, corrugated cardboard, cartons, corrugated cartons, crepe paper, news print, kraft paper, wall paper, wax paper, silk paper; shredded currencies removed from circulation (US and Foreign); wood
10 fibers; glass fibers; shredded textiles; cotton fibers; hemp; mineral fiber chosen from wollastonite, mica, rock wool, slag wool, and graphite; polyolefin fibers; polyvinyl alcohol (PVA); carbon fibers; nylon; para-aramid synthetic fiber; polyester fibers, natural fibers chosen from sisal fibers, cotton, flax,
15 jute, coconut husks, protein-based fibers, banana, pineapple, wool, mohair and silk; shredded polystyrene, shredded PET; and mixtures of any of the foregoing.

[0081] In certain embodiments, the fiber or fibers have elongated bodies with a length to equivalent diameter ratio of
20 at least about 10, preferably at least about 50. In certain embodiments, when the fibers are added to the cementitious composition such as concrete, they introduce anchoring surface area for the cementitious composition between 275 and 50,000 square meters per cubic meter of cementitious composition. In
25 accordance with certain embodiments, the amount of aggregate-

forming inducer used is such that the additional surface area added to the mix is at least about 400 square meters per cubic meter of concrete, preferably at least about 1000 square meters per cubic meter of concrete, more preferably at least about 1500

5 square meters per cubic meter of concrete or cementitious material. The higher amounts of aggregate-forming inducer result in decreased workability of the resulting composition, facilitating the formation of granular material. In accordance with certain embodiments the fiber having an elongated body

10 increases its specific surface area during mixing of the concrete due to surface roughening or fibrillation by at least 10 percent. In accordance with certain embodiments the fiber having an elongated body increases its specific surface area during mixing of the concrete due to surface roughening or

15 fibrillation by at least 50 percent.

[0082] In some embodiments, the aggregate-forming inducer is a formulation that may include a water absorbing component that exhibits a high water absorption capacity such as a super absorbent polymer. In certain embodiments, the formulation is

20 devoid of a set accelerator. In certain embodiments, the formulation is devoid of a set retarder. In certain embodiments, the formulation is devoid of both a set accelerator and a set retarder. In some embodiments, the aggregate-forming inducer is shredded news print. In some embodiments, the news print is

25 untreated; e.g., it is not rendered hydrophobic.

[0083] In a preferred embodiment, the aggregate-forming inducer is news print that has been shredded and/or cut. Suitable material is CF100 commercially available from JRS and has the following specifications:

Average Particle size (% Retained)				Fiber Length	Viscosity (Water))	Viscosity (30 W Oil)	Ash Content	Moisture Content	Oil Absorption Times
<u>20</u>	<u>60</u>	<u>100</u>	<u>140</u>	<u>Average</u>	<u>4%</u>	<u>2% conc.</u>	<u>Max</u>	<u>Max</u>	<u>Weight</u>
<u>Mesh</u>	<u>Mesh</u>	<u>Mesh</u>	<u>Mesh</u>	<u>Average</u>	<u>conc.</u>	<u>2% conc.</u>	<u>Max</u>	<u>Max</u>	<u>Weight</u>
35-72	6-17	1-3	2-4	1.31mm	16700cP	140000cP	15%	7%	11X

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[0084] FIGS. 1, 2 and 3 show shredded post-consumer news print at different magnifications. The material appears to be fractal in nature where there's a combination of fine and coarse material at different length scales. The fine material are individual fibers or fibrous in nature and the coarse material is comprised of an agglomerate of fibers. There are also pieces of paper that have not been shredded. A combination of shredded and non-shredded news print may be used. Preferably the majority of the news print is shredded.

15 [0085] In certain embodiments, the aggregate-forming inducer may be introduced to cementitious material directly in a concrete mixing truck containing the cementitious material. In some embodiments, the aggregate-forming inducer is introduced to the cementitious material with a driving force such as a

20 pneumatic system that uses pressurized air or other gas insert to the ingredients used. The pneumatic system may blow the

inducer into a concrete mixing truck containing the cementitious material, such as a ready-mix truck with a rotatable drum. The inducer may be blown into the drum using forced air while the drum is rotating, or prior to rotating the drum, and when a
5 suitable amount of inducer has been added, the speed of the drum rotation may be increased to thoroughly mix the inducer and cementitious material. A mixing time of about 1 to 10 minutes per cubic yard of concrete and a drum rotation rate between 10 and 15 rpm have been found to be suitable. Alternatively, the
10 inducer may be introduced by adding containers of the inducer, such as paper bags, pulpable bags, and/or water-soluble polymer bags, plastic bags into the vessel containing the cementitious material. Other methods of introducing the inducer into the cementitious material may be used, including a conveyor belt
15 transporting the inducer to a vessel containing the cementitious composition, manually adding the inducer to a vessel containing the cementitious composition, or using one or more automatic dispensers to dispense the inducer to a vessel containing the cementitious composition, and are within the scope of the
20 embodiments disclosed herein. In some embodiments, the inducer may be introduced by manually feeding compressed material in the form of blocks, cubes or tubes and allowing the inducer to be broken up in the drum during mixing. In some embodiments, the cementitious composition may be introduced to the vessel after
25 the inducer is added to the vessel. In some embodiments, the

aggregate-forming inducer will increase its specific surface area due to surface roughening or fibrillation of filaments.

[0086] In certain embodiments wherein the vessel is a rotatable concrete mixer drum mounted on a concrete ready-mix delivery vehicle, and further wherein concrete within the mixer drum is monitored by an automated slump monitoring system to ensure that the aggregate-forming inducer becomes uniformly mixed within concrete contained within the mixer drum.

[0087] The cementitious material may be a cementitious paste fraction separate from residual or returned concrete, and thus may not comprise sand and/or stone aggregate.

[0088] In certain embodiments, one or more set accelerators may be used, and may be introduced to the cementitious material simultaneously with the aggregate-forming inducer, or after the aggregate-forming inducer has been added. The set accelerator may be blended with the aggregate-forming inducer prior to introduction into the cementitious material, or it may be added to the cementitious material separately from the aggregate-forming inducer. The set accelerator may be added in equal amounts, by weight, of the aggregate-forming inducer. Suitable set accelerators are those conventionally used in the art to accelerate set, including calcium aluminum hydrates, aluminum sulfate, calcium nitrate, calcium nitrite, calcium formate, calcium chloride, sodium nitrate, and thiocyanate, etc.

[0089] In certain embodiments, one or more set retarders may be used, and may be introduced to the cementitious material simultaneously with the aggregate-forming inducer, or after the aggregate-forming inducer has been added. The set retarder may be blended with the aggregate-forming inducer prior to introduction into the cementitious material, or it may be added to the cementitious material separately from the aggregate-forming inducer. The set retarder may be added in amounts equal to approximately 5 to 50 ounces per 100 lbs of cement. Suitable set retarders are those conventionally used in the art to retard set, including lignin, tartaric acid and salts thereof, lignosulfonates acids, hydroxylated carboxylic acids, carbohydrates, etc.

[0090] In certain embodiments, one or more superabsorbent polymers may be used, and may be introduced to the cementitious material simultaneously with the aggregate-forming inducer, or after the aggregate-forming inducer has been added. The superabsorbent polymer may be blended with the aggregate-forming inducer prior to introduction into the cementitious material, or it may be added to the cementitious material separately from the aggregate-forming inducer. Suitable amounts of superabsorbent polymer are approximately 2 lbs/yd³ or greater. Suitable superabsorbent polymers are those conventionally used in the art, and may include sodium polyacrylate, carboxyalkyl cellulose polymers, carboxyalkyl starch polymers, alginates,

chitosans, and starches. Also, polymers from the group of polyacrylic acid polymers, polyacrylamide polymers and polyaspartic acid polymers.

[0091] Other ingredients typically added to concrete also may
5 be used, including colorants, pigments, dyes, air entraining agents, air de-training agents, etc.

[0092] In certain embodiments, a container or housing suitable for introduction into a load of cementitious material is provided. The container may contain one or more of an aggregate-
10 forming inducer, one or more set accelerators, one or more set retarders and/or one or more superabsorbent polymers or thickeners. In some embodiments, the container is a single-use container that has no negative impact on the properties of the resulting concrete, such as a paper bag. In some embodiments,
15 the container contains only one or more aggregate-forming inducers. In some embodiments, the container contains only one or more aggregate-forming inducers and one or more a set accelerators. In some embodiments, the container contains only one or more aggregate-forming inducers and one or more a
20 superabsorbent polymers. In certain embodiments, one or more of any of these containers are manually introduced in to a drum of a ready-mix truck containing concrete or other cementitious material, and the drum of the truck is rotated at a sufficient speed and for a sufficient time to cause the formation of
25 aggregates.

[0093] The mixing time for mixing the aggregate-forming inducer and cementitious material is not particularly limited. Generally a mixing time of about 1 to 10 minutes per cubic yard of concrete by rotating the drum of a typical ready-mix truck is sufficient. The mixing time may be determined by visual inspection to see if the granular material has been formed. Suitable ready-mix drum mixing speeds are between 5 and 25 rpm, preferably between 10 and 15 rpm. In certain embodiments, the VERIFI® In-transit Concrete Management system commercially available from GCP Applied Technologies may be used to monitor the properties of the mix during conversion to a granular form and determine when the conversion is complete.

[0094] An important advantage of the methods disclosed herein is that the addition of an aggregate-forming inducer to a vessel, particularly a drum of a cement truck, in accordance with embodiments disclosed herein, minimizes material build-up on the drum or drum components, and thus does not materially impact the properties of subsequent loads of cementitious material added to the truck. For example, in certain embodiments, the nature of the aggregate-forming inducer in accordance with embodiments disclosed herein is such that no or only minimal residual material remains in the truck, and of residual material that does remain on any of the various components of the truck, including drum inner walls, blades and chute, causes little or no change or effect on the properties (e.g., slump, amount of

air entrainment, strength, etc.) of subsequent loads after the treated load is discharged from the truck, and will have no negative impact on any such properties.

[0095] The embodiments disclosed herein now will be described more fully hereinafter with reference to the accompanying drawings, in which various exemplary embodiments are shown illustrating variations within the scope of this disclosure.

[0096] Unless otherwise indicated, the shredded news print used in the following Examples was post-consumer shredded news print having the following particle size distribution as measured using sieve analysis: between 45 and 62% was retained on a mesh 20 sieve, and between 12 and 21% was retained on a 40 mesh sieve. The ash content was between 3 and 20% and the moisture content was approximately 7%.

[0097] Also unless otherwise indicated, slump cone measurements, per ASTM C143/C143M, were used to show how the addition of shredded post-consumer news print (or other aggregate-inducing formers) reduces concrete workability and rheology.

[0098] FIGS. 4, 5 and 6 show the granular material after it has been treated with shredded post-consumer news print and aluminum sulfate. In these figures the effect of aluminum sulfate dosage was investigated. The range of aluminum sulfate is 12.2 - 36.7 lbs/yd³ and the dosage of shredded post-consumer news print was fixed at 24.5 lbs/yd³. In all cases, the granular material

appears to be a mixture of coarse and fine aggregate. Note, as the addition of aluminum sulfate is increased, the appearance of the coarse aggregate is smooth (FIG. 4) compared to the material treated with a lower level of aluminum sulfate (FIG. 6), indicating less adhesion of the paste/mortar fraction to the coarse material. The coarse aggregate in FIG. 4 appears rough in nature with small deposits of paste/mortar on the outer surface. FIG. 4 represents the material after being treated with 24.5 lbs/yd³ of shredded post-consumer news print and 36.7 lbs/yd³ of aluminum sulfate. FIG. 6 is granular material treated with the same dosage of shredded post-consumer news print but a lower dosage of aluminum sulfate, 12.2 lbs/yd³.

[0099] Example 1

[00100] In this study the effect shredded post-consumer news print and concrete set accelerator (aluminum sulfate) on the conversion of plastic concrete to a granular material was investigated. In the first part of this study the effect of shredded post-consumer news print on the conversion of plastic concrete to a granular form was studied (sample numbers 2 - 4). The dosage range of shredded post-consumer news print used in the first study (sample numbers 1-4) was between 0 and 36.7 lbs/yd³. When the concrete is in the plastic state, shredded post-consumer news print was manually added to the material and mixed using a stationary concrete mixer for about 3 minutes or until the material is converted to a granular form. At the

dosage range investigated, 12.2 to 36.7 lbs/yd³, the addition of shredded post-consumer news print transformed plastic concrete to a granular form as indicated by the zero slump measurements. The addition of shredded post-consumer news print also resulted
5 in a decrease in the 28 day compressive strength relative to the reference mix. The 28 day compressive strength for the reference mix (no shredded post-consumer news print) is 4552 psi. At a cellulose fiber dosage of 36.7 lbs/yd³, the 28 day strength decreases to 447 psi. The lower the compressive strength, the
10 easier it is for the granular material to be broken up at a later time.

[00101] In the second study (sample numbers 5 - 11), the effect of a set accelerator, aluminum sulfate, in combination with shredded post-consumer news print on the conversion of plastic
15 concrete to a granular form was investigated. The objective was to determine if the addition of a set accelerator would enhance the performance of the shredded post-consumer news print during the conversion process and also result in a weaker material over time. Plastic concrete was converted to a granular material by
20 adding shredded post-consumer news print with the following characteristics: particle sized distribution as measured using sieve analysis: between 45 and 62 % was retained on the mesh 20 sieve, between 12 and 21% was retained on the 40 mesh sieve. The ash content was between 3 and 20% and the moisture content
25 was approximately 7%. The addition of shredded post-consumer

news print and aluminum sulfate are given in the Table below together with the concrete mix design. Similar to the study above, the shredded post-consumer news print was manually added to the plastic concrete in a stationary batch mixer and then
5 mixed between 15 and 45 rpm for about 3 minutes or until the plastic material was converted to a granular form. After the addition of fibers, a set accelerator, aluminum sulfate, was added and mixed for an additional 5 minutes. The dosage range of shredded post-consumer news print and aluminum sulfate were
10 between 0 to 36.7 pounds per cubic yard of concrete. In all cases, the plastic material was converted to a granular form as indicated by the zero slump. Also, the compressive strength could not be measured since a single hardened mass could not be produced. This work showed that the addition of a set
15 accelerator, aluminum sulfate, produced a granular material that was significantly weaker compared to the addition of only shredded post-consumer news print in the dosage range or addition rates investigated in this example. A later example will show that the same results can be achieved by increasing
20 the dosage rate of fibers beyond 37 pounds per cubic yard of concrete. For example, at a shredded post-consumer news print dosage of 36.7 pounds per cubic yard of concrete, the compressive strength for material treated with only cellulose fiber was 447 psi (pounds per square inch when measured in accordance with
25 ASTM C39/C39M, Standard Test Method for Compressive Strength of Cylindrical Concrete Specimens). The same material treated with

the same dosage of fiber and aluminum sulfate broke apart before it could be measured.

[00102] In the following examples, to facilitate compressive strength measurements, the level of consolidation was significantly increased beyond what's called for in ASTM C31/C31M - 15a, Standard Practice for Making and Curing Concrete Test Specimens in the Field. A vibration table in combination with a tamping rod were implemented to consolidate the granular material in compressive strength cylinder molds. The cylinder molds were 4 inches in diameter by 8 inches in length in accordance with ASTM C39/C39M, Standard Test Method for Compressive Strength of Cylindrical Concrete Specimens.

[00103] Table 1

Number	Units	1	2	3	4	5	6	7	8	9	10	11	12
cement	lbs/yd ³	611	611	611	611	611	611	611	611	611	611	611	611
coarse aggregate	lbs/yd ³	1775	1775	1775	1775	1775	1775	1775	1775	1775	1775	1775	1775
sand	lbs/yd ³	1303	1303	1303	1303	1303	1303	1303	1303	1303	1303	1303	1303
granular material	lbs/yd ³	0	0	0	0	0	0	0	0	0	0	0	0
water	lbs/yd ³	318	318	318	318	318	318	318	318	318	318	318	318
w/c		0.52	0.52	0.52	0.52	0.52	0.52	0.52	0.52	0.52	0.52	0.52	0.52
fiber	type		shredded post-consumer news print	post-consumer news print	post-consumer news print	post-consumer news print	post-consumer news print	post-consumer news print	post-consumer news print	post-consumer news print	post-consumer news print	post-consumer news print	
	grams		162	324	486	162	324	486	162	324	486	324	
	lbs/yd ³		12.2	24.5	36.7	12.2	24.5	36.7	12.2	24.5	36.7	24.5	
accelerator	Type					aluminum sulfate	aluminum sulfate	aluminum sulfate	aluminum sulfate	aluminum sulfate	aluminum sulfate	aluminum sulfate	
	grams					162	162	162	324	324	324	486	
	lbs/yd ³					12.2	12.2	12.2	24.5	24.5	24.5	36.7	
polymer	type												
	grams												
	lbs/yd ³												
compressive strength (psi)	1 day	1723	1793	571	141	1240	362	67	349	39	15	24	1839
	7 day	3930	3422	984	337	2276	832			662			3749
	28 day	4552	4265	1388	447	2531	823		945				4941
granular	yes/no	no	yes	Yes	yes	Yes	yes	yes	yes	yes	yes	yes	no

slump	inches	8	0	0	0	0	0	0	0	0	0	0	6.5
weight	grams	20620	20210	18580	18350	20030	17450	17070	18410	17420	16170	16240	20510
air	%	1.8	3	7	8	4	4.5	5	5	4	2.9	4.2	2
unit weight	kg/m ³	2387	2329	2099	2067	2304	1939	1886	2075	1935	1759	1769	2372
	pcf	149.0	145.4	131.0	129.0	143.8	121.0	117.7	129.5	120.8	109.8	110.4	148.1
concrete temp.	°C	22.2	22.2	22.7	22.2	23.3	22.2	23.3	22.7	26.6	25.5	27.7	22.2

[00104] Example 2,

[00105] In this example, material made in Example 1, specifically sample numbers 6 and 9, were used to replace a fraction of the coarse aggregate, 10, 20 and 40%, of the reference mix (sample number 1). The granular material used to replace the aggregate was produced using 24.5 pounds per cubic yard of concrete of shredded post-consumer news print and 12.2 and 24.5 pounds per cubic yard of concrete of accelerator, aluminum sulfate, samples 6 and 9 respectively. The reference mix contains 1775 lbs/yd³ of coarse aggregate. In sample number 2, 10% of the coarse aggregate, 178 lbs/yd³, was replaced with the granular material produced in Example 1, specifically sample number 6. The total amount of coarse aggregate remains the same as the control, 1775 lbs/yd³. In subsequent mixes, 20 and 40% of the coarse aggregate were replaced as indicated in Table 2 below. The plastic and hardened properties were measured and provided in Table 2 below. There is a decrease in compressive strength compared to the reference mix (number 1) as the fraction of coarse aggregate replacement increases. At 40% replacement, the strength decreases from 5031 psi to 4339 psi. When the replacement material was treated with more accelerator, the

strength decrease was less, 4940 psi. One could argue that this difference is not significant. As the fraction of treated material in the mix increases, plastic air increases. At 40% aggregate replacement the plastic air increases from 2% to 2.9%
 5 (material treated with 12.2 lbs/yd³ aluminum sulfate) and 3.3% (material treated with 24.5 lbs/yd³ aluminum sulfate). The increase in air content could explain the decrease in strength.

[00106] Table 2

Number	Units	1	2	3	4	5	6	7	8	9	10	11	12
cement	lbs/yd ³	611	611	611	611	611	611	611	611	611	611	611	611
coarse aggregate	lbs/yd ³	1775	1775	1775	1775	1775	1775	1775	1775	1775	1775	1775	1775
sand	lbs/yd ³	1303	1303	1303	1303	1303	1303	1303	1303	1303	1303	1303	1303
granular material	lbs/yd ³	0	0	0	0	0	0	0	0	0	0	0	0
water	lbs/yd ³	318	318	318	318	318	318	318	318	318	318	318	318
w/c		0.52	0.52	0.52	0.52	0.52	0.52	0.52	0.52	0.52	0.52	0.52	0.52
fiber	type		shredded post-consumer news print	shredded post-consumer news print	shredded post-consumer news print	shredded post-consumer news print	shredded post-consumer news print	shredded post-consumer news print	shredded post-consumer news print	shredded post-consumer news print	shredded post-consumer news print	shredded post-consumer news print	
	grams		162	324	486	162	324	486	162	324	486	324	
	lbs/yd ³		12.2	24.5	36.7	12.2	24.5	36.7	12.2	24.5	36.7	24.5	
accelerator	Type					aluminum sulfate	aluminum sulfate	aluminum sulfate	aluminum sulfate	aluminum sulfate	aluminum sulfate	aluminum sulfate	
	grams					162	162	162	324	324	324	486	
	lbs/yd ³					12.2	12.2	12.2	24.5	24.5	24.5	36.7	
polymer	type												
	grams												
	lbs/yd ³												
compressive strength (psi)	1 day	1723	1793	571	141	1240	362	67	349	39	15	24	1839
	7 day	3930	3422	984	337	2276	832			662			3749
	28 day	4552	4265	1388	447	2531	823		945				4941
granular	yes/no	no	yes	Yes	Yes	yes	yes	yes	yes	yes	yes	yes	no
slump	inches	8	0	0	0	0	0	0	0	0	0	0	6.5
weight	grams	20620	20210	18580	18350	20030	17450	17070	18410	17420	16170	16240	20510
air	%	1.8	3	7	8	4	4.5	5	5	4	2.9	4.2	2
unit weight	kg/m ³	2387	2329	2099	2067	2304	1939	1886	2075	1935	1759	1769	2372
	pcf	149.0	145.4	131.0	129.0	143.8	121.0	117.7	129.5	120.8	109.8	110.4	148.1
concrete temp.	°C	22.2	22.2	22.7	22.2	23.3	22.2	23.3	22.7	26.6	25.5	27.7	22.2

10

[00107] Example 3

[00108] Plastic concrete was converted to a granular material by adding polymer fibers and aluminum sulfate. Sample number 1 is the reference mix. The next series, samples 2-4, use fibers
 15 made from polypropylene (commercial fibers, SINTA M and SINTA F

polypropylene micro and fibrillated fibers sold by GCP Applied Technologies) in combination with aluminum sulfate. Fibers made from PVA in combination with aluminum sulfate were used in samples 5-7. The dosage rate for the fibers in both cases varied from 12.2 lbs/yd³ to 36.7 lbs/yd³. The accelerator dosage was fixed at 12.2 lbs/yd³. The process was the same as previously described. Fibers were manually added to the plastic concrete and mixed using a 3.0 cubic foot concrete mixer for approximately 3 minutes. To accelerate set, aluminum sulfate was then added and mixed for an additional 5 minutes. In all cases, material was converted to a granular form as indicated by the decrease in unit weight and zero slump. The concrete mix design together with the plastic and hardened properties are also given in Table 3 below. As previously observed with shredded post-consumer news print, as the dosage rate of polypropylene and polyvinyl alcohol fibers increase, the 28 day compressive strength decreases. For the case of polypropylene, at a dosage of 36.7 lbs/yd³ the strength decreases from 4855 psi to 1322 psi. The addition of polyvinyl alcohol fibers at a dosage of 36.7 lbs/yd³ results in a 28 day strength of 1336 psi, similar to values obtained for polypropylene. The values are higher compared for the same treatment using shredded post-consumer news print. From the first example, the 28 day strength for a granular material treated with 24.5 lbs/yd³ of shredded post-consumer news print and 12.2 lbs/yd³ of aluminum was 823 psi. From the previous study, the equivalent dosage resulted in a material

that broke apart when removing from the mold and as a consequence a compressive strength measurement could not be made.

[00109] Table 3

Number	Units	1	2	3	4	5	6	7
cement	lbs/yd ³	611	611	611	611	611	611	611
coarse aggregate	lbs/yd ³	1775	1775	1775	1775	1775	1775	1775
sand	lbs/yd ³	1303	1303	1303	1303	1303	1303	1303
granular material	lbs/yd ³	0	0	0	0	0	0	0
water	lbs/yd ³	318	318	318	318	318	318	318
w/c		0.52	0.52	0.52	0.52	0.52	0.52	0.52
fiber	type		polypropylene fibers	polypropylene fibers	polypropylene fibers	pva fibers	pva fibers	pva fibers
	grams		162	324	486	162	324	486
	lbs/yd ³		12.2	24.5	36.7	12.2	24.5	36.7
accelerator	Type		aluminum sulfate	aluminum sulfate	aluminum sulfate	aluminum sulfate	aluminum sulfate	aluminum sulfate
	grams		162	162	162	162	162	162
	lbs/yd ³		12.2	12.2	12.2	12.2	12.2	12.2
polymer	type							
	grams							
	lbs/yd ³							
compressive strength (psi)	1 day	1797	1994	906	803	1572	975	706
	7 day	3798	3588	1890	937	2662	1656	1304
	28 day	4855	4633	1994	1322	2650	2384	1336
granular	yes/no	no	no	yes	yes	yes	yes	yes
slump	inches	8.25	0.25	0	0	0	0	0
weight	grams	20610	20470	19840	18900	20200	19210	18960
air	%	1.7	0	0	0	0	0	0
unit weight	kg/m ³	2386	2366	2277	2144	2328	2188	2153
	pcf	149.0	147.7	142.1	133.8	145.3	136.6	134.4
concrete temp.	°C	22.2	24.4	25.5	24.4	24.4	24.4	24.4

5

[00110] Example 4

[00111] In this example, material made in Example 1, specifically sample number 11, was used to replace a fraction of the coarse aggregate, 10, 20 and 40%, i.e., samples 2-4. Sample 11 in Example 1 used 24.5 lbs/yd³ of cellulose fiber and 36.7 lbs/yd³ of set accelerator, aluminum sulfate. The effect on plastic and hardened properties were measured and given in Table 4 below. There's a slight decrease in the 28 day compressive strength relative to the reference mix. At 40% coarse aggregate replacement, the 28 day strength is 4887 psi, which is 339 psi less than the reference mix. As the fraction of treated material increases in the mix, plastic air increases. The reference mix

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contains 1.9% plastic air. At 40% replacement of the coarse aggregate the plastic air increases to 2.6%.

[00112] Samples 5-7 are looking at the effect on concrete plastic properties with the addition of 24.5 lbs/yd³ of shredded post-consumer news print and a variation in the addition rate of aluminum sulfate, from 12.2 to 36.7 lbs/yd³. As previously demonstrated, the addition of shredded post-consumer news print and aluminum sulfate can convert plastic concrete to a granular form. In this case, the dosage rate of shredded post-consumer news print is fixed at 24.5 lbs/yd³ and the dosage rate of aluminum sulfate is varied between 12.2 and 36.7 lbs/yd³. As previously demonstrated, the addition of shredded post-consumer news print and aluminum sulfate in the dosage range between 12.2 and 36.7 lbs/yd³ significantly reduces the 28 day strength making it easier to manage granular material as a function of time. For example, at an accelerator dosage of 36.7 lbs/yd³ the compressive strength decreases from 5226 psi for the reference mix to 381 psi. The last sample, number 8, is the treatment of plastic concrete with a competitive product called RECON Zero, from Mapei. RECON Zero is a two-component system comprised of a super absorbent polymer (crossed linked sodium polyacrylic polymer) and set accelerator, aluminum sulfate. The dosage of polymer and accelerator are relatively low compared to the use of cellulose fiber and set accelerator used in previous examples. The polymer dosage is 0.8 lbs/yd³ and the set accelerator is 10.1 lbs/yd³. RECON Zero also results in a

granular material with a concomitant decrease in 28 day compressive strength relative to the reference mix. For this case, the 28 day strength decreases to 447 psi.

[00113] Table 4

Number	Units	1	2	3	4	5	6	7	8
cement	lbs/yd ³	611	611	611	611	611	611	611	611
coarse aggregate	lbs/yd ³	1775	1597.5	1420	1065	1775	1775	1775	1775
sand	lbs/yd ³	1303	1303	1303	1303	1303	1303	1303	1303
granular material	lbs/yd ³	0	178	355	710	0	0	0	0
water	lbs/yd ³	318	318	318	318	318	318	318	318
w/c		0.52	0.52	0.52	0.52	0.52	0.52	0.52	0.52
fiber	type		shredded post-consumer news print	shredded post-consumer news print	shredded post-consumer news print	shredded post-consumer news print	shredded post-consumer news print	shredded post-consumer news print	
	grams		324	324	324	324	324	324	
	lbs/yd ³		24.5	24.5	24.5	24.5	24.5	24.5	
accelerator	Type		aluminum sulfate	aluminum sulfate	aluminum sulfate	aluminum sulfate	aluminum sulfate	aluminum sulfate	aluminum sulfate
	grams		486	486	486	162	324	486	133
	lbs/yd ³		36.7	36.7	36.7	12.2	24.5	36.7	10.1
polymer	type								sap
	grams								11.1
	lbs/yd ³								0.8
compressive strength (psi)	1 day	1946	1979	1771	1830	402	412	218	283
	7 day	3510	3795	3423	3514	796	577	286	522
	28 day	5226	4906	4844	4887	907	903	381	447
granular	yes/no	no	No	no	no	yes	yes	yes	yes
slump	inches	8.25	7.5	8	8.25	0	0	0	0
weight	grams	20590	20420	20320	20030	16460	16280	15820	16470
air	%	1.9	2	2.1	2.6	0	0	0	0
unit weight	kg/m ³	2383	2359	2345	2304	1800	1774	1709	1801
	pcf	148.8	147.3	146.4	143.8	112.4	110.7	106.7	112.4
concrete temp.	°C	23.3	23.3	23.3	23.3	25.5	27.7	28.8	27.2

5

[00114] **Example 5** (batch number 17247)

[00115] In this example, three small studies were carried out. In the first study, samples 2-3, the effect of polypropylene fibers (commercial fibers, SINTA M and SINTA F polypropylene micro and fibrillated fibers sold by GCP Applied Technologies) without the addition of aluminum sulfate was investigated. At 12.2 lbs/yd³, the addition of polypropylene fibers could not convert plastic concrete to a granular form. At 24.5 lbs/yd³, the addition of polypropylene fibers was able to transform plastic concrete to a granular form. The decrease in the 28 day

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compressive strength was small compared to the use of shredded post-consumer news print at the same dosage. At 24.5 lbs/yd³ of fibers the compressive strength for concrete treated with cellulose was 1388 psi compared to 4844 psi for concrete treated
5 with polypropylene fibers.

[00116] In the second study, sample number 4-6, the dosage of polypropylene fibers was fixed at 12.2 lbs/yd³ and the dosage rate of aluminum sulfate was varied between 12.2 and 36.7 lbs/yd³. In all three cases, plastic concrete was converted to
10 a granular form as indicated by the zero slump, decrease in unit weight and compressive strength. The addition of accelerator in excess of 12.2 lbs/yd³ results in a significant decrease in 28 day strength. At a dosage of 24.5 lbs/yd³, the 28 day strength decreases from 5226 psi to 907 psi.

15 [00117] In the last study, in addition to the shredded post-consumer news print and aluminum sulfate, a super absorbent polymer (SAP), Hysorb 8600 from BASF and CoolTie AgSAP from M2Polymer, was added to determine if the granular properties of the material improves, i.e., is weaker when the SAP is
20 introduced. The role of the super absorbent polymer is to absorb water from the system facilitating the conversion of plastic concrete to a granular material. The dosage rate or dependence of the SAP was studied between 0.4 and 1.7 lbs/yd³. In the absence of SAP, the 28 day strength for concrete treated with
25 cellulose fiber and accelerator at a dosage of 12.2 lbs/yd³ was 2531 psi. The addition of 0.4 lbs/yd³ of SAP reduces the 28 day

strength to 381 psi. Results indicate that the 28 day strength is independent of SAP dosage in the range investigated. At a dosage of 1.7 lbs/yd³, the 28 day strength is 447 psi which is higher than the value measured at a dosage of 0.4 lbs/yd³.

5 [00118] Table 5

Number		1	2	3	4	5	6	7	8	9
cement	lbs/yd ³	611	611	611	611	611	611	611	611	611
coarse aggregate	lbs/yd ³	1775	1775	1775	1775	1775	1775	1775	1775	1775
sand	lbs/yd ³	1303	1303	1303	1303	1303	1303	1303	1303	1303
granular material	lbs/yd ³	0	0	0	0	0	0	0	0	0
water	lbs/yd ³	318	318	318	318	318	318	318	318	318
w/c		0.52	0.52	0.52	0.52	0.52	0.52	0.52	0.52	0.52
fiber	type		polypropylene fibers	polypropylene fibers	polypropylene fibers	polypropylene fibers	polypropylene fibers	shredded post-consumer news print	shredded post-consumer news print	shredded post-consumer news print
	grams		162	324	162	162	162	162	162	162
	lbs/yd ³		12.2	24.5	12.2	12.2	12.2	12.2	12.2	12.2
accelerator	Type				aluminum sulfate	aluminum sulfate	aluminum sulfate	aluminum sulfate	aluminum sulfate	aluminum sulfate
	grams				162	324	486	162	162	162
	lbs/yd ³				12.2	24.5	36.7	12.2	12.2	12.2
polymer	type							Sap	sap	sap
	grams							5.6	11.1	22.3
	lbs/yd ³							0.4	0.8	1.7
compressive strength (psi)	1 day	1443	1488	1108	1566	1192	762	399	254	141
	7 day	4319	3386	2204	3674	3452	1709	754	466	409
	28 day	5226	4906	4844	4887	907	903	381	447	447
granular	yes/no	no	no	yes	yes	yes	yes	Yes	yes	yes
slump	inches	9	1.25	0	0	0	0	0	0	0
weight	grams	20360	19560	18410	18420	18060	17600	16490	16600	16180
air	%	2.6	0	0	0	0	0	0	0	0
unit weight	kg/m ³	2351	2238	2075	2077	2026	1961	1804	1819	1760
	Pcf	146.8	139.7	129.5	129.7	126.5	122.4	112.6	113.6	109.9
concrete temp.	°C	21.1	22.7	22.7	22.2	23.3	27.2	24.4	23.8	23.3

[00119] Example 6

[00120] In the first study, sample numbers 2-4, treated material was used to replace coarse aggregate in the reference mix (sample number 1). The treated material was made in Example 4, sample number 7. The level of replacement was similar to previous studies, 10, 20 and 40% of the coarse aggregate (as shown in the table below). Unlike in some of the previous studies, the compressive strength did not change significantly. The 28 day strength for the reference mix was 4977 psi. At 40% replacement,

the 28 day strength was 4949 psi. The air did increase slightly as the amount of treated material in the mix increased. The air increased from 1.7 to 2.9%. The shredded post-consumer news print and aluminum sulfate content in the treated material was approximately 24.5 lbs/yd³ and 36.7 lbs/yd³ respectively. One reason why the difference in compressive strength was not significant could be due to the increased level of accelerator, aluminum sulfate.

[00121] In the second study, sample numbers 5-6, treated material was used to replace coarse aggregate in the reference mix (sample number 1). The treated material was made in Example 4, sample number 8. In this study the level of coarse aggregate replacement was approximately 10 and 20%. Similar to the first study, there was no significant effect on the concrete hardened properties. Compressive strength of the treated material was comparable to the reference mix. Unlike mixes containing shredded post-consumer news print, there was a reduction in air as the percent replacement increased. However, the plastic air was still higher than the reference mix. Example 4, sample number 8 was treated using a commercially available product called RECON Zero manufactured by Mapei. RECON Zero is a two-part system comprised of a super absorbent polymer (sodium polyacrylate, part A) and a set accelerator (aluminum sulfate, part B). The relative dosages are given or provided in the examples (4 and 6).

[00122] The last two examples, 7 & 8, were simply replicates of previous studies.

[00123] Table 6

Number		1	2	3	4	5	6	7	8
cement	lbs/yd ³	611	611	611	611	611	611	611	611
coarse aggregate	lbs/yd ³	1775	1597.5	1420	1065	1597.5	1420	1775	1775
sand	lbs/yd ³	1303	1303	1303	1303	1303	1303	1303	1303
granular material	lbs/yd ³	0	178	355	710	178	355	0	0
water	lbs/yd ³	318	318	318	318	318	318	318	318
w/c		0.52	0.52	0.52	0.52	0.52	0.52	0.52	0.52
fiber	type		shredded post-consumer news print	shredded post-consumer news print	shredded post-consumer news print				shredded post-consumer news print
	grams		324	324	324				324
	lbs/yd ³		24.5	24.5	24.5				24.5
accelerator	type		aluminum sulfate	aluminum sulfate	aluminum sulfate	aluminum sulfate	aluminum sulfate	aluminum sulfate	aluminum sulfate
	grams		486	486	486	133	133	133	486
	lbs/yd ³		36.7	36.7	36.7	10.1	10.1	10.1	36.7
polymer	type					sap	Sap	sap	
	grams					11.1	11.1	11.1	
	lbs/yd ³					0.8	0.8	0.8	
compressive strength (psi)	1 day	1952	2169	1983	2168	1753	2103	478	128
	7 day	3963	3997	3902	3955	3874	3942	731	221
	28 day	4977	5052	5106	4949	5083	5128	1340	555
granular	yes/no	no	no	no	no	no	No	yes	yes
slump	inches	8.25	8	5.5	3.75	8.25	5.75	0	0
weight	grams	20620	20510	20390	20050	20420	20510	18230	16780
air	%	1.7	2	2.4	2.9	2.4	1.9	0	0
unit weight	kg/m ³	2387	2372	2355	2307	2359	2372	2050	1845
	pcf	149.0	148.1	147.0	144.0	147.3	148.1	128.0	115.2
concrete temp.	°C	22.7	22.7	22.7	22.7	22.7	23.3	23.8	27.2

[00124] Example 7

5 [00125] In the first study, sample numbers 2-4, treated material was used to replace coarse aggregate in the reference mix (sample number 1). The treated material was made in Example 6, sample number 7. The level of replacement was similar to previous studies, 10, 20 and 40% of the coarse aggregate (as shown in the

10 table below). Unlike in some of the previous studies, the compressive strength did not change significantly. The air did increase slightly as the amount of treated material in the mix increased. This was not observed at the lower dosage previously studied (Example 6). In this study the treated material used

15 to replace the coarse aggregate was made using a commercially available product called RECON Zero manufactured by Mapei.

RECON Zero is a two-part system comprised of a super absorbent polymer (sodium polyacrylate, part A) and a set accelerator (aluminum sulfate, part B). The dosage rates of part A and part B are 0.8 and 10.1 lbs/yd³ respectively.

- 5 **[00126]** In the second study, sample numbers 5-7, treated material was used to replace coarse aggregate in the reference mix (sample number 1). The treated material was made in Example 6, sample number 8. The material in Example 6, sample number 8 was treated using shredded post-consumer news print and aluminum sulfate.
- 10 The level of replacement was similar to previous studies, 10, 20 and 40% of the coarse aggregate (as shown in the table below). Unlike in some of the previous studies, the compressive strength did not change significantly. The air did increase slightly as the amount of treated material in the mix increased. The
- 15 cellulose and aluminum sulfate content in the treated material was approximately 24.5 lbs/yd³ and 36.7 lbs/yd³ respectively. One reason why the difference in compressive strength was not significant could be due to the increased level of accelerator, aluminum sulfate.
- 20 **[00127]** In the third study, the use of cellulose fiber and accelerator to convert plastic concrete to a granular material was repeated. The dosage rate of cellulose fiber was fixed at 24.5 lbs/yd³. The dosage rate of aluminum sulfate was between 12.2 and 36.7 lbs/yd³.
- 25 **[00128]** The last two examples, 7 & 8, were simply replicates of previous studies.

[00129] Table 7

Number		1	2	3	4	5	6	7	8	9	10
cement	lbs/yd ³	611	611	611	611	611	611	611	611	611	611
coarse aggregate	lbs/yd ³	1775	1597.5	1420	1065	1597.5	1420	1065	1775	1775	1775
sand	lbs/yd ³	1303	1303	1303	1303	1303	1303	1303	1303	1303	1303
granular material	lbs/yd ³	0	178	355	710	178	355	710	0	0	0
water	lbs/yd ³	318	318	318	318	318	318	318	318	318	318
w/c		0.52	0.52	0.52	0.52	0.52	0.52	0.52	0.52	0.52	0.52
fiber	type					shredded post-consumer news print	shredded post-consumer news print	shredded post-consumer news print	shredded post-consumer news print	shredded post-consumer news print	shredded post-consumer news print
	grams					324	324	324	324	324	324
	lbs/yd ³					24.5	24.5	24.5	24.5	24.5	24.5
accelerator	type		aluminum sulfate	aluminum sulfate	aluminum sulfate	aluminum sulfate	aluminum sulfate	aluminum sulfate	aluminum sulfate	aluminum sulfate	aluminum sulfate
	grams		133.1	133.1	133.1	486	486	486	162	324	486
	lbs/yd ³		10.1	10.1	10.1	36.7	36.7	36.7	12.2	24.5	36.7
polymer	type		sap	sap	sap						
	grams		11.1	11.1	11.1						
	lbs/yd ³		0.8	0.8	0.8						
compressive strength (psi)	1 day	2041	2021	1817	1986	1704	1813	1873	753	354	309
	7 day	4098	4054	3896	4194	3643	3975	3847	1458	730	655
	28 day	5296	5590	5193	5675	4808	5094	4664	1773	684	743
granular	yes/no	no	no	no	no	no	no	no	yes	yes	yes
slump	Inches	5.25	6.25	6.25	5.5	8	6.25	3.5	0	0	0
weight	grams	19840	19710	19770	19400	19750	19580	19310	16950	16880	15990
air	%	2.1	2.1	2.2	2.5	2.1	2.6	3.4	0	0	0
unit weight	kg/m ³	2277	2259	2267	2215	2264	2240	2202	1869	1859	1733
	pcf	142.1	141.0	141.5	138.3	141.3	139.8	137.5	116.7	116.1	108.2
concrete temp.	°C	21.1	21.6	22.2	21.1	21.6	21.6	22.2	23.3	25.5	26.1

[00130] Example 8

[00131] In this example, two studies were carried out using a fixed dosage rate of shredded post-consumer news print and aluminum sulfate. The effect of dosage rate on the performance or conversion of plastic concrete to a granular form was studied using two different protocols. In the first study (sample numbers 2-4) the addition of materials was sequential. The super absorbent polymer was added first and mixed for three minutes, followed by the addition of shredded post-consumer news print and mixed for the same amount of time, 3 minutes. After the mixing of cellulose fiber, the set accelerator, aluminum sulfate, was added and mixed for 5 minutes. In the second study (sample numbers 5-7), all materials were blended and added

simultaneously. In both cases the performance, plastic and hardened properties were similar indicating that the addition sequence of raw materials has no effect on the conversion of plastic concrete to a granular form.

5 [00132] Table 8

Number		1	2	3	4	5	6	7
cement	lbs/yd ³	611	611	611	611	611	611	611
coarse aggregate	lbs/yd ³	1775	1775	1775	1775	1775	1775	1775
sand	lbs/yd ³	1303	1303	1303	1303	1303	1303	1303
granular material	lbs/yd ³	0	0	0	0	0	0	0
water	lbs/yd ³	318	318	318	318	318	318	318
w/c		0.52	0.52	0.52	0.52	0.52	0.52	0.52
fiber	type		shredded post-consumer news print	shredded post-consumer news print	shredded post-consumer news print	shredded post-consumer news print	shredded post-consumer news print	shredded post-consumer news print
	grams		162	162	162	162	162	162
	lbs/yd ³		12.2	12.2	12.2	12.2	12.2	12.2
accelerator	type		aluminum sulfate	aluminum sulfate	aluminum sulfate	aluminum sulfate	aluminum sulfate	aluminum sulfate
	grams		162	162	162	162	162	162
	lbs/yd ³		12.2	12.2	12.2	12.2	12.2	12.2
polymer	type		sodium polyacrylate	sodium polyacrylate	sodium polyacrylate	sodium polyacrylate	sodium polyacrylate	sodium polyacrylate
	grams		5.5	11	22	5.5	11	22
	lbs/yd ³		0.4	0.8	1.7	0.4	0.8	1.7
compressive strength (psi)	1 day	1738	267	86	83	258	136	107
	7 day	3756	545	185	219	397	273	135
	28 day	4817	992	218	425	532	369	237
granular	yes/no	no	yes	yes	yes	Yes	yes	yes
slump	inches	8.25	0	0	0	0	0	0
weight	grams	20680	18400	16980	17310	18450	16800	17700
air	%	1.3	0	0	0	0	0	0
unit weight	kg/m ³	2396	2074	1873	1920	2081	1848	1975
	pcf	149.6	129.5	116.9	119.9	129.9	115.4	123.3
concrete temp.	°C	25	26.1	25.6	25.6	25.6	25.6	25.6

Note: the difference between samples 2,3,4 and 5,6,7 is that for the case of 5,6,7 the sap (sodium polyacrylate), accelerator (aluminum sulfate) and shredded post-consumer news print were pre-blended before addition.

10 [00133] Example 9

[00134] In this example, two studies were carried out to determine the effect of accelerator dosage rate on the conversion of plastic concrete to a granular form at a fixed dosage of shredded post-consumer news print. In the first study, the dosage rate of shredded post-consumer news print was fixed at 12.2 lbs/yd³. The dosage rates of set accelerator investigated were 12.2, 24.5 and 37.7 lbs/yd³. In the second study, a similar investigation was carried out except in this

case the dosage of cellulose fiber was increased from 12.2 to 24.5 lbs/yd³. The dosages of aluminum sulfate remained the same. The most significant difference is in the compressive strength. For the same dosage of aluminum sulfate, the addition of shredded post-consumer news print results in a significant decrease in compressive strength. For example, at fixed accelerator dosage of 12.2 lbs/yd³, when the dosage in shredded post-consumer news print increases from 12.2 and 24.5 lbs/yd³ the 28 day strength decreases from 3870 to 483 psi. The addition of shredded post-consumer news print significantly decreases the compressive strength making it easier to breakup.

[00135] Table 9

Number		1	2	3	4	5	6	7
cement	lbs/yd ³	611	611	611	611	611	611	611
coarse aggregate	lbs/yd ³	1775	1775	1775	1775	1775	1775	1775
sand	lbs/yd ³	1303	1303	1303	1303	1303	1303	1303
granular material	lbs/yd ³	0	0	0	0	0	0	0
water	lbs/yd ³	318	318	318	318	318	318	318
w/c		0.52	0.52	0.52	0.52	0.52	0.52	0.52
fiber	type		shredded post-consumer news print	shredded post-consumer news print	shredded post-consumer news print	shredded post-consumer news print	shredded post-consumer news print	shredded post-consumer news print
	grams		162	162	162	324	324	324
	lbs/yd ³		12.2	12.2	12.2	24.5	24.5	24.5
accelerator	type		aluminum sulfate	aluminum sulfate	aluminum sulfate	aluminum sulfate	aluminum sulfate	aluminum sulfate
	grams		162	324	486	162	324	486
	lbs/yd ³		12.2	24.5	36.7	12.2	24.5	36.7
polymer	type							
	grams							
	lbs/yd ³							
compressive strength (psi)	1 day	1386	1398	474	218	162	275	23
	7 day	3151	2762	659	338	358	486	66
	28 day	4790	3870	905	485	483	517	129
granular	yes/no	no	yes	yes	yes	yes	yes	yes
slump	inches	6.5	0	0	0	0	0	0
weight	grams	20420	20100	18400	17160	17380	17000	17270
air	%	1.8	0	0	0	0	0	0
unit weight	kg/m ³	2359	2314	2074	1899	1930	1876	1914
	pcf	147.3	144.5	129.5	118.6	120.5	117.1	119.5
concrete temp.	°C	23.3	25.6	27.2	27.2	26.7	26.7	27.8

15 [00136] Example 10

[00137] In the first study, sample numbers 2-4, treated material was used to replace coarse aggregate in the reference mix (sample number 1). The treated material was made in Example 9, sample number 4. The level of replacement was similar to previous studies, 10, 20 and 40% of the coarse aggregate (as shown in the table below). Similar to previous studies the compressive strength decreased slightly with a concomitant increase in plastic air. The material used to replace the coarse aggregate was treated with shredded post-consumer news print and aluminum sulfate at 12.2 and 36.7 lbs/yd³, respectively.

[00138] In the second study, sample numbers 5-7, treated material was used to replace coarse aggregate in the reference mix (sample number 1). The treated material was made in Example 6, sample number 7. The level of replacement was similar to previous studies, 10, 20 and 40% of the coarse aggregate (as shown in the table below). Similar to previous studies the compressive strength decreased slightly with a concomitant increase in plastic air. The material used to replace the coarse aggregate was treated with shredded post-consumer news print and aluminum sulfate at 24.5 and 36.7 lbs/yd³, respectively. In this case, the increase in air was higher compared to the first study indicating that as the dosage rate of fibers increases so does the plastic air when the material is reused as aggregate.

25

[00139] Table 10

Number		1	2	3	4	5	6	7
cement	lbs/yd ³	611	611	611	611	611	611	611
coarse aggregate	lbs/yd ³	1775	1597.5	1420	1065	1597.5	1420	1065
sand	lbs/yd ³	1303	1303	1303	1303	1303	1303	1303
granular material	lbs/yd ³	0	178	355	710	178	355	710
water	lbs/yd ³	318	318	318	318	318	318	318
w/c		0.52	0.52	0.52	0.52	0.52	0.52	0.52
fiber	type		shredded post-consumer news print	shredded post-consumer news print	shredded post-consumer news print	shredded post-consumer news print	shredded post-consumer news print	shredded post-consumer news print
	grams		162	162	162	324	324	324
	lbs/yd ³		12.2	12.2	12.2	24.5	24.5	24.5
accelerator	Type		aluminum sulfate	aluminum sulfate	aluminum sulfate	aluminum sulfate	aluminum sulfate	aluminum sulfate
	grams		486	486	486	486	486	486
	lbs/yd ³		36.7	36.7	36.7	36.7	36.7	36.7
polymer	type							
	grams							
	lbs/yd ³							
compressive strength (psi)	1 day	1792	2010	1468	1886	1912	1946	1523
	7 day	3649	3600	3657	3631	3125	3787	3647
	28 day	5611	5315	5601	5296	5206	5341	4877
granular	yes/no	no	no	no	no	no	no	no
slump	inches	8	7	6.5	5.25	6.5	6	6.75
weight	grams	20610	20510	20340	20090	20460	20440	20030
air	%	2	2	2.6	2.8	2.4	2.3	3.3
unit weight	kg/m ³	2386	2372	2348	2312	2365	2362	2304
	Pcf	149.0	148.1	146.6	144.3	147.6	147.5	143.8
concrete temp.	°C	24.4	23.8	22.2	23.8	22.2	21.6	22.2

[00140] Example 11

[00141] In this study, the effect of fiber type, Drill Paper, shredded post-consumer news print and ARBOCEL (All materials were supplied by J Rettenmaier and Soehne, GMBH and CO KG) on the conversion of plastic concrete to a granular form was investigated. All paper types are cellulose-based. The most significant difference between the ARBOCEL material and the other two fibers is the particle size. Drill Paper has an average particle size of equal to or greater than 1.31mm. The particle size for shredded post-consumer news print is also of the order of 1 mm. The particle size of ARBOCEL is between 0.2 and 0.3 mm. As a result, the dosage efficiency of ARBOCEL should be better than the other two materials. Studies showed that the addition of ARBOCEL was able to produce zero slump concrete

(granular material) at dosage rates between 12.2 and 36.7 lbs/yd³. Shredded post-consumer news print and Drill Paper did not produce zero slump concrete at a dosage rate of approximately 12.2 lbs/yd³. Earlier studies showed that the addition of

5 shredded post-consumer news print was able to convert plastic concrete to a granular form. In all cases a set accelerator, aluminum sulfate, was used at a dosage rate of 12.2 lbs/yd³. Even though ARBOCEL had the smallest particle size, the 28 day strengths are significantly higher compared to shredded post-

10 consumer news print and Drill Paper. The 28 day strength for material treated with 36.7 lbs/yd³ of drill paper and shredded post-consumer news print are 737 and 599 psi respectively. For ARBOCEL at equivalent dosage the 28 day strength was more than double, 1565 psi. The higher 28 day compressive strength

15 indicates that the material would be more difficult to break up and would require material management more frequently.

[00143] Table 11

Product	Average Particle Size (% Retained)				Fiber Length	Viscosity (Water)	Viscosity (30W Oil)	Ash Content	Moisture Content	Oil Absorption
	20 Mesh	60 Mesh	100 Mesh	140 Mesh	Avg.	4% conc., cP	2% conc., cP	Max	Max	Times Weight
CF100	35-72	6-17	1-3	2-4	1.31 mm	16700	140000	15%	7%	11X
CF220	17-28	10-17	3-7	4-9	1.05 mm	8400	29500	27%	5%	9X
CF315	10-18	13-21	4-8	4-10	1.05 mm	25000	35500	23%	5%	5X
CF325	9-17	12-19	4-8	5-10	0.83 mm	7900	35700	28%	5%	8X
CF335	8-17	11-18	4-8	4-10	0.87 mm	7400	38300	29%	5%	8X
CFS40605	0	10-30	8-14	9-23	0.53 mm	1800	7400	18%	5%	8X
CF425	0-1	7-18	6-13	8-19	0.72 mm	2200	8200	28%	5%	7X
CF525	0	1-12	8-15	6-20	0.57 mm	2400	9800	25%	5%	6X
CF725	0	0-8	8-14	13-26	0.54 mm	2600	6700	25%	5%	6X
Drill Paper	<50	8-14	2-6	N/A	N/A	13100	110300	11%	10%	11X
	10 Mesh	35 Mesh								
ARBOCEL	18 max	88 min			0.2-0.3 mm			0.50%		
	20 Mesh	40 Mesh	Passing (in Pan)					Ash content	Moisture content	
SHREDDED POST-CONSUMER NEWS PRINT	45-62	12-21	4-17					3-20	7%	

5

[00144] Table 11A

Number		1	2	3	4	5	6	7	8	9	10
cement	lbs/yd ³	611	611	611	611	611	611	611	611	611	611
coarse aggregate	lbs/yd ³	1775	1775	1775	1775	1775	1775	1775	1775	1775	1775
sand	lbs/yd ³	1303	1303	1303	1303	1303	1303	1303	1303	1303	1303
granular material	lbs/yd ³	0	0	0	0	0	0	0	0	0	0
water	lbs/yd ³	318	318	318	318	318	318	318	318	318	318
w/c		0.52	0.52	0.52	0.52	0.52	0.52	0.52	0.52	0.52	0.52
fiber	type		drill paper	drill paper	drill paper	shredded post-consumer news print	shredded post-consumer news print	shredded post-consumer news print	ARBOCEL	ARBOCEL	ARBOCEL
	grams		162	324	486	162	324	486	162	324	486
	lbs/yd ³		12.2	24.5	36.7	12.2	24.5	36.7	12.2	24.5	36.7
accelerator	type		aluminum sulfate	aluminum sulfate	aluminum sulfate	aluminum sulfate	aluminum sulfate	aluminum sulfate	aluminum sulfate	aluminum sulfate	aluminum sulfate
	grams		162	162	162	162	162	162	162	162	162
	lbs/yd ³		12.2	12.2	12.2	12.2	12.2	12.2	12.2	12.2	12.2
polymer	type										
	grams										
	lbs/yd ³										
compressive strength (psi)	1 day	2034	1863	739	390	1156	355	139	1978	1816	556
	7 day	4181	3247	1257	416	2577	425	370	3899	3410	1342
	28 day	4826	4229	1525	737	2321	973	599	4816	4456	1565
granular slump	yes/no	no	no	no	yes	no	yes	Yes	yes	yes	yes
	inches	7.5	0.25	0.25	0	0.25	0	0	0	0	0
weight	grams	20590	19640	18050	17640	18370	17530	16890	20030	18680	18260
air	%	2.3	6.8	0	0	0	0	0	0	0	0
unit weight	kg/m ³	2383	2249	2024	1966	2069	1951	1860	2304	2113	2054
	pcf	148.8	140.4	126.4	122.7	129.2	121.8	116.1	143.8	131.9	128.2
concrete temp.	°C	22.2	22.2	22.2	21.6	24.4	25.5	26.1	26.1	25.5	25.5

10 [00145] Example 12

[00146] In this example, the effect of water absorbing polymers, specifically super absorbent polymer, on the conversion of

plastic concrete to granular material was studied in combination with a fixed amount of shredded post-consumer news print and aluminum sulfate. The objective was to determine if the addition of super absorbent polymers could improve the performance of the other materials in the conversion process including post processing behavior. Two super absorbent acrylic polymers with a mean particle size of 20 and 60 microns were used.

[00147] Both materials were able to convert plastic concrete to a granular form. In terms of post-processing granular material, concrete treated with shredded post-consumer news print, accelerator and cross-linked modified acrylic polymer, resulted in a decrease in workability and compressive strength as indicated in the table below. The dosage range for the polymers used in this study was between 5.5 and 22 pounds per cubic yard of concrete. In both cases the compressive strength was reduced by approximately 40%.

TABLE 12

Number		1	2	3	4	5	6	7	8
cement	lbs/yd ³	611	611	611	611	611	611	611	611
coarse aggregate	lbs/yd ³	1775	1775	1775	1775	1775	1775	1775	1775
sand	lbs/yd ³	1303	1303	1303	1303	1303	1303	1303	1303
granular material	lbs/yd ³	0	0	0	0	0	0	0	0
water	lbs/yd ³	318	318	318	318	318	318	318	318
w/c		0.52	0.52	0.52	0.52	0.52	0.52	0.52	0.52
fiber	type		shredded post-consumer news print	shredded post-consumer news print	shredded post-consumer news print		shredded post-consumer news print	shredded post-consumer news print	shredded post-consumer news print
	grams		162	162	162		162	162	162
	lbs/yd ³		12.2	12.2	12.2		12.2	12.2	12.2
accelerator	type		aluminum sulfate	aluminum sulfate	aluminum sulfate		aluminum sulfate	aluminum sulfate	aluminum sulfate
	grams		162	162	162		162	162	162
	lbs/yd ³		12.2	12.2	12.2		12.2	12.2	12.2
polymer	type		Acrylic polymer 20 microns	Acrylic polymer 20 microns	Acrylic polymer 20 microns		Acrylic polymer 60 microns	Acrylic polymer 60 microns	Acrylic polymer 60 microns
	grams		5.5	11	22		5.5	11	22
	lbs/yd ³		0.4	0.8	1.7		0.4	0.8	1.7

compressive strength (psi)	1 day	1747	1902	1674	1430	1902	1871	1810	1383
	7 day	3911	3339	2672	2610	3858	2976	2921	2563
	28 day	5649	4222	3849	3373	7099	3850	3873	3739
granular	yes/no	no	yes	yes	Yes	no	Yes	yes	yes
slump	inches	6	0	0	0	6	0	0	0
weight	grams	20510	18180	17990	18400	20600	18650	18830	18760
air	%	2.6	0	0	0	2.1	0	0	0
unit weight	kg/m ³	2372	2043	2016	2074	2384	2109	2134	2125
	pcf	148.1	127.5	125.9	129.5	148.8	131.7	133.2	132.7
concrete temp.	°C	22.2	25.5	25	25	22.7	22.7	23.3	22.7

5 [00148] Example 13

[00149] In this study, the effect of fiber type was investigated. Cellulose and glass fibers were compared at different dosage rates to determine the effect on the conversion of plastic concrete to a granular form and on the 28 day compressive strength. Shredded post-consumer news print were added at a dosage range between approximately 12.2 and 36.7 lbs/yd³. The addition of glass fibers was between 36.77 and 61.2 lbs/yd³. In both cases the addition of post-consumer shredded news print or glass fibers could transform plastic concrete to a granular form. The difference between the two fibers was in the 28 day compressive strength. At comparable dosages, the 28 day compressive strength for concrete treated with shredded post-consumer news print was less than material treated with glass fibers. For example, at a dosage of 36.7 lbs/yd³, the compressive strengths for concrete treated with shredded post-consumer news print and glass fibers were 869 and 4466 psi respectively. Even at higher dosages, the 28 day strength for concrete treated with glass fibers, up to a dosage of 61.2 lbs/yd³, was greater than

the concrete treated with 36.7 lbs/yd³ of shredded post-consumer news print.

[00150] Table 13

Number		1	2	3	4	5	6	7
cement	lbs/yd ³	611	611	611	611	611	611	611
coarse aggregate	lbs/yd ³	1775	1775	1775	1775	1775	1775	1775
sand	lbs/yd ³	1303	1303	1303	1303	1303	1303	1303
granular material	lbs/yd ³	0	0	0	0	0	0	0
water	lbs/yd ³	318	318	318	318	318	318	318
w/c		0.52	0.52	0.52	0.52	0.52	0.52	0.52
fiber	type		shredded post-consumer news print	shredded post-consumer news print	shredded post-consumer news print	glass fibers	glass fibers	glass fibers
	grams		162	324	486	486	648	810
	lbs/yd ³		12.2	24.5	36.7	36.7	48.9	61.2
accelerator	type		aluminum sulfate	aluminum sulfate	aluminum sulfate	aluminum sulfate	aluminum sulfate	aluminum sulfate
	grams		324	324	324	324	324	324
	lbs/yd ³		24.5	24.5	24.5	24.5	24.5	24.5
polymer	type							
	grams							
	lbs/yd ³							
compressive strength (psi)	1 day	1640	1592	730	435	1774	1851	1368
	7 day	3637	2947	1268	914	3346	3369	2845
	28 day	5245	3947	1678	869	4466	4063	3828
granular	yes/no	no	yes	yes	yes	yes	yes	yes
slump	inches	8	0	0	0	0	0	0
weight	grams	20540	17390	16700	16430	17850	17890	17290
air	%	1.9	0	0	0	0	0	0
unit weight	kg/m ³	2376	1931	1834	1795	1996	2002	1917
	pcf	148.3	120.5	114.5	112.1	124.6	125.0	119.7
concrete temp.	°C	22.2	22.7	23.3	23.8	23.8	24.4	24.4

5

[00151] Example 14

[00152] In this study, the use of cellulose powder (cellulose, microcrystalline powder, material no. 435236 from Sigma-Aldrich, Inc.) was compared to shredded post-consumer news print. In addition mixes were done using a competitive product, Mapei's RECON Zero. Mix number 1 is the reference mix. Mix number 2 uses cellulose powder, specifically microcrystalline cellulose powder with a mean particle size of 125 microns. The powder was being used as a naturally occurring water absorbing material (similar to SAP) and aluminum sulfate at equivalent dosages, 24.5 lbs/yd³. The objective was to determine if there's a

15

difference between the performance of cellulose powder and shredded post-consumer news print. Mix number 6 is the comparable mix using shredded post-consumer news print. In both cases the plastic concrete is transformed to granular form. The most significant difference is the measured 28 day compressive strength. The material or concrete treated with cellulose powder had a compressive strength of 4272 psi after 28 days. The concrete treated with shredded post-consumer news print had a 28 day compressive strength of less than 1600 psi. Mix number three shows the effect of the addition of a small amount of super absorbent polymer and a reduction in aluminum sulfate. In fact, number 3 is an example of concrete treated with RECON Zero plus the addition of cellulose powder. The measured 28 day compressive strength is less than 1000 psi. That represents a significant reduction relative to the reference or untreated mix, 5428 psi. The remaining mixes are replicates from previous studies. Mix number 4 is the treatment of plastic concrete using Mapei's RECON Zero. Mixes 5-7 is the treatment of plastic concrete with a fixed cellulose fiber dosage, 24.5 lbs/yd³, and a variable amount of aluminum sulfate, 12.2 - 36.7 lbs/yd³.

[00153] Table 14

Number		1	2	3	4	5	6	7
cement	lbs/yd ³	611	611	611	611	611	611	611
coarse aggregate	lbs/yd ³	1775	1775	1775	1775	1775	1775	1775
sand	lbs/yd ³	1303	1303	1303	1303	1303	1303	1303
granular material	lbs/yd ³	0	0	0	0	0	0	0
water	lbs/yd ³	318	318	318	318	318	318	318
w/c		0.52	0.52	0.52	0.52	0.52	0.52	0.52
fiber	type			cellulose powder		shredded post-consumer news print	shredded post-consumer news print	shredded post-consumer news print
	grams			324		324	324	324
	lbs/yd ³			24.5		24.5	24.5	24.5

accelerator	type		aluminum sulfate	aluminum sulfate	aluminum sulfate	aluminum sulfate	aluminum sulfate	aluminum sulfate
	grams		324	324	133.7	162	324	486
	lbs/yd ³		24.5	24.5	10.1	12.2	24.5	36.7
polymer	type		cellulose powder	sap	sap			
	grams		324	11.1	11.1			
	lbs/yd ³		24.5	0.8	0.8			
compressive strength (psi)	1 day	2056	1970	293	594	1026	559	499
	7 day	4117	2488	530	1177	1541	1256	815
	28 day	5428	4272	823	1409	2250	1594	1234
granular	yes/no	no	yes	yes	yes	yes	yes	yes
slump	inches	8	0	0	0	0	0	0
weight	grams	20610	18700	17400	17870	18450	17200	16810
air	%	2.1	0	0	0	0	0	0
unit weight	kg/m ³	2386	2116	1932	1999	2081	1904	1849
	pcf	149.0	132.1	120.6	124.8	129.9	118.9	115.4
concrete temp.	°C	21.6	25	22.7	22.7	22.2	25.5	25.5

[00154] Example 15

[00155] In this study, the replacement of SAP in Mapei's RECON
 5 Zero with cellulose powder was investigated. In Mapei's patent they claim that cellulose is a naturally occurring super absorbent polymer and can be used to convert returned concrete to aggregate. In this study cellulose powder (cellulose microcrystalline powder, material no. 435236, from Sigma
 10 Aldrich, Inc.) was used to replace the super absorbent polymer at equivalent dosage, 0.8 lbs/yd³. The aluminum sulfate was fixed at 10.1 lbs/yd³. The cellulose powder at 0.8 lbs/yd³ was not sufficient to convert plastic concrete to a granular form indicating that at equivalent dosage it was not as effective as
 15 the super absorbent polymer. The compressive strength confirms the ineffectiveness of the cellulose powder. The compressive strength was similar to the reference mix indicating no reduction in strength.

[00156] Table 15

Number		1	2
Cement	lbs/yd ³	611	611
coarse aggregate	lbs/yd ³	1775	1775
Sand	lbs/yd ³	1303	1303
granular material	lbs/yd ³	0	0
Water	lbs/yd ³	318	318

w/c		0.52	0.52
Fiber	type		
	grams		
	lbs/yd ³		
accelerator	type		aluminum sulfate
	grams		133.7
	lbs/yd ³		10.1
polymer	type		cellulose
	grams		11.1
	lbs/yd ³		0.8
compressive strength (psi)	1 day	2159	2462
	7 day	3846	3939
	28 day	5030	5195
granular	yes/no	No	no
slump	inches	7	2.25
weight	grams	20580	20500
air	%	2.3	2
unit weight	kg/m ³	2382	2370
	pcf	148.7	148.0
concrete temp.	°C	23.3	26.1

[00157] Example 16

[00158] In this example, the effect of different fiber types and composition were investigated. In an earlier example, glass fibers were used to convert plastic concrete to granular form. The dosage rates were significantly higher compared to shredded post-consumer news print. In this study, fiber glass insulation (Owen's Corning Atticat Expanding Blown-In Insulation), comparable in density to shredded post-consumer news print, was used. The reason to match density was to try and match specific surface area. The dosage of fibers was varied between 12.2 and 36.7 lbs/yd³. The dosage of aluminum sulfate was fixed at 12.2 lbs/yd³. In all cases, the addition of fiber glass or shredded post-consumer news print transforms plastic concrete to granular form. The 28 day compressive strength as a function of dosage are comparable indicating that the treatment or conversion of concrete to a granular form with a concomitant decrease in compressive strength is associated with surface area rather than material chemistry.

[00159] Table 16

Number		1	2	3	4	5	6	7
cement	lbs/yd ³	611	611	611	611	611	611	611
coarse aggregate	lbs/yd ³	1775	1775	1775	1775	1775	1775	1775
sand	lbs/yd ³	1303	1303	1303	1303	1303	1303	1303
granular material	lbs/yd ³	0	0	0	0	0	0	0
water	lbs/yd ³	318	318	318	318	318	318	318
w/c		0.52	0.52	0.52	0.52	0.52	0.52	0.52
fiber	type		fiber glass	fiber glass	fiber glass	shredded post-consumer news print	shredded post-consumer news print	shredded post-consumer news print
	grams		162	324	486	162	324	486
	lbs/yd ³		12.2	24.5	36.7	12.2	24.5	36.7
accelerator	type		aluminum sulfate	aluminum sulfate	aluminum sulfate	aluminum sulfate	aluminum sulfate	aluminum sulfate
	grams		162	162	162	162	162	162
	lbs/yd ³		12.2	12.2	12.2	12.2	12.2	12.2
polymer	type							
	grams							
	lbs/yd ³							
compressive strength (psi)	1 day	2040	2294	695	400	1033	653	210
	7 day	4059	3756	1456	553	2440	1284	578
	28 day	4628	5049	2254	982	3642	1751	826
granular	yes/no	no	yes	yes	Yes	Yes	yes	yes
slump	inches	5	0	0	0	0	0	0
weight	grams	20550	20020	18230	17500	19570	18500	17160
air	%	2.1	0	0	0	0	0	0
unit weight	kg/m ³	2377	2303	2050	1947	2239	2088	1899
	pcf	148.4	143.8	128.0	121.5	139.8	130.3	118.6
concrete temp.	°C	23.3	25.5	27.2	25.5	25.5	25.5	24.4

[00160] Example 17 (batch number 17395)

5 [00161] In this study, the effect of fiber and accelerator dosage on the conversion of plastic concrete to granular form was investigated. Fiber glass (Owen's Corning Atticat Expanding Blown-In Insulation) was used at a dosage between 12.2 and 36.7 lbs/yd³. The accelerator, aluminum sulfate, dosage was between

10 12.2 and 36.7 lbs/yd³. Similar to the observations made for shredded post-consumer news print and aluminum sulfate, as the dosage of fiber increases the 28 day compressive strength decreases. As the dosage of aluminum sulfate increases, the 28 day compressive strength decreases making the material easier

15 to manage or break up as a function of time.

[00162] Table 17

Number		1	2	3	4	5	6
cement	lbs/yd ³	611	611	611	611	611	611

coarse aggregate	lbs/yd ³	1775	1775	1775	1775	1775	1775
sand	lbs/yd ³	1303	1303	1303	1303	1303	1303
granular material	lbs/yd ³	0	0	0	0	0	0
water	lbs/yd ³	318	318	318	318	318	318
w/c		0.52	0.52	0.52	0.52	0.52	0.52
fiber	type		fiber glass	fiber glass	fiber glass	fiber glass	fiber glass
	grams		162	324	486	486	324
	lbs/yd ³		12.2	24.5	36.7	36.7	24.5
accelerator	type		aluminum sulfate	aluminum sulfate	aluminum sulfate	aluminum sulfate	aluminum sulfate
	grams		162	324	486	324	486
	lbs/yd ³		12.2	24.5	36.7	24.5	36.7
polymer	type						
	grams						
	lbs/yd ³						
compressive strength (psi)	1 day	2014	2583	593	303	312	488
	7 day	3624	4295	2130	546	653	1070
	28 day	4737	5750	2415	891	1389	1118
granular	yes/no	no	yes	Yes	Yes	yes	yes
slump	inches	6.75	0	0	0	0	0
weight	grams	20440	20140	19270	17850	18210	18290
air	%	2.3	0	0	0	0	0
unit weight	kg/m ³	2362	2319	2197	1996	2047	2058
	pcf	147.5	144.8	137.2	124.6	127.8	128.5
concrete temp.	oC	25.5	25.5	26.6	27.7	27.2	27.7

[00163] Example 18

[00164] In this study, the effect of fiber and accelerator dosage on the conversion of plastic concrete to granular form was investigated. Fiber glass (Owen's Corning AttiCat Expanding Blown-In Insulation) was used at a dosage between 12.2 and 36.7 lbs/yd³. The accelerator, aluminum sulfate, was used at a dosage between 12.2 and 36.7 lbs/yd³. Similar to the observations made for shredded post-consumer news print and aluminum sulfate, as the dosage of fiber increases the 28 day compressive strength decreases. As the dosage of aluminum sulfate increases, the 28 day compressive strength decreases making the material easier to manage or break up as a function of time.

15 [00165] Table 18

Number		1	2	3	4	5	6	7
cement	lbs/yd ³	611	611	611	611	611	611	611
coarse aggregate	lbs/yd ³	1775	1775	1775	1775	1775	1775	1775
sand	lbs/yd ³	1303	1303	1303	1303	1303	1303	1303
granular material	lbs/yd ³	0	0	0	0	0	0	0
water	lbs/yd ³	318	318	318	318	318	318	318

w/c		0.52	0.52	0.52	0.52	0.52	0.52	0.52
fiber	type		fiber glass	fiber glass	fiber glass	fiber glass	fiber glass	fiber glass
	grams		162	324	486	162	324	486
	lbs/yd ³		12.2	24.5	36.7	12.2	24.5	36.7
accelerator	type		aluminum sulfate	aluminum sulfate	aluminum sulfate	aluminum sulfate	aluminum sulfate	aluminum sulfate
	grams		162	162	162	486	486	486
	lbs/yd ³		12.2	12.2	12.2	36.7	36.7	36.7
polymer	type							
	grams							
	lbs/yd ³							
compressive strength (psi)	1 day	2027	2349	957	328	433	238	159
	7 day	3934	4664	1830	790	615	391	348
	28 day	4911	5680	2572	1083	1166	598	389
granular	yes/no	no	yes	yes	yes	yes	yes	yes
slump	inches	5.5	0	0	0	0	0	0
weight	grams	20620	20380	20010	18950	19140	18480	17860
air	%	2.1	0	0	0	0	0	0
unit weight	kg/m ³	2387	2353	2301	2151	2178	2085	1997
	pcf	149.0	146.9	143.6	134.3	136.0	130.2	124.7
concrete temp.	oC	22.2	26.1	25.5	26.6	27.7	26.6	27.2

[00166] Example 19

[00167] In this study, the effect of fiber dosage on the conversion of plastic concrete to granular form was investigated. Fiber glass (Owen's Corning AttiCat Expanding Blown-In Insulation) was used at a dosage between 12.2 and 36.7 lbs/yd³. The accelerator, aluminum sulfate, dosage was fixed at 24.5 lbs/yd³. Similar to the observations made for shredded post-consumer news print and aluminum sulfate, as the dosage of fiber increases the 28 day compressive strength decreases. As the dosage of aluminum sulfate increases, the 28 day compressive strength decreases making the material easier to manage or break up as a function of time.

15 [00168] Table 19

Number		1	2	3	4	5
cement	lbs/yd ³	611	611	611	611	611
coarse aggregate	lbs/yd ³	1775	1775	1775	1775	1775
sand	lbs/yd ³	1303	1303	1303	1303	1303

granular material	lbs/yd ³	0	0	0	0	0
water	lbs/yd ³	318	318	318	318	318
w/c		0.52	0.52	0.52	0.52	0.52
fiber	type		fiber glass	fiber glass	fiber glass	shredded post-consumer news print
	grams		162	324	486	162
	lbs/yd ³		12.2	24.5	36.7	12.2
accelerator	type		aluminum sulfate	aluminum sulfate	aluminum sulfate	aluminum sulfate
	grams		324	324	324	324
	lbs/yd ³		24.5	24.5	24.5	24.5
polymer	type					
	grams					
	lbs/yd ³					
compressive strength (psi)	1 day	1839	1725	1301	678	1906
	7 day	3848	3170	2416	1294	3682
	28 day	5080	4230	3147	2181	4579
granular	yes/no	no	Yes	Yes	yes	yes
slump	inches	7.75	0	0	0	0
weight	grams	19950	19600	19410	18530	19800
air	%	2.2	0	0	0	0
unit weight	kg/m ³	2293	2243	2216	2092	2271
	pcf	143.1	140.0	138.3	130.6	141.8
concrete temp.	°C	22.7	22.7	27.2	26.6	27.2

[00169] Example 20

[00170] In this study, higher dosage rates, greater than 36.7
 5 lbs/yd³, of shredded post-consumer newsprint were investigated. The shredded newsprint dosage was varied between 48.9 and 73.4 lbs/yd³. As the shredded newsprint dosage increases, the 28 day compressive strength decreases. The same is true for the accelerator. At equivalent shredded newsprint dosages, an
 10 increase in accelerator dosage results in a decrease in 28 day strength. In all cases, the addition of shredded post-consumer news print and aluminum sulfate at dosages in excess of 36.7 lbs/yd³ transforms plastic concrete to a granular form.

[00171] Table 20

Number		1	2	3	4	5	6	7
cement	lbs/yd ³	611	611	611	611	611	611	611
coarse aggregate	lbs/yd ³	1775	1775	1775	1775	1775	1775	1775
sand	lbs/yd ³	1303	1303	1303	1303	1303	1303	1303
granular material	lbs/yd ³	0	0	0	0	0	0	0
water	lbs/yd ³	318	318	318	318	318	318	318
w/c		0.52	0.52	0.52	0.52	0.52	0.52	0.52
fiber	type		shredded post-consumer news print	shredded post-consumer news print	shredded post-consumer news print	shredded post-consumer news print	shredded post-consumer news print	shredded post-consumer news print
	grams		648	810	972	648	810	972
	lbs/yd ³		48.9	61.2	73.4	48.9	61.2	73.4

accelerator	type		aluminum sulfate	aluminum sulfate	aluminum sulfate	aluminum sulfate	aluminum sulfate	aluminum sulfate
	grams		486	486	486	324	324	324
	lbs/yd ³		36.7	36.7	36.7	24.5	24.5	24.5
polymer	type							
	grams							
	lbs/yd ³							
compressive strength (psi)	1 day	1765	430	173	126	343	192	108
	7 day	4364	709	360	252	898	464	273
	28 day	5192	919	328	254	553	436	323
granular	yes/no	no	yes	yes	Yes	yes	yes	yes
slump	inches	7.75	0	0	0	0	0	0
weight	grams	20580	18400	17240	17000	17800	17480	17300
air	%	1.9	0	0	0	0	0	0
unit weight	kg/m ³	2382	2074	1910	1876	1989	1944	1918
	pcf	148.7	129.5	119.2	117.1	124.2	121.4	119.7
concrete temp.	°C	23.3	28.8	27.7	28.8	29.3	27.7	27.7

[00172] Example 21

[00173] In this study, higher dosage rates, greater than 36.7
 5 lbs/yd³, of fiber glass (Owen's Corning AttiCat Expanding Blown-In Insulation) was investigated. The fiber dosage was varied between 48.9 and 73.4 lbs/yd³. As the fiber dosage increases, the 28 day compressive strength decreases. The same is true for the accelerator. At equivalent fiber dosages, an increase in
 10 accelerator dosage results in a decrease in 28 day strength. In all cases, the addition of fiber glass and aluminum sulfate at dosages in excess of 36.7 lbs/yd³ transforms plastic concrete to a granular form.

[00174] Table 21

Number		1	2	3	4	5	6	7
cement	lbs/yd ³	611	611	611	611	611	611	611
coarse aggregate	lbs/yd ³	1775	1775	1775	1775	1775	1775	1775
sand	lbs/yd ³	1303	1303	1303	1303	1303	1303	1303
granular material	lbs/yd ³	0	0	0	0	0	0	0
water	lbs/yd ³	318	318	318	318	318	318	318
w/c		0.52	0.52	0.52	0.52	0.52	0.52	0.52
fiber	type		fiber glass	fiber glass	fiber glass	fiber glass	fiber glass	fiber glass
	grams		648	810	972	648	810	972
	lbs/yd ³		48.9	61.2	73.4	48.9	61.2	73.4
accelerator	type		aluminum sulfate	aluminum sulfate	aluminum sulfate	aluminum sulfate	aluminum sulfate	aluminum sulfate
	grams		324	324	324	486	486	486
	lbs/yd ³		24.5	24.5	24.5	36.7	36.7	36.7
polymer	type							
	grams							
	lbs/yd ³							
compressive strength (psi)	1 day	1660	303	275	131	158	109	72
	7 day	3815	684	419	217	262	235	99

	28 day	5297	740	527	217	490	260	89
granular	yes/no	no	yes	yes	yes	yes	yes	yes
slump	inches	6.75	0	0	0	0	0	0
weight	grams	20590	15880	15500	15420	16600	16080	15320
air	%	2	0	0	0	0	0	0
unit weight	kg/m ³	2383	1718	1664	1653	1819	1746	1639
	pcf	148.8	107.3	103.9	103.2	113.6	109.0	102.3
concrete temp.	°C	21.1	22.2	24.4	25	23.3	25	24.4

[00175] Example 22

[00176] In this study, the addition or dosage of fiber glass
 5 (Owen's Corning Expanding Blown-In Insulation) was investigated
 at values equal to and less than 36.7 lbs/yd³ and at a fixed
 accelerator dosage of 12.2 lbs/yd³. The fiber dosage was varied
 between 6.1 and 36.7 lbs/yd³. As the fiber dosage increased,
 the 28 day compressive strength decreased. In all cases, the
 10 addition of fiber glass at dosages between 6.1 and 36.7 lbs/yd³
 transformed plastic concrete to a granular form at a fixed dosage
 of aluminum sulfate, 12.2 lbs/yd³. The 28 day compressive
 strength does not change significantly until the dosage exceeds
 12.2 lbs/yd³. At a fiber glass dosage of 24.5 lbs/yd³, the 28
 15 day compressive strength decrease from approximately 4595 psi
 for the reference mix to 3237 psi.

[00177] Table 22

Number		1	2	3	4	5
cement	lbs/yd ³	611	611	611	611	611
coarse aggregate	lbs/yd ³	1775	1775	1775	1775	1775
sand	lbs/yd ³	1303	1303	1303	1303	1303
granular material	lbs/yd ³	0	0	0	0	0
water	lbs/yd ³	318	318	318	318	318
w/c		0.52	0.52	0.52	0.52	0.52
fiber	type		fiber glass	fiber glass	fiber glass	fiber glass
	grams		81	162	324	486
	lbs/yd ³		6.1	12.2	24.5	36.7
accelerator	type		aluminum sulfate	aluminum sulfate	aluminum sulfate	aluminum sulfate
	grams		162	162	162	162
	lbs/yd ³		12.2	12.2	12.2	12.2
polymer	type					
	grams					
	lbs/yd ³					
compressive strength (psi)	1 day	2072	2443	2210	1597	592
	7 day	4272	4114	4457	3009	1541
	28 day	4595	5232	5107	3237	1170
granular	yes/no	no	yes	yes	yes	yes
slump	inches	8	0	0	0	0
weight	grams	20770	20460	19690	19550	18030

air	%	1.9	0	0	0	0
unit weight	kg/m ³	2408	2365	2256	2236	2021
	pcf	150.3	147.6	140.8	139.6	126.2
concrete temp.	°C	21.6	23.3	22.2	22.7	22.7

[00178] Example 23

[00179] In this study, the addition or dosage of shredded post-
 5 consumer news print was investigated at values equal to and less
 than 36.7 lbs/yd³ at a fixed accelerator dosage of 12.2 lbs/yd³.
 The shredded newsprint dosage was varied between 6.1 and 36.7
 lbs/yd³. As the shredded newsprint dosage increased, the 28 day
 compressive strength decreased. In all cases, the addition of
 10 shredded post-consumer news print at dosages between 6.1 and
 36.7 lbs/yd³ transformed plastic concrete to a granular form at
 a fixed dosage of aluminum sulfate, 12.2 lbs/yd³. The 28 day
 compressive strength does not change significantly until the
 dosage exceeds 6.1 lbs/yd³. At a shredded newsprint dosage of
 15 12.2 lbs/yd³, the 28 day compressive strength decrease from
 approximately 5349 psi for the reference mix to 4194 psi. At a
 shredded newsprint dosage of 24.5 lbs/yd³, the 28 day compressive
 strength decreases to 1499 psi, a 72% strength reduction.

[00180] Table 23

Number		1	2	3	4	5
ceement	lbs/yd ³	611	611	611	611	611
coarse aggregate	lbs/yd ³	1775	1775	1775	1775	1775
sand	lbs/yd ³	1303	1303	1303	1303	1303
granular material	lbs/yd ³	0	0	0	0	0
water	lbs/yd ³	318	318	318	318	318
w/c		0.52	0.52	0.52	0.52	0.52
fiber	type		shredded post- consumer news print	shredded post- consumer news print	shredded post- consumer news print	shredded post- consumer news print
	grams		81	162	324	486
	lbs/yd ³		6.1	12.2	24.5	36.7
accelerator	type		aluminum sulfate	aluminum sulfate	aluminum sulfate	aluminum sulfate
	grams		162	162	162	162
	lbs/yd ³		12.2	12.2	12.2	12.2
polymer	type					
	grams					
	lbs/yd ³					
compressive strength (psi)	1 day	2058	2315	1987	429	294

	7 day	4040	4274	3427	984	518
	28 day	5349	5483	4194	1499	669
granular	yes/no	no	yes	yes	yes	yes
slump	inches	7.5	0	0	0	0
weight	grams	20610	20290	17900	16100	16160
air	%	2	0	0	0	0
unit weight	kg/m ³	2386	2341	2003	1749	1757
	pcf	149.0	146.1	125.0	109.2	109.7
concrete temp.	°C	21.6	22.7	23.8	24.4	25

[00181] Example 24 (batch number 17435)

5 [00182] In this study, higher dosage rates, greater than 36.7 lbs/yd³, of shredded post-consumer news print was investigated. The dosage rate of set accelerator was fixed at 12.2 lbs/yd³. The dosage was varied between 48.9 and 73.4 lbs/yd³. As the shredded newsprint dosage increases, the 28 day compressive strength decreases. In all cases, the addition of shredded post-consumer news print at dosages in excess of 37 lbs/yd³ transforms plastic concrete to a granular form. The one interesting observation is that the addition of accelerator, though makes a small difference is not be required to reduce 28 day compressive strengths to facilitate management of granular material. In fact results show that the compressive strength begins to converge as the fiber dosage increases independent of the accelerator dosage. These results indicate that shredded newsprint alone is sufficient to convert plastic concrete to a granular form and facilitate the management of the granular material over time.

[00183] Table 24

Number		1	2	3	4
cement	lbs/yd ³	611	611	611	611
coarse aggregate	lbs/yd ³	1775	1775	1775	1775
sand	lbs/yd ³	1303	1303	1303	1303
granular material	lbs/yd ³	0	0	0	0
water	lbs/yd ³	318	318	318	318
w/c		0.52	0.52	0.52	0.52

fiber	type		shredded post-consumer news print	shredded post-consumer news print	shredded post-consumer news print
	grams		648	810	972
	lbs/yd ³		48.9	61.2	73.4
accelerator	type		aluminum sulfate	aluminum sulfate	aluminum sulfate
	grams		162	162	162
	lbs/yd ³		12.2	12.2	12.2
polymer	type				
	grams				
	lbs/yd ³				
compressive strength (psi)	1 day	1854	311	112	65
	7 day	3915	345	284	122
	28 day				
granular	yes/no	no	Yes	yes	yes
slump	inches	8	0	0	0
weight	grams	20540	17960	17480	16960
air	%	2.3	0	0	0
unit weight	kg/m ³	2376	2012	1944	1870
	pcf	148.3	125.6	121.4	116.7
concrete temp.	°C	21.1	21.1	22.9	22.2

[00184] Example 25

[00185] In this study, the effect of shredded post-consumer news print in the absence of a set accelerator was investigated. The shredded newsprint dosage was varied between 48.9 and 73.4 lbs/yd³. As the shredded newsprint dosage increases, the 7 day compressive strength decreases. At such high shredded newsprint dosages, the 28 day cylinders fell apart. In all cases, the addition of shredded post-consumer news print at dosages in excess of 37 lbs/yd³ transforms plastic concrete to a granular form. In this study it was demonstrated that the addition of a set accelerator, aluminum sulfate, though makes a small difference in strength development, is not required to produce a granular material that can be managed over time.

[00186] Table 25

Number		1	2	3	4
cement	lbs/yd ³	611	611	611	611
coarse aggregate	lbs/yd ³	1775	1775	1775	1775
sand	lbs/yd ³	1303	1303	1303	1303
granular material	lbs/yd ³	0	0	0	0
water	lbs/yd ³	318	318	318	318
w/c		0.52	0.52	0.52	0.52
fiber	type		shredded post-consumer news print	shredded post-consumer news print	shredded post-consumer news print
	grams		648	810	972
	lbs/yd ³		48.9	61.2	73.4
accelerator	type				
	grams				

	lbs/yd ³				
polymer	type				
	grams				
	lbs/yd ³				
compressive strength (psi)	1 day	1821	247	200	108
	7 day	4346	531	565	343
	28 day				
granular	yes/no	no	yes	yes	yes
slump	inches	4.25	0	0	0
weight	grams	20530	18310	17540	17470
air	%	2.5	0	0	0
unit weight	kg/m ³	2375	2061	1952	1942
	pcf	148.3	128.7	121.9	121.2
concrete temp.	°C	21.1	20.6	20	20

[00187] Example 26

[00188] In this study, the effect of fiber glass in the absence
 5 of a set accelerator was investigated. The fiber glass dosage
 was varied between 43.5 and 73.4 lbs/yd³. As the fiber glass
 dosage increases, the 7 day compressive strength decreases. At
 such high fiber dosages, the 28 day cylinders fell apart. In
 all cases, the addition of fiber glass at dosages in excess of
 10 37 lbs/yd³ transforms plastic concrete to a granular form. In
 this study it was demonstrated that the addition of a set
 accelerator, aluminum sulfate, though makes a small difference
 in strength development, is not required to produce a granular
 material that can be managed over time.

15

[00189] Table 26

Number		1	2	3	4
cement	lbs/yd ³	611	611	611	611
coarse aggregate	lbs/yd ³	1775	1775	1775	1775
sand	lbs/yd ³	1303	1303	1303	1303
granular material	lbs/yd ³	0	0	0	0
water	lbs/yd ³	318	318	318	318
w/c		0.52	0.52	0.52	0.52
fiber	type		glass fibers	glass fibers	glass fibers
	grams		648	576	972
	lbs/yd ³		48.9	43.5	73.4
accelerator	type				
	grams				
	lbs/yd ³				
polymer	type				
	grams				
	lbs/yd ³				
compressive strength (psi)	1 day	1572	357	567	122
	7 day	3949	555	660	277

	28 day				
granular	yes/no	no	yes	yes	yes
slump	inches	6.75	0	0	0
weight	grams	20550	17440	17800	17530
air	%	2.3	0	0	0
unit weight	kg/m ³	2377	1938	1989	1951
	pcf	148.4	121.0	124.2	121.8
concrete temp.	°C	22.2	22.2	22.7	21.6

[00190] Example 27

[00191] In this study, the introduction of additional mix water on the effect of shredded post-consumer news print and aluminum sulfate to convert plastic concrete to granular form was investigated. In this case the shredded newsprint and aluminum dosage were fixed at 24.5 lbs/yd³. That amount of additional water was increased from 16.7 lbs/yd³ to 100.1 lbs/yd³ (or 2 to 12 gallons/yd³). In the range studied there was a no change in compressive strength. The 7 day strength varied between 856 and 1669 psi with the highest value measured at the lowest water addition rate. It makes sense in terms of the effect water/cement ratio has on strength.

15

[00192] Table 27

Number		1	2	3	4	5	6	7
cement	lbs/yd ³	611	611	611	611	611	611	611
coarse aggregate	lbs/yd ³	1775	1775	1775	1775	1775	1775	1775
sand	lbs/yd ³	1303	1303	1303	1303	1303	1303	1303
granular material	lbs/yd ³	0	0	0	0	0	0	0
water	lbs/yd ³	318	318	318	318	318	318	318
w/c		0.52	0.52	0.52	0.52	0.52	0.52	0.52
fiber	type		shredded post-consumer news print	shredded post-consumer news print	shredded post-consumer news print	shredded post-consumer news print	shredded post-consumer news print	shredded post-consumer news print
	grams		324	324	324	324	324	324
	lbs/yd ³		24.5	24.5	24.5	24.5	24.5	24.5
accelerator	type		aluminum sulfate	aluminum sulfate	aluminum sulfate	aluminum sulfate	aluminum sulfate	aluminum sulfate
	grams		324	324	324	324	324	324
	lbs/yd ³		24.5	24.5	24.5	24.5	24.5	24.5
polymer	type		additional water	additional water	additional water	additional water	additional water	additional water
	grams		221	442	662	883	1104	1325
	lbs/yd ³		16.7	33.4	50.0	66.7	83.4	100.1
compressive strength (psi)	1 day	2018	738	670	695	636	627	509
	7 day	4673	1669	1031	931	856	1281	1105
	28 day							
granular	yes/no	no	yes	yes	yes	yes	yes	yes

slump	inches	8	0	0	0	0	0	0
weight	grams	20680	18900	18120	18560	18770	19200	19130
air	%	1.5	0	0	0	0	0	0
unit weight	kg/m ³	2396	2144	2034	2096	2126	2187	2177
	pcf	149.6	133.8	127.0	130.8	132.7	136.5	135.9
concrete temp.	°C	22.7	26.1	26.6	26.6	26.1	27.2	27.2

Claims

1. A method for producing aggregate particles from cementitious compositions, comprising: combining in a vessel a cementitious composition and at least one aggregate-forming inducer for adhering to cement paste, wherein the at least one aggregate-forming inducer comprises a fiber having an elongated body with a length to equivalent diameter ratio of at least 10 and, when added to the cementitious composition, introduces a surface of between 500 and 10,000 square meters per cubic meter for cement paste to bond/adhere to,

wherein the at least one aggregate-forming inducer is chosen from shredded and/or cut paper, cardboard, corrugated cardboard, cartons, corrugated cartons, crepe paper, newsprint, kraft paper, wall paper, wax paper, silk paper, shredded currencies removed from circulation, wood fibers, glass fibers, shredded textiles, cotton fibers, hemp, mineral fiber chosen from wollastonite, mica, rock wool, slag wool, graphite, natural fibers chosen from sisal fibers, cotton, flax, jute, coconut husks, protein-based fibers, banana, pineapple, wool, mohair, silk, and mixtures of any of the foregoing.

2. The method of claim 1, wherein said surface area is between 1,000 and 5,000 square meters per cubic meter of cementitious composition.

3. The method of claim 1, wherein the fiber having an elongated body has a length to equivalent diameter ratio of at least 50.

4. The method of claim 1, wherein the fiber having an elongated body increases its specific surface area during mixing of the concrete due to surface roughening or fibrillation by at least 10 percent.

5. The method of claim 1, wherein said vessel is the drum of a concrete mixing truck or a stationary mixing drum or pan or any mixing vessel where the vessel rotates or the mixing blades rotate.

6. The method of claim 1 wherein the time needed to combine said at least one aggregate-forming inducer and the cementitious composition and convert the resulting mix to a granular material is 1 to 10 minutes per cubic yard of cementitious composition.

7. The method of claim 1 wherein the aggregate-forming inducer does not negatively impact subsequent concrete mixes with regard to its plastic and hardened properties chosen from air, unit weight, slump, set time and strength.

8. The method of claim 1 wherein the cementitious composition is residual or returned concrete or is a cementitious paste fraction separated from residual or returned concrete.
9. The method of claim 1, wherein said aggregate-forming inducer is newsprint.
10. The method of claim 9, wherein said newsprint is shredded and has a surface area per unit weight between 10 and 500 square meters per kilogram.
11. The method of claim 1 wherein the cementitious composition is returned concrete in a delivery truck mixer-drum, and the at least one aggregate-forming inducer is shredded newsprint.
12. The method of claim 1, further comprising the addition of an admixture chosen from one or more set accelerators, set retarders, water reducers, rheology modifiers chosen from clay, super absorbent polymers and thickeners, corrosion inhibitors, shrinkage reducing admixtures, colorants, air entrainers, air detrainers, and combinations thereof.
13. The method of claim 12, wherein said set accelerator is aluminum sulfate, aluminum trihydrate, calcium nitrate, calcium nitrite, calcium chloride, sodium nitrate, thiocyanate or mixtures thereof.
14. The method of claim 1, further comprising the addition of a super absorbent polymer chosen from sodium polyacrylate, carboxyalkyl cellulose polymers, carboxyalkyl starch polymers, alginates, chitosans, starches, polyacrylic acid polymers, polyacrylamide polymers and polyaspartic acid polymers.
15. A method for producing aggregate particles from cementitious compositions, comprising: combining a cementitious composition and a formulation consisting essentially of at least one aggregate-forming inducer, wherein the at least one aggregate-forming inducer when added to said cementitious composition introduces surface area of between 500 and 10,000 square meters per cubic meter of the cementitious composition, and mixing said cementitious composition with said formulation until the mixed components form granular material, wherein the at least one aggregate-forming inducer is chosen from shredded and/or cut paper, cardboard, corrugated cardboard, cartons, corrugated cartons, crepe paper, newsprint, kraft paper, wall paper, wax paper, silk paper, shredded currencies removed from circulation, wood fibers, glass fibers, shredded textiles, cotton fibers, hemp, mineral fiber chosen from wollastonite, mica, rock wool, slag wool, graphite, natural fibers chosen from sisal fibers, cotton, flax, jute, coconut husks, protein-based fibers, banana, pineapple, wool, mohair, silk, and mixtures of any of the foregoing.

16. The method of claim 15, wherein said formulation is combined with said cementitious material with a conveyor belt, a pneumatic system, a blower or a dispenser.

17. The method of claim 1 wherein the vessel is a rotatable concrete mixer drum mounted on a concrete ready-mix delivery vehicle, the method further comprising monitoring the concrete within the mixer drum using an automated slump monitoring system to ensure that the aggregate-forming inducer becomes uniformly mixed within concrete contained within the mixer drum.