SECTION 100.00 QUALITY ASSURANCE PROGRAM INTRODUCTION

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SECTION 100.00 QUALITY ASSURANCE PROGRAM

INTRODUCTION

The Code of Federal Regulations, (CFR) Part 637 of Title 23, specifies all state highway agencies, which includes the Idaho Transportation Department, must develop a quality assurance program. The program will assure that materials and workmanship incorporated into each federal-aid highway construction project on the NHS are in conformity with the requirements of the approved plans and specifications, including approved changes. The program must be approved by the Federal Highway Administration and must contain certain elements identified in the federal regulation.

The ITD Quality Assurance (QA) Program, as approved by FHWA, applies to all projects, whether federal-aid or state funded. The ITD QA program contains the three required elements: the Acceptance Program (Section 200.00), the Independent Assurance Program (Section 300.00), and the Project Materials Certification (Section 400.00).

The ITD Quality Assurance Program defines three levels of evaluation:

**100.00.01 Quality Control (QC) (Producer)**. Quality Control includes all Contractor/Vendor operational techniques and activities that are performed or conducted to fulfill the contract requirements. Quality control of construction materials is the responsibility of the Contractor and is performed during the production of the material and/or at the point of delivery. The test results provide information to substantiate the uniformity of the material as it is produced and the conformity of the product to specification requirements. A useful tool in quality control is the control chart or run chart. It charts each test result on a graph that shows the average, the variation about the average, and any change in the process during production.

**100.00.02 Acceptance Program (Buyer)**. The acceptance program encompasses all factors that comprise the Department’s determination of the quality of the product as specified in the contract requirements. In addition to inspection, these factors include:

- Manufacturer’s Certification
- Acceptance sampling and testing is sampling and testing used in the acceptance decision. Acceptance sampling and testing may include verification and quality control sampling and testing.
- Verification sampling and testing is sampling and testing performed by the Department or their designated agent, hired by the Department, to validate the quality of the product. All verification samples will be taken independently of QC samples.
- QC sampling and testing results may be used for acceptance as specified if they are validated by the independent verification sampling and testing.
The results of the acceptance program are used by the Department to accept the material at full price, reject the material, or accept the material at a reduced price.

**100.00.03 Independent Assurance (IA).** Independent Assurance is an unbiased and independent evaluation of all the sampling and testing procedures, personnel, and equipment used in the acceptance program. It is a procedure, personnel, and equipment check and is not a part of the acceptance decision.
100.01 Conflict of Interest. In order to avoid a conflict of interest, any non-Department laboratory is allowed to perform only one of the following types of testing on the same project:

- Verification and/or Acceptance testing performed by the Department
- Quality Control
- Independent Assurance
- Dispute Resolution

All levels of testing by Contractors or their designated laboratories to control the quality of a product are considered QC testing. When properly validated by Verification testing, quality control test results may be used for acceptance of material when specified in the contract.

A laboratory performing one of the above types of testing is allowed to prepare mix designs for the same project. The lab must also meet the requirements of Section 225.00 of the Laboratory Operations Manual.
110.00 Quality Assurance Specification Team. In 1996, an ongoing Quality Team was formed to implement and oversee Quality Assurance measures in accordance with the CFR and to ensure the quality of materials and construction on Idaho’s roadways by partnering with Contractors.

In Spring of 2003, the team was reestablished and renamed the Quality Assurance Specification Team. The Division of Engineering Services Administrator serves as the team’s executive sponsor to accomplish the following charge:

To provide continued development and improvement of the Department’s Quality Assurance specifications, measures, and programs to assure quality materials are incorporated into Department projects.

Team members consist of HQ and District representatives from Construction, Materials, Central Laboratory, and Training. An FHWA member, together with representatives from the Consultant and Contracting communities, are also chosen based on knowledge and experience. Contracting members will be recommended by the Association of General Contractors (AGC) and consulting members will be recommended by the Association of Consulting Engineers (ACEC), each to serve for 4 years. Materials Engineers and Resident Engineers will be rotated every 4 years. Reappointments will be allowed based upon expertise and interest.

The Quality Assurance Specification Team will have authority for establishing, maintaining, and promoting Quality Assurance Specifications and programs for the Department.
SECTION 200.00 ACCEPTANCE PROGRAM.

    200.00.01 Test Result Dispute-Resolution.

    200.01 Specifications Compliance and Expenditure of Public Funds.
        200.01.01 Semi-Annual Status Report.

    200.02 How the ITD Acceptance Program Applies to Various Types of Projects.
        200.02.01 Rest Areas and Buildings.

SECTION 210.00 INSPECTION AND TESTING RESPONSIBILITY

    210.01 Inspection and Testing at the Project Site.

    210.02 Inspector Safety.

SECTION 215.00 MATERIALS OR WORK FAILING SPECIFICATIONS.

    215.01 Check Tests.

    215.02 Price Adjustments for Non-compliant Materials or Products.

SECTION 220.00 SAMPLING PROCEDURES

    220.01 Sample Size.
        220.01.01 Improper Sampling.

    220.02 Frequency of Sampling
        220.02.01 Inspection and Observations Made While Sampling and Testing.

    220.03 Numbering
        220.03.01 Numbering Check Tests.

    220.04 Transporting Flammable and Hazardous Material Samples
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        220.04.02 BUS.
        220.04.03 AIR FREIGHT.
        220.04.04 PARCEL SERVICES

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SECTION 230.00 ACCEPTANCE OF MATERIALS BY MANUFACTURER’S OR FABRICATOR’S CERTIFICATION.

230.01 General Provisions.

230.02 Certification Program Procedures for Portland Cement and Fly Ash.
   230.02.01 Portland Cement.
   230.02.01.01 Cement Testing.
   230.02.01.02 Cement Testing Appeal Process.
   230.02.02 Fly Ash
   230.02.02.01 Fly Ash Testing.
   230.02.02.02 Fly Ash Testing Appeal Process.

230.03 Steel.
   230.03.01 Steel Bridge Girders.
   230.03.02 Metal Reinforcement.
   230.03.03 Buy America.
   230.03.03.01 FHWA Q&A on Buy America.

230.04 Concrete Pipe Products.

230.05 Concrete Guardrail and Other Pre-cast Concrete Products.
   230.05.01 Pre-cast, Pre-stressed Concrete.

230.06 Concrete with Specified Strength 3000 psi or Less (Including Seal Concrete).

230.07 Corrugated Metal Pipe and Corrugated Plate Pipe.

230.08 Plastic Pipe.

230.09 Geosynthetics.
   230.09.01 Shipping Procedures.
   230.09.01.01 Geotextile:
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230.10 Performance Graded Asphalt Binder.

230.11 Emulsified Asphalt.

230.12 Seeding.
230.13 Miscellaneous Items Accepted by Certification.

230.13.01 General Provisions.

230.13.02 List of Miscellaneous Materials Accepted on the Basis of the Manufacturer’s or Fabricator’s Certification.

SECTION 240.00 PRE-TESTED AND PRE-QUALIFIED MATERIALS.

240.01 Pre-tested Materials.

240.01.01 Bulk Material/Products Sampled at the Manufacturing Plant.

240.01.02 Materials/Products Sampled at the Project.

240.02 Pre-Qualified Materials.
SECTION 200.00 ACCEPTANCE PROGRAM.

In order to implement the quality assurance elements outlined in Section 100.00, the Acceptance Program must provide a frequency guide, identify the location, and identify specific quality attributes for sampling and testing. Section 270.00 contains this information for each contract bid item and the ITD Quality Assurance Special Provision (QASP) has this information for bid items under the QASP.

Quality control sampling and testing results may be used as part of the acceptance decision provided the following requirements are met:

- The contract identifies items for which QC test results may be used in the acceptance decision.
- The sampling and testing must be performed by qualified laboratories and qualified sampling and testing personnel.
- The quality of the material must be validated by verification sampling and testing. The verification testing must be performed on samples taken independently of the quality control samples.
- The quality control sampling and testing must be evaluated by an Independent Assurance (IA) program.

If the results from the quality control sampling and testing are used in the acceptance program, then there must be a dispute-resolution system established.

200.00.01 Test Result Dispute-Resolution. When quality control and verification test results conflict and the conflict cannot be resolved, the Department has established a Test Result Dispute Resolution process in Section 106.07 of the Standard Specifications.

The Central Laboratory will perform all dispute resolutions unless a potential for conflict of interest exists or the Contractor requests an independent laboratory.

200.01 Specifications Compliance and Expenditure of Public Funds. The specifications and plans provide the minimum requirements that must be met for bidding and completing the contract. The Contractor commits to furnishing materials and completing work that will equal or exceed such requirements. The Engineer must be satisfied, through quality assurance measures, that the public is receiving what it is entitled to under the contract. Nothing less should be accepted. To do so is not only a disservice to the state, but would be giving undue advantage to the Contractor. Other Contractors who bid on the same work could contend that they would have offered a lower bid had they been able to anticipate that materials or work outside of specifications is acceptable.

When payment is made to the Contractor for materials furnished and work performed, the duly designated state officials must authorize disbursement of public funds for this purpose. Through the quality assurance program, the Resident Engineer and the project staff will acquire substantiating data in the form of tests,
inspection records, and measurements to justify acceptance of the Contractor’s work. Thus, the Engineer can be assured the Contractor has fulfilled the contract obligation and is entitled to payment. The Resident Engineer will withhold payment to the Contractor for any material where the required QC and Verification sampling, testing, and/or certification have not been accomplished.

In case of failure to meet the requirements, the quality assurance program data will constitute the basis for rejection of work deemed unfit for acceptance. This data may also be the basis for acceptance of the work upon appropriate contract price adjustment, if permitted under the provisions of the specifications.

Complete records, including tests and inspection reports covering acceptance or rejection of any materials, are kept in the project files and required copies are distributed to other offices as needed for review and documentation. The Resident Engineer is responsible for compiling the records to provide a Materials Summary Report (MSR) for each project. Follow the instructions in Section 400.00, Project Materials Certification for compiling the MSR. The MSR is used to complete the Materials Certification letter for each project.

200.01.01 Semi-Annual Status Report. The District Materials Section must monitor the Districts’ progress on a semi-annual basis and provide the Chief Engineer with reports of deficiencies. Deficiencies are defined as:
1. Payment for out-of-specification material
2. Payment for material that was not sampled, tested, or certified as required by the specifications
3. Failure to perform, or a lack of, Independent Assurance testing
4. Failure to submit the Materials Summary Report and the Materials Certification letter to the Chief Engineer within 60 days from the District Engineer’s final acceptance of the project.

200.02 How the ITD Acceptance Program Applies to Various Types of Projects. The ITD Acceptance Program applies to all project types according to the requirements shown in Table 200.02.1. There could be situations where more than one project type is included in a single contract. In these cases, the acceptance will be determined by the specifications that govern each contract item.

For example, a Department contract awarded by Contracting Services could contain several contract items for constructing local roadways and/or buildings which are covered by different local building codes in the contract. The local jurisdiction is responsible for the inspection and acceptance of the items. At the completion of the work, the local jurisdiction must provide a letter to the Department stating the contract item met the contract specifications.
Table 200.02.1: Acceptance Requirements According to the Type of Project

<table>
<thead>
<tr>
<th>Type of Project</th>
<th>Awarded By</th>
<th>Type of specifications</th>
<th>Materials Inspection &amp; Acceptance</th>
<th>Materials Certification</th>
<th>Final Department Acceptance</th>
</tr>
</thead>
<tbody>
<tr>
<td>ITD Contract</td>
<td>ITD Contracting Services</td>
<td>ITD Standard Specifications</td>
<td>ITD Project Personnel per ITD QA Manual</td>
<td>Resident Engineer per Section 400.01</td>
<td>District Engineer per Section 400.01</td>
</tr>
<tr>
<td>ITD Contract</td>
<td>ITD Contracting Services</td>
<td>Public Works Specifications</td>
<td>Out-source to Consultant inspection per contract specifications</td>
<td>Resident Engineer per Section 400.01</td>
<td>District Engineer per Section 400.01</td>
</tr>
<tr>
<td>Local Agency Enhancement</td>
<td>Local Agency</td>
<td>Public Works or Local Specifications</td>
<td>Local Agency per contract and specifications</td>
<td>Local Agency provides letter to ITD District Engineer</td>
<td>District Engineer provides Final Acceptance after Final Inspection.</td>
</tr>
<tr>
<td>Local Agency Off-System Highway</td>
<td>Local Agency</td>
<td>ITD Standard Specifications</td>
<td>Local Agency per ITD QA Manual.</td>
<td>Local Agency provides letter to ITD District Engineer</td>
<td>District Engineer provides Final Acceptance after Final Inspection.</td>
</tr>
</tbody>
</table>

200.02.01 Rest Areas and Buildings. Rest Area and Building projects that have contract items with acceptance requirements different from ITD specifications will require the following:

1. The Architect of Record will issue a letter of acceptance based on field inspections and approval of required contract submittals for items governed by the Architectural Special Provisions. A copy of the inspections and approvals must be included with the letter.

2. Documented inspections by the Department of Building Safety for the applicable components.

3. Concrete governed by non-ITD specifications will require additional acceptance by:
   a) Department field-inspection personnel must observe Contractor field quality control sampling and testing for proper testing methods and procedures. Actions taken pertaining to Contractor field quality control sampling and testing activities will be recorded in the Construction Diary.
   b) The Department will perform field tests for air, slump, unit weight, and temperature from the same truck as every companion test cylinder set is made.
   c) The Contractor must provide companion test cylinder sets to the Department for acceptance testing at the concrete sampling frequency required by the contract.
4. Metal reinforcement bar governed by non-ITD specifications will require additional acceptance by Department field-inspection personnel in accordance with the Quality Assurance Manual, Section 270.00 Minimum Testing Requirements for 503 Metal Reinforcement.

5. Acceptance and documentation for items with the requirements contained in the Idaho Standards of Public Works Construction (ISPWC) will be accepted by manufacturer’s certification referencing the ISPWC specifications. Project inspection and acceptance of ISPWC items will be out-sourced by the owner (the Department or Local Agency).

Items that are not ITD specifications are exempt from the ITD Quality Assurance Manual Independent Assurance requirements.
SECTION 210.00 INSPECTION AND TESTING RESPONSIBILITY. Inspection personnel assigned to a project will inspect all portions of the day-to-day work. They will also inspect, test, and approve all material going into the work. Certification of some material is allowed. Use Section 230.00 for specific directions for accepting material by certification.

All testers and inspectors must be properly qualified in accordance with ITD specifications and policies. Sampling, testing, and inspection personnel are expected to know which materials must be sampled, when and where samples must be taken, the size of samples required, the proper methods of obtaining samples, and methods of field testing.

The ITD Standard Specifications for Highway Construction state the required sampling and testing methods or the required standard practice methods. Methods include AASHTO, ASTM, Idaho Standard Methods, etc. The QA Manual contains Western Alliance for Quality Transportation (WAQTC) FOPs, Idaho FOPs, and Standard Procedures that modify certain methods. The modifications in the QA Manual govern over the methods shown in the Standard Specification. The Standard Procedures govern over the WAQTC FOPs. The Standard Procedures are included at the end of each applicable method.

Diligent inspection of the work in progress and of each successively completed portion is important. There must be assurance when the work is finished that all parts are acceptable. No amount of sampling and testing can give this assurance without documenting observations at the same time.

210.01 Inspection and Testing at the Project Site. The project inspector must identify and check all materials received on the project before they are incorporated into the work and must ascertain that acceptable test and inspection reports are available for all items inspected by others.

Test reports must show the tester’s printed name and qualification number and be initialed or signed by the tester.

Any individual that signs the Checked By box or certify the test results on any materials testing report must have been qualified in the appropriate Sampler/Tester area at one time or be a licensed Professional Engineer in the State of Idaho. This individual can have an expired qualification or license, provided they are not suspended.

Materials that have been inspected by anyone other than project personnel must be reexamined for any damage or contamination that may have occurred subsequently, or for any defects that may not have been observed in the original inspection. Defects or contamination, unless satisfactorily remedied, may be cause for rejection in spite of prior approval.

The project inspector will sample and test as required all materials received on the project without prior inspection and approval. The Contractor is notified if the material was rejected. If the required tests cannot be performed at the project site, send appropriate samples to the District or the Central Laboratory for testing. Upon notification of the test results, the material will be accepted or rejected and the Contractor promptly
notified. The project inspector must know the appropriate options for disposition of any rejected or failing material and fully document the action taken.

Fabricated items accepted by certification must be visually inspected. See Section 230.00 for additional discussion on products or items accepted by certification.

Along with examining and checking all materials brought onto the project site, inspectors must maintain a continuing visual inspection of the Contractor’s operations where the materials are handled and incorporated into the work. Any procedures that result in damage or change in any material to the extent that it will fall outside the specification limits will not be permitted to continue. The affected materials will be rejected or the defects satisfactorily remedied.

210.02 Inspector Safety. Sampling and testing procedures may involve hazardous materials, operations, and equipment. The inspector must be aware of safety hazards and comply with established safety procedures. Department safety policies reinforce the necessity of protective clothing and equipment when working around construction equipment and machinery. Occupational Safety and Health Administration (OSHA) regulations must be followed for non-Department personnel on the project site. The Contractors are responsible for providing a safe working environment and a safe means of obtaining random samples. The Department is responsible for stopping any unsafe operations until corrective action is taken.

When there is a safety concern for the sampler, the Department will allow the Contractor, due to familiarity with their equipment or operation, to obtain the sample as long as a WAQTC-qualified sampler observes the sampling.

The sampling and testing technicians must limit the weight of aggregate sample increments to no more than 40 pounds per sack or bucket.
SECTION 215.00 MATERIALS OR WORK FAILING SPECIFICATIONS. For material or work that does not meet specification requirements:

- Reject or remove when incorporated.
- Accept with a price adjustment when allowed to remain in place.
- Correct or remedy, by the Contractor, and re-test.

Failing material that has not been incorporated into the work and can be remedied by further processing may be accepted after correction.

If completed work is found to contain material that is not within specifications, a determination must be made of the extent of the nonconformance with specifications, the limits of use of non-conforming material, and if it is feasible to be remedied.

The action taken must be fully documented by the project inspector or tester in the project file by reports, records covering samples, tests, measurements, and/or corrective action taken, if any. The Resident Engineer is responsible that disposition of the failing material is fully explained, including justification for acceptance, removal, or price reduction. See Standard Specifications Section 105.03.

215.01 Check Tests. Check tests are performed after an acceptance test fails to verify the material does, or does not, meet specifications in the scenarios presented below. Document and report all test results. For the numbering of Check Tests see Section 220.03.01 Numbering Check Tests.

When a failing test result is followed by a passing check test, the check test result becomes the basis for acceptance.

When a failing test result is verified with a check test, additional testing may be performed to define the boundaries of the unacceptable material for corrective treatment.

In all cases, if the check test results indicate the failing test results were caused by a faulty sample or faulty test, record both test results, but add comments to the faulty test data with appropriate reference to the check test.

The field report includes the type of failure, the corrective action taken to get the material back within specifications, and the disposition of the failing material. Include a full explanation of where the failing material was disposed of. After corrective treatment, retesting is required to document acceptability.

Compaction for Excavation, Borrow, Granular Borrow, Backfill: Perform the check test after there has been additional compaction effort and/or remedial efforts, such as drying out or reprocessing the material. The check test will be taken within 10 ft. of the original test and at the same elevation.

Concrete Field Acceptance: Perform the check test immediately after the failing test. Continue checking each load until 2 consecutive tests are passing.
Gradation for Sand Membrane Protection Blanket: Perform check test immediately after failing test. If check test fails, reject material.

215.02 Price Adjustments for Non-compliant Materials or Products. Non-compliant (failing or out of specification) material will be rejected/removed, or remedied by the Contractor, before payment is made to the Contractor. However, if it is not feasible to remove or remedy the non-compliant material incorporated into the project, a price adjustment must be made to the Contractor. The Contractor will not be paid full contract price for non-compliant material.

There are certain materials, listed below, that are subject to price adjustments when laboratory tests indicate the materials have failed the required specifications. All other non-specification material is handled as allowed by the contract.

The magnitude of the price adjustment, expressed as a percentage, will be based on the extent of deviation from the specifications as indicated from test results. The price adjustments are shown in the ITD Laboratory Operations Manual.

The determined price adjustment percentage will be applied to the quantity of material that is represented by the non-compliant test results. The cost amount of the price adjustment will be calculated by the Resident Engineer’s office using the actual invoice cost of the product, excluding freight, from the Contractor. The following materials or products are subject to price adjustments:

- Portland Cement.
- Fly Ash.
- Waterborne Traffic Line Paint.
- Coating Systems (all formulas).
- Liquid Deicer.
- Performance Graded Asphalt Binder.
- Emulsified Asphalt.
- Geosynthetics.
SECTION 220.00 SAMPLING PROCEDURES  An ITD Sampler Tester Qualification Program (STQP)-qualified individual will take samples in accordance with the procedures required by the specifications. Samples are taken concurrently with the project operations or from actual material delivered to the project. A stratified random method will be used to obtain samples when required by the contract.

Standard methods of sampling are set forth in the specifications and in this QA Manual for nearly all materials. The District and the Central Laboratory are resources for guidance when a standard method of sampling is not available.

220.01 Sample Size. The required size of a sample for the various tests on a given material is stated in the standard method of sampling. These sample sizes are considered as minimums to avoid any deviation due to sample size alone.

When samples of materials are taken for testing by the Department, the samples are to be of the prescribed size and shipped in the specified type of container in accordance with Table 220.01.1. Consulting or independent laboratories may require slightly modified sample containers; however, the samples must be adequately protected and handled to maintain the sample’s condition before testing.

220.01.01 Improper Sampling. Any sample received that has not been properly sampled will not be tested. The laboratory will immediately notify the Resident Engineer and the sampler. Another sample must be obtained as soon as possible to replace the rejected sample. Lack of required samples is a project deficiency. The laboratory will document the improper sampling for the project files by creating a test report with a note to indicate the sample was improperly taken. The test report will be distributed as usual with one copy forwarded to the District IA Inspector. The District IA Inspector will complete a buff-colored IA evaluation form, obtain resolution, and distribute according to the usual procedures, including a copy submitted to the ITD Sampler Tester Qualification Committee (STQC) for action.

Quality control and verification samples must not be collected at the same location. They must be taken independently of each other.

220.02 Frequency of Sampling. The frequencies at which samples are taken will conform to the Minimum Testing Requirements (MTRs Section 270.00). The frequencies include fractions of quantity and are minimums. When the minimums are not met, this will constitute a deficiency on the project that could impact payment to the Contractor or funding to the Department. Department project personnel and the Contractor are responsible for meeting the daily minimum frequency and fraction thereof, thus ensuring adequate samples are taken for the total quantity of material used/paid.

220.02.01 Inspection and Observations Made While Sampling and Testing. Reliance must not be placed wholly on the sampling and testing results to determine the acceptability of the materials and construction work. The sampling and testing must be supplemented by sufficient visual inspection of the materials as a whole to ascertain whether the samples and tests are reasonably representative of the entire mass of material. In addition, there must be sufficient observation of the actual construction operations and processes to ascertain whether they can be expected to consistently produce uniform, satisfactory results.
220.03 Numbering. Field tests will be numbered consecutively starting with test number 1 for each contract item. When a variety of field tests are performed for the same contract item, multiple series of test numbers will be necessary. For example, gradation tests and compaction tests are required for aggregate base. Numbers 1 to 100 could be assigned to gradation tests and numbers 101 to 200 could be used for the compaction tests. Test numbering must be consecutive to verify tests were not skipped or not recorded.

220.03.01 Numbering Check Tests. Circle failing test numbers on the test result form, along with the failing test result. A check test will be performed and numbered as follows:

Compaction and Gradation: The sample numbering will continue sequentially with each test and check test. Add a remark on the check test report to indicate the test is a check test. Note the location where failing material is disposed.

Concrete: The sample numbering will continue sequentially with each test and check test. Add a remark on the check test report to indicate the test is a check test.

220.04 Transporting Flammable and Hazardous Material Samples. The following is reference information to help comply with the shipping regulations. Local conditions and/or regulations may vary and must be complied with when shipping flammable and/or hazardous materials.

220.04.01 U.S. POSTAL SERVICE: Flammable materials [flashpoint below 101°F] cannot be shipped by air mail but can be shipped by surface mail if properly labeled, packaged, and certified. Combustible materials [flashpoint between 101°F and 200°F] can be shipped by air mail when properly packaged, labeled, and certified.

220.04.02 BUS. All flammable and hazardous materials are prohibited – specifically mentions paints. Includes all flammable, combustible, corrosive, and/or caustic materials.

220.04.03 AIR FREIGHT. Flammable materials can be shipped by most air freight companies but must be properly packaged, labeled, and certified. Need to know exact chemicals involved, flashpoints, etc.

220.04.04 PARCEL SERVICES. Shipping of flammable materials is allowed under certain conditions depending on the exact chemical and amount. Packages must be labeled with a flammable sticker and a Hazardous Materials label filled out. The information for the Hazardous Materials label can be obtained by:

- Calling carrier and exactly identifying the chemical to be shipped

OR

- Referring to the carrier handbook, which gives hazard codes, packaging instructions, and certificates required for shipping

Nuclear density gauges have special shipping requirements. If help is needed in arranging for transportation of these devices, contact the Central Laboratory Radiation Safety Officer (RSO).
<table>
<thead>
<tr>
<th>MATERIAL</th>
<th>MINIMUM SAMPLE SIZE</th>
<th>SAMPLING METHOD</th>
<th>TYPE OF CONTAINER</th>
</tr>
</thead>
<tbody>
<tr>
<td>AGGREGATES:</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Preliminary Base and Surfacing</td>
<td>400 lb</td>
<td>All aggregates will be sampled according to FOP for AASHTO T 2 / FOP for AASHTO R 76.</td>
<td>Canvas Sacks or 5 gallon Plastic Buckets</td>
</tr>
<tr>
<td>F.A. for Concrete</td>
<td>30 lb</td>
<td></td>
<td></td>
</tr>
<tr>
<td>C.A. for Concrete</td>
<td>55 lb</td>
<td></td>
<td></td>
</tr>
<tr>
<td>P.C.C. Pavement Design (Pit Run)</td>
<td>1,500 lb</td>
<td></td>
<td></td>
</tr>
<tr>
<td>P.C.C. Pavement Design (Crushed)</td>
<td>500 lb Coarse 300 lb Fine</td>
<td>Minimum mass of field samples will be based on the maximum nominal size of the aggregates.</td>
<td></td>
</tr>
<tr>
<td>Base Course</td>
<td>80 lb</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Surface Course</td>
<td>80 lb</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Cover Coat Material</td>
<td>60 lb</td>
<td>Samples for quality testing should be at least 60 lb</td>
<td></td>
</tr>
<tr>
<td>Mineral Filler</td>
<td>25 lb</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Special Backfill</td>
<td>60 lb</td>
<td>Single aggregate sacks must not contain more than 40 lb</td>
<td></td>
</tr>
<tr>
<td>Borrow &amp; Granular Borrow</td>
<td>60 lb</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Blotter</td>
<td>30 lb</td>
<td></td>
<td></td>
</tr>
<tr>
<td>SUPERPAVE HMA JOB MIX FORMULA (Submitted by Contractor for Confirmation)</td>
<td>See 405.03</td>
<td>FOP for AASHTO R 66</td>
<td>¹Screw Top Can</td>
</tr>
<tr>
<td>SUPERPAVE HMA</td>
<td>See 405.03</td>
<td>FOP for AASHTO T 168</td>
<td>Cardboard Box of approximate equal dimensions</td>
</tr>
<tr>
<td>ASPHALTS:</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>PG Binder</td>
<td>Three 1 qt containers</td>
<td>FOP for AASHTO R 66</td>
<td>¹Screw Top Can</td>
</tr>
<tr>
<td>Emulsified Asphalts</td>
<td>1 qt</td>
<td>FOP for AASHTO R 66</td>
<td>¹Screw Top Plastic Jar</td>
</tr>
<tr>
<td>Anti-Strip Additive</td>
<td>4 oz</td>
<td></td>
<td>Glass or Plastic Bottle</td>
</tr>
<tr>
<td>CONCRETE:</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Cement/Fly Ash/Silica Fume</td>
<td>1 gal</td>
<td>Idaho IR 143</td>
<td>¹Cylinder Can</td>
</tr>
<tr>
<td>Cylinders</td>
<td>Set of 3</td>
<td>FOP for AASHTO T 23</td>
<td>¹Cylinder Cans</td>
</tr>
<tr>
<td>Curing Compound</td>
<td>1 qt</td>
<td>Idaho IR 7</td>
<td>Metal Screw Top Can</td>
</tr>
<tr>
<td>Water</td>
<td>1 gal</td>
<td></td>
<td>Plastic Bottle</td>
</tr>
<tr>
<td>Concrete for Chlorides</td>
<td>15 grams pulverized</td>
<td>Idaho IR 128</td>
<td>New 20-Gram Plastic Vial</td>
</tr>
<tr>
<td>Quality Assurance</td>
<td>Sampling Procedures</td>
<td>220.00</td>
<td></td>
</tr>
<tr>
<td>-------------------------------------------------------</td>
<td>-------------------------------------------</td>
<td>--------</td>
<td></td>
</tr>
<tr>
<td>GLASS BEADS</td>
<td>1 - 50 lb Sack</td>
<td>Sack</td>
<td></td>
</tr>
<tr>
<td>JOINT MATERIAL</td>
<td>24 in. x full width</td>
<td></td>
<td></td>
</tr>
<tr>
<td>LIME</td>
<td>1 gal</td>
<td>AASHTO T 218</td>
<td></td>
</tr>
<tr>
<td>METALS:</td>
<td></td>
<td>Plastic bucket</td>
<td></td>
</tr>
<tr>
<td>Reinf. Steel, All Grades, All Sizes</td>
<td>Two - 36 in.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Dowel Bars for Transverse Joints in Concrete Pavement</td>
<td>Two – Special cut by the supplier-</td>
<td>Field sample from shipments delivered to project.</td>
<td></td>
</tr>
<tr>
<td>Tie Bars for Longitudinal Joints in Concrete Pavement</td>
<td>Approximately 36 in.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Prestressing Reinforcement</td>
<td>Two - At least 30 in.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Welded Wire Fabric</td>
<td>60 in. Length each heat number</td>
<td></td>
<td></td>
</tr>
<tr>
<td>PAINT</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Waterborne</td>
<td>1 qt</td>
<td>Idaho IR 7</td>
<td></td>
</tr>
<tr>
<td>Solvent</td>
<td>1 qt</td>
<td>Idaho IR 7</td>
<td></td>
</tr>
<tr>
<td>PIPE:</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Galvanized Coating (Steel Sheet)</td>
<td>2 in. Square</td>
<td>AASHTO M 36</td>
<td></td>
</tr>
<tr>
<td>SALT</td>
<td>10 lb</td>
<td>ASTM D632</td>
<td></td>
</tr>
<tr>
<td>SEALANTS (SILICONE)</td>
<td></td>
<td>1 Plastic Wide Mouth or Cylinder Can</td>
<td></td>
</tr>
<tr>
<td>SOIL &amp; SOIL AGGREGATE MIX</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>pH &amp; Resistivity (T 288, T 289)</td>
<td>5 lb</td>
<td>AASHTO R 13</td>
<td></td>
</tr>
<tr>
<td>Soil Classification (M 145)</td>
<td>5 lb</td>
<td>AASHTO R 13</td>
<td></td>
</tr>
<tr>
<td>pH &amp; Resistivity &amp; Soil Classification (T 288, T 289, M 145*)</td>
<td>5 lb</td>
<td>AASHTO R 13</td>
<td></td>
</tr>
<tr>
<td></td>
<td>50 lb</td>
<td>AASHTO R 13</td>
<td></td>
</tr>
</tbody>
</table>

*Plastic Wide Mouth or Cylinder Can

Sealed Non-Metallic Container

Sack/ Canvas Bag
<table>
<thead>
<tr>
<th>Geosynthetic Type</th>
<th>Minimum Quantity</th>
<th>Standard Inspection Procedure</th>
<th>Notes</th>
</tr>
</thead>
<tbody>
<tr>
<td>Geotextiles</td>
<td>At least 6 LF across the entire roll width</td>
<td>AASHTO M 145*</td>
<td>M 145 requires T 88, T 89, T 90 for Classification</td>
</tr>
<tr>
<td>Biaxial Geogrids</td>
<td>At least 6 LF across the entire roll width</td>
<td>AASHTO M 145*</td>
<td>See Section 230.09</td>
</tr>
<tr>
<td>Uniaxial Geogrids</td>
<td>At least 15 LF across the entire roll width</td>
<td>AASHTO M 145*</td>
<td>See Section 230.09</td>
</tr>
</tbody>
</table>

**FENCING:**

<table>
<thead>
<tr>
<th>Fencing Type</th>
<th>Minimum Quantity</th>
<th>Standard Inspection Procedure</th>
</tr>
</thead>
<tbody>
<tr>
<td>Barb Wire</td>
<td>6 LF</td>
<td>AASHTO M 280</td>
</tr>
<tr>
<td>Woven Wire</td>
<td>6 LF</td>
<td>ASTM A 116</td>
</tr>
<tr>
<td>Chain Link</td>
<td>3 LF</td>
<td>AASHTO M 181</td>
</tr>
<tr>
<td>Tension Wire</td>
<td>3 LF</td>
<td>AASHTO M 181</td>
</tr>
</tbody>
</table>

1. Standard ITD Supply Inventory item; do not re-use a sample container; all sample containers must be new.
2. If Idaho T 74 (vibrator compactor curve) is required; submit at least 100 lb of material for minus 3/4" material and 150 lb for minus 3" material.
SECTION 225.00 TESTING QUALIFICATIONS. Testing and sampling should be done strictly in accordance with the specified procedures. Standard testing procedures have been developed by organizations such as AASHTO, ASTM, AWS (American Welding Society), WAQTC, and ITD.

Section 590.00 is the ITD STQP and contains all the instructions for the required qualifications.

For areas not covered by STQP, qualification to the appropriate recognized standard is required. An example would be nondestructive testing related to welding inspection, which would be covered by qualification programs of the AWS and American Society for Nondestructive Testing (ASNT). The ITD District Materials Engineer, with the assistance of Construction/Materials and the Central Laboratory sections if necessary, will verify and document the qualification of those not covered by STQP qualification. The Independent Assurance Inspector will evaluate and document the competency of personnel qualified through STQP according to the IA Program. See Section 590.30
SECTION 230.00 ACCEPTANCE OF MATERIALS BY MANUFACTURER’S OR FABRICATOR’S CERTIFICATION. Standard Specification Subsection 106.04 allows the acceptance of certain materials based on certification provided by the manufacturer or fabricator. The certification must be complete and meet the criteria outlined in this section and any additional criteria if specified in the contract.

230.01 General Provisions. Standard ITD certification forms will be used. The standard forms are:

- ITD-914 Steel
- ITD-849 Geotextile and Geogrid
- ITD-851 Miscellaneous Items
- ITD-966 PG Asphalt Binder
- ITD-968 Cement / Fly Ash
- ITD-875 Non-Structural Concrete

The standard forms must be completed in their entirety and be signed by the manufacturer’s representative who has quality control responsibility for the manufacture or fabrication of the material.

When required by the contract, QC test results must be attached to the specified ITD standard form.

Certification does not preclude inspection, sampling, testing, or verification of certified test results of the material received on the project. Project inspectors will review all certification results for specification compliance before accepting the material. If the certified material is found to be outside acceptable specification limits, the material is subject to rejection.

Each shipment of certified material must be visually inspected for obvious defects and shipping/handling damage. Repair, reject, or replace damaged or defective material to the satisfaction of the Engineer. Where feasible, simple measurements of specified properties should be spot-checked at least once per project and recorded to verify certification. Examples would be length, mass per unit length, or thickness of steel items.

Withdraw acceptance of material by certification when sample test or inspection results show the material consistently fails to meet specifications requirements. Reestablishment of the certification acceptance may be achieved through Department pre-testing, pre-inspection, and review of historical certification records and test results of the material before its incorporation into a project. Additionally, the manufacturer’s QA program may require revision and reevaluation by the Department.

230.02 Certification Program Procedures for Portland Cement and Fly Ash. Cement or fly ash manufacturers approved under the ITD Qualified Products List (QPL) Program can supply cement and/or fly ash to Department projects by certification. The Central Laboratory determines which manufacturing plants have met the requirements for the certification program.

To be approved under the program, the Department will evaluate the following:

- A copy of manufacturer’s current quality control program.
- Historical certification records and copies of all test results.
- Certified Mill Analysis test reports for material delivered to Department projects.
- Acceptable verification tests on 10 samples submitted from Department projects.
- Other methods deemed necessary by the Department.

Once approved under the Department’s QPL Program, the manufacturer must continue to provide certified test results for all material produced.

If a project sample indicates out-of-specification material based on Department verification testing, additional testing may be conducted to define the extent of the problem. Price reduction or item removal will be required when specified tolerances are exceeded. In the event of continual non-conformance, the manufacturer will be removed from the certification program.

**230.02.01 Portland Cement.** The Department only accepts portland cement by certification from manufacturers approved by the Department’s QPL Program. Cement from manufacturers not approved under the QPL requires pre-approval before use.

The concrete supplier furnishing portland cement to any Department project from a manufacturer approved under the Department’s QPL Program must provide to the project inspector, at the end of each week in which concrete is placed, a completed ITD-968 Concrete Supplier’s Cement / Fly Ash Certificate form with the cement bill of lading attached with the mill analysis number.

Failure to submit the completed form with the appropriate signatures will result in material rejection.

The cement manufacturer must submit certified mill test reports to the Central Laboratory for all cement produced. The cement manufacturer's certified mill test reports must include:

- Name of the cement manufacture company.
- Location of the cement mill.
- Cement Type.
- Mill analysis number.
- Manufacturer’s bin or silo number from which cement was shipped.
- Mill analysis test report date and production period.
- Mill analysis test results pertinent to Idaho specifications.
- Certification statement indicating the cement meets all specification requirements pertinent to Idaho specifications.
- Signature, title, and date by the cement company chemist or other authorized official.

The test result data will be monitored for compliance with the specifications and for the manufacturer to remain under the certification program.

Cement samples must be taken for the project, in accordance with the Minimum Testing Requirements (Section 270.00) and Idaho IR-143, from the bulk tank during unload to the concrete plant silo. Samples must be immediately shipped to the Central Laboratory in Boise in moisture-proof containers. A 6" x 12" concrete cylinder container must be used for the sample, with the lid securely taped shut. The cylinder
container must be completely filled and immediately sealed to eliminate excess air in the sample and to avoid moisture absorption and aeration. **Sample cans received that are not completely filled (discounting normal settling) may be rejected.**

The Contractor or the supplier may take as many cement samples as they want for information only. Samples are tested for chemical and physical parameters to monitor production characteristics and to verify the certification.

**230.02.01.01 Cement Testing.** The Central Laboratory groups cement samples according to the manufacturer’s mill analysis numbers as the samples are received from projects. Samples with the same mill analysis number are referenced as a mill analysis unit.

The Central Laboratory performs a complete test on the first sample received in the mill analysis unit. The selected sample is tested for all specification parameters. If the first tested cement sample complies with the specifications, The Department will randomly choose one cement sample from the mill analysis unit and perform an alkali test for every 150 tons of cement received for Items 411 and 502 (500 tons for Item 409).

If a cement sample does not comply with the specifications, additional testing will be performed on samples from the mill analysis unit until the extent of the non-compliant material has been determined. The initial and additional test results for each specification item are averaged and the average value for each specification item will be considered the final value. These final values are used to determine compliance or noncompliance of the mill analysis unit.

When test results indicate the cement does not meet specifications, a price adjustment is applied to the entire quantity of material representing that mill analysis unit. The penalty is assessed according to Section 340.05.02 of the ITD Laboratory Operations Manual.

**230.02.01.02 Cement Testing Appeal Process.** The Central Laboratory retains sufficient cement material from each mill analysis unit for dispute resolution.

If the Contractor wishes to appeal the Department’s test results and price reductions, a written appeal request must be submitted within 14 calendar days of the reported test results. The appeal must state the grounds or the circumstances of the appeal. If the test results are in question, the appeal must be accompanied by all of the quality control test results that represent the mill analysis unit in question. The appeal must also be accompanied by Contractor-obtained test results for at least one complete cement test series conducted on the mill analysis in question. The state will not accept appeals when Contractor test results are out of specifications.

When an appeal is accepted, the appeal testing must include all specification parameters for the material in question.

If the appeal is not accepted, the Department will submit a denial letter to the Contractor stating the grounds for the denial.
Appeal testing will be conducted by an independent, AASHTO accredited laboratory, mutually acceptable to the Contractor and the Department. The AASHTO accredited laboratory will report the results to the Department. The results of such tests will be binding to both parties and any price reduction on the unit in question will be based on those test results. The Contractor will agree to bear the costs of the appeal testing if the tests verify noncompliance.

**230.02.02 Fly Ash.** The Department will accept fly ash by certification only from those manufacturers approved by the ITD QPL Program. Fly ash from manufacturers not approved under the certification program requires pre-approval before use.

The concrete supplier furnishing fly ash to any Department project from a manufacturer approved under the ITD QPL Program must provide to the project inspector, at the end of each week in which concrete is placed, a completed ITD-968, Concrete Supplier’s Cement/ Fly Ash Certificate form with the fly ash bill of lading attached with the Sample Identification Number.

Failure to submit the completed form with the appropriate signatures will result in material rejection.

The fly ash manufacturer must submit certified test reports to the Central Laboratory for all fly ash produced. The fly ash source’s certified laboratory test reports must include:

- Name of the fly ash source company.
- Plant Origin.
- Sample Identification number.
- Laboratory test report date and production period.
- Laboratory test results pertinent to Idaho specifications.
- Signature, title, and date by the testing laboratory chemist or other authorized official.

The test result data will be monitored for compliance with the specifications and for the fly ash source to remain under the certification program.

Fly ash samples must be taken, in accordance with the Minimum Testing Requirements (Section 270.00) and Idaho IR-143, from the bulk tank during unload to the concrete plant silo. Samples must be immediately shipped to the Central Laboratory in Boise in moisture-proof containers. A 6” x 12” concrete cylinder container will be used, with the lid securely taped shut. The cylinder container must be completely filled and immediately sealed to eliminate excess air in the sample and to avoid moisture absorption and aeration of the sample. **Sample containers received that are not completely filled (discounting minor settling) may be rejected.**

These samples are tested for chemical and physical parameters to monitor production characteristics and to verify the certification.

**The Contractor or the supplier may take as many fly ash samples as they want for information only.**

**230.02.02.01 Fly Ash Testing.** The Central Laboratory groups fly ash samples according to the manufacturer’s identification numbers as the samples are received from projects. Samples with the same identification number are referenced as a mill analysis unit.
The Department’s AASHTO accredited laboratory performs a complete test on the first sample received in the mill analysis unit. The selected sample is tested for all specification parameters.

If a fly ash sample does not comply with the specifications, additional testing will be performed on samples from the mill analysis unit until the extent of the non-compliant material has been determined. The initial and additional test results for each specification item are averaged and the average value for each specification item is considered the final value. These final values are used to determine compliance or noncompliance of the mill analysis unit.

When test results indicate the fly ash does not meet specifications, a price adjustment is applied to the entire quantity of material representing that mill analysis unit. The penalty is assessed according to Section 340.05.08 of the ITD Laboratory Operations Manual.

**230.02.02 Fly Ash Testing Appeal Process.** The Central Laboratory retains sufficient fly ash material from each mill analysis unit for dispute resolution.

If the Contractor wishes to appeal the Department’s test results and price reductions, a written appeal request must be submitted within 14 calendar days of the reported test results. The appeal must state the grounds or the circumstances of the appeal. If the test results are in question, the appeal must be accompanied by all of the quality control test results that represent the mill analysis unit in question. The appeal must also be accompanied by Contractor-obtained test results for at least one complete fly ash test series conducted on the mill analysis unit in question. The state will not accept appeals when Contractor test results are out of specifications.

When an appeal is accepted, the appeal testing must include all specification parameters for the material in question.

If the appeal is not accepted, the Department will submit a denial letter to the Contractor, stating the grounds for the denial.

Appeal testing will be conducted by an independent, AASHTO accredited laboratory, mutually acceptable to the Contractor and Department. The AASHTO accredited laboratory will report the results to the Department. The results of such tests will be binding to both parties and any price reduction on the unit in question will be based on those test results. The Contractor will agree to bear the costs of the appeal testing if the tests verify noncompliance.

**230.03 Steel.** The steel fabricator must complete the standard ITD-914, Steel Certification form for each shipment of a steel product to a project. Certified mill test reports from the steel mill for all heats in the shipment must be attached to the ITD-914 form, except as noted in the MTRs.

The certified mill test report must include the following:
- Name and location of the rolling mill.
- Consignee and/or destination of the shipment.
- Specification.
- Size.
• Heat number.
• Chemical analysis.
• Physical tests.
• Certificate number, order release number or shipment number, etc.
• Signature of authorized official.
• Buy America certification.

230.03.01 Steel Bridge Girders. The Construction/Materials Section will provide inspection during the fabrication of steel bridge girders. The district must contact the Construction/Materials Section as soon as the fabricator is known so the inspection can be scheduled. The inspection may be contracted to an independent company, hired by the Department, when the fabrication is out-of-state.

The Construction/Materials Section will obtain the required certifications, including form ITD-914, Steel Certification, during the fabrication of the steel girders.

The Construction/Materials Section will notify the Resident Engineer by departmental memorandum when the fabrication of the girders is satisfactorily complete and accepted for delivery to the project. Copies of the inspection and certification reports will be forwarded to the Resident Engineer for the project files.

Project personnel should contact the Construction/Materials Section before final erection of the steel girders to schedule an in-place inspection, including, paint, bolting, fabrication tolerances, and field welding.

230.03.02 Metal Reinforcement. The metal reinforcement (reinforcing steel or rebar and cable strand) supplier must submit the ITD-914 form and the certified mill test reports with each shipment of bars delivered to a project site (See Section 230.03).

Metal reinforcement is sampled in the field by Department personnel from shipments delivered to the project. A sample is defined as two 36-inch pieces cut from materials delivered to the project of the same size and heat number. A cable strand sample requires one 6-foot sample cut from every reel. Department inspectors must witness or perform the sampling at the project site.

See Standard Specification Section 503.

The two additional bars which replace the field samples, if from the same heat number, will not require sampling. It is not necessary to resample any bars from a heat number that has previously been tested for the project.

In the event the same heat number is used for a long bar and a shorter bar, the shorter bar will be used for the sample to minimize the cost for the replacement bar.

Some fabricated bent bars may not have a 36-inch length for sampling, however, the sample bars should be submitted and the Central Laboratory will determine if a test specimen can be obtained.
Sampling of bars comprised of spirals will be taken from the extra length of the spiral as required by the specifications. No cutting that would require splicing to obtain samples will be permitted.

In the event of a specialized, non-standard length or size bar, the Central Laboratory should be consulted for the correct sampling technique.

Samples must be promptly shipped or delivered to the Central Laboratory within two working days for testing. Next-day shipping is recommended when necessary. Tests are performed to detect non-specification steel for replacement before incorporation into the structure. Samples must be properly tagged and accompanied by ITD-914, ITD-1044, and the Mill Certifications.

When epoxy-coated steel is specified, the coater must mark the portion of ITD-914 referring to the epoxy-coating and provide a certification statement that the coating complies with ASTM A775. Copies of holiday tests and coating thickness tests representing the shipment will be included. An occasional check of coating thickness will be made on the sample bars during laboratory testing using a dry film paint thickness gauge.

Epoxy-coated steel must be visually inspected for coating damage upon delivery to the project, using criteria of ASTM A775. It is especially important to check the outside of bends for cracking, de-bonding, and rust.

230.03.03 Buy America. Buy America applies to any contract eligible for Federal Aid Highway funding within the scope of an applicable NEPA finding, determination, or decision regardless of the funding source of such contracts if at least one contract or phase of the project is funded with Federal-Aid highway funds. All permanently incorporated steel and iron materials must be certified that the steel and iron was manufactured in the United States of America including application of a coating. Certification must be provided before incorporation of the materials into the project. Materials that are only used or rented during the project construction, but not incorporated into the work (temporality installed), do not require certification.

The ITD-914 form will serve as Buy America Certification and be signed by a person having quality control responsibility for the company that manufactures or fabricates the material. The ITD-914 will be sent with mill tests reports attached, except as noted in the MTRs.

Small quantities of steel and iron may be accepted without Buy American Certification, so long as its total cost for the project does not exceed 0.1% of the contract amount or $2,500, whichever is greater. The total cost of steel and iron includes the cost of the material plus the cost of transportation to the project site, as evidenced by delivery receipt, but does not include labor cost involved in final assembly performed on the project site.

If Department project staff or consultant inspectors discover that foreign iron and/or steel products are incorporated into a federal-aid project that exceed the Buy America minimal use amount (the greater of $2,500 or 0.1% of the contract value), the FHWA Idaho Division must be contacted to resolve this after-the-fact discovery. All information on foreign iron and steel permanently incorporated into a project
that exceeds the minimal use amount must be presented to FHWA to determine the appropriate resolution. The Department will not complete a project’s Material’s Certification without FHWA’s resolution when the project is not compliant with Buy America. The Department has no authority to complete such a resolution and cannot resolve Buy America compliance issues by use of non-Federal funds.

**230.03.03.01 FHWA Q&A on Buy America.** Additional information is available at the following website:

[https://www.fhwa.dot.gov/construction/contracts/buyam_qa.cfm](https://www.fhwa.dot.gov/construction/contracts/buyam_qa.cfm)

Below is a commonly asked question concerning FHWA Buy America.

**Question #13.** Does Buy America apply to recycled steel?

**Answer to #13.** No. Although raw materials used in the steel manufacturing process may be imported, all manufacturing processes to produce steel products must occur domestically, including the addition of additives and the application of coatings. However, raw materials such as iron ore, limestone and waste products are not covered. The FHWA’s November 25, 1983 final rule defined waste products to include scrap as steel that is no longer useful in its present form (e.g. steel from old automobiles, machinery, pipe, railroad tracks, etc.).

**230.04 Concrete Pipe Products.** Concrete pipe or related products (catch basins, manhole sections, elbows, etc.) delivered to a Department project will be accompanied by form ITD-851, Miscellaneous Items, completed by the manufacturer certifying that all material furnished was manufactured in accordance with the specifications set forth in the contract. All quantities and sizes included under the certification for that project must be listed on the ITD-851 form.

The ITD-851 form for reinforced concrete pipe (RCP) must certify the concrete strength (psi) and wall thickness of the pipe delivered to the project meets the requirements of the contract.

Manufacturers furnishing concrete pipe and related products must hold current certification under the NPCA Plant Certification Program, the ACPA Q-Cast Plant Certification Program, or PCI Plant Certification.

**230.05 Concrete Guardrail and Other Pre-cast Concrete Products.** Concrete Guardrail and other pre-cast concrete products are required to meet Standard Specification Section 502. Standard Form ITD-851 must be completed by the manufacturer and list all materials used.

Manufacturers furnishing pre-cast concrete products must hold current certification under the NPCA Plant Certification Program, the ACPA Q-Cast Plant Certification Program, or PCI Plant Certification.

**230.05.01 Pre-cast, Pre-stressed Concrete.** All manufacturers furnishing pre-cast, pre-stressed concrete girders are required to hold current PCI plant certification.

The Contractor is required to give the Resident Engineer advance notice before starting pre-cast operations for the State. Advance notice will allow Department personnel time to review items 1, 2, & 3,
and perform appropriate testing of items 4, 5, & 6 listed below. Items 4, 5, & 6 will be obtained by Department inspectors or during their presence.

Provide the following items to the Resident Engineer:

1. Shop drawings on 22”x34”, approved by the Department.
2. Production schedule for the entire project: what is being produced on what day and a tentative timeframe for pre-placement inspections and placing of concrete.
3. All submittal information and approved mix design.
4. Aggregate samples with ITD-1044 to confirm gradation.
5. Cement/Fly Ash/Slag Cement sample with ITD-1044, Mill Analysis, and Bill of Lading.

The Department requires 5 working days to review and test items mentioned above to ensure compliance with the specification.

The Department will conduct random inspections at precast facilities to verify release strengths before removal of forms, stressing release and the stressing of the cable strand during pre-placement operations.

Precast manufacturers are NOT to do any type of work on a Department item until a Department Inspector or equivalent has had the opportunity to inspect the product after it has been removed from the form. Once removed from the form, the product is to be set in the precast facilities storage area and await Department approval. The piece must be marked accordingly or communication must be made with precast facilities management.

The Contractor is required to give 48-hour notice to the Resident Engineer before shipping items to project site. This allows the Department time to check products in the precast yard for final inspection and sign-off. Products will have the precast facilities Quality Control Manager’s initials or signature on them before final plant inspection of the product. The Precast facility must furnish a tag or identification sticker to initial and apply to the product, signifying the Department has done a final inspection and the product is ready to be loaded and shipped.

The Department will provide on-site inspection of the manufacturing process of each member, including acceptance, field sampling, and testing as required per Section 270.00 Minimum Testing Requirements. The Department inspector will provide written acceptance of each girder to the Resident Engineer by interdepartmental memo. The Resident Engineer is required to perform on-site inspection for acceptance of the girder upon delivery to the project and throughout the installation of the member. No member will be accepted that contains failing material.
The documentation of the samples and testing, as well as required manufacturer’s certification, will be collected by the Department on-site inspector at the manufacturing plant and the originals provided to the Resident Engineer with the acceptance memo.

**230.06 Concrete with Specified Strength 3000 psi or Less (Including Seal Concrete)**. When 3000 psi or less concrete is specified, the concrete may be accepted by certification if produced using a qualified aggregate source. Section 265.02 explains the requirements for qualification of aggregate sources. The concrete mix design must be submitted for review.

The concrete producer must furnish a signed, completed ITD-875 form with the class and concrete mix design designation listed. Department project personnel will provide project placement locations on the form.

The specifications require the producer or Contractor to perform quality control field tests and compressive strength tests for concrete placed on the project. The test results must be attached to the ITD-875 certification.

Follow the requirements of Section 230.03 when concrete products require metal reinforcement.

**230.07 Corrugated Metal Pipe and Corrugated Plate Pipe**. The supplier will furnish a completed ITD-914 Steel Certification form, covering the quantity of steel shipped to the project. The ITD form will be accompanied by mill test reports from the pipe manufacturer for all heats of steel involved. A certification will be attached to the ITD-914 and be accompanied with Quality Control test results from the galvanizer indicating the galvanized coating complies with the applicable specification. The appropriate AASHTO or ASTM specifications must be referenced on the form.

For aluminum corrugated metal pipe, the supplier must furnish a completed ITD-851 form from the pipe manufacturer, citing appropriate AASHTO or ASTM specifications in accordance with the contract.

Visual inspection is required at the project site to check for obvious defects, including damage in handling and shipping. Coated or bare galvanized pipe must always be checked for damage or visible gaps in the protective layers.

Bituminous coating must be verified by field inspection.

**230.08 Plastic Pipe**. The supplier will furnish a completed certification ITD-851 form from the pipe manufacturer, citing appropriate AASHTO or ASTM specifications in accordance with the contract. Final acceptance is subject to visual inspection for damage in shipping or handling or other obvious defects.

**230.09 Geosynthetics**. The Contractor must furnish the manufacturer’s certified test results and the completed ITD-849 form covering the quantity furnished to the project.

- The documentation and sampling for the Department will be in accordance with Standard Specifications Subsection 718.02 and 718.03 for geotextiles; the contract special provisions for Geogrid (See also Section 270.60, MTR Section 640).
• Silt Fence; see Section 270.10, MTR Section 212-1.

• Pavement Fabrics; see Section 270.30 MTR, Section 405.8, and Standard Specifications 718.02 and 718.08

• For handling and disputes; see Standard Specifications Section 106.06 and 106.07 respectively

230.09.01 Shipping Procedures. Follow the procedures below to ship the samples. Placing multiple samples in a capped tube is acceptable and preferred as follows.

230.09.01.01 Geotextile:
1. Fold the sample to match the uncut selvedge edges.*
2. After rolling the first sample, place the documents under the outside layer.
3. Use a paint pen (silver is preferable) to identify the sample with key #, pay item #, and sample #.
4. Roll the next samples on over the previous ones.
5. Shipping is available on the contracted freight trucks between the District Supply Offices and HQ. Tubes are returned to the district of origin.

230.09.01.02 Geogrid:
1. Fold the sample to match the uncut selvedge edges.*
2. Roll the sample from the fold and tie as necessary.
3. Place the required documents securely under the outside layer.
4. Ship as above.

*Selvedge - The longitudinal edges of a fabric are formed in such a way to prevent unraveling.

Acceptance of geosynthetics must be in accordance with ASTM D 4759 Standard Practice for Determining the Specification Conformance of Geosynthetics.

230.10 Performance Graded Asphalt Binder. The supplier must submit, on a yearly basis, a Quality Assurance plan to the Central Laboratory for Performance Graded Asphalt Binder, see Section 255.00.

230.10.01 Certification. ITD-966, PG Binder Supplier's Certification, accompanies the initial shipment of PG binder to the project. Qualified personnel must furnish this form with each lot change of PG binder shipped to the project. The Supplier will attach a completed ITD-966 form to the bill of lading that represents the first shipment of each new lot.

230.10.02 Sampling. The first load of asphalt binder delivered to the project must be sampled from the delivery truck. Thereafter, each shift that produces plant mix requires a binder sample comprised of three one-quart cans. The Department determines, at a random time, when to take the samples from the mix plant’s asphalt-binder tank injection line. Representatives of the Department and the Contractor, one of which must be WAQTC Asphalt qualified, must obtain or witness the sampling. Both parties must then sign the ITD-859 sample identification form. The Department must retain all three
quarts of the samples. Purge at least one gallon from the injection line valve before taking the sample and adhere to FOP for AASHTO R 66.

Send all three cans to the Central Laboratory. Two quarts are for the Department’s verification testing and one quart is for dispute resolution. The Contractor or the supplier may take as many samples as they want for information only.

Note: Standard Specifications, Section 405.03.C – Mixing Plants, states "provisions shall be made for measuring and sampling contents of the (PG binder) storage tanks." Personnel must be aware that the injection line is usually under pressure. The Contractor must provide a safe means to obtain the random samples.

When mix plant operations are just starting or after being suspended for more than 48 hours, the sampling sequence must not begin with a completely random sample; instead, take this binder sample near the beginning or at the resumption of operations.

Samples must be submitted to the Central Laboratory for testing no later than 30 days after the sample date.

230.10.03 Binder Verification Unit. The quantity of binder used in one week’s production of plant mix, except as modified in the remainder of this subsection, constitutes a binder verification unit. A binder verification unit is comprised of daily binder samples.

A binder unit must include only one PG grade. Thus, if the PG grade is changed within a production day, one daily binder sample will be taken for each PG grade used and grouped with other daily binder samples representing the corresponding binder verification unit.

Complete the ITD-859 PG Binder Sample Identification Form. The daily binder sample, comprised of three individual quart cans, must be labeled with the sample identification numbers (i.e., 2001-C for the first day, 2002-C for the second day, etc.). Include the daily binder sample identification number and sample date on each sample. The Department and the Contractor must sign the form for each daily binder sample and indicate on the ITD-859 form the date when a supplier’s binder lot changes. Idaho IT-99, Presence of Anti-Strip, must be completed in accordance with the required frequency as shown in Section 270.30, Minimum Testing Requirements. Record these results on the ITD-859 form.

The Contractor is responsible for inspecting or certifying their storage tank for contamination.

230.10.04 Testing. The Central laboratory will randomly choose one daily binder sample from each unit to represent the entire unit and either completely or partially test the selected daily binder sample. If the tested PG grade complies with the specified PG grade properties, the binder unit will be accepted. If the PG grade does not comply with the specified PG grade, additional testing will be performed on the verification unit until the extent of the non-compliant material has been determined.

If multiple tests are conducted on the same binder sample, the initial and additional test results for each specification item will be averaged and the average value for each specification item will be considered
the final value. These final values will be used to determine compliance or noncompliance. Non-compliant materials will be subject to the price reduction as specified in the ITD Laboratory Operations Manual.

230.10.05 Appeal Process. The Central Laboratory will retain one daily binder sample for dispute resolution.

If the Contractor wishes to appeal the Department’s test results and price reductions, a written appeal request must be submitted within 21 calendar days of the reported test results. The appeal must state the grounds or the circumstances of the appeal. If the test results are in question, the appeal must be accompanied by all of the quality control test results and worksheets that represent each verification unit in question. The Contractor must also supply complete PG binder test results on all daily binder samples in question. The state will not accept appeals when Contractor test results are below the minimum specifications.

When an appeal is accepted, the appeal testing must include all specification parameters for the material in question. If the appeal is not accepted, the Department will submit a denial letter to the Contractor, stating the grounds for the denial.

Appeal testing must be conducted by an independent, AASHTO accredited laboratory, mutually acceptable to the Contractor and the Department. The AASHTO accredited laboratory will report the results to the Department. The results of such tests will be binding to both parties and any price reduction on the unit in question will be based on those test results. The Contractor will agree to bear the costs of the appeal testing if the tests verify noncompliance.

Anti-strip additives must be on the QPL before use, see Section 240.02.

230.11 Emulsified Asphalt. The supplier must submit, on an annual basis, a Quality Assurance Plan to the Central Laboratory for emulsified asphalt, see Section 256.00.

A supplier’s bill of lading must be furnished to the inspector with each load of liquid asphalt or emulsion supplied to the project. The bill of lading must contain the following information in accordance with Standard Specification Section 702.05 and 702.08:
- Date of delivery, project number, key number, county, bill of lading number, and name of customer.
- Product identification, tonnage, truck/trailer number, specific gravity, Saybolt viscosity for emulsified asphalt, and signed certification statement.
- Supplier’s name, address, and phone number.

Department project inspectors only sample undiluted emulsified asphalt, as received from the Supplier, for verification testing in accordance with the individual bid schedule items in Section 270.00 Minimum Testing Requirements.

Department project inspectors perform field viscosity testing on sealcoat emulsions as required by the Minimum Testing Requirements in Section 270.00, Section 403 from the truck on the project site or at a
location as close to the project as practical. The Contractor must provide a safe means for obtaining the emulsion samples, including but not limited to fall protection, heat resistant clothing and gloves, etc.

230.12 Seeding. For Contractor Furnished Seed, the Contractor must provide official certification tags with tests results for each seed species and verify it meets the contract specifications. The Contractor must verify the company or person(s) providing the seed holds a valid Idaho Seed Dealer’s License issued for the current year and must meet all provisions of the Idaho Pure Seed Law. Before acceptance, a member of the Association of Official Seed Certifying Agencies (AOSCA) or state laboratory must provide seed certification tags and test results as well as validate that the seed has been tested within the current year. The official AOSCA tag or report must accompany each species and be submitted to the Engineer at least sixty (60) working days before seeding. The official tag or report must indicate seed classification, seed germination rate, seed germination purity, lot number, number of weed seeds, number of noxious weed seeds, and number of crop seeds. All restricted, prohibited, and noxious weed seeds found during testing must be displayed in an official AOSCA tag or report. All seed bags (Department or Contractor-supplied) must have the analysis (certification) tag attached and secured to each bag or container.

No additional seed tests are required for Department-supplied seed if the project meets all of the following parameters:

- Project has two acres or less to be seeded.
- Project is using seed from district stored seed inventory.
- Seed to be used has original certification tags attached to the bag(s).
- Seed tags indicate seed tests were conducted within one year from the date of seeding or seed was tested at ISDA for purity and germination rates within one year of the date the project will be seeded.
- Seed samples are taken and tested to verify seed germination rate and purity as well as absence of noxious weeds. Seed germination and purity can be drastically reduced between the time it is originally tested and when it is actually seeded. For this reason, the Department requests seed to be tested 6 weeks before seeding. If there is inconsistency with seed germination and/or purity information on the tags and the current test results, the Department can adjust the seeding rates in the field to obtain optimal seed germination and increase the success rate.

One random sample from unblended and individually packaged seed containers from each species and each lot must be obtained and placed in a one-gallon size heavy-duty zipped plastic bag (See note 1 below). The samples must be submitted to the Idaho State Seed Laboratory for analysis and verification. The sample must not be taken from the top layer of the container. Send the completed ITD-1044 form to the test lab with a copy of the seed certification tags and seed samples. Refer to the instructions for the ITD-1044 so all required information is included. Allow 30 days for testing and receiving official test results. The test results must show the seed meets the contract specifications before seeding. ISDA will email the test results to the Resident Engineer and copy the HQ Roadside Program Manager. After receiving the test
results, contact the Roadside Program Manager for acceptable purity and germination limits and acceptable seeding rates before seeding. The test lab will return all useable seed if the Resident Engineer’s address is shown on the ITD-1044.

Address: Idaho State Seed Lab
2240 Kellogg Lane
Boise, ID 83712

Note 1: Fill the one-gallon bag approximately half full for medium seed species including wheatgrasses, squirreltail, and wildrye (150 g). Fill the one-gallon bag approximately full for large seed including grain, Lupines, Biscuitroot, Bitterbrush and similar size seed, as well as Brome species and Woods Rose (550 g). Fill the one-gallon bag approximately one-quarter full for small seed species including fescues, saltgrass, alfalfa, clover, and blue flax (70 g). Fill the one-gallon bag approximately one-eighth full for very small seed species including bluegrasses, penstemon species, sagebrush, rabbitbrush, globemallow, and yarrow, (40 g). All other large seed types require a full one-gallon bag. For species not covered here, refer to ISDA website for specific species sample weights:

http://www.agri.state.id.us/Categories/Laboratories/Seed/sampleWeights.php

The State Seed Lab will bill the Resident Engineer for the testing. Contact the District Business Manager or District Records Inspector for charging the costs to the project.

230.13 Miscellaneous Items Accepted by Certification. Certification of miscellaneous materials is acceptable as defined in this section.

230.13.01 General Provisions. In addition to the materials discussed individually in Section 230.00, the following miscellaneous items may also be accepted on the basis of the manufacturer’s or fabricator’s (not the supplier unless the supplier is also the manufacturer) certification, using form ITD-851 signed by the manufacturer’s representative who has quality control responsibility. The material must be manufactured in accordance with specification requirements. Each certification must detail the quantity of material furnished to the project under that certification. Laboratory test reports must also be furnished where applicable (e.g., steel mill test reports, wood preservative treatment reports).

230.13.02 List of Miscellaneous Materials Accepted on the Basis of the Manufacturer’s or Fabricator’s Certification. Table 230.1 lists miscellaneous items that may be accepted by certification. The manufacturer’s or fabricator’s certification will not preclude the sampling and testing of the material or its final acceptance or rejection on the basis of the test results. Project samples are to be taken, as indicated in the Minimum Testing Requirements (Section 270.00), for verification testing. Samples may also be taken and tested at the option of the Materials Engineer or Resident Engineer.

Visual inspection for obvious defects and handling and shipping damage should always be done. Where feasible, simple measurements of specified properties must be spot-checked at least once per project and recorded to verify certification (e.g., measuring length, mass per unit length, thickness of steel items).
### Table 230.1 Miscellaneous Materials Accepted by Certification

<table>
<thead>
<tr>
<th>Material</th>
<th>Standard Specification</th>
<th>Section</th>
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</thead>
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<tr>
<td>Brick and Blocks, Masonry</td>
<td></td>
<td>504</td>
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<tr>
<td>Bridge Rail, Metal</td>
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<td></td>
</tr>
<tr>
<td>Concrete, Rapid Set</td>
<td>Special Contract Provision</td>
<td></td>
</tr>
<tr>
<td>Delineators and Mileposts</td>
<td></td>
<td>617</td>
</tr>
<tr>
<td>Dowel Bars and Tie Bars for Concrete Pavement</td>
<td></td>
<td>409, 503, 510, 609, 611</td>
</tr>
<tr>
<td>Dust Oil</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Electrical</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Epoxies</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Epoxy Patch</td>
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<td></td>
</tr>
<tr>
<td>Guard Rail and Posts</td>
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<td>612</td>
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<tr>
<td>H-Beam Piles</td>
<td></td>
<td>505</td>
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<tr>
<td>Illumination Poles and Bases</td>
<td></td>
<td>619</td>
</tr>
<tr>
<td>Joint Sealants and Sealers</td>
<td></td>
<td>409, 502, 625</td>
</tr>
<tr>
<td>Paint (only small quantities less than 25 gallons (100L))</td>
<td></td>
<td>504, 505, 627</td>
</tr>
<tr>
<td>Sewers (Storm and Sanitary)</td>
<td></td>
<td>605</td>
</tr>
<tr>
<td>Signs and Posts</td>
<td></td>
<td>616</td>
</tr>
<tr>
<td>Steel Shell Piling</td>
<td></td>
<td>505</td>
</tr>
<tr>
<td>Structural Bolts</td>
<td></td>
<td>504</td>
</tr>
<tr>
<td>Timber (Structural)</td>
<td></td>
<td>609, 612, 616</td>
</tr>
<tr>
<td>Traffic Signal Poles and Mast Arms</td>
<td></td>
<td>656</td>
</tr>
</tbody>
</table>
SECTION 240.00 PRE-TESTED AND PRE-QUALIFIED MATERIALS.

240.01 Pre-tested Materials. The following materials require pre-testing before acceptance on a project.

- Traffic Line Paint
- Glass Beads
- Curing Compound

The Department project personnel must verify the material/product is approved before use on a project. Those materials/products deemed acceptable will appear on the pre-approved list found on the ITD Central Laboratory Intranet page or on a list obtained from the Central Laboratory.

240.01.01 Bulk Material/Products Sampled at the Manufacturing Plant. A major portion of the pre-tested products are sampled at the manufacturer’s plant for bulk production. The Central Laboratory is responsible for obtaining the samples at the plants and testing such material.

240.01.02 Materials/Products Sampled at the Project. Department project personnel must obtain samples, or witness the sampling, at the project site when the lot/batch of traffic line paint, glass beads, or curing compound is not shown as pre-tested or pre-approved.

The samples will be obtained from the material delivered to the project and sent to the Central Laboratory for testing. Allow 30 days for the testing. The material must be accepted before use. The sample must be properly identified with sample date, sampler’s name, the product & manufacturer, and the lot or batch number.

240.02 Pre-Qualified Materials. The Department established a Qualified Products List (QPL) to formalize the process for the use of pre-qualified products on Department highway projects. The list of pre-qualified products is disseminated via the Department’s official website to department staff, materials suppliers, manufactures, consultants, and Contractors.

QPL products still need the appropriate tests and certifications required by the contract in order to be accepted on the project.

The QPL is administered by the Product Review Committee (PRC). Activities of the PRC are coordinated by the QPL Program Administrator. Details of the QPL program are described on the QPL webpage:

http://apps.itd.idaho.gov/apps/materials/QPL.aspx

Documentation (such as a printout of the QPL page showing approval of the item) must be placed in the project files and posted in the MSR for QPL items that were on ITD’s QPL at the time of the project.
SECTION 250.00 ACCEPTANCE OF MATERIAL ON THE BASIS OF THE RESIDENT ENGINEER’S LETTER OF INSPECTION (FORM ITD-854). The purpose of the ITD-854 form is for the Resident Engineer to document the inspection of certain materials and to document acceptable materials that meet the plans and specifications. In most cases, the Resident Engineer of the installation of these items is the most crucial element of the acceptance. The form should not be used as a catchall for items usually accepted by sampling and testing and inclusion on the form does not excuse the Resident Engineer from sampling and testing or obtaining manufacture certifications required by the Minimum Testing Requirements.

The ITD-854 form must provide accurate information of the total quantity of material accepted, the source of the material, and the date of the inspection/acceptance of the material. The project files must contain documentation to support the information on the form. The source should identify the manufacturer or fabricator, whenever possible, for future information regarding the material.

The Section 270.00 Minimum Testing Requirement (MTR) tables list materials accepted by the ITD-854 form. The specifications provide a complete description of the necessary inspection elements for acceptance of each item. The Resident Engineer must sign the ITD-854 form after inspecting the listed items for acceptance and verifying that the required material documentation is in the project item file.
SECTION 255.00 PERFORMANCE GRADED BINDER QUALITY ASSURANCE PLAN.

The Performance Graded (PG) binder supplier will conform to quality control testing and certification requirements in accordance with Subsection 702.08 of the Standard Specifications. The Supplier must have accreditation through the AASHTO Accreditation Program, (AAP) for PG Binder. The supplier must submit, on an annual basis, a Quality Assurance Plan to the Central Laboratory for PG Asphalt Binder that meets the requirements of AASHTO R 26 Certifying Suppliers of Performance Graded Asphalt Binders.
SECTION 256.00 ASPHALT EMULSIONS QUALITY ASSURANCE PLAN. The asphalt emulsion supplier will conform to quality control testing and certification requirements in accordance with Subsection 702.03 of the Standard Specifications. The Supplier must be accredited through the AASHTO Accreditation Program for Emulsion Testing by January 2018. The supplier will submit, on an annual basis, a Quality Assurance Plan to the Central Laboratory for emulsified asphalt.
SECTION 260.00 MIX DESIGNS. Mix designs are an essential part of both flexible and rigid pavements and structural concrete mixtures. This section provides additional information needed to prepare a Job Mix Formula (JMF) for asphaltic paving mixtures, portland cement concrete mix designs for concrete pavements, and portland cement concrete mix designs for structural concrete.

260.01 Superpave Hot Mix Asphalt (HMA) (Standard Specification Section 405). This section outlines the JMF confirmation process for Superpave HMA found in Subsection 405.03-A, Mix Design.

260.01.01 Mix Design Requirements and Review Procedure. The Contractor must submit a request for use of materials source(s) to the Resident Engineer, and if acceptable, its use will be approved in writing. The Superpave HMA mix design is the Contractor’s responsibility. The Contractor must submit the proposed mix design and all test reports, data, and worksheets used for each attempted trial design to the Resident Engineer. The Resident Engineer will submit the data to the Central Laboratory for mix design approval. The JMF must be approved before paving.

The Contractor’s mix design must develop the JMF for the project using an AASHTO Accredited laboratory that is qualified through the Department’s Laboratory Qualification Program. Mix designs must be prepared specifically for the project they are submitted for and each class of mix and grade of binder will have a separate mix design created, unless otherwise allowed. Refer to Standard Specification Section 405 Superpave HMA for the mix design specifications and a complete list of submittal requirements.

The Contractor’s mix design submittal must include all the information required in “A. Mix Design” of the Construction Requirements of Section 405.03.

The Central Laboratory will prepare a written recommendation and email copies to the Resident Engineer, District Materials Engineer, and District Engineering Manager.

The Contractor, or a designated representative, must perform a Superpave HMA mix design in accordance with the current version of AASHTO R 35, “Superpave Volumetric Design for Hot-Mix Asphalt.” The Asphalt Institute publication “Asphalt Mix Design Methods,” (MS-2), is available at www.asphaltinstitute.org. The proposed JMF shall specify a single aggregate gradation, optimum asphalt content, a theoretical maximum specific gravity, and a bulk specific gravity of a specimen compacted to N\text{design}.

The Superpave Mix Design Technician (SPMDT) must maintain current qualifications for all test procedures performed during the mix design as shown in Section 405.03 A. Mix Design and Table 260.01.1. The Laboratory used to develop the Superpave Mix Design must be accredited through the AASHTO Accreditation Program and all tests must be performed in the qualified laboratory by the SPMDT or they may be subcontracted to an AASHTO accredited Laboratory and be performed by a qualified sampler tester. The SPMDT shall take responsibility for all test results obtained in the development of the mix design.
Table 260.01.1 contains standards referred to in AASHTO R 35 and not listed in 405.02. Column 3 indicates if the standard is required for the mix design. Column 4 indicates if the SPMDT must maintain a qualification in the listed standard or if an alternate standard qualification is required.

<table>
<thead>
<tr>
<th>AAASHTO Method</th>
<th>Name</th>
<th>Required for Mix Design</th>
<th>Qualification Required for SPMDT</th>
</tr>
</thead>
<tbody>
<tr>
<td>M 320</td>
<td>Performance Graded Asphalt Binder</td>
<td>Yes</td>
<td>No</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>(Performed by Binder Supplier on virgin binder and by subcontractor for RAP)</td>
</tr>
<tr>
<td>PP 60</td>
<td>Preparation of Cylindrical Performance Test Specimens Using the Superpave Gyratory Compactor (SGC)</td>
<td>Not used</td>
<td>No</td>
</tr>
<tr>
<td>T 100</td>
<td>Specific Gravity of Soils</td>
<td>Not used</td>
<td>No</td>
</tr>
<tr>
<td>T 195</td>
<td>Determining Degree of Particle Coating of Asphalt Mixtures</td>
<td>Not used</td>
<td>No</td>
</tr>
<tr>
<td>T 228</td>
<td>Specific Gravity of Semi-Solid Asphalt Materials</td>
<td>Not used</td>
<td>No</td>
</tr>
<tr>
<td>T 275</td>
<td>Bulk Specific Gravity (Gmb) of Compacted Hot Mix Asphalt (HMA) Using Paraffin Coated Specimens</td>
<td>Not used</td>
<td>AASHTO T 331</td>
</tr>
<tr>
<td>T 283</td>
<td>Resistance of Compacted Asphalt Mixtures to Moisture-Induced Damage</td>
<td>Not Used</td>
<td>ASTM D1075 and AASHTO T 167</td>
</tr>
<tr>
<td>T 320</td>
<td>Determining the Permanent Shear Strain and Stiffness of Asphalt Mixtures Using the Superpave Shear Tester (SST)</td>
<td>Not used</td>
<td>No</td>
</tr>
<tr>
<td>T 322</td>
<td>Determining the Creep Compliance and Strength of Hot Mix Asphalt (HMA) Using the Indirect Tensile Test Device</td>
<td>Not Used</td>
<td>No</td>
</tr>
<tr>
<td>TP 79</td>
<td>Determining the Dynamic Modulus and Flow Number for Asphalt Mixtures Using the Asphalt Mixture Performance Tester (AMPT)</td>
<td>Not used</td>
<td>No</td>
</tr>
</tbody>
</table>

When subcontracting ASTM D1075 and AASHTO T 167, perform the testing in an AASHTO accredited laboratory with a qualified Sampler Tester. The SPMDT may fabricate the samples in accordance with Section 405.03 A. Mix Design, Material and Sample Submittals, item 3, and deliver them to the subcontractor. The subcontractor shall prepare the samples and test them. The subcontractor will randomly select one of the eight samples and test by AASHTO T 308 and T 30 and will report the results as part of the Immersion-Compression results.
260.01.02 Definitions. The following definitions are from sources common to the HMA industry. These items require further definition because the form of the equation published in the reference text may be different from the form used by the Department or additional explanation is warranted. Asphalt Institute MS-2, 7th Edition is used in addition to AASHTO and ASTM methods.

**Bulk Specific Gravity of Aggregate, \( G_{sb} \)** The ratio of the weight in air of a unit volume of a permeable material (including both permeable and impermeable voids normal to the material) at a stated temperature to the weight in air of equal density of an equal volume of gas-free distilled water at a stated temperature. (FOP for AASHTO T 85 and Asphalt Institute MS-2). Use Idaho IT-144 and FOP for T 85 to determine the bulk specific gravity of fine and coarse aggregates respectively.

When the total aggregate consists of separate fractions of coarse aggregate, fine aggregate, and mineral filler, all having different specific gravities, the bulk specific gravity of the total aggregate is calculated using:

\[
G_{sb} = \frac{P_1 + P_2 + \cdots + P_n}{\left( \frac{P_1}{G_1} \right) + \left( \frac{P_2}{G_2} \right) + \cdots + \left( \frac{P_n}{G_n} \right)}
\]

where, \( G_{sb} \) = average bulk specific gravity

\( P_1, P_2, P_n \) = individual percentages by mass of aggregate, coarse and fine

\( P_1 + P_2 + \cdots + P_n = 100 \)

\( G_1, G_2, G_n \) = individual bulk specific gravities of aggregate, coarse and fine.

(Asphalt Institute MS-2).

Because the amount of fine aggregate present in the coarse aggregate fraction and the amount of coarse aggregate present in the fine aggregate fraction is very small, this equation can be simplified and written as:

\[
G_{sb} = \left[ \frac{100}{\left( \frac{P_{(+4)}}{G_{(+4)}} \right) + \left( \frac{P_{(-4)}}{G_{(-4)}} \right)} \right]
\]

where, \( G_{sb} \) = average bulk specific gravity for the total aggregate

\( P_{(+4)}, P_{(-4)} \) = individual percentages by mass of aggregate, coarse, (+4) and fine, (-4)

\( G_{(+4)}, G_{(-4)} \) = individual bulk specific gravities of aggregate, coarse, (+4) and fine, (-4)
When more than one materials source is used to provide the coarse aggregate fraction and/or more than one materials source is used to provide the fine aggregate fraction for a mix design or mineral fillers are used, the original form of the Asphalt Institute equation will be used.

**Bulk Specific Gravity of Recycled Asphalt Pavement, (RAP), RAP G_{sb}** The bulk Dry Aggregate Specific Gravity of RAP aggregate, (RAP G_{sb}), is determined from Maximum Theoretical Specific Gravity, RAP G_{mm}, tests performed on the RAP material; the Effective Specific Gravity of Aggregate, G_{se}; and the asphalt absorption. Use Idaho IT-146 to determine the Bulk Dry Specific Gravity, (G_{sb}), of the RAP.

\[
RAP \ G_{se} = \left( \frac{100 - Adjusted \ P_b}{100 \ G_{mm}} - \frac{Adjusted \ P_b}{G_b} \right)
\]

where, 
- RAP G_{se} = effective specific gravity of aggregate
- P_{b} = asphalt content (from AASHTO T 308)
- G_{b} = specific gravity of asphalt (from mix design)
- RAP G_{mm} = maximum specific gravity of mix (no air voids)

\[
Adjusted \ P_b = \left( \frac{\text{Mass of RAP AC} + \text{Mass of Virgin AC added}}{\text{New RAP Mass}} \right)
\]

RAP G_{sb} = dry bulk specific gravity of the RAP

RAP G_{sb} = RAP G_{se} – asphalt absorption

Estimate or assume the asphalt binder absorption of the RAP, P_{ba}

Asphalt absorption of RAP is assumed to be two-thirds of the water absorption of virgin aggregates used in the project.

Determine the water absorption values by FOP for AASHTO T 85 and Idaho IT-144 and calculate the total water absorption for the virgin aggregate by proportionately combining the coarse and fine absorption by the percent of each aggregate.

\[
P_{ba} = \text{water absorption} \times 0.667
\]

Calculate the stone bulk gravity (G_{sb}) of the RAP:

\[
G_{sb(RAP)} = \frac{G_{se(RAP)}}{\left( \frac{P_{ba(RAP)} \times G_{se(RAP)}}{100 \times G_{b(RAP)}} \right) + 1}
\]
**Voids in the Mineral Aggregate, (VMA):** The volume of intergranular void space between the aggregate particles of a compacted paving mixture that includes the air voids and the effective asphalt content, expressed as a percent of the total volume of the sample (Asphalt Institute MS-2). VMA can be calculated either as percent by weight of total mix or as a percent by weight of aggregate.

VMA will be calculated using the following formula when the mix composition is determined as percent by weight of total mixture:

\[
VMA = 100 - \left( \frac{G_{mb}P_s}{G_{sb}} \right)
\]

where,  
VMA = voids in mineral aggregate, percent of bulk volume  
(calculate to 0.01; report to 0.1)  
\(G_{sb}\) = bulk specific gravity of total aggregate  
\(G_{mb}\) = bulk specific gravity of compacted mixture (FOP for AASHTO T 166 Method A)  
\(P_s\) = aggregate content, percent by total weight,  
(this can be written as \(P_s = 100-%AC\))

**Air Voids, \(P_a\):** the total volume of small pockets of air between the coated aggregate particles throughout a compacted paving mixture, expressed as a percent of the bulk volume of the compacted paving mixture. (Asphalt Institute Manual Series No. 2 (MS-2).

\[
P_a = 100 - \left( \frac{100 \times G_{mb}}{G_{mm}} \right)
\]

where,  
\(P_a\) = air voids in compacted mixture, percent of total volume  
(calculate to 0.01; report to 0.1)  
\(G_{mm}\) = maximum specific gravity of paving mixture (FOP for AASHTO T 209, Bowl Method)  
\(G_{mb}\) = bulk specific gravity of compacted mixture (FOP for AASHTO T 166, Method A)

**Note:** MS-2, 7th Edition now defines Air Voids as \(P_a\) rather than \(V_a\). Using “P” for percent is the most commonly used abbreviation. Not all publications have changed at this time and the use of \(P_a\) or \(V_a\) to define the percent air voids by total volume is acceptable.

**Voids Filled with Asphalt, (VFA):** the portion of the volume of intergranular void space between the aggregate particles (VMA) that is occupied by the effective asphalt. (Asphalt Institute MS-2).

\[
VFA = 100 \times \left( \frac{VMA - P_a}{VMA} \right)
\]
where,  
\[ \text{VFA} = \text{voids filled with asphalt, percent of VMA} \] 
(calculate to 0.1; report to 1)

\[ \text{VMA} = \text{voids in mineral aggregate, percent of bulk volume} \]

\[ \text{P}_a = \text{air voids in compacted mixture, percent of total volume} \]

**Dust-to-Binder Ratio (DP = P_{#200}/P_{be})** The ratio between the percent of aggregate passing the No. 200 (0.075-mm) sieve and the effective binder content (P_{be}). (Asphalt Institute MS-2).

\[ DP = \left( \frac{P_{#200}}{P_{be}} \right) \]

where,  
\[ \text{DP} = \text{Dust Proportion, (dust-to-binder ratio)} \] 
(calculate to 0.01; report to 0.1)

\[ P_{#200} = \text{aggregate passing the -#200 (0.075 mm) sieve, percent by mass of aggregate} \]

\[ P_{be} = \text{effective asphalt content, percent by total mass of mixture} \] 
(Calculate to 0.01; report to 0.1)

The following equations are used to calculate P_{be}:

**Effective Asphalt Content, P_{be}**

\[ P_{be} = P_b - \frac{P_{ba}}{100} (100 - P_b) \]

Where,  
\[ P_b = \text{asphalt content (from FOP for AASHTO T 308)} \]

\[ P_{ba} = \text{absorbed asphalt} \]

**Absorbed Asphalt, P_{ba}**

\[ P_{ba} = \left( \frac{G_{se} - G_{sb}}{G_{sb}G_{se}} \right) G_b \]

Where,  
\[ G_{se} = \text{effective specific gravity of aggregate} \]

\[ G_{sb} = \text{bulk specific gravity of aggregate} \]

\[ G_b = \text{specific gravity of asphalt (from mix design)} \]
Effective Specific Gravity of Aggregate, \( G_{se} \)

\[
G_{se} = \left( \frac{(100 - P_b)}{\left(\frac{100}{G_{mm}} - \frac{P_b}{G_b}\right)} \right)
\]

Where,

- \( G_{mm} \) = maximum specific gravity of mix (no air voids)
- \( P_b \) = asphalt content (from FOP for AASHTO T 308)
- \( G_b \) = specific gravity of asphalt (from mix design)

260.01.03 Tolerances. The tolerances from Table 405.03.1 of the Standard Specifications will be applied to the Engineer’s test results when confirming the JMF.
260.02 Concrete Pavement (Standard Specification Section 409). Mix designs will be reviewed or confirmed according to the contract requirements.

260.02.01 Portland Cement Concrete Pavement. Central Laboratory will confirm concrete mix designs for Portland Cement Concrete Pavement in accordance with the following procedures.

All sampling and testing performed shall be in accordance with the sampling and testing methods as specified in the ITD Standard Specifications.

260.02.01.01 Items Provided to Central Laboratory. The Central Laboratory must receive the following items before the concrete mix design confirmation process will be initiated. All samples submitted to Central Laboratory must be accompanied by a completed ITD-1044 form. These items must be submitted 60 days in advance of proposed use:

1. A complete mix design including specific gravity (SSD) and absorption for both fine and coarse aggregates per AASHTO T 84 and FOP for T 5, respectively. The mix design must identify the aggregate source that will be used and the aggregate correction factor per FOP for AASHTO T 152.
2. For concrete aggregate sources identified during source approval as reactive per AASHTO T 303 baseline testing, ASTM C1293, or ASTM C295, the mix design must include ASTM C1567 or CRD C 662 test results for mitigation of Alkali-silica reaction (ASR) expansion.
3. Gradation test results representing the material that will be used.
4. Final Set time per AASHTO T 197M / T 197.
5. For projects over 2,500 CY, samples of the proposed aggregate, cement and admixtures. A minimum of 350 pounds of coarse aggregate, 200 pounds of fine aggregate, and 100 pounds of cement must be supplied to the Central Materials Laboratory. No sample container may weigh more than 50 pounds. All materials provided must meet the contract specifications.
6. Mill analysis test reports from the manufacturer must be included for the cement, fly ash, and/or silica fume submitted.
7. Copies of all data, test reports, and worksheets associated with the mix design.
8. Each mix design must be assigned a unique mix identification number identical to that which will be recorded on all batch tickets for concrete batched according to the mix design.

260.02.01.02 Central Materials Laboratory Procedures. The Central Laboratory will complete the following before batching the proposed mix design:

1. Verify the Contractor’s compressive strength test results are based on the average of three 28-day cylinders and indicate a minimum compressive strength of 5,600 psi. If this requirement is not met, the mix design will not be confirmed.
2. For aggregate sources identified as reactive for ASR, verify the Contractor’s ASR mitigation expansion testing (ASTM C1567 or CRD C 662) meets the following requirements:
a. Expansion of mortar bars shall not exceed 0.10 percent at 14 days with the addition of fly ash, lithium, or other ASR mitigation additives.

b. The aggregate blend percentages used in the testing are reported and are within 2% of the blend percentages proposed in the mix design and to be used on the project. Coarse and fine aggregates may also be tested separately.

c. The materials used in the expansion testing are the same materials (aggregate sources, cement, fly ash, mitigation additive) and at the same proportions reported in the proposed mix design and to be used on the project.

d. When lithium is used, ensure the lithium dosage is reported as a volume and as a percent of the standard or full dose.

If these requirements are not met, the mix design will not be confirmed.

3. Verify the aggregate is from an approved aggregate materials source. If the source has not been approved, no further testing will be conducted until source approval has been obtained.

4. Check the mix design for conformance with the contract specifications (i.e., cement content, air, slump, etc.). The design volume must be checked to ensure it totals 27 cubic feet. Should the mix design not meet contract requirements, the mix design confirmation process will not proceed and the mix design will not be confirmed.

5. Test the fine aggregate for gradation and sand equivalent. Verify the specific gravity and absorption of the coarse and fine aggregate. Should the gradation or sand equivalent testing indicate the aggregate does not meet the contract specifications, the mix design confirmation process will be halted until acceptable materials are submitted.

6. Additional testing of the individual materials (cement, aggregates, fly ash, silica fume, admixtures, mineral fillers) may be conducted to verify conformance with contract specifications.

Central Laboratory will batch the concrete in accordance with ASTM C192/C 192M at the proportions indicated in the Contractor’s mix design submittal. Admixture dosages may be adjusted in accordance with the manufacturer’s recommendations to achieve desired mix parameters. Coarse aggregate must be separated into individual-sized fractions and recombined to produce the gradation indicated in the Contractor’s submittal. The weight of coarse and fine aggregate to be used in the batch will be determined per sections 6.3.2.2 and 6.3.2.3 of ASTM C192/C 192M, respectively.

The following mixing sequence will be used by the Central Laboratory unless otherwise agreed to in writing:

1. Add coarse aggregate, ¾ of the mix water and the air-entraining agent (if required) dispensed in solution with the mix water and mix.
2. Add fine aggregate, cement, and fly ash (if required) and mix.

3. Add ¼ of the mix water and the water reducing agent (if required) dispensed in solution with the mix water and mix.

If additional admixtures and/or silica fume are used in the mix, they will be added in the above sequence per the manufacturer’s written recommendations.

The above mixing sequence will not be altered unless the alternate sequence is pre-approved in writing by the admixture manufacturer(s) and the approved alternate mix sequence is provided with the mix design submittal. It is strongly recommended that all laboratories performing mix designs follow the mixing sequence as described above. This ensures results between labs will be as consistent as possible and enables the mix design confirmation process to be completed in as timely a manner as possible.

After mixing, the concrete must be tested for slump, air content, unit weight, and yield. Cylinders will be prepared for compressive strength testing.

For mixes using aggregates that are identified as ASR reactive, the Central Laboratory may conduct AASHTO T 303 (modified) testing using the proposed mitigation admixtures to confirm the Contractor’s testing.

260.02.01 Confirmation. The Contractor’s mix design will be confirmed for strength provided the Central Laboratory’s compressive strength test results, based on the average of three 28-day cylinders, indicate a minimum compressive strength of 5,300 psi.

When applicable, the Contractor’s mix design will be confirmed for ASR mitigation provided the Central Laboratory’s expansion test results indicate contract specifications are met (0.10% expansion or less at 14 days) or are within the established multi-laboratory precision of the Contractor’s passing expansion test results.

The mix design confirmation results will be reported to the District Resident Engineer via memo from the Central Laboratory.

260.03 Structural Concrete (Standard Specification Section 502). All sampling and testing methods performed shall be as specified in the ITD Standard Specifications. Concrete mix design requires concurrence by the Central Laboratory.

260.03.01 Approval Procedures. Complete the following:

1. Verify the complete mix design submittal for conformance with the contract specifications. Designs that do not meet ITD project requirements and specifications will not be approved.

2. The mix design must identify the approved aggregate source(s) and aggregate correction factor (FOP for AASHTO T 152).
3. Final Set time per AASHTO T 197M / T 197

4. For aggregate sources that are reactive according to AASHTO T 303 baseline testing, follow ASTM C1293 or ASTM C295 and review the ASTM C1567 or CRD C662 test reports.

5. For aggregate sources identified as reactive for ASR, concrete mix design approval requires the following be met for the ASTM C1567 or CRD C662 mitigation testing:

   a. Expansion of mortar bars shall not exceed 0.10 percent at 14 days with the addition of fly ash, mineral admixtures, or other ASR mitigation additives, except lithium. Expansion of mortar bars using lithium nitrate expansion shall not exceed 0.10 percent at 28 days.
   b. The aggregate blend percentages used in the testing are reported and are within 2% of the blend percentages proposed in the mix design. Aggregates may also be tested separately.
   c. The materials used in the expansion testing are the same materials (aggregate sources, cement, fly ash, mitigation additive) reported in the proposed mix design.
   d. When fly ash is used, ensure the calcium oxide content of the fly ash used on the project meets the 2% tolerance as established by the specifications.
   e. When lithium is used, ensure the lithium dosage is reported as a volume and as a percent of the standard or full dose.

6. Mill analysis test reports from the manufacturer must be included for the cement, fly ash, and/or silica fume, meet contract specifications, and be the same material to be used on the project. Check that any admixtures are approved. Central Laboratory in Boise keeps an updated qualified products list for concrete admixtures.

7. Verify that Basic Mix Strength and Design Mix Strength have been determined per Subsection 502.03 of the Specifications. Basic mix strength must equal or exceed the design mix strength calculated for the specified class of concrete. Classes 15 and 22 are exempt from this requirement.

8. Each mix design shall be assigned a unique mix identification number identical to that which will be recorded on all batch tickets for concrete batched according to the mix design.

9. Check the absolute volume of the mix design. Yield must be checked with air in the mid-range. Verify that the moisture content of the aggregate is included in the water content. In addition, efforts to mitigate ASR using lithium-nitrate admixture will increase the water content in the mix and must be adjusted for.
10. Calculate the volume using the maximum air content to ensure that the cement factor does not fall below specifications. (Do not base the mix design using maximum air for anything but checking cement content.)

11. Check the percentage of sand based on total weight of aggregate. Generally, this percentage is 30% to 42%. (When sand exceeds 42%, the slump will become more difficult to achieve and maintain because the surface area of the aggregate has increased and requires a larger volume of paste. If during mix design additional water is used to get the slump and workability, the w/c ratio goes up. The yield goes up, the cement content goes down, and strength goes down.)

12. The water-cement ratio must be designed at a realistic figure for the strength/class of concrete needed. At no time should the water-cement ratio be based on the maximum allowable specification. If the upper end of the water-cement ratio is to be targeted, stay at least 0.02 under the maximum specification, allowing for fluctuation in batch weights.

13. If Secondary Cementitious Materials (SCMs) are used, minimum and maximum content varies as calculated by total cementitious material (cement and SCMs) per specifications. The specific gravity of the SCM is required. The weight of SCM(s) is added to the weight of cement when calculating cement content and the water cement ratio.

Attached is an example of ITD-907 Concrete Mix Design Review for Structural or Pavement Design.
**Quality Assurance Mix Designs 260.00**

**CONCRETE MIX DESIGN REVIEW FOR STRUCTURAL OR PAVEMENT DESIGN**

**PROJECT NO.** TR-861-2 (035) 95  
**CONCRETE SUPPLIER** ACME  
**CONTRACT ITEM NO.** 407  
**CONCRETE MIX DESIGN NO.** 3

**COUNTY** Elmore  
**SOURCE NO.** EL-116  
**CONCRETE, CLASS** 45 (5600/28 day)  
**DATE** 7/14/97

<table>
<thead>
<tr>
<th>CLASS OF CONCRETE IN 100 PSI</th>
<th>MINIMUM CEMENT CONTENT LB./C.Y.</th>
<th>MINIMUM FLY ASH CONTENT LB./C.Y.</th>
<th>MAX. W/C + FLY ASH RATIO LB./LB.</th>
<th>% AIR CONTENT</th>
<th>A.E.A. OZ./C.Y.</th>
<th>SLUMP RANGE, INCHES</th>
<th>COARSE AGGREGATE SIZE</th>
</tr>
</thead>
<tbody>
<tr>
<td>56</td>
<td>467</td>
<td>116</td>
<td>0.47</td>
<td>4-7</td>
<td>1/2-3</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

% SAND = MC - M  
R = 34.5 %  
W/C = 0.40

**ABSOLUTE VOLUME METHOD for DESIGN of CONCRETE**

**YIELD** = 27 CU. FT./CU. YD. = 27,000 C.F. - Y  
28  
**WATER** = 27,000 C.F. - W  
3,743 C.F.  
**CEMENT** = 27,000 C.F. - C  
2,376 C.F.  
**FLY ASH** = 27,000 C.F. - F  
0.830 C.F. - FLY ASH  
198.56 SP.GR.  
2,290 X 62.4 Y  
**AIR** = 27,000 C.F. - A  
1,876 C.F. - A

**DETERMINATION OF THE YIELD**

**TOTAL BATCH WEIGHT (DESIGN)** = 3,743 LB.  
**WEIGHT PER CUBIC FOOT (DESIGN)** = 138.7 LB.  
**WEIGHT PER CUBIC FOOT (FRESH CONCRETE)** = 138.8 LB.  
**TOTAL BATCH WEIGHT** = 26,981 CU. FT. (VOLUME OF CONCRETE PRODUCED)

**VOLUME OF CONCRETE PRODUCED** = 0.999 RELATIVE YIELD

**BATCH WEIGHTS CORRECTED FOR BATCHING**

**CUBIC YARD BATCH**

**CEMENT** = 467 LB.  
467 LB.  
**FLY ASH** = 116 LB.  
116 LB.  
**WATER** = 275 LB.  
275 LB.  
**COARSE** = 198.56 LB. (DRY) (SSD)  
198.56 LB. (DRY) (SSD)  
**FINE** = 1020 LB. (DRY) (SSD)  
1020 LB. (DRY) (SSD)  
**BLEND SAND** = 1020 LB. (DRY) (SSD)  
1020 LB. (DRY) (SSD)

**BATCH WEIGHT**

**ABSORPTION**

**MOISTURE**

**DECREASE THE MIXING WATER BY THE SUM OF THESE TWO**

**INCREASE THE WEIGHT OF THE C.A. BY (X)**

**INCREASE THE WEIGHT OF THE F.A. BY (Z)**

**COMPUTED BY** D.T.  
**CHECKED BY** Mr.  
**DATE** 7/14/97
SECTION 265.00 QUALIFIED AGGREGATE MATERIAL SUPPLIERS. The District maintains current lists of qualified aggregate material suppliers. The lists are divided by the aggregate product category. To be included on a list means the aggregate supplier has provided the Department with adequate documentation to verify conformance with state specifications, including but not limited to Standard Specification Sections 106.09, 107.02, 107.17, 107.18, 703.12, and 703.13. Sampling and testing must be by an approved independent laboratory. The purpose of having the current lists is to provide Department personnel and Contractors with readily available information regarding aggregate suppliers that have met the requirements for aggregate quality and source clearance. The availability and quantity of the material in the source is not to be implied.

The lists do not imply acceptance of material should the quality change or the material not meet the contract requirements. The material must meet the contract requirements for acceptance.

The Resident Engineer has the authority to grant written approval for a Contractor to use an aggregate source from the qualified material suppliers list for a specific project, provided the District Materials Engineer or District Engineer concurs.

The aggregate supplier’s source must be identified by pit number and location. Combining stockpiles or aggregates from other sources that are not qualified will invalidate the qualification. The source may be included on the list for a period of not more than two years before the source must be re-evaluated by the District Materials Engineer. The re-evaluation will be based on the suppliers’ current operation and adequate documentation, including new test results when necessary, to determine specification compliance. An aggregate source may be removed from a list at any time should evidence of noncompliance exist.

ITD may test source aggregates to evaluate the submitted test results. The Contractor shall provide full access to the source, including raw and crushed materials, for ITD sampling and testing.

Refer to Subsection 106.09, Material Sources, in the Contract Administration Manual for administration of source approval.

265.01 Qualified Asphalt Mix Aggregate Suppliers. The District Materials Engineer will evaluate the source based on Standard Specifications Section 703 – Aggregates, and applicable asphalt mix specification requirements and notify the supplier if the source is qualified to be included on the list. In no case will inclusion on the list imply approval of a mix design, JMF, or specification material.

Mix designs or JMFs must be evaluated separately for each project based on Standard Specification Section 405.03.A Mix Design.

265.02 Qualified Concrete Aggregate Suppliers. The District Materials Engineer will evaluate the source based on Standard Specifications Section 703 – Aggregates, and applicable concrete specification requirements and notify the supplier if the source is qualified to be included on the list. Inclusion on the list does not imply approval of a concrete mix design or specification material.

265.03 Qualified Base Aggregate Suppliers. The District Materials Engineer will evaluate the source
based on Standard Specifications Section 703 – Aggregates, and applicable base aggregate specification requirements and notify the supplier if the source is qualified to be included on the list.

265.03 Other Specification Aggregate Items. Other aggregate items not included in the base, asphalt mix, or concrete categories that have quality requirements may be listed as qualified, provided the supplier submits adequate documentation to the district for evaluation to verify specification conformance.
SECTION 270.00 – MINIMUM TESTING REQUIREMENTS

270.01 Content of The MTR Tables.

270.02 Source Approval.

270.03 Obviously Defective Material.

270.04 Acceptance Of Small Quantities.

270.05 Non-standard Acceptance of Materials.

270.06 Special Provision Items.

270.07 Change Order Items.

270.08 MASH or NCHRP-350 Requirements

270.09 Minimum Testing Requirements Tables

270.10 MTR Tables 200 Earthwork.

205 - Excavation and Embankment.

209 - Small Ditches.

210 - Compacting Backfill.

212 - Erosion and Sediment Control.

270.20 MTR Tables 300 Bases.

301 - Granular Subbase.

302 - Emulsion Treated Base.

303 - Aggregate Base.

304 - Reconditioning.

307- Open-graded Rock Base (Rock Cap).

308 - Cement Recycled Asphalt Base Stabilization (CRABS).

270.30 MTR Tables 400 Surface Courses and Bituminous Pavement.

401 - Tack Coat.

402 - Prime Coat.

403 - Seal Coat.

404 - Surface Treatment.

405 - SuperPave Hot Mix Asphalt.

406 - Road Mix.
407 - Scrub Coat.
408 - Fog Coat.
412 - Plant Mix Seal.
415 - Microsurfacing

270.40 MTR Tables 409 Portland Cement Concrete Pavement.
409 - Portland Cement Concrete Pavement.
411 - Urban Concrete Pavement.

270.50 MTR Tables 500 Structures.
502 - Concrete.
503 - Metal Reinforcement.
504 - Structural Metals.
505 - Piling.
506 - Pre-Stressing Concrete.
507 - Bearing Pads and Plates.
508 - Corrugated Plate Pipe.
509 - Non-Structural Concrete
510 - Concrete Overlay.
511 - Concrete Waterproofing Systems.
512 - Gabion Structure.

270.60 MTR Tables 600 Incidental Construction.
602 - Culverts.
603 - Pipe Siphons.
604 - Irrigation Pipe Lines.
605 - Sewers.
606 - Pipe Underdrains.
607 - Embankment Protectors.
608 - Aprons for Pipe.
609 - Minor Structures.
610 - Fence.
611 - Cattle Guards.
612 - Metal Guardrail.

612 - Concrete Guardrail.

613 - Sidewalks.

614 - Urban Approaches.

615 - Curb and Gutter.

616 - Signs and Sign Supports.

617 - Delineators and Mileposts.

618 - Marker Posts, Witness Posts and Street Monuments.

619 - Illumination.

620 - Planting.

621 - Seeding.

622 - Pre-cast Concrete Headgates.

623 - Concrete Slope Paving.

624 - Riprap.

625 - Joints.

626 - Construction Traffic Control Devices.

627 - Painting.

628 - Snow Poles.

634 - Mailbox.

635 - Anti-skid Material.

640 - Geotextiles.

656 - Traffic Signal Installation.

Miscellaneous Building Items.

Miscellaneous Items.
SECTION 270.00 MINIMUM TESTING REQUIREMENTS. The following tables outline the minimum testing and acceptance (MTR) requirements for materials incorporated into Department construction projects and are a part of the ITD Quality Assurance (QA) Program. The tables apply to the sampling and testing of material characteristics not specified as accepted by statistical procedures. For material characteristics accepted by statistical procedures, the acceptance requirements are included in Table 106.03-1 of the Quality Assurance Special Provision. On projects containing the QA Special Provision (QASP), the minimum testing requirements outlined here apply for all material characteristics not included in Table 106.03-1 of the QASP.

The requirements outlined in this section are the minimum acceptance requirements for materials used in standard applications and paid for under standard bid items. For Special Provision items, material used in non-standard, non-roadway or temporary applications or small quantities of materials alternative acceptance requirements will be determined here or as specified in the contract documents.

Minimum testing frequencies are included in the tables. These frequencies may be reduced by change order with the concurrence of the District Materials Engineer and Construction/Materials Engineer for good quality materials with a history of uniform test results. The Engineer may elect to increase testing frequency at any time. Testing frequency should be increased when accepting material from newly developed sources or those with a wide range of results.

270.01 Content of the MTR Tables. The MTR tables are organized by Standard Specification Section. For each material listed, the testing and acceptance requirements are included. The tables also include Department specification references and test methods. The tables indicate who is responsible for sampling and testing for each material. The Required Report Form Number columns include forms related to materials acceptance that are the responsibility of the project personnel. Some reports generated as a result of Central Laboratory testing are included and indicated as a Lab Report.

The Minimum Required Frequency columns list the maximum quantity, and fractions of a quantity, of material that can be represented by a single test. For example, a frequency of “Each 500 CY” for gradation indicates that there must be one gradation test located within each 500 cubic yards of material accepted. Testing for each item and material must be distributed throughout the project to represent the total quantity of material accepted.

There are three types of testing listed in the Purpose of Testing columns: Acceptance, Verification, and Independent Assurance:

Acceptance of material is by one or a combination of the following as indicated in the MTR tables:

- acceptance testing performed by the Department.
- certification.
- certification with quality control or other test results provided by the supplier or manufacturer.
• pre-testing or prequalification by the Department.
• inspection by the Department.
• laboratory testing by the Department.

Pre-testing or prequalification, typically performed by the Central Laboratory and is used to verify manufacturer’s certifications.

Independent Assurance requirements are also included in the tables. The Independent Assurance Program is described in detail in Section 300.00.

The Remarks, Notes, or Additional Directions columns of the tables specify the location of acceptance, references to sections of the manual, small quantity exceptions, and other notes and remarks as applicable.

**270.02 Source Approval.** Materials source approval requirements and associated quality testing (e.g., Idaho Degradation, LA Abrasion, Ethylene Glycol testing) are not included in the tables. All fill and aggregate materials imported from off the project must be obtained from approved materials sources. Section 265.00 provides an overview of the materials source approval process.

**270.03 Obviously Defective Material.** Based on inspection and without regard for testing frequency, the Engineer may isolate and reject obviously defective material.

**270.04 Acceptance of Small Quantities.** The Department may accept small quantities of certain materials without sampling and testing. The Engineer may elect to sample and test small quantities at any time. The following materials are not eligible for small quantity acceptance:

• Materials that are accepted by manufacturer’s certification. Manufacturer’s certifications must be provided for all quantities of material accepted by certification.
• Concrete with a specified strength of greater than 3,000 psi.
• Paving on the Interstate, with quantities above 100 ton, excluding median crossovers

Material can be accepted as a small quantity if the estimated plan quantity is less than the minimum testing frequency. The following minimum requirements must be met and documented when using small quantity acceptance:

• Aggregates must be obtained from approved materials sources.
• A mix design must be submitted, reviewed, and approved before use for plant mix pavement and concrete items.
• Visual inspection of the materials during installation, placement, or compaction.
• For small quantities of traveled way paving, intersection paving, or paving at intersection radiiuses, cores are required as specified in the Standard Specifications 405.03.L for in-place density acceptance. Small quantity pavement applications that do not require cores for in-place density acceptance include small patches, utility repairs, and pavement placed outside the traveled way.

The basis for acceptance of the material must be documented. Documentation will be by file memo and will be included in the daily diary or will be on field or test reports. A brief statement summarizing the basis for acceptance must be included in the Materials Summary Report submitted at the end of the project. Examples of basis for small quantity acceptance are as follows:

• Satisfactory test results on the same material from a recent or concurrent project.

• Visual inspection of the materials and installation.

• Material certification (ITD-851) with supporting QC or manufacturer’s test results where applicable.

• The use of sufficient compaction effort and equipment, as determined by the Engineer.

Sampling and laboratory verification testing may be waived for the following items when the quantity of material is equal to or less than that indicated below:

Table 270.04-1: Items That May be Waived

<table>
<thead>
<tr>
<th>Item</th>
<th>Quantity</th>
</tr>
</thead>
<tbody>
<tr>
<td>Asphalt (Emulsified)</td>
<td>2000 gallons; (8 tons)</td>
</tr>
<tr>
<td>Asphalt (PG Binder)</td>
<td>22 Tons</td>
</tr>
<tr>
<td>Cement, Lime, Fly ash</td>
<td>40 cubic yards of concrete placed</td>
</tr>
<tr>
<td>Geotextiles</td>
<td>600 square yards</td>
</tr>
</tbody>
</table>

270.05 Non-standard Acceptance of Materials. Acceptance requirements will be determined on a case-by-case basis for the following, regardless of the quantity, and identified on the ITD-862 form:

• Material not permanently incorporated into the project (e.g., temporary detours).

• When sampling and testing per the standard requirements is not applicable due to the application or use of the material.

• When sampling and testing per the standard requirements is not applicable due to the sequence of placement.

Some examples of non-standard applications are:
• Driveways
• Field approaches
• Mailbox turnouts
• Asphalitic ditches and slopes
• Material behind guardrail and for guardrail terminals
• Asphalitic sidewalk and curb

The Engineer, in consultation with the District Materials Engineer, will develop a written acceptance plan that identifies the non-standard acceptance criteria before incorporating the material.

For numerous fractions of an item, such as short pipe extensions, where the required minimum frequency of testing is not practical, a written acceptance plan can be developed to replace some of the testing with visual inspection. The plan must be approved before incorporating the material.

The minimum requirements listed for small quantities (Section 270.04) must be met (i.e. approved sources, mix designs approval, inspection and cores for mainline and intersection paving). The documentation requirements for materials acceptance will be the same as those outlined for small quantity acceptance.

270.06 Special Provision Items. A Special Provision pay item may include multiple different materials, all of which require acceptance. When the materials acceptance requirements for a special provision item are not included in the contract, the acceptance requirements for each material incorporated will be determined based on the following criteria:

• When the material is included in the MTR tables and is being used in a standard application, the MTR table acceptance requirements will be used.

• When the material is not included in the MTR tables or is not being used in a standard application, acceptance requirements will be determined by the Engineer, in consultation with the District Materials Engineer.

• When the material is required by the contract to meet a given specification, such as an ASTM or AASHTO specification, at minimum, acceptance of material will require a manufacturer’s certification in accordance with Section 230.00.

A brief statement summarizing the basis for acceptance must be included in the Materials Summary Report submitted at the end of the project.
270.07 Change Order Items. A Change Order can include material to be paid for under standard pay items or can establish nonstandard pay items. For standard pay items, the MTR tables will apply. Acceptance requirements for nonstandard items will be determined based on the following criteria:

- When the material is included in the MTR tables and is being used in a standard application, the MTR table acceptance requirements will be used. This would include a change order that is paid by lump sum and includes materials covered in the MTR tables. When the material is not included in the MTR tables or is not being used in a standard application, acceptance requirements will be determined by the Engineer, in consultation with the District Materials Engineer.
- When the material is required by the change order or by reference to meet a given specification, such as an ASTM or AASHTO specification, at minimum, acceptance of material will require a manufacturer’s certification in accordance with Section 230.00.

A brief statement summarizing the basis for acceptance must be included in the Materials Summary Report submitted at the end of the project.

270.08 MASH or NCHRP-350 Requirements. Manual for Assessing Safety Hardware (MASH) or National Cooperative Highway Research Program (NCHRP) Report 350 recommended procedures for conducting vehicle crash tests and in-service evaluation of roadside safety features. The features covered by these procedures are grouped into the four categories defined below:

- **Longitudinal Barrier**: A device whose primary functions are to prevent vehicular penetration and to safely redirect an errant vehicle away from a roadside or median hazard. The longitudinal barriers include roadside barriers, median barriers, bridge rails, guardrails, transitions, and terminals.
- **Crash Cushion and Truck-Mounted Attenuators (TMA)**: A device designed primarily to safely stop a vehicle within a relatively short distance.
- **Support Structure**: A system used to support sign panels, chevron panels, luminaires, utility lines, mailboxes, or emergency call boxes. The system includes the post(s), pole(s), structural elements, foundation, breakaway mechanism if used, and accompanying hardware used to support the given feature.
- **Work Zone Traffic Control Device**: A device used in a work zone to regulate, warn, and guide road users and advise them to traverse a section of highway or street in the proper manner. Work zone traffic control devices include signs, plastic drums, lights, cones, barricades, chevron panels, any accompanying support systems, and any other such device(s) commonly exposed to traffic that may pose a hazard to occupants of a vehicle and/or to work zone personnel.
These items, if used or permanently added to the project, must have certifications (ITD 851) from the Manufacturer meeting MASH or NCHRP-350 requirements.

For Contracts with a letting date after the dates below, only safety hardware evaluated using the 2016 edition of MASH criteria will be allowed for new permanent installations and full replacements:

- December 31, 2017: w-beam barriers and cast-in-place concrete barriers
- June 30, 2018: w-beam terminals
- December 31, 2018: cable barriers, cable barrier terminals, and crash cushions
- December 31, 2019: bridge rails, transitions, all other longitudinal barriers, all other terminals, sign supports, and all other breakaway hardware

270.09 Minimum Testing Requirements Tables. The following tables contain the MTRs for each of the Standard Specification sections:

<table>
<thead>
<tr>
<th>MTR Table Section</th>
<th>Standard Specification Section</th>
</tr>
</thead>
<tbody>
<tr>
<td>270.10</td>
<td>200 Earthwork</td>
</tr>
<tr>
<td>270.20</td>
<td>300 Bases</td>
</tr>
<tr>
<td>270.30</td>
<td>400 Surface Courses and Bituminous Pavement</td>
</tr>
<tr>
<td>270.40</td>
<td>409 Portland Cement</td>
</tr>
<tr>
<td>270.50</td>
<td>500 Structures</td>
</tr>
<tr>
<td>270.60</td>
<td>600 Incidental Construction</td>
</tr>
</tbody>
</table>

See Section 270.01 for content of the tables.
<table>
<thead>
<tr>
<th>TYPE OF CONSTRUCTION</th>
<th>BID ITEM/ MATERIAL</th>
<th>PURPOSE OF TESTING</th>
<th>ITD SPEC. REF.</th>
<th>TEST METHOD</th>
<th>REQUIRED REPORT FORM NO.</th>
<th>MINIMUM REQUIRED FREQUENCY</th>
<th>REMARKS, NOTES, OR ADDITIONAL DIRECTIONS</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Excavation, Class C Compaction</strong></td>
<td><strong>Acceptance In-Place Density (1)</strong></td>
<td></td>
<td>205.03-E</td>
<td>FOP for AASHTO T 99, FOP for AASHTO T 180, FOP for AASHTO T 272, Idaho IT-74, FOP for AASHTO T 310 Method B</td>
<td>ITD-850</td>
<td>Each 5,000 SY.</td>
<td>Document compaction effort (equipment, number of passes etc.) for lifts not tested. After remedial efforts, obtain check tests within 10 feet and at same depth as original test. See QA Manual Section 215.00</td>
</tr>
<tr>
<td><strong>Excavation Subgrade Embankment Fill</strong></td>
<td><strong>Acceptance In-Place Density (1)</strong></td>
<td></td>
<td>205.03-E</td>
<td>FOP for AASHTO T 99, FOP for AASHTO T 180, FOP for AASHTO T 272, Idaho IT-74, FOP for AASHTO T 310 Method B</td>
<td>ITD-850</td>
<td>Each 2,500 CY or 4,000 tons but not less than 1 test per lift for each bottom 3 and each top 3 lifts and 1 test every 2,500 CY or 4,000 tons in between.</td>
<td>Document compaction effort (equipment, number of passes etc.) for lifts not tested. After remedial efforts, obtain check tests within 10 feet and at same depth as original test. See QA Manual Section 215.00</td>
</tr>
</tbody>
</table>

(1) Document that the material is too granular to test on the ITD-850 by completing gradation, compaction effort (including equipment and roller passes), and SE (for granular borrow and if more than 5% passing the #200 sieve) at the same frequency as the required density acceptance.

Note: Median areas and on slopes (approximate 2H:1V) that are outside the roadway prism where Class D compaction is required, fill out ITD-850 listing at least one coverage using Engineer approved track-type or rubber-tired earth moving equipment.
<table>
<thead>
<tr>
<th>BID ITEM/MATERIAL</th>
<th>PURPOSE OF TESTING</th>
<th>ITD SPEC. REF.</th>
<th>TEST METHOD</th>
<th>REQUIRED REPORT FORM NO.</th>
<th>MINIMUM REQUIRED FREQUENCY</th>
<th>REMARKS, NOTES, OR ADDITIONAL DIRECTIONS</th>
</tr>
</thead>
<tbody>
<tr>
<td>Borrow Subgrade Embankment Fill</td>
<td>ACCEPTANCE In-Place Density (1)</td>
<td>205.03 -E</td>
<td>FOP for AASHTO T 99 FOP for AASHTO T 180 FOP for AASHTO T 272 Idaho IT-74 FOP for AASHTO T 310 Method B</td>
<td>ITD-850</td>
<td>Each 2,500 CY or 4,000 tons but not less than 1 test per lift for each bottom 3 and each top 3 lifts and 1 test every 2,500 CY or 4,000 tons in between.</td>
<td>Document compaction effort (equipment, number of passes etc.) for lifts not tested. After remedial efforts, obtain check tests within 10 feet and at same depth as original test. See QA Manual Section 215.00</td>
</tr>
<tr>
<td>Granular Borrow Subgrade Embankment Fill</td>
<td>ACCEPTANCE In-Place Density (1)</td>
<td>205.03 -E</td>
<td>FOP for AASHTO T 99 FOP for AASHTO T 180 FOP for AASHTO T 272 Idaho IT-74 FOP for AASHTO T 310 Method B</td>
<td>ITD-850</td>
<td>Each 5,000 CY but not less than one test per lift for each bottom 3 and each top 3 lifts and 1 test every 5,000 CY in between.</td>
<td>Document compaction effort (equipment, number of passes etc.) for lifts not tested. After remedial efforts, obtain check tests within 10 feet and at same depth as original test. See QA Manual Section 215.00</td>
</tr>
<tr>
<td>Soft Spot Repair</td>
<td>ACCEPTANCE In-Place Density (1)</td>
<td>205.03 -D</td>
<td>FOP for AASHTO T 99 FOP for AASHTO T 180 FOP for AASHTO T 272 Idaho IT-74 FOP for AASHTO T 310 Method B</td>
<td>ITD-850</td>
<td>Each repair area or combination of areas but not less than each 300 SF</td>
<td>Sand equivalent requirements do not apply to Recycled Asphalt Pavement (RAP) used as granular borrow.</td>
</tr>
</tbody>
</table>

(1) Document that the material is too granular to test on the ITD-850 by completing gradation, compaction effort (including equipment and roller passes), and SE (for granular borrow and if more than 5% passing the #200 sieve) at the same frequency as the required density acceptance.

(2) Sand Equivalent is not required if the material has less than 5% passing the No. 200 sieve in accordance with AASHTO T 27/T 11. Document on Form ITD-901.

Note: Median areas and on slopes (approximate 2H:1V) that are outside the roadway prism where Class D compaction is required, fill out ITD-850 listing at least one coverage using Engineer approved track-type or rubber tired-earth moving equipment.
<table>
<thead>
<tr>
<th>BID ITEM/MATERIAL</th>
<th>PURPOSE OF TESTING</th>
<th>ITD SPEC. REF.</th>
<th>TEST METHOD</th>
<th>REQUIRED REPORT FORM NO.</th>
<th>MINIMUM REQUIRED FREQUENCY</th>
<th>REMARKS, NOTES, OR ADDITIONAL DIRECTIONS</th>
</tr>
</thead>
<tbody>
<tr>
<td>TYPE OF CONSTRUCTION</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Small Ditches</td>
<td>ACCEPTANCE</td>
<td>205.03 209.03</td>
<td>FOP for AASHTO T 99 FOP for AASHTO T 180 FOP for AASHTO T 272 Idaho IT-74 FOP for AASHTO T 310 Method B</td>
<td>ITD-850</td>
<td>1 per project</td>
<td>Testing required only when constructed upon dikes per Standard Specification Subsection 209.03.</td>
</tr>
<tr>
<td>When constructed upon dikes</td>
<td>In-Place Density (1)</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>ITD Project Personnel</td>
<td>ITD Project Personnel</td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>IA Inspector</td>
<td>IA Inspector</td>
<td>ITD-857</td>
<td>1 observation per project</td>
</tr>
</tbody>
</table>

(1) Document that the material is too granular to test on the ITD-850 by completing gradation, compaction effort (including equipment and roller passes), and SE (for granular borrow and if more than 5% passing the #200 sieve) at the same frequency as the required density acceptance.

Note: Median areas and on slopes (approximate 2H:1V) that are outside the roadway prism where Class D compaction is required, fill out ITD-850 listing at least one coverage using Engineer approved track-type or rubber-tired earth moving equipment.
<table>
<thead>
<tr>
<th>BID ITEM/ MATERIAL</th>
<th>PURPOSE OF TESTING</th>
<th>ITD SPEC. REF.</th>
<th>TEST METHOD</th>
<th>REQUIRED REPORT FORM NO.</th>
<th>MINIMUM REQUIRED FREQUENCY</th>
<th>REMARKS, NOTES, OR ADDITIONAL DIRECTIONS</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>TYPE OF CONSTRUCTION</strong></td>
<td><strong>ACCEPTANCE</strong></td>
<td><strong>IN-PLACE DENSITY (1)</strong></td>
<td>210.03</td>
<td>FOP for AASHTO T 99 FOP for AASHTO T 180 FOP for AASHTO T 272 Idaho IT-74 FOP for AASHTO T 310 Method B</td>
<td>ITD-850</td>
<td>Each 2,500 CY or 4,000 Tons for each structure component. Abutments for Bridge approach slabs not less than one test per 8-in compacted lift. After remedial efforts, obtain check tests within 10 feet and at same depth as original test. See QA Manual Section 215.00</td>
</tr>
<tr>
<td><strong>COMPACTING BACKFILL</strong></td>
<td><strong>INDEPENDENT ASSURANCE</strong></td>
<td><strong>IN-PLACE DENSITY</strong></td>
<td>IA Inspector</td>
<td>IA Inspector</td>
<td>ITD-857</td>
<td>1 observation per project</td>
</tr>
<tr>
<td><strong>Compacting Backfill</strong></td>
<td><strong>Compacting Backfill</strong></td>
<td><strong>(Pipe Backfill)</strong></td>
<td>210.03</td>
<td>FOP for AASHTO T 99 FOP for AASHTO T 180 FOP for AASHTO T 272 Idaho IT-74 FOP for AASHTO T 310 Method B</td>
<td>ITD-850</td>
<td>Each 200 LF of pipe installed, but no less than 1 test per pipe installed. A pipe is considered the total continuous length as shown on the project pipe summary sheet.</td>
</tr>
<tr>
<td><strong>INDEPENDENT ASSURANCE</strong></td>
<td><strong>IN-PLACE DENSITY</strong></td>
<td>IA Inspector</td>
<td>IA Inspector</td>
<td>ITD-857</td>
<td>1 observation per project</td>
<td></td>
</tr>
<tr>
<td><strong>Compacting Backfill</strong></td>
<td><strong>Compacting Backfill</strong></td>
<td><strong>(Retaining Wall Backfill)</strong></td>
<td>210.03</td>
<td>FOP for AASHTO T 99 FOP for AASHTO T 180 FOP for AASHTO T 272 Idaho IT-74 FOP for AASHTO T 310 Method B</td>
<td>ITD-850</td>
<td>Each 2,500 CY or 4,000 Tons Document compaction effort for each lift. After remedial efforts, obtain check tests within 10 feet and at same depth as original test. See QA Manual Section 215.00</td>
</tr>
<tr>
<td><strong>INDEPENDENT ASSURANCE</strong></td>
<td><strong>IN-PLACE DENSITY</strong></td>
<td>IA Inspector</td>
<td>IA Inspector</td>
<td>ITD-857</td>
<td>1 observation per project</td>
<td></td>
</tr>
</tbody>
</table>

(1) Document that the material is too granular to test on the ITD-850 by completing gradation, compaction effort (including equipment and roller passes), and SE (for granular borrow and if more than 5% passing the #200 sieve) at the same frequency as the required density acceptance.

Note: Median areas and on slopes (approximate 2H:1V) that are outside the roadway prism where Class D compaction is required, fill out ITD-850 listing at least one coverage using Engineer approved track-type or rubber-tired earth moving equipment.
<table>
<thead>
<tr>
<th>BID ITEM/ MATERIAL</th>
<th>PURPOSE OF TESTING</th>
<th>ITD SPEC. REF.</th>
<th>TEST METHOD</th>
<th>REQUIRED REPORT FORM NO.</th>
<th>MINIMUM REQUIRED FREQUENCY</th>
<th>REMARKS, NOTES, OR ADDITIONAL DIRECTIONS</th>
</tr>
</thead>
<tbody>
<tr>
<td>Slope Drain</td>
<td>ACCEPTANCE Certification</td>
<td>212.03-B 706</td>
<td>Manufacturer</td>
<td>Manufacturer</td>
<td>ITD-914 with mill test report attached for steel/iron ITD-851 (All other material)</td>
<td>Total Quantity Paid</td>
</tr>
<tr>
<td>Fiber Wattles</td>
<td>ACCEPTANCE Certification</td>
<td>711.20</td>
<td>Manufacturer</td>
<td>Manufacturer</td>
<td>ITD-851</td>
<td>Total Quantity Paid</td>
</tr>
<tr>
<td>Sediment Trap</td>
<td>ACCEPTANCE (Erosion Control Geotextile) Certification</td>
<td>212.03-B</td>
<td>Manufacturer</td>
<td>Manufacturer</td>
<td>ITD-849</td>
<td>Total Quantity Paid</td>
</tr>
<tr>
<td>Silt Fence</td>
<td>ACCEPTANCE Certification</td>
<td>212.03-B 718.09</td>
<td>Manufacturer</td>
<td>Manufacturer</td>
<td>ITD-849</td>
<td>Total Quantity Paid</td>
</tr>
<tr>
<td>Diversion Channels and Ditches</td>
<td>ACCEPTANCE Inspection</td>
<td>212.03-B</td>
<td>No sample required</td>
<td>No testing required</td>
<td>ITD-854</td>
<td>Total Quantity Paid</td>
</tr>
<tr>
<td></td>
<td>ACCEPTANCE Certification</td>
<td>212.03-B</td>
<td>Manufacturer</td>
<td>Manufacturer</td>
<td>ITD-849 (When Erosion Control Geotextile used)</td>
<td>Total Quantity Paid</td>
</tr>
<tr>
<td>Dikes and Berms</td>
<td>ACCEPTANCE Inspection</td>
<td>212.03 -B</td>
<td>No sample required</td>
<td>No testing required</td>
<td>ITD-854</td>
<td>Total Quantity Paid</td>
</tr>
<tr>
<td>Open-top Culvert</td>
<td>ACCEPTANCE Inspection</td>
<td>212.03-B</td>
<td>No sample required</td>
<td>No testing required</td>
<td>ITD-854</td>
<td>Total Quantity Paid</td>
</tr>
<tr>
<td>Water Bar</td>
<td>ACCEPTANCE Inspection</td>
<td>212.03-B</td>
<td>No sample Required</td>
<td>No testing Required</td>
<td>ITD-854</td>
<td>Total Quantity Paid</td>
</tr>
<tr>
<td>BID ITEM/ MATERIAL</td>
<td>PURPOSE OF TESTING</td>
<td>ITD SPEC. REF.</td>
<td>TEST METHOD</td>
<td>REQUIRED REPORT FORM NO.</td>
<td>MINIMUM REQUIRED FREQUENCY</td>
<td>REMARKS, NOTES, OR ADDITIONAL DIRECTIONS</td>
</tr>
<tr>
<td>---------------------</td>
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<td>---------------</td>
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<td>---------------------------</td>
<td>------------------------------------------</td>
</tr>
<tr>
<td>Siltation Berm</td>
<td>ACCEPTANCE Inspection</td>
<td>212.03-B</td>
<td>ITD-854</td>
<td>Total Quantity Paid</td>
<td>RE Letter-See QA Manual Section 250.00</td>
<td></td>
</tr>
<tr>
<td>Stabilized Construction Entrance</td>
<td>ACCEPTANCE Inspection</td>
<td>212.03-B</td>
<td>ITD-854</td>
<td>Total Quantity Paid</td>
<td>RE Letter-See QA Manual Section 250.00</td>
<td></td>
</tr>
<tr>
<td></td>
<td>(Erosion Control Geotextile) Certification</td>
<td>212.03-B</td>
<td>ITD-849</td>
<td>Total Quantity Paid</td>
<td>See QA Manual Section 230.09</td>
<td></td>
</tr>
<tr>
<td>Soil Binder</td>
<td>ACCEPTANCE Certification</td>
<td>212.03-B</td>
<td>ITD-851</td>
<td>Total Quantity Paid</td>
<td>Certification of non-toxic properties</td>
<td></td>
</tr>
<tr>
<td>Gabion</td>
<td>FOLLOW MTR TABLE STANDARD SPECIFICATION SECTION 512</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Revet Mattress</td>
<td>FOLLOW MTR TABLE STANDARD SPECIFICATION SECTION 512</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Stone Filter Berms/Dams</td>
<td>ACCEPTANCE Inspection</td>
<td>212.03-C Permanent Measures</td>
<td>ITD-854</td>
<td>Total Quantity Paid</td>
<td>RE Letter-See QA Manual Section 250.00</td>
<td></td>
</tr>
<tr>
<td>Sediment Basin</td>
<td>ACCEPTANCE Inspection</td>
<td>212.03-C Permanent Measures</td>
<td>ITD-854</td>
<td>Total Quantity Paid</td>
<td>RE Letter-See QA Manual Section 250.00</td>
<td></td>
</tr>
<tr>
<td>BID ITEM/ MATERIAL</td>
<td>PURPOSE OF TESTING</td>
<td>ITD SPEC. REF.</td>
<td>TEST METHOD</td>
<td>REQUIRED REPORT FORM NO.</td>
<td>MINIMUM REQUIRED FREQUENCY</td>
<td>REMARKS, NOTES, OR ADDITIONAL DIRECTIONS</td>
</tr>
<tr>
<td>-------------------</td>
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<td>-------------</td>
<td>-------------------------</td>
<td>---------------------------</td>
<td>--------------------------------------</td>
</tr>
</tbody>
</table>
| Aggregate         | ACCEPTANCE        | 301.02 703.11  | FOP for AASHTO T 2  
FOP for AASHTO R 76  
FOP for AASHTO T 27  
FOP for AASHTO T 255  
FOP for AASHTO T 265  
FOP for AASHTO T 176  
Alt. Method 2, Mechanical | ITD-901 | Each 5,000 Tons  
or 3,000 CY | Acceptance from windrow or roadway.  
Wash method not required.  
Moisture percent required for payment only |
|                   | INDEPENDENT ASSURANCE
Gradation Sand Equivalent | IA Inspector | IA Inspector | ITD-857 | Each 100,000 Tons |

(1) The test sample mass for sieve analysis will be determined using the nominal maximum size of the tested material according to FOP for AASHTO T27, except the maximum test sample mass, after reduction, will not be greater than 65 lb.

| Compacted Roadway | ACCEPTANCE In-Place Density | 301.02 | FOP for Idaho IT-74  
FOP for AASHTO T 180  
FOP for AASHTO T 310  
Method B | ITD-850 | Each 5,000 Tons | Contractor is responsible to provide FOP for Idaho IT 74 density curve. |
|                   | INDEPENDENT ASSURANCE
In-Place Density | IA Inspector | IA Inspector | ITD-857 | 1 observation per project |
<p>| Recycled Asphalt Pavement | ACCEPTANCE Gradation | 301.02 | Visual Inspection | ITD-854 | Each 5,000 Tons |
|                   | ACCEPTANCE In-Place Density | 301.03 | FOP for AASHTO T 355 modified | ITD-854 | Each 7,200 SY but not less than 1 test each lift |</p>
<table>
<thead>
<tr>
<th>BID ITEM/ MATERIAL</th>
<th>PURPOSE OF TESTING</th>
<th>ITD SPEC. REF.</th>
<th>TEST METHOD</th>
<th>REQUIRED REPORT FORM NO.</th>
<th>MINIMUM REQUIRED FREQUENCY</th>
<th>REMARKS, NOTES, OR ADDITIONAL DIRECTIONS</th>
</tr>
</thead>
<tbody>
<tr>
<td>Emulsified Asphalt</td>
<td>ACCEPTANCE</td>
<td>702.03</td>
<td>Loading Certificate</td>
<td>Each shipment to the project</td>
<td>See QA Manual Section 230.11</td>
<td></td>
</tr>
<tr>
<td>Saybolt Viscosity Field Test</td>
<td>Manufacturer</td>
<td>Idaho IT 61</td>
<td>ITD-1045</td>
<td>Test each load for Saybolt viscosity. Reject failing loads.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Verification</td>
<td>Laboratory Tests(1)</td>
<td>702.03</td>
<td>FOP for AASHTO R 66 AASHTO T 59</td>
<td>ITD-1045</td>
<td>1 undiluted sample per project</td>
<td></td>
</tr>
<tr>
<td>Aggregate (prior to mixing)</td>
<td>ACCEPTANCE</td>
<td>302.02</td>
<td>FOP for AASHTO T 2 FOP for AASHTO R 76 FOP for AASHTO T 27 FOP for AASHTO T 11 FOP for AASHTO T 255 FOP for AASHTO T 265 FOP for AASHTO T 176 Alt. Method 2, Mechanical FOP for AASHTO T 335 Method 1</td>
<td>ITD-901</td>
<td>Each 700 CY or 1,000 Tons</td>
<td>Acceptance at point of delivery prior to mixing. Moisture percent required for payment only</td>
</tr>
<tr>
<td>Gradation Sand Equivalent Fracture Count</td>
<td>INDEPENDENT ASSURANCE</td>
<td>IA Inspector</td>
<td>IA Inspector</td>
<td>ITD-857</td>
<td>Each 14,000 CY or 20,000 tons</td>
<td></td>
</tr>
<tr>
<td>Compacted Roadway</td>
<td>ACCEPTANCE</td>
<td>302.03</td>
<td>FOP for AASHTO T 310 Method B</td>
<td>ITD-850</td>
<td>Each 700 CY or 1,000 Tons</td>
<td></td>
</tr>
<tr>
<td>In-Place Density</td>
<td>INDEPENDENT ASSURANCE</td>
<td>IA Inspector</td>
<td>IA Inspector</td>
<td>ITD-857</td>
<td>1 observation per project</td>
<td></td>
</tr>
<tr>
<td>BID ITEM/ MATERIAL</td>
<td>PURPOSE OF TESTING</td>
<td>ITD SPEC. REF.</td>
<td>TEST METHOD</td>
<td>REQUIRED REPORT FORM NO.</td>
<td>MINIMUM REQUIRED FREQUENCY</td>
<td>REMARKS, NOTES, OR ADDITIONAL DIRECTIONS</td>
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<tr>
<td><strong>Aggregate</strong></td>
<td>ACCEPTANCE</td>
<td>303.02</td>
<td>FOP for AASHTO T 2  FOP for AASHTO R 76 FOP for AASHTO T 27 FOP for AASHTO T 11 FOP for AASHTO T 255 FOP for AASHTO T 265 FOP for AASHTO T 176 Alt.Method 2, Mechanical FOP for AASHTO T 335 Method 1</td>
<td>ITD-901</td>
<td>Each 700 CY or 1,000 Tons</td>
<td>Acceptance from windrow or roadway. Moisture percent required for payment only</td>
</tr>
<tr>
<td></td>
<td>Gradation Sand Equivalent Fracture Count</td>
<td>703.04</td>
<td></td>
<td></td>
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</tr>
<tr>
<td></td>
<td>ITD Project Personnel</td>
<td>ITD Project Personnel</td>
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</tr>
<tr>
<td><strong>Compacted Roadway</strong></td>
<td>ACCEPTANCE</td>
<td>303.02</td>
<td>FOP for AASHTO T 310 Method B</td>
<td>ITD-850</td>
<td>Each 700 CY or 1,000 Tons</td>
<td>Contractor is responsible for providing an FOP for Idaho T 74 density curve.</td>
</tr>
<tr>
<td></td>
<td>In-Place Density</td>
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<td></td>
<td>ITD Project Personnel</td>
<td>ITD Project Personnel</td>
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<tr>
<td><strong>INDEPENDENT ASSURANCE</strong></td>
<td>Gradation Sand Equivalent Fracture Count</td>
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<tr>
<td></td>
<td>IA Inspector</td>
<td>IA Inspector</td>
<td>ITD-857</td>
<td>Each 14,000 CY or 20,000 tons</td>
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<tr>
<td></td>
<td>IA Inspector</td>
<td>IA Inspector</td>
<td>ITD-857</td>
<td>1 observation per project</td>
<td></td>
<td></td>
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<tr>
<td><strong>Compacted Roadway</strong></td>
<td>ACCEPTANCE</td>
<td>303.02</td>
<td>FOP for AASHTO T 310 Method B</td>
<td>ITD-850</td>
<td>Each 700 CY or 1,000 Tons</td>
<td>Contractor is responsible for providing an FOP for Idaho T 74 density curve.</td>
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<td></td>
<td>In-Place Density</td>
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<tr>
<td></td>
<td>IA Inspector</td>
<td>IA Inspector</td>
<td>ITD-857</td>
<td>1 observation per project</td>
<td></td>
<td></td>
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<tr>
<td>BID ITEM/MATERIAL</td>
<td>PURPOSE OF TESTING</td>
<td>ITD SPEC. REF.</td>
<td>TEST METHOD</td>
<td>REQUIRED REPORT FORM NO.</td>
<td>MINIMUM REQUIRED FREQUENCY</td>
<td>REMARKS, NOTES, OR ADDITIONAL DIRECTIONS</td>
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<tr>
<td><strong>STANDARD SPECIFICATION SECTION: 304 – RECONDITIONING</strong></td>
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<tr>
<td>Pulverizing Roadbed</td>
<td>ACCEPTANCE</td>
<td>304.03</td>
<td>Visual Inspection</td>
<td>ITD-854</td>
<td>Prior to compaction each lane mile</td>
<td></td>
</tr>
<tr>
<td></td>
<td>Gradation</td>
<td></td>
<td></td>
<td>ITD Project Personnel</td>
<td>ITD Project Personnel</td>
<td></td>
</tr>
<tr>
<td></td>
<td>ACCEPTANCE</td>
<td>304.03</td>
<td>FOP for AASHTO T 310 Method A modified (CRABS)</td>
<td>ITD-1866 or ITD-854</td>
<td>Establish roller pattern every lane mile.</td>
<td>Acceptance at roadway.</td>
</tr>
<tr>
<td></td>
<td>In-Place Density</td>
<td></td>
<td></td>
<td>ITD Project Personnel</td>
<td>ITD Project Personnel</td>
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<tr>
<td>Soft Spot Repair</td>
<td>ACCEPTANCE</td>
<td>205.03 D 304.03</td>
<td>FOP for AASHTO T 310 Method B</td>
<td>ITD-850</td>
<td>Each repair area or combination of areas but not less than each 1,500 SF</td>
<td></td>
</tr>
<tr>
<td></td>
<td>In-Place Density</td>
<td></td>
<td></td>
<td>ITD Project Personnel</td>
<td>ITD Project Personnel</td>
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<tr>
<td><strong>STANDARD SPECIFICATION SECTION: 307 – OPEN-GRADED BASE</strong></td>
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</tr>
<tr>
<td>Aggregate</td>
<td>ACCEPTANCE</td>
<td>703.08</td>
<td>FOP for AASHTO T 2 FOP for AASHTO T 27</td>
<td>ITD-901</td>
<td>Each 1,800 CY or 2,500 Tons</td>
<td>Acceptance at Crusher Conveyor Belt Reducing &amp; wash method not required for Class I &amp; II Drying to constant mass is not required for Class I &amp; II</td>
</tr>
<tr>
<td></td>
<td>Gradation (1)</td>
<td></td>
<td></td>
<td>ITD Project Personnel</td>
<td>ITD Project Personnel</td>
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<tr>
<td></td>
<td>INDEPENDENT ASSURANCE</td>
<td>IA Inspector</td>
<td>IA Inspector</td>
<td>ITD-857</td>
<td>Each 14,000 CY or 20,000 Tons</td>
<td>Field Test samples will be used for IA evaluation. No split samples required.</td>
</tr>
<tr>
<td></td>
<td>Gradation</td>
<td></td>
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<tr>
<td></td>
<td>ACCEPTANCE</td>
<td>307.03</td>
<td>Method Specification</td>
<td>ITD-850</td>
<td></td>
<td>Each 3,000 LF but not less than once per day</td>
</tr>
<tr>
<td></td>
<td>In-place Density</td>
<td></td>
<td></td>
<td>ITD Project Personnel</td>
<td>ITD Project Personnel</td>
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</tr>
</tbody>
</table>

(1) The minimum test sample mass for FOP for AASHTO T27 Sieve Analysis will be 65 lb.
<table>
<thead>
<tr>
<th>BID ITEM/MATERIAL</th>
<th>PURPOSE OF TESTING</th>
<th>ITD SPEC. REF.</th>
<th>TEST METHOD</th>
<th>REQUIRED REPORT FORM NO.</th>
<th>MINIMUM REQUIRED FREQUENCY</th>
<th>REMARKS, NOTES, OR ADDITIONAL DIRECTIONS</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td></td>
<td>SAMPLED BY</td>
<td>TESTED BY</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Standard Specification Section: 308 - CEMENT RECYCLED ASPHALT BASE STABILIZATION (CRABS)</td>
<td></td>
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</tr>
<tr>
<td>Cement</td>
<td>ACCEPTANCE Certification</td>
<td>701.01</td>
<td>AASHTO M 85</td>
<td>Bill of Lading with chemical analysis attached</td>
<td>Weekly</td>
<td>See QA Manual Sections 230.02 and 230.02.01</td>
</tr>
<tr>
<td></td>
<td>Manufacturer</td>
<td>Manufacturer</td>
<td></td>
<td></td>
<td></td>
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</tr>
<tr>
<td>Pulverizing Roadbed</td>
<td>ACCEPTANCE Gradation</td>
<td>308.03</td>
<td>Visual Inspection</td>
<td>ITD-854</td>
<td>Prior to compaction each lane mile</td>
<td></td>
</tr>
<tr>
<td></td>
<td>ITD Project Personnel</td>
<td>ITD Project Personnel</td>
<td></td>
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</tr>
<tr>
<td>Compacted Roadway</td>
<td>ACCEPTANCE In-Place Density</td>
<td>308.03</td>
<td>FOP for AASHTO T 310 Method A modified (CRABS)</td>
<td>ITD-850 ITD-1866</td>
<td>Verify the contractor met the density specification every lane mile or when mixture properties changes</td>
<td>Acceptance at roadway.</td>
</tr>
<tr>
<td>BID ITEM/ MATERIAL</td>
<td>PURPOSE OF TESTING</td>
<td>ITD SPEC. REF.</td>
<td>TEST METHOD</td>
<td>REQUIRED REPORT FORM NO.</td>
<td>MINIMUM REQUIRED FREQUENCY</td>
<td>REMARKS, NOTES, OR ADDITIONAL DIRECTIONS</td>
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<td>----------------------------------------</td>
</tr>
<tr>
<td>Emulsified Asphalt</td>
<td>ACCEPTANCE Certification</td>
<td>702.03 702.05</td>
<td>Loading Certificate</td>
<td>Each individual truck, trailer, car or shipment to the project.</td>
<td>See QA Manual Section 230.11</td>
<td></td>
</tr>
<tr>
<td>Verified Laboratory Tests</td>
<td>702.03 FOP for AASHTO R 66 AASHTO T 59</td>
<td>ITD-1045</td>
<td>1 undiluted sample (as received from the asphalt supplier) per project</td>
<td>No samples required when total project quantity is less than 2,000 Gal 8 Tons.</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

**STANDARD SPECIFICATION SECTION: 401 - TACK COAT**

**Distributors** will be calibrated each season. The Contractor will submit a valid calibration certification for the distributor before beginning work. Calibrate the distributor according to ASTM D2995.

<table>
<thead>
<tr>
<th>BID ITEM/ MATERIAL</th>
<th>PURPOSE OF TESTING</th>
<th>ITD SPEC. REF.</th>
<th>TEST METHOD</th>
<th>REQUIRED REPORT FORM NO.</th>
<th>MINIMUM REQUIRED FREQUENCY</th>
<th>REMARKS, NOTES, OR ADDITIONAL DIRECTIONS</th>
</tr>
</thead>
<tbody>
<tr>
<td>Emulsified Asphalt</td>
<td>ACCEPTANCE Certification</td>
<td>702.03 702.05</td>
<td>Loading Certificate</td>
<td>Each individual truck, trailer, car or shipment to the project.</td>
<td>See QA Manual Section 230.11</td>
<td></td>
</tr>
<tr>
<td>Verified Laboratory Tests</td>
<td>702.03 FOP for AASHTO R 66 AASHTO T 59</td>
<td>ITD-1045</td>
<td>1 undiluted sample (as received from the asphalt supplier) per project</td>
<td>No samples required when total project quantity is less than 2,000 Gal 8 Tons.</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

**STANDARD SPECIFICATION SECTION: 402 - PRIME COAT**

**Distributors** will be calibrated each season. The Contractor will submit a valid calibration certification for the distributor before beginning work. Calibrate the distributor according to ASTM D2995.

<table>
<thead>
<tr>
<th>BID ITEM/ MATERIAL</th>
<th>PURPOSE OF TESTING</th>
<th>ITD SPEC. REF.</th>
<th>TEST METHOD</th>
<th>REQUIRED REPORT FORM NO.</th>
<th>MINIMUM REQUIRED FREQUENCY</th>
<th>REMARKS, NOTES, OR ADDITIONAL DIRECTIONS</th>
</tr>
</thead>
<tbody>
<tr>
<td>Blotter</td>
<td>ACCEPTANCE Gradation</td>
<td>703.07 402.02</td>
<td>ITD-901</td>
<td>1 field gradation per source.</td>
<td>Sample at point of loading to the project.</td>
<td></td>
</tr>
</tbody>
</table>

**STANDARD SPECIFICATION SECTION: 404 SURFACE TREATMENT**

**Distributors** will be calibrated each season. The Contractor will submit a valid calibration certification for the distributor before beginning work. Calibrate the distributor according to ASTM D2995.

<table>
<thead>
<tr>
<th>BID ITEM/ MATERIAL</th>
<th>PURPOSE OF TESTING</th>
<th>ITD SPEC. REF.</th>
<th>TEST METHOD</th>
<th>REQUIRED REPORT FORM NO.</th>
<th>MINIMUM REQUIRED FREQUENCY</th>
<th>REMARKS, NOTES, OR ADDITIONAL DIRECTIONS</th>
</tr>
</thead>
<tbody>
<tr>
<td>Emulsified Asphalt</td>
<td>ACCEPTANCE Saybolt Viscosity Field Test</td>
<td>702.03</td>
<td>ITD-1045</td>
<td>Test each load for Saybolt viscosity. If the district Saybolt viscosity result is outside specified limits, <strong>reject the load.</strong></td>
<td>Do not sample emulsions from storage tank discharge lines.</td>
<td></td>
</tr>
<tr>
<td>ACCEPTANCE Certification</td>
<td>702.03 702.05</td>
<td>Manufacturer Manufacturer</td>
<td>Loading Certificate</td>
<td>Each individual truck, trailer, car or shipment to the project.</td>
<td>See QA Manual Section 230.11</td>
<td></td>
</tr>
<tr>
<td>BID ITEM/ MATERIAL</td>
<td>PURPOSE OF TESTING</td>
<td>ITD SPEC. REF.</td>
<td>TEST METHOD</td>
<td>REQUIRED REPORT FORM NO.</td>
<td>MINIMUM REQUIRED FREQUENCY</td>
<td>REMARKS, NOTES, OR ADDITIONAL DIRECTIONS</td>
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</tr>
<tr>
<td>Emulsified Asphalt (cont.)</td>
<td>VERIFICATION Laboratory Tests</td>
<td>702.03</td>
<td>FOP for AASHTO R 66 AASHTO T 59</td>
<td>ITD-1045</td>
<td>Each 25,000 Gal or 100 Tons</td>
<td>No samples required when total project quantity is less than 2,000 Gal 8 Tons.</td>
</tr>
<tr>
<td></td>
<td>INDEPENDENT ASSURANCE Viscosity Field Test</td>
<td>IA Inspector</td>
<td>IA Inspector</td>
<td>ITD-857</td>
<td>1 observation of Saybolt viscosity per project.</td>
<td>See QA Manual Sections 330.00 &amp; 380.00</td>
</tr>
<tr>
<td>PG. Binder</td>
<td>ACCEPTANCE Certification</td>
<td>702.01 702.05</td>
<td>FOP for AASHTO R 66 AASHTO M 320</td>
<td>ITD-859 OR manufacturer certification</td>
<td>Initial lot &amp; each new lot to project</td>
<td>See QA Manual Sections 230.10 &amp; 255.00</td>
</tr>
<tr>
<td></td>
<td>VERIFICATION Laboratory Tests</td>
<td>ITD Project Personnel</td>
<td>ITD Central Laboratory</td>
<td>ITD-859AW (ITD-859AW is the Central Laboratory Report)</td>
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<tr>
<td></td>
<td>PG. Binder</td>
<td>Manufacturer</td>
<td>Manufacturer</td>
<td>Loading Certificate</td>
<td>Each shipment to project</td>
<td>No samples required when total project quantity is less than 22 tons</td>
</tr>
<tr>
<td>Anti-Strip Additive</td>
<td>ACCEPTANCE Presence of Anti-Stripping Additive</td>
<td>702.04</td>
<td>Idaho IT 99 (color method only)</td>
<td>ITD-859</td>
<td></td>
<td>If anti-strip cannot be detected, the supplier must add the anti-strip on-site.</td>
</tr>
<tr>
<td></td>
<td></td>
<td>ITD Project Personnel</td>
<td>ITD Project Personnel</td>
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<tr>
<td>Cover Coat Material</td>
<td>ACCEPTANCE Gradation Cleanness Value Fracture Count</td>
<td>703.06</td>
<td>FOP for AASHTO T 2 FOP for AASHTO R 76 FOP for AASHTO T 27 FOP for AASHTO T 11 Idaho IT 72 FOP for AASHTO T335 Method 1</td>
<td>ITD-901</td>
<td>Each 280 CY or 400 Tons 26,000 yd²</td>
<td>Sample at point of loading to the roadway</td>
</tr>
<tr>
<td></td>
<td>INDEPENDENT ASSURANCE Gradation Cleanness Value Fracture Count</td>
<td>IA Inspector</td>
<td>IA Inspector</td>
<td>ITD-857</td>
<td>Each 5,600 CY or 8,000 Tons .</td>
<td></td>
</tr>
<tr>
<td>BID ITEM/ MATERIAL</td>
<td>PURPOSE OF TESTING</td>
<td>ITD SPEC. REF.</td>
<td>TEST METHOD</td>
<td>REQUIRED REPORT FORM NO.</td>
<td>MINIMUM REQUIRED FREQUENCY</td>
<td>REMARKS, NOTES, OR ADDITIONAL DIRECTIONS</td>
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</tr>
<tr>
<td>Blotter</td>
<td>ACCEPTANCE</td>
<td>703.07 404.02</td>
<td>FOP for AASHTO T 2 FOP for AASHTO R 76 FOP for AASHTO T 27 FOP for AASHTO T 11</td>
<td>ITD-901</td>
<td>1 field gradation per source.</td>
<td>Sample at point of loading to the project.</td>
</tr>
<tr>
<td></td>
<td>Gradation</td>
<td></td>
<td></td>
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<td></td>
<td></td>
<td>ITD Project Personnel</td>
<td>ITD Project Personnel</td>
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</tr>
<tr>
<td>Choke Sand</td>
<td>ACCEPTANCE</td>
<td>703.07 404.02</td>
<td>FOP for AASHTO T 2 FOP for AASHTO R 76 FOP for AASHTO T 27 FOP for AASHTO T 11</td>
<td>ITD-901</td>
<td>1 per day</td>
<td>Sample at point of loading to the project.</td>
</tr>
<tr>
<td></td>
<td>Gradation</td>
<td></td>
<td></td>
<td></td>
<td></td>
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<tr>
<td></td>
<td></td>
<td>ITD Project Personnel</td>
<td>ITD Project Personnel</td>
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<tr>
<td>BID ITEM/ MATERIAL</td>
<td>PURPOSE OF TESTING</td>
<td>ITD SPEC. REF.</td>
<td>TEST METHOD</td>
<td>REQUIRED REPORT FORM NO.</td>
<td>MINIMUM REQUIRED FREQUENCY</td>
<td>REMARKS, NOTES, OR ADDITIONAL DIRECTIONS</td>
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<tr>
<td>ACCEPTANCE Certification</td>
<td>702.01  702.05</td>
<td>ITD-66 or manufacturer certification</td>
<td>Loading Certificate</td>
<td>Initial lot &amp; each new lot to project</td>
<td>See QA Manual Sections 230.10</td>
<td></td>
</tr>
<tr>
<td>Performance Graded Binder</td>
<td>FOP for AASHTO R 66 AASHTO M 320</td>
<td>FOP for AASHTO R 66</td>
<td>ITD-59</td>
<td>1 sample (3 quart cans) per shift combined into weekly binder verification unit. Sampled from the line between the storage tank (or the delivery truck) and the mix plant. Purge one gallon from the injection line valve before taking sample</td>
<td>No samples required when total quantity is less than 22 Tons</td>
<td>See QA Manual Section 230.10</td>
</tr>
<tr>
<td>Anti-Strip Additive</td>
<td>Idaho IT 99</td>
<td>ITD-859</td>
<td>Test the initial truck &amp; trailer prior to unloading into the contractor's storage tank. Thereafter, test at same frequency as sampling of asphalt binder</td>
<td>If anti-strip cannot be detected, the supplier must add additional anti-strip. The binder will be sampled and tested until a positive result is determined. (green or blue color)</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Construction of Test Strip by Contractor</td>
<td>405.03</td>
<td>Idaho IR 125</td>
<td>ITD-891 (Completed by Contractor)</td>
<td>2 locations per Test Section</td>
<td>Contractor establishes roller pattern.</td>
<td></td>
</tr>
<tr>
<td>Superpave HMA for Acceptance Test Strip</td>
<td>405.02  405.02H  405.03F  703.05</td>
<td>Idaho IR 125  FOP for AASHTO T 2  FOP for AASHTO R 76  FOP for AASHTO T 176 Alt.Method 2, Mechanical FOP for AASHTO T 335 Method 1 Idaho FOP ASTM D4791 Idaho FOP AASHTO T 304</td>
<td>ITD-1046  ITD-772</td>
<td>**3 cold feed increments per test strip.</td>
<td>Random Samples per Idaho IR 125</td>
<td></td>
</tr>
<tr>
<td>Independent Assurance</td>
<td>IA Inspector</td>
<td>IA Inspector</td>
<td>ITD-857</td>
<td>Each 15,000 Tons</td>
<td>**When multiple test strips are required due to failures, the passing aggregate properties determined from the original cold feed sample will be used for subsequent test strips.</td>
<td></td>
</tr>
<tr>
<td>BID ITEM/ MATERIAL</td>
<td>PURPOSE OF TESTING</td>
<td>ITD SPEC. REF.</td>
<td>TEST METHOD</td>
<td>REQUIRED REPORT FORM NO.</td>
<td>MINIMUM REQUIRED FREQUENCY</td>
<td>REMARKS, NOTES, OR ADDITIONAL DIRECTIONS</td>
</tr>
<tr>
<td>-------------------</td>
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<td>----------------------------------------</td>
</tr>
<tr>
<td>405-2</td>
<td>Superpave HMA for Acceptance Test Strip (Cont.)</td>
<td>405.02 405.03-H 405.03-I</td>
<td>Idaho IR 125 FOP for AASHTO T 168 * FOP for AASHTO R 47 FOP for AASHTO T 166 Method A or AASHTO T 331 FOP for AASHTO T 209 Bowl Method AASHTO T 269 FOP for AASHTO T 308 FOP for AASHTO T 30 FOP for AASHTO T329 FOP for AASHTO T 312 AASHTO T 340(4)</td>
<td>ITD-773 ITD-772</td>
<td>3 per test section. Each sample must be at least 100 lb.</td>
<td>Random sample locations per Idaho IR125 *See Note 405-6 (2) Test results for each loose mix sample are averaged for each test section to determine test section acceptance. (3) For calculating VMA use the combined aggregate bulk specific gravity, ( G_{sb} ), determined by the Engineer (4) For SP 3 and SP5 mixes only</td>
</tr>
</tbody>
</table>

**Note:** Test Strip mix verification testing will be performed by HQ Central Lab or District lab. District Labs must be qualified by HQ Central Lab in order to perform Superpave Test Strip testing. Contact Central Laboratory Manager for details: Phone: (208) 334-8453

<p>| INDEPENDENT ASSURANCE | IA Inspector | IA Inspector | ITD-857 | Observation of loose mix testing performed by District Lab every 90 days. |</p>
<table>
<thead>
<tr>
<th>BID ITEM/MATERIAL</th>
<th>PURPOSE OF TESTING</th>
<th>ITD SPEC. REF.</th>
<th>TEST METHOD</th>
<th>REQUIRED REPORT FORM NO.</th>
<th>MINIMUM REQUIRED FREQUENCY</th>
<th>REMARKS, NOTES, OR ADDITIONAL DIRECTIONS</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td>405.03-L</td>
<td>Idaho IR 125 FOP for AASHTO T 355 (Backscatter mode)</td>
<td>ITD-820</td>
<td>5 per test section</td>
<td>Use same cores that were taken for density acceptance.</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>(5) Each gauge to be used on the project for QC or acceptance testing must be correlated on the test strip.</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>Gauge readings for each core must be obtained at each test site prior to coring using each gauge.</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>Each gauge will have a unique correlation factor.</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>Form ITD-820 is completed for each gauge.</td>
</tr>
<tr>
<td></td>
<td>Density (5) GAUGE CORRELATION</td>
<td>Contractor</td>
<td>Contractor and ITD District Project Personnel</td>
<td>ITD-820</td>
<td>5 per test section</td>
<td>Random sample locations per Idaho IR 125</td>
</tr>
<tr>
<td></td>
<td>ACCEPTANCE (6) Cores Density (Percent Compaction)</td>
<td>405.03-L</td>
<td>Idaho IR 125 FOP for AASHTO R 67 FOP for AASHTO T 166 Method A FOP for AASHTO T 331 ASTM D7227</td>
<td>ITD-892 ITD-772</td>
<td>5 per test section</td>
<td>(6) Test section densities are calculated as the average percent compaction of all cores from the test section using the average Gmm of the test section.</td>
</tr>
<tr>
<td></td>
<td>INDEPENDENT ASSURANCE</td>
<td>IA Inspector</td>
<td>IA Inspector</td>
<td>ITD-857</td>
<td>Observation of core testing performed by District Lab every 90 days</td>
<td></td>
</tr>
</tbody>
</table>

**STANDARD SPECIFICATION SECTION:** 405 - SUPERPAVE HOT MIX ASPHALT
<table>
<thead>
<tr>
<th>BID ITEM/ MATERIAL</th>
<th>PURPOSE OF TESTING</th>
<th>ITD SPEC. REF.</th>
<th>TEST METHOD</th>
<th>REQUIRED REPORT FORM NO.</th>
<th>MINIMUM REQUIRED FREQUENCY</th>
<th>REMARKS, NOTES, OR ADDITIONAL DIRECTIONS</th>
</tr>
</thead>
<tbody>
<tr>
<td>405-4 Production Paving SP2</td>
<td>ACCEPTANCE Loose Mix from Roadway</td>
<td>405.03</td>
<td>FOP for AASHTO T 168* FOP for AASHTO R 47 FOP for AASHTO T 329 FOP for AASHTO T 308 FOP for AASHTO T 30</td>
<td>ITD-833</td>
<td>Each 750 Tons Each sample must be at least 50 lb</td>
<td>Random sample locations * See page 405-6</td>
</tr>
<tr>
<td></td>
<td>Asphalt Content Gradation Moisture</td>
<td>ITD Project Personnel</td>
<td>ITD Project Personnel</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>INDEPENDENT ASSURANCE Sampling Asphalt Content Gradation Moisture</td>
<td></td>
<td></td>
<td>ITD-857</td>
<td>1 observation each project.</td>
<td></td>
</tr>
<tr>
<td></td>
<td>ACCEPTANCE Density (Percent Compaction)</td>
<td>405.03</td>
<td>FOP for AASHTO T 355 (Backscatter Mode)</td>
<td>ITD-855</td>
<td>Each 750 Tons</td>
<td>Test at random locations The average G_{mm} of the Test Strip test section corresponding to the Contractor’s JMF shall be used to determine densities for all production paving.</td>
</tr>
<tr>
<td></td>
<td>(Density using correlated density gauge)</td>
<td>ITD Project Personnel</td>
<td>ITD Project Personnel</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>INDEPENDENT ASSURANCE Density (Percent Compaction)</td>
<td></td>
<td></td>
<td>ITD-857</td>
<td>1 observation each project</td>
<td></td>
</tr>
<tr>
<td>BID ITEM/ MATERIAL</td>
<td>PURPOSE OF TESTING</td>
<td>ITD SPEC. REF.</td>
<td>TEST METHOD</td>
<td>REQUIRED REPORT FORM NO.</td>
<td>MINIMUM REQUIRED FREQUENCY</td>
<td>REMARKS, NOTES, OR ADDITIONAL DIRECTIONS</td>
</tr>
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</tr>
<tr>
<td></td>
<td>ACCEPTANCE</td>
<td></td>
<td>TESTED BY</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>Loose Mix from Roadway</td>
<td>405.03</td>
<td>FOP for AASHTO T 168*</td>
<td>ITD-833</td>
<td>Each 750 Tons</td>
<td>Random Sample Locations</td>
</tr>
<tr>
<td></td>
<td>Air Voids VMA Moisture</td>
<td></td>
<td>FOP for AASHTO R 47</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>FOP for AASHTO T 329</td>
<td></td>
<td></td>
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<tr>
<td></td>
<td></td>
<td></td>
<td>FOP for AASHTO T 308</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>FOP for AASHTO T 166 Method A</td>
<td>ITD-777</td>
<td>Each sample must be at least 50 lb</td>
<td></td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>FOP for AASHTO T 331</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>FOP for AASHTO T 209 Bowl Method</td>
<td></td>
<td></td>
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<tr>
<td></td>
<td></td>
<td></td>
<td>AASHTO T 269</td>
<td></td>
<td></td>
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</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>FOP for AASHTO T 312</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Production Paving SP3, SP5</td>
<td>INDEPENDENT ASSURANCE Sampling Air Voids VMA Moisture</td>
<td>IA Inspector</td>
<td>IA Inspector</td>
<td>ITD-857</td>
<td>1 observation each project.</td>
<td>Observation of the tests that are performed to calculate air voids, VMA, and Moisture</td>
</tr>
<tr>
<td>Production Paving</td>
<td>ACCEPTANCE Density (Percent Compaction) (Density using correlated density gauge)</td>
<td>405.03</td>
<td>FOP for AASHTO T 355 (Backscatter Mode)</td>
<td>ITD-855</td>
<td>Each 750 Tons</td>
<td>Test at random locations The average G$_{mm}$ of the Test Strip test section corresponding to the Contractor’s JMF shall be used to determine densities for all production paving</td>
</tr>
<tr>
<td>Production Paving</td>
<td>INDEPENDENT ASSURANCE Density (Percent Compaction)</td>
<td>IA Inspector</td>
<td>IA Inspector</td>
<td>ITD-857</td>
<td>1 observation each project</td>
<td></td>
</tr>
<tr>
<td>Production Paving Non-structural and Temporary, except on NHS.***</td>
<td>ACCEPTANCE Certification</td>
<td>405.03</td>
<td>Manufacturer</td>
<td>ITD-851</td>
<td>Total Quantity Paid</td>
<td>ITD Project Inspector documents visual inspection.</td>
</tr>
</tbody>
</table>

*** Temporary paving on the NHS with divided highways will require the same mix design as the mainline paving. Acceptance will be by density; the average percent compaction of 3 random cores must be greater than 90.0%. A random loose mix sample will be obtained to determine the theoretical maximum specific gravity, (G$_{mm}$). Sampling will be by the Contractor; testing by the State.
<table>
<thead>
<tr>
<th>BID ITEM/MATERIAL</th>
<th>PURPOSE OF TESTING</th>
<th>ITD SPEC. REF.</th>
<th>TEST METHOD</th>
<th>REQUIRED REPORT FORM NO.</th>
<th>MINIMUM REQUIRED FREQUENCY</th>
<th>REMARKS, NOTES, OR ADDITIONAL DIRECTIONS</th>
</tr>
</thead>
<tbody>
<tr>
<td>Production Paving</td>
<td>Acceptance Loose Mix from Roadway</td>
<td>405.03</td>
<td>FOP for AASHTO T 168 * FOP for AASHTO R 47 FOP for AASHTO T 329 FOP for AASHTO T 308 FOP for AASHTO T 30</td>
<td>ITD-833</td>
<td>Each 750 Tons</td>
<td>* See page 405-6 SP2 Specification Limits apply.</td>
</tr>
<tr>
<td></td>
<td>Asphalt Content</td>
<td>ITD Project Personnel</td>
<td>ITD Project Personnel</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>Gradation</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>Moisture</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Independent</td>
<td>Acceptance Density (Percent Compaction)</td>
<td>405.03 405.03-L</td>
<td>FOP for AASHTO R 67 FOP for AASHTO T 168 * FOP for AASHTO T 166 Method A FOP for AASHTO T 331 FOP for AASHTO T 209 (Bowl Method) ASTM D7227</td>
<td>ITD-773 ITD-892</td>
<td>5 Stratified Random Cores</td>
<td>* See page 405-6 Density (percent compaction) acceptance will be determined from the average of the cores. The average max. specific gravity, (G_{mm}) from the loose mix samples will be used to determine core density (percent compaction).</td>
</tr>
<tr>
<td>Assurance</td>
<td>Sampling Asphalt Content Gradation Moisture</td>
<td>IA Inspector</td>
<td>IA Inspector</td>
<td>ITD-857</td>
<td>1 observation each project.</td>
<td></td>
</tr>
<tr>
<td>Production Paving</td>
<td>Acceptance Density (Percent Compaction)</td>
<td>405.03 405.03-L</td>
<td>FOP for AASHTO R 67 FOP for AASHTO T 168 * FOP for AASHTO T 166 Method A FOP for AASHTO T 331 FOP for AASHTO T 209 (Bowl Method) ASTM D7227</td>
<td>ITD-773 ITD-892</td>
<td>5 Stratified Random Cores</td>
<td>* See page 405-6 Density (percent compaction) acceptance will be determined from the average of the cores. The average max. specific gravity, (G_{mm}) from the loose mix samples will be used to determine core density (percent compaction).</td>
</tr>
<tr>
<td></td>
<td>Density</td>
<td>ITD Project Personnel</td>
<td>ITD Project Personnel</td>
<td></td>
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<td></td>
</tr>
<tr>
<td></td>
<td>Moisture</td>
<td></td>
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</tr>
</tbody>
</table>

* The plate method is the primary method for obtaining samples from the roadway. For the lifts of 0.2' or less, the samples may be obtained from the plant using an attached sampling device or sample from haul units. When the point of sampling is not the roadway and the minimum frequency results in more than 3 tests, the State will obtain at least two additional samples from the roadway, behind the paver, using the plate method for information to identify possible handling or placement variability. These tests will not be used as verification tests. The roadway samples will be taken randomly in the first and second thirds of the project. The samples will be tested by the State for asphalt content per FOP for AASHTO T 308 and gradation per FOP for AASHTO T 30. The test results will be evaluated by comparing to the average of the production test results up to that point. The comparison must be within the significant difference as shown in the table under dispute resolution section. For SuperPave (SP3 and SP5) items, the two roadway samples will be tested by the State for air void and VMA. The test results will be compared to the average of the production test results up to that point. The comparison must be within the significant difference as shown in the table under dispute resolution section. When the difference in the test result is significant, the contractor shall determine the cause of the difference and shall make any necessary corrections.
<table>
<thead>
<tr>
<th>BID ITEM/ MATERIAL</th>
<th>PURPOSE OF TESTING</th>
<th>ITD SPEC. REF.</th>
<th>TEST METHOD</th>
<th>REQUIRED REPORT FORM NO.</th>
<th>MINIMUM REQUIRED FREQUENCY</th>
<th>REMARKS, NOTES, OR ADDITIONAL DIRECTIONS</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Surface Smoothness</td>
<td>405.03-P</td>
<td>AASHTO R 57</td>
<td></td>
<td>Contractor furnishes IRI QC test results to Engineer by next calendar day following placement. Acceptance testing to be completed on final lift within 1 week of completion of paving</td>
<td></td>
</tr>
<tr>
<td></td>
<td></td>
<td>Contractor</td>
<td>Contractor</td>
<td></td>
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</tr>
<tr>
<td></td>
<td>VERIFICATION</td>
<td>405.03-P</td>
<td>ITD-854</td>
<td>Fully witnessed with report</td>
<td>ITD-769</td>
<td></td>
</tr>
<tr>
<td>Profiler</td>
<td></td>
<td>ITD Project Personnel</td>
<td>ITD Project Personnel</td>
<td></td>
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<tr>
<td></td>
<td>Pavement</td>
<td>718.02</td>
<td>ASTM D4632</td>
<td>ITD-849 with QC test results attached</td>
<td>Total Quantity Paid</td>
<td>See QA Manual Section 230.09</td>
</tr>
<tr>
<td>Reinforcement</td>
<td>certification</td>
<td>718.08</td>
<td>ASTM D4533</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Fabric</td>
<td></td>
<td>718.03</td>
<td>ASTM D6140</td>
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</tr>
<tr>
<td></td>
<td>VERIFICATION</td>
<td>718.03</td>
<td>ITD-1044</td>
<td>1 sample from each manufacturer-identified lot for each type</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Laboratory Tests</td>
<td></td>
<td>718.08</td>
<td>(Sample Data)</td>
<td>(Lab Report)</td>
<td></td>
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</tr>
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<td></td>
<td>ITD Project Personnel</td>
<td>HQ Central Lab</td>
<td></td>
<td></td>
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</tr>
<tr>
<td>BID ITEM/ MATERIAL</td>
<td>PURPOSE OF TESTING</td>
<td>ITD SPEC. REF.</td>
<td>TEST METHOD</td>
<td>REQUIRED REPORT FORM NO.</td>
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<td>REMARKS, NOTES, OR ADDITIONAL DIRECTIONS</td>
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<td>------------------------------------------</td>
</tr>
<tr>
<td>Aggregate</td>
<td>ACCEPTANCE Gradation Sand Equivalent Fracture Count</td>
<td>703 406.02 407.02</td>
<td>FOP for AASHTO T 2 FOP for AASHTO R 76 FOP for AASHTO T 27 FOP for AASHTO T 11 FOP for AASHTO T 176 Alt Method 2, Mechanical FOP for AASHTO T 335 Method 1</td>
<td>ITD-901</td>
<td>Each 700 CY or 1,000 Tons</td>
<td>Sample at point of loading to the roadway</td>
</tr>
<tr>
<td></td>
<td>INDEPENDENT ASSURANCE Gradation Sand Equivalent Fracture Count</td>
<td>IA Inspector</td>
<td>IA Inspector</td>
<td>ITD-857</td>
<td>Each 14,000 CY or 20,000 Tons</td>
<td></td>
</tr>
<tr>
<td>Emulsified Asphalt</td>
<td>ACCEPTANCE Certification</td>
<td>702.03 702.05</td>
<td>Loading Certificate</td>
<td>Manufacturer</td>
<td>Each individual truck, trailer, car or shipment</td>
<td>See QA Manual Section 230.11</td>
</tr>
<tr>
<td></td>
<td>VERIFICATION Laboratory Tests</td>
<td>702.03 FOP for AASHTO R 66 AASHTO T 59</td>
<td></td>
<td>ITD Project Personnel HQ Central Laboratory</td>
<td>ITD-1045</td>
<td>Each 100 tons</td>
</tr>
<tr>
<td>PG. Binder</td>
<td>ACCEPTANCE Certification</td>
<td>702.01 702.05</td>
<td>Loading Certificate</td>
<td>Manufacturer</td>
<td>Each shipment to project</td>
<td>See QA Manual Sections 230.10 &amp; 255.00</td>
</tr>
<tr>
<td></td>
<td>VERIFICATION Laboratory Tests</td>
<td>702.01 AASHTO M 320 FOP for AASHTO R 66</td>
<td></td>
<td>ITD Project Personnel</td>
<td>ITD-859</td>
<td>One (1) sample (3 quart cans) per shift combined into weekly binder verification unit. Sampled from the line between the storage tank (or the delivery truck) and the mix plant. Purge one gallon from the injection line valve before taking sample</td>
</tr>
</tbody>
</table>

Distributors will be calibrated each season. The Contractor will submit a valid calibration certification for the distributor before beginning work. Calibrate the distributor according to ASTM D2995.
### Quality Assurance

#### 400 Surface Courses and Bituminous Pavement

<table>
<thead>
<tr>
<th>BID ITEM/ MATERIAL</th>
<th>PURPOSE OF TESTING</th>
<th>ITD SPEC. REF.</th>
<th>TEST METHOD</th>
<th>REQUIRED REPORT FORM NO.</th>
<th>MINIMUM REQUIRED FREQUENCY</th>
<th>REMARKS, NOTES, OR ADDITIONAL DIRECTIONS</th>
</tr>
</thead>
<tbody>
<tr>
<td>406/407-2</td>
<td>Anti-Strip Additive</td>
<td>ACCEPTANCE Presence of Anti-Striping Additive</td>
<td>702.04</td>
<td>Idaho IT 99</td>
<td>ITD-859</td>
<td>Test the initial truck &amp; trailer prior to unloading into the contractor's storage tank. Thereafter, test at same frequency as sampling of asphalt binder. If anti-strip cannot be detected, the supplier must add additional anti-strip. The binder will be sampled and tested until a positive result is determined. (Green or Blue color)</td>
</tr>
</tbody>
</table>

#### STANDARD SPECIFICATION SECTION: 408 - FOG COAT

<table>
<thead>
<tr>
<th>Emulsified Asphalt</th>
<th>ACCEPTANCE Certification</th>
<th>702.03 702.05</th>
<th>Loading Certificate</th>
<th>Each individual truck, trailer, car or shipment</th>
<th>See QA Manual Section 230.11</th>
</tr>
</thead>
<tbody>
<tr>
<td>VERIFICATION Laboratory Tests</td>
<td>702.02 702.03</td>
<td>FOP for AASHTO R 66 AASHTO T 59</td>
<td>ITD-1045</td>
<td>One (1) undiluted sample (as received from the asphalt supplier) per project.</td>
<td>No samples required when total project quantity is less than 2,000 Gal 8 Tons.</td>
</tr>
<tr>
<td>ITD Project Personnel</td>
<td>HQ Central Laboratory</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Blotter</th>
<th>ACCEPTANCE Gradation</th>
<th>703.07 408.02</th>
<th>FOP for AASHTO T 2 AASHTO T 76 AASHTO T 176 Alt. Method 2, Mechanical</th>
<th>ITD-901</th>
<th>1 field gradation per source.</th>
<th>Sample at point of loading to the project.</th>
</tr>
</thead>
<tbody>
<tr>
<td>ITD Project Personnel</td>
<td>ITD Project Personnel</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

Distributors will be calibrated each season. The Contractor will submit a valid calibration certification for the distributor before beginning work. Calibrate the distributor according to ASTM D2995.

#### STANDARD SPECIFICATION SECTION 415 - MICROSURFACING

<table>
<thead>
<tr>
<th>Aggregate</th>
<th>ACCEPTANCE Certification</th>
<th>703 415</th>
<th>FOP for AASHTO T 2 AASHTO T 76 AASHTO T 176 Alt. Method 2, Mechanical</th>
<th>ITD-901</th>
<th>Each 750 Tons or fraction thereof.</th>
<th>Acceptance at stockpile</th>
</tr>
</thead>
<tbody>
<tr>
<td>ITD Project Personnel</td>
<td>ITD Project Personnel</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Polymer-modified Emulsified Asphalt</th>
<th>ACCEPTANCE Certification</th>
<th>702.03 702.05</th>
<th>Loading Certificate</th>
<th>Each individual truck, trailer, car or shipment</th>
<th>See QA Manual Section 230.11</th>
</tr>
</thead>
<tbody>
<tr>
<td>VERIFICATION Laboratory Tests</td>
<td>702.03</td>
<td>FOP for AASHTO R 66 AASHTO T 59</td>
<td>ITD-1045</td>
<td>1 random undiluted sample (as received from the asphalt supplier) twice per day</td>
<td></td>
</tr>
</tbody>
</table>
### Quality Assurance

#### 409 Portland Cement

<table>
<thead>
<tr>
<th>BID ITEM/ MATERIAL</th>
<th>PURPOSE OF TESTING</th>
<th>ITD SPEC. REF.</th>
<th>TEST METHOD</th>
<th>REQUIRED REPORT FORM NO.</th>
<th>MINIMUM REQUIRED FREQUENCY</th>
<th>REMARKS, NOTES, OR ADDITIONAL DIRECTIONS</th>
</tr>
</thead>
<tbody>
<tr>
<td>Concrete Ready-Mix Plant Inspection</td>
<td>ITD Project Personnel</td>
<td>ITD Project Personnel</td>
<td>ITD-893</td>
<td>1 per project</td>
<td>Inspection of plant is valid for 1 year.</td>
<td></td>
</tr>
<tr>
<td><strong>Mix Design</strong></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>CONFIRMATION (Mix samples not required for projects less than 2,500 CY)</td>
<td>409.01 409.03-A</td>
<td>Contractor</td>
<td>ITD Central Lab</td>
<td>Central Lab will notify the Engineer of the confirmation</td>
<td>Submittal required 60 days prior to use</td>
<td>See QA Manual Section 260.02</td>
</tr>
<tr>
<td>ACCEPTANCE (Water from other than a municipal drinking supply) Certification</td>
<td>720.01</td>
<td>ASTM C1602</td>
<td></td>
<td></td>
<td></td>
<td>Water from any municipal drinking supply does not require testing.</td>
</tr>
<tr>
<td>ACCEPTANCE (Admixtures) Approved List</td>
<td>709.02 709.03 709.04 709.05</td>
<td>ASTM C494 AASHTO M 154</td>
<td>Qualifed Products List</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>Fine Aggregate</strong></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>ACCEPTANCE Gradation Sand Equivalent</td>
<td>409.02 703.02</td>
<td>FOP for AASHTO T 2 FOP for AASHTO R 76 FOP for AASHTO T 27 FOP for AASHTO T 11 FOP for AASHTO T 176 Alt Method 2 Mechanical</td>
<td>ITD-901 OR ITD-1043</td>
<td>Each 1,000 CY of concrete placed</td>
<td>Frequency applies to multiple concrete items from same concrete plant per project.</td>
<td></td>
</tr>
<tr>
<td>INDEPENDENT ASSURANCE Gradation Sand Equivalent</td>
<td>IA Inspector</td>
<td>IA Inspector</td>
<td>ITD-857</td>
<td>Each 20,000 CY of concrete placed</td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>Coarse Aggregate</strong></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>ACCEPTANCE Gradation</td>
<td>409.02 703.03</td>
<td>FOP for AASHTO T 2 FOP for AASHTO R 76 FOP for AASHTO T 27</td>
<td>ITD-901 OR ITD-1043</td>
<td>Each 1,000 CY of concrete placed</td>
<td>Frequency applies to multiple concrete items from same concrete plant per project. Wash method not required.</td>
<td></td>
</tr>
<tr>
<td>INDEPENDENT ASSURANCE Gradation</td>
<td>IA Inspector</td>
<td>IA Inspector</td>
<td>ITD-857</td>
<td>Each 20,000 CY of concrete placed</td>
<td></td>
<td></td>
</tr>
<tr>
<td>BID ITEM/ MATERIAL</td>
<td>PURPOSE OF TESTING</td>
<td>ITD SPEC. REF.</td>
<td>TEST METHOD</td>
<td>REQUIRED REPORT FORM NO.</td>
<td>MINIMUM REQUIRED FREQUENCY</td>
<td>REMARKS, NOTES, OR ADDITIONAL DIRECTIONS</td>
</tr>
<tr>
<td>---------------------</td>
<td>---------------------</td>
<td>---------------</td>
<td>-------------</td>
<td>--------------------------</td>
<td>---------------------------</td>
<td>------------------------------------------</td>
</tr>
<tr>
<td></td>
<td>ACCEPTANCE</td>
<td>701.01</td>
<td>AASHTO M 85 or AASHTO M 240</td>
<td>ITD-968 with bills of lading attached</td>
<td>Each week concrete is placed representing the amount of cement used</td>
<td>See QA Manual Section 230.02</td>
</tr>
<tr>
<td></td>
<td>Certification</td>
<td></td>
<td>Total Alkali</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>Manufacturer</td>
<td>Manufacturer</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>VERIFICATION</td>
<td>701.01</td>
<td>AASHTO M 85 or AASHTO M 240</td>
<td>ITD-1044 (1A) (Sample Data)</td>
<td>Each 2,500 CY of concrete placed and for each mill analysis number. (2)</td>
<td></td>
</tr>
<tr>
<td></td>
<td>Laboratory Tests(1)</td>
<td></td>
<td></td>
<td>ITD-1825 (Lab Report)</td>
<td></td>
<td></td>
</tr>
<tr>
<td>409-2</td>
<td>ITD Project Personnel</td>
<td>ITD Central Lab</td>
<td></td>
<td></td>
<td></td>
<td>The frequency applies to multiple concrete items from the same concrete plant per project. Price adjustment for failing cement.</td>
</tr>
<tr>
<td></td>
<td>ACCEPTANCE</td>
<td>714</td>
<td>AASHTO M 295</td>
<td>ITD-968 with bills of lading attached</td>
<td>Each week concrete is placed representing the amount of SCM used</td>
<td>See QA Manual Section 230.02</td>
</tr>
<tr>
<td></td>
<td>Certification</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>Manufacturer</td>
<td>Manufacturer</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>VERIFICATION</td>
<td>714</td>
<td></td>
<td>ITD-1044 (1A) (Sample Data)</td>
<td>Each 15,000 CY of concrete placed and for each sample ident number. (2)</td>
<td></td>
</tr>
<tr>
<td></td>
<td>Laboratory Tests(1)</td>
<td></td>
<td></td>
<td>ITD-1826 (Lab Report)</td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>ITD Project Personnel</td>
<td>ITD Central Lab</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

(1) No samples for laboratory tests when total quantity of concrete for project is less than 40 cubic yards
(1A) Include acceptance certification documents with ITD-1044 and sample (ITD-968 and bills of lading).
(2) When the project quantity is 40 CY or more but less than the minimum sample frequency, the cement or SCM sample may represent multiple projects provided the material is from the same mill analysis or sample ident number, manufacturer, supplier and concrete plant. The sample test report and a file memo must be included in each project file and on each Materials Summary Report.
<table>
<thead>
<tr>
<th>BID ITEM/ MATERIAL</th>
<th>PURPOSE OF TESTING</th>
<th>ITD SPEC. REF.</th>
<th>TEST METHOD</th>
<th>REQUIRED REPORT FORM NO.</th>
<th>MINIMUM REQUIRED FREQUENCY</th>
<th>REMARKS, NOTES, OR ADDITIONAL DIRECTIONS</th>
</tr>
</thead>
<tbody>
<tr>
<td>Dowel Bars</td>
<td>FOLLOW MTR TABLE STANDARD SPECIFICATION SECTION 503</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Tie Bars</td>
<td>FOLLOW MTR TABLE STANDARD SPECIFICATION SECTION 503</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>Concrete Production (1A)</strong></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>FIELD ACCEPTANCE Field Tests</strong></td>
<td>409.02</td>
<td>FOP for WAQTC TM 2 FOP for AASHTO T 119 FOP for AASHTO T 121 FOP for AASHTO T 309 FOP for AASHTO T 152</td>
<td>ITD-70</td>
<td>Each 300 CY</td>
<td>See QA Manual Section 215.00 Materials or Work Failing Specifications Computerized batch ticket accompanies each load to project.</td>
<td></td>
</tr>
<tr>
<td></td>
<td>Slump Air Content Temperature Unit Weight Cement Factor W/C Ratio ITD Project Personnel</td>
<td>ITD Project Personnel</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>INDEPENDENT ASSURANCE Field Tests</strong></td>
<td>IA Inspector</td>
<td>IA Inspector</td>
<td>ITD-857</td>
<td>Each 6,000 CY</td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>ACCEPTANCE Compressive Strength</strong></td>
<td>409.02</td>
<td>AASHTO T 22 FOP for AASHTO T 23 AASHTO T 358</td>
<td>ITD-1044 (Sample Data) ITD-845 (Lab Report)</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>ITD Project Personnel</td>
<td>ITD District or Central Lab</td>
<td></td>
<td></td>
<td>Each set consists of 3 28-day and 2 7-day cylinders. Make the cylinders from loads that are tested for slump, air content, etc.</td>
<td></td>
</tr>
<tr>
<td><strong>INDEPENDENT ASSURANCE Making Cylinders</strong></td>
<td>IA Inspector</td>
<td>IA Inspector</td>
<td>ITD-857</td>
<td>1 observation per project</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

(1A) When concrete is delivered to the forms by means of a concrete pump, the sample will be obtained at the point of discharge in accordance with WAQTC TM 2.
<table>
<thead>
<tr>
<th>BID ITEM/MATERIAL</th>
<th>PURPOSE OF TESTING</th>
<th>ITD SPEC. REF.</th>
<th>TEST METHOD</th>
<th>REQUIRED REPORT FORM NO.</th>
<th>MINIMUM REQUIRED FREQUENCY</th>
<th>REMARKS, NOTES, OR ADDITIONAL DIRECTIONS</th>
</tr>
</thead>
<tbody>
<tr>
<td>Concrete Production (1A) (Multiple small placements of less than 200 CY per day, i.e. slab replacements, intersections)</td>
<td>FOLLOW MTR TABLE STANDARD SPECIFICATION SECTION 502</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Curing Compound</td>
<td>ACCEPTANCE Laboratory Test</td>
<td>709.01</td>
<td>ASTM C309</td>
<td>ITD-1044 (Sample Data) ITD-1823 (Lab Report)</td>
<td>Submit sample at least 30 days prior to use for each batch/lot</td>
<td>Pre-approved by batch or lot number.</td>
</tr>
<tr>
<td>Finished Pavement</td>
<td>ACCEPTANCE (Depth Measurements)</td>
<td>409.03-J</td>
<td>FOP for AASHTO T 359</td>
<td>ITD-827</td>
<td>Randomly once every 0.1 mile</td>
<td>Thickness price adjustment.</td>
</tr>
<tr>
<td></td>
<td>ACCEPTANCE Profiler (Smoothness)</td>
<td>409.03-K</td>
<td>AASHTO R 57</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>Verification Profiler</td>
<td>409.03-K</td>
<td></td>
<td>ITD-854 ITD-769</td>
<td>Fully witnessed with report</td>
<td></td>
</tr>
<tr>
<td></td>
<td>ACCEPTANCE (Final Finish)</td>
<td>409.03-J</td>
<td>Idaho IT 147</td>
<td>ITD-797</td>
<td>Initially, then each lane mile</td>
<td></td>
</tr>
<tr>
<td>Joints</td>
<td>FOLLOW MTR TABLE STANDARD SPECIFICATION SECTION 625</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

**STANDARD SPECIFICATION SECTION: 411 - URBAN CONCRETE PAVEMENT**

- For all items and materials: FOLLOW MTR TABLE STANDARD SPECIFICATION SECTION 409
- For multiple small placements of less than 200 CY per day: FOLLOW MTR TABLE STANDARD SPECIFICATIONS SECTION 502

(1A) When concrete is delivered to the forms by means of a concrete pump, the sample will be obtained at the point of discharge in accordance with WAQTC TM 2.
<table>
<thead>
<tr>
<th>BID ITEM/MATERIAL</th>
<th>PURPOSE OF TESTING</th>
<th>ITD SPEC. REF.</th>
<th>TEST METHOD</th>
<th>REQUIRED REPORT FORM NO.</th>
<th>MINIMUM REQUIRED FREQUENCY</th>
<th>REMARKS, NOTES, OR ADDITIONAL DIRECTIONS</th>
</tr>
</thead>
<tbody>
<tr>
<td>Concrete Ready-Mix Plant Inspection</td>
<td>ITD Project Personnel</td>
<td>ITD Project Personnel</td>
<td>ITD-893</td>
<td>1 per project</td>
<td>Inspection of plant is valid for 1 year.</td>
<td></td>
</tr>
<tr>
<td>Mix Design</td>
<td>REVIEW BY HQ Central Lab</td>
<td>502.01 502.03-A</td>
<td>Contractor</td>
<td>See Section 260.03.</td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>ACCEPTANCE (Admixtures) Approved List</td>
<td>709.02 709.03 709.04 709.05</td>
<td>ASTM C494 AASHTO M 154</td>
<td>Qualified Products List</td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>ACCEPTANCE (Water from other than a municipal drinking supply) Certification</td>
<td>720.01</td>
<td>ASTM C1602</td>
<td>Independent Lab</td>
<td>1 per project</td>
<td>Water from any municipal drinking supply does not require testing.</td>
</tr>
<tr>
<td>Fine Aggregate</td>
<td>ACCEPTANCE Gradation Sand Equivalent</td>
<td>409.02 703.02</td>
<td>FOP for AASHTO T 2 FOP for AASHTO R 76 FOP for AASHTO T 27 FOP for AASHTO T 176</td>
<td>ITD-901 OR ITD-1043</td>
<td>Each 500 CY of concrete placed</td>
<td>Frequency applies to multiple concrete items from same concrete plant per project.</td>
</tr>
<tr>
<td></td>
<td>INDEPENDENT ASSURANCE Gradation Sand Equivalent</td>
<td></td>
<td>IA Inspector</td>
<td>IA Inspector</td>
<td>ITD-857</td>
<td>Each 10,000 CY of concrete placed</td>
</tr>
<tr>
<td>Coarse Aggregate</td>
<td>ACCEPTANCE Gradation</td>
<td>409.02 703.03</td>
<td>FOP for AASHTO T 2 FOP for AASHTO R 76 FOP for AASHTO T 27</td>
<td>ITD-901 OR ITD-1043</td>
<td>Each 500 CY of concrete placed</td>
<td>Frequency applies to multiple concrete items from same concrete plant per project. Wash method not required.</td>
</tr>
<tr>
<td></td>
<td>INDEPENDENT ASSURANCE Gradation</td>
<td></td>
<td>IA Inspector</td>
<td>ITD District Lab</td>
<td>ITD-857</td>
<td>Each 10,000 CY of concrete placed</td>
</tr>
<tr>
<td>BID ITEM/MATERIAL</td>
<td>PURPOSE OF TESTING</td>
<td>ITD SPEC. REF.</td>
<td>TEST METHOD</td>
<td>REQUIRED REPORT FORM NO.</td>
<td>MINIMUM REQUIRED FREQUENCY</td>
<td>REMARKS, NOTES, OR ADDITIONAL DIRECTIONS</td>
</tr>
<tr>
<td>-------------------</td>
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<td>--------------------------</td>
<td>----------------------------</td>
<td>----------------------------------------</td>
</tr>
<tr>
<td>502-2 Cement</td>
<td>Acceptance</td>
<td>701.01</td>
<td>AASHTO M 85 or AASHTO M 240 Total Alkali</td>
<td>ITD-968 with bill of lading attached</td>
<td>Each week concrete is placed representing the amount of cement used</td>
<td>See QA Manual Section 230.02</td>
</tr>
<tr>
<td></td>
<td>Verification</td>
<td>701.01</td>
<td>AASHTO M 85 or AASHTO M 240</td>
<td>ITD-1044(1B) (Sample Data) ITD-1825 (Lab Report)</td>
<td>Each 1,000 CY of concrete placed and for each mill analysis number (2)</td>
<td>The frequency applies to multiple concrete items from the same concrete plant per project. Price adjustment for failing cement.</td>
</tr>
<tr>
<td></td>
<td>Laboratory Tests(1)</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>Secondary</td>
<td>714</td>
<td>ITD-968 with bill of lading attached</td>
<td>Each week concrete is placed representing the amount of SCM used</td>
<td>See QA Manual Section 230.02</td>
<td></td>
</tr>
<tr>
<td>Cementitious</td>
<td>Acceptance</td>
<td>714</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Material (SCM)</td>
<td>Verification</td>
<td>714</td>
<td>AASHTO M 85 or AASHTO M 240</td>
<td>ITD-1044(1B) (Sample Data) ITD-1826 (Lab Report)</td>
<td>Each 4,000 CY of concrete placed and for each sample ident number (2)</td>
<td>The frequency applies to multiple concrete items from the same concrete plant per project.</td>
</tr>
<tr>
<td></td>
<td>Laboratory Tests(1)</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Metal Reinforcement</td>
<td>FOLLOW MTR TABLE STANDARD SPECIFICATION SECTION 503</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Pre-Stressing</td>
<td>FOLLOW MTR TABLE STANDARD SPECIFICATION SECTION 506</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Strand</td>
<td>Curing Compound(1A)</td>
<td>709.01</td>
<td>ASTM C309</td>
<td>ITD-1044 (Sample Data) ITD-1823 (Lab Report)</td>
<td>Submit sample at least 30 days before use for each batch/lot</td>
<td>Pre-approved by batch or lot number.</td>
</tr>
<tr>
<td></td>
<td>Acceptance</td>
<td>709.01</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>Certification</td>
<td>709.01</td>
<td></td>
<td>ITD-851</td>
<td>Total Quantity Paid</td>
<td>See QA Manual Section 230.01</td>
</tr>
<tr>
<td>Joint Fillers</td>
<td>FOLLOW STANDARD SPECIFICATION SECTION 625 OF THE MTR TABLE</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>and Sealers</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

(1) No samples for laboratory tests when total quantity of concrete for project is less than 40 cubic yards.
(1A) Acceptance by manufacturer’s certification when total project quantity is less than 55 gallons.
(2) When the project quantity is 40 CY or more but less than the minimum sample frequency, the cement or SCM sample may represent multiple projects provided the material is from the same mill analysis or sample ident number, manufacturer, and concrete plant. The sample test report and a file memo must be included in each project file and on each Materials Summary Report. (1B) Include acceptance certification documents with ITD-1044 and sample. (ITD-968 and bill of lading)
<table>
<thead>
<tr>
<th>BID ITEM/ MATERIAL</th>
<th>PURPOSE OF TESTING</th>
<th>ITD SPEC. REF.</th>
<th>TEST METHOD</th>
<th>REQUIRED REPORT FORM NO.</th>
<th>MINIMUM REQUIRED FREQUENCY</th>
<th>REMARKS, NOTES, OR ADDITIONAL DIRECTIONS</th>
</tr>
</thead>
<tbody>
<tr>
<td>Concrete Production (1B) Specified Strength of 3,500 psi or greater</td>
<td>FIELD ACCEPTANCE Slump Air Content Temperature Unit Weight Cement Factor W/C Ratio</td>
<td>502.02</td>
<td>FOP for WAQTC TM 2 FOP for AASHTO T 119 FOP for AASHTO T 121 FOP for AASHTO T 309 FOP for AASHTO T 152</td>
<td>ITD-70</td>
<td>First load, then randomly each 50 CY until quantity exceeds 100 CY. Thereafter, randomly every 100 CY but not less than one per day. (2)</td>
<td>When there is a failing test, obtain check tests immediately and continue checking each load until 2 consecutive tests are passing. Computerized batch ticket accompanies each load to project.</td>
</tr>
<tr>
<td></td>
<td>INDEPENDENT ASSURANCE Field Tests</td>
<td>IA Inspector</td>
<td>IA Inspector</td>
<td>ITD-857</td>
<td>Each 2,000 CY</td>
<td></td>
</tr>
<tr>
<td></td>
<td>ACCEPTANCE Compressive Strength/Surface Resistivity</td>
<td>502.02</td>
<td>AASHTO T 22 FOP for AASHTO T 23 AASHTO T 358</td>
<td>ITD-1044 (Sample Data) ITD-845 (Lab Report)</td>
<td>1 set of three 28-day cylinders and 1 set of two 7-day cylinders each 100 CY but not less than 1 per day(2).</td>
<td>A single sample of concrete must be of sufficient size for the cylinders and air, slump, unit weight tests.</td>
</tr>
<tr>
<td></td>
<td>INDEPENDENT ASSURANCE Making Cylinders</td>
<td>IA Inspector</td>
<td>IA Inspector</td>
<td>ITD-857</td>
<td>1 observation per project</td>
<td></td>
</tr>
</tbody>
</table>

(1B) When concrete is delivered to the forms by means of a concrete pump, then samples will be obtained at the point of discharge in accordance with WAQTC TM-2.

(2) For some applications involving multiple small placements not on the same day, the minimum one test per day is not required. Examples where this applies are non-structural items such as median barriers, small bases for signs or poles. Examples of items where this does not apply are sign or pole bases larger than 4 CY bridge footings, columns, pier caps or bridge parapet.

| Concrete Specified Strength of 3,000 psi or less | ACCEPTANCE Certification (2B) | 502.01-B | ITD-875 with QC test results attached(3) QC tests on the first load, then randomly each 50 CY until quantity exceeds 100 CY. Thereafter randomly every 100 CY. | Total Quantity Paid | Unless lack of quality control is evident, plant inspection, aggregate testing, cement & fly ash certs & sampling, field tests and compressive strength tests by the State are not required. (2B) See QA Manual Section 230.06 Concrete supplier's certification. Note locations on ITD-875 |
| Concrete Supplier | Concrete Supplier | |

(2B) Concrete for curb and sidewalk will be accepted by certification regardless of strength requirements. Concrete for landscaping using sack mixes will NOT require certification (ITD-875) or verification tests. Acceptance will be by inspection on the RE Letter (ITD-854).

(3) When total is less than 50CY, QC tests can be from previous batches in the 30 days prior to the first placement.
<table>
<thead>
<tr>
<th>BID ITEM/ MATERIAL</th>
<th>PURPOSE OF TESTING</th>
<th>ITD SPEC. REF.</th>
<th>TEST METHOD</th>
<th>REQUIRED REPORT FORM NO.</th>
<th>MINIMUM REQUIRED FREQUENCY</th>
<th>REMARKS, NOTES, OR ADDITIONAL DIRECTIONS</th>
</tr>
</thead>
<tbody>
<tr>
<td>Pre-cast Stringers, Prestressed Members</td>
<td>ACCEPTANCE Field Tests (Air, slump, unit weight, temperature)</td>
<td>502.02</td>
<td>FOP for AASHTO T 119 FOP for AASHTO T 152 FOP for AASHTO T 309 FOP for AASHTO T 121</td>
<td>ITD-70</td>
<td>1 per member</td>
<td>The ITD On-site Inspector will provide a memo of acceptance to the Engineer with all required test reports and certifications attached.</td>
</tr>
<tr>
<td></td>
<td>ACCEPTANCE Compressive Strength</td>
<td>502.02</td>
<td>AASHTO T 22 FOP for AASHTO T 23</td>
<td>ITD-845</td>
<td>1 set of 3 28-day cylinders per member</td>
<td></td>
</tr>
<tr>
<td>Concrete Parapet</td>
<td>FOLLOW MTR FOR STRENGTH SPECIFIED</td>
<td>502.4</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Voided Slabs, Approach Slabs</td>
<td>ACCEPTANCE Field Tests (Air, slump, unit weight, temperature)</td>
<td>502.02</td>
<td>FOP for AASHTO T 119 FOP for AASHTO T 152 FOP for AASHTO T 309 FOP for AASHTO T 121</td>
<td>ITD-70</td>
<td>1 per member</td>
<td>The ITD On-site Inspector will provide a memo of acceptance to the Engineer with all required test reports and certifications attached.</td>
</tr>
<tr>
<td></td>
<td>ACCEPTANCE Compressive Strength</td>
<td>502.02</td>
<td>AASHTO T 22 FOP for AASHTO T 23</td>
<td>ITD-845</td>
<td>1 set of 3 28-day cylinders per member</td>
<td></td>
</tr>
<tr>
<td>Permanent Metal Concrete Forms</td>
<td>ACCEPTANCE Certification</td>
<td>708.31</td>
<td>ASTM A653 SS (SS=structural steel)</td>
<td>ITD-914</td>
<td>Total Quantity Paid</td>
<td>See QA Manual Section 230.01 and Section 230.03</td>
</tr>
<tr>
<td>Finished Concrete</td>
<td>ACCEPTANCE (Smoothness)</td>
<td>502.03-I-e</td>
<td>Idaho IT 87</td>
<td>ITD-854 ITD-769</td>
<td>As required</td>
<td></td>
</tr>
<tr>
<td></td>
<td>ACCEPTANCE (Final Finish)</td>
<td>502.03-I-d</td>
<td>Idaho IT 147</td>
<td>ITD-797</td>
<td>Once per project</td>
<td></td>
</tr>
<tr>
<td>BID ITEM/ MATERIAL</td>
<td>PURPOSE OF TESTING</td>
<td>ITD SPEC. REF.</td>
<td>TEST METHOD</td>
<td>REQUIRED REPORT FORM NO.</td>
<td>MINIMUM REQUIRED FREQUENCY</td>
<td>REMARKS, NOTES, OR ADDITIONAL DIRECTIONS</td>
</tr>
<tr>
<td>-------------------</td>
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</tr>
<tr>
<td><strong>Reinforcing Steel</strong></td>
<td>ACCEPTANCE Certification</td>
<td>503.02 708.02</td>
<td>AASHTO M 31</td>
<td>ITD-914 with mill test reports attached for steel/iron</td>
<td>Total Quantity Paid</td>
<td>See QA Manual Section 230.01 and Section 230.03</td>
</tr>
<tr>
<td></td>
<td>VERIFICATION Laboratory Tests (3)</td>
<td>503.02</td>
<td></td>
<td>ITD-1044(3A) (Sample Data) ITD-1810 ITD 812 Lab Report</td>
<td>Field sample every size and heat number from deliveries to project</td>
<td>FedEx or overnight samples. Reject failing heat numbers. See QA Manual Section 230.03.02</td>
</tr>
<tr>
<td><strong>Epoxy Coated Metal Reinforcement</strong></td>
<td>ACCEPTANCE Certification</td>
<td>503.02 708.02</td>
<td>ASTM A775</td>
<td>ITD-914 with mill test reports attached for steel/iron and Holiday and coating thickness test reports attached</td>
<td>Total Quantity Paid</td>
<td>See QA Manual Section 230.01 and Section 230.03</td>
</tr>
<tr>
<td></td>
<td>VERIFICATION Laboratory Tests (3)</td>
<td>503.02</td>
<td></td>
<td>ITD-1044(3A) (Sample Data) ITD-1810 ITD 812 Lab Report</td>
<td>Field sample every size and heat number from deliveries to project</td>
<td>FedEx or overnight samples. Reject failing heat numbers. See QA Manual Section 230.03.02</td>
</tr>
<tr>
<td><strong>Dowel Bars</strong></td>
<td>ACCEPTANCE Certification</td>
<td>708.03</td>
<td>AASHTO M 254</td>
<td>ITD-914 with mill test reports attached for steel/iron</td>
<td>Total Quantity Paid</td>
<td>See QA Manual Section 230.01 and Section 230.03</td>
</tr>
</tbody>
</table>

(3) Samples not required when used with concrete of specified strength of 3,000 psi or less. Form ITD-914 is required.

(3A) Including acceptance certification documents with ITD-1044 and sample (ITD-914 and mill test reports).
<table>
<thead>
<tr>
<th>BID ITEM/MATERIAL</th>
<th>PURPOSE OF TESTING</th>
<th>ITD SPEC. REF.</th>
<th>TEST METHOD</th>
<th>REQUIRED REPORT FORM NO.</th>
<th>MINIMUM REQUIRED FREQUENCY</th>
<th>REMARKS, NOTES, OR ADDITIONAL DIRECTIONS</th>
</tr>
</thead>
<tbody>
<tr>
<td>503-2</td>
<td>Tie Bars</td>
<td>708.04</td>
<td>AASHTO M 31</td>
<td>ITD-914 with mill test reports attached for steel/iron</td>
<td>Total Quantity Paid</td>
<td>See QA Manual Section 230.01 and Section 230.03</td>
</tr>
<tr>
<td></td>
<td></td>
<td>Manufacturer</td>
<td>Manufacturer</td>
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<tr>
<td></td>
<td></td>
<td>503.02</td>
<td></td>
<td>ITD-1044(3A) (Sample Data) ITD-1810 (ITD-812 Lab Report)</td>
<td>1 sample of 2 bars per day of concrete paving</td>
<td>Slab replacement or rehab project where less than 1,000 bars, then 1 sample of 2 bars per project.</td>
</tr>
<tr>
<td></td>
<td></td>
<td>ITD Project Personnel</td>
<td>ITD Central Lab</td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

(3) Samples not required when used with concrete of specified strength of (3,000 psi) or less. Form ITD-914 is required.
(3A) Including acceptance certification documents with ITD-1044 and sample (ITD-914 and mill test reports).
(4) Samples not required when less than 200 bars are used on a project.
### Quality Assurance

#### 500 Structures

<table>
<thead>
<tr>
<th>BID ITEM/ MATERIAL</th>
<th>PURPOSE OF TESTING</th>
<th>ITD SPEC. REF.</th>
<th>TEST METHOD</th>
<th>REQUIRED REPORT FORM NO.</th>
<th>MINIMUM REQUIRED FREQUENCY</th>
<th>REMARKS, NOTES, OR ADDITIONAL DIRECTIONS</th>
</tr>
</thead>
<tbody>
<tr>
<td>Steel Bridge</td>
<td>ACCEPTANCE</td>
<td>504.01 504.03</td>
<td>AASHTO M 270</td>
<td>ITD-914 with mill test reports attached for steel/iron</td>
<td>Total Quantity Paid</td>
<td>See QA Manual Section 230.01 and Section 230.03</td>
</tr>
<tr>
<td></td>
<td>Certification</td>
<td>708.06</td>
<td></td>
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<tr>
<td></td>
<td></td>
<td>Manufacturer</td>
<td>Manufacturer</td>
<td></td>
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</tr>
<tr>
<td></td>
<td>ACCEPTANCE</td>
<td>504.01 504.02</td>
<td>AASHTO M 270</td>
<td>HQ will provide memo of inspection</td>
<td>Total Quantity Paid</td>
<td>District notifies HQ as soon as fabricator is known. HQ arranges fabrication inspection.</td>
</tr>
<tr>
<td>Fabrication Inspection(5)</td>
<td></td>
<td>504.03</td>
<td></td>
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</tr>
<tr>
<td></td>
<td></td>
<td>ITD Project Personnel</td>
<td>ITD Central Lab</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Structural Steel</td>
<td>ACCEPTANCE</td>
<td>504.01 504.03</td>
<td>AASHTO M 270</td>
<td>ITD-914 with mill test reports attached for steel/iron</td>
<td>Total Quantity Paid</td>
<td>See QA Manual Section 230.01 and Section 230.03</td>
</tr>
<tr>
<td></td>
<td>Certification</td>
<td>708.06</td>
<td></td>
<td></td>
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</tr>
<tr>
<td></td>
<td></td>
<td>Manufacturer</td>
<td>Manufacturer</td>
<td></td>
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</tr>
<tr>
<td></td>
<td>ACCEPTANCE</td>
<td>504.01 504.02</td>
<td>AASHTO M 270</td>
<td>HQ will provide memo of inspection</td>
<td>Total Quantity Paid</td>
<td>District notifies HQ as soon as fabricator is known. HQ arranges fabrication inspection.</td>
</tr>
<tr>
<td>Fabrication Inspection(5)</td>
<td></td>
<td>504.03</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td></td>
<td>ITD Project Personnel</td>
<td>ITD Central Lab</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Steel Forgings</td>
<td>ACCEPTANCE</td>
<td>708.06</td>
<td>AASHTO M 270</td>
<td>ITD-914 with mill test reports attached for steel/iron</td>
<td>Total Quantity Paid</td>
<td>See QA Manual Section 230.01 and Section 230.03</td>
</tr>
<tr>
<td></td>
<td>Certification</td>
<td>Manufacturer</td>
<td>Manufacturer</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>ACCEPTANCE</td>
<td>504.03</td>
<td>AASHTO M 270</td>
<td>HQ will provide memo of inspection</td>
<td>Total Quantity Paid</td>
<td>District notifies HQ as soon as fabricator is known. HQ arranges fabrication inspection.</td>
</tr>
<tr>
<td>Fabrication Inspection(5)</td>
<td></td>
<td></td>
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</tr>
<tr>
<td></td>
<td></td>
<td>ITD Project Personnel</td>
<td>ITD Central Lab</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Paint</td>
<td>FOLLOW MTR TABLE STANDARD SPECIFICATION SECTION 627</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

(5) Fabrication Inspection not required if less than 16 Ton. District notification is still required. Field inspection of steel member is required. Acceptance by certification and ITD-854 Resident Engineer’s Letter of Inspection (See QA Manual Section 250.00).
<table>
<thead>
<tr>
<th>BID ITEM/ MATERIAL</th>
<th>PURPOSE OF TESTING</th>
<th>ITD SPEC. REF.</th>
<th>TEST METHOD</th>
<th>REQUIRED REPORT FORM NO.</th>
<th>MINIMUM REQUIRED FREQUENCY</th>
<th>REMARKS, NOTES, OR ADDITIONAL DIRECTIONS</th>
</tr>
</thead>
<tbody>
<tr>
<td>Bolts, Nuts, Hardened Washers, Direct Tension Indicators</td>
<td>ACCEPTANCE Certification</td>
<td>504.03-L 708.06-2</td>
<td>ASTM A307 ASTM A325 ASTM A490 ASTM E18</td>
<td>ITD-914 no mill test reports for steel/iron</td>
<td>Total Quantity Paid</td>
<td>See QA Manual Section 230.01 and Section 230.03</td>
</tr>
<tr>
<td></td>
<td>VERIFICATION Laboratory Tests</td>
<td>504.03-L 708.06-2</td>
<td>ASTM A307 ASTM A325 ASTM A490 ASTM E18</td>
<td>ITD-1044 (Sample Data) ITD-1811 (Lab Report)</td>
<td>3 random samples of each assembly from each lot and size</td>
<td>Sample from material delivered to the project.</td>
</tr>
<tr>
<td>Structural Steel Handrail</td>
<td>ACCEPTANCE Certification</td>
<td>504.02 708.06-1</td>
<td>AASHTO M 270</td>
<td>ITD-914 with mill test reports attached for steel/iron</td>
<td>Total Quantity Paid</td>
<td>See QA Manual Section 230.01 and Section 230.03</td>
</tr>
<tr>
<td>Two Tube Curb-Mount Railing</td>
<td>ACCEPTANCE Certification</td>
<td>504.02 708.06-1</td>
<td>AASHTO M 270</td>
<td>ITD-914 with mill test reports attached for steel/iron</td>
<td>Total Quantity Paid</td>
<td>See QA Manual Section 230.01 and Section 230.03</td>
</tr>
<tr>
<td>Pedestrian Bicycle Railing</td>
<td>ACCEPTANCE Certification</td>
<td>504.02 708.06-1</td>
<td>AASHTO M 270</td>
<td>ITD-914 with mill test reports attached for steel/iron</td>
<td>Total Quantity Paid</td>
<td>See QA Manual Section 230.01 and Section 230.03</td>
</tr>
<tr>
<td>Combination Pedestrian, Bicycle, and Traffic Railing</td>
<td>ACCEPTANCE Certification</td>
<td>504.02 708.06-1</td>
<td>AASHTO M 270</td>
<td>ITD-914 with mill test reports attached for steel/iron</td>
<td>Total Quantity Paid</td>
<td>See QA Manual Section 230.01 and Section 230.03</td>
</tr>
<tr>
<td>BID ITEM/MATERIAL</td>
<td>PURPOSE OF TESTING</td>
<td>ITD SPEC. REF.</td>
<td>TEST METHOD</td>
<td>REQUIRED REPORT FORM NO.</td>
<td>MINIMUM REQUIRED FREQUENCY</td>
<td>REMARKS, NOTES, OR ADDITIONAL DIRECTIONS</td>
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</tr>
<tr>
<td><strong>STANDARD SPECIFICATION SECTION: 505 - PILING</strong></td>
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</tr>
<tr>
<td>H-Beam Piles</td>
<td>ACCEPTANCE Certification</td>
<td>505.02 708.08</td>
<td>ASTM A36</td>
<td>ITD-914 with mill test reports attached for steel/iron</td>
<td>Total Quantity Paid</td>
<td>See QA Manual Section 230.01 and Section 230.03</td>
</tr>
<tr>
<td>Steel Shell Piles</td>
<td>ACCEPTANCE Certification</td>
<td>505.02 708.30</td>
<td>ITD-914 with mill test reports attached for steel/iron</td>
<td>Total Quantity Paid</td>
<td>See QA Manual Section 230.01 and Section 230.03</td>
<td></td>
</tr>
<tr>
<td>Timber Piles</td>
<td>ACCEPTANCE Certification</td>
<td>505.02 710.05</td>
<td>ASTM D25</td>
<td>ITD-851</td>
<td>Total Quantity Paid</td>
<td>See QA Manual Section 230.01 and Section 230.03</td>
</tr>
<tr>
<td>Pile Point</td>
<td>ACCEPTANCE Approval List and Certification</td>
<td>505.03-C</td>
<td>ITD-914 with mill test reports attached for steel/iron</td>
<td>Total Quantity Paid</td>
<td>See QA Manual Section 230.01 and Section 230.03</td>
<td></td>
</tr>
<tr>
<td>Concrete with specified strength of 3,000 psi or less</td>
<td>ACCEPTANCE Certification</td>
<td>502.02-B</td>
<td>ITD-875 with QC test results attached</td>
<td>Total Quantity Paid</td>
<td>See QA Manual Section 230.06 Concrete Suppliers Certification Note locations on ITD-875</td>
<td></td>
</tr>
</tbody>
</table>

| **STANDARD SPECIFICATION SECTION: 506 - PRE-STRESSING CONCRETE** |
| Reinforcement | FOLLOW MTR TABLE STANDARD SPECIFICATION SECTION 503 |
| Welded Wire | ACCEPTANCE Certification | Manufacturer | Manufacturer | ITD-914 with mill test reports attached for steel/iron | Total Quantity Paid | See QA Manual Section 230.01 and Section 230.03 |
| Pre-Stressing Strand | ACCEPTANCE Certification | 708.05 | ASTM A416 ASTM A722 | ITD-914 with mill test reports attached for steel/iron | Total Quantity Paid | See QA Manual Section 230.01 and Section 230.03 |
| Grout Type A | ACCEPTANCE Compressive Strength | 506.03-1 705 | ID FOP for AASHTO R 64 AASHTO T 106 | Grout cubes once per day for each type grout used | The average of 3 28-day cubes for Type A or Type B. The average of 3 24-hour cubes for Type C |
| Type B Class I Type B Class II Type C (used in post tensioning) | INDEPENDENT ASSURANCE Observation | IA Inspector | IA Inspector | ITD-857 | 1 observation per project |

**ITD Project Personnel** and **ITD Central Lab** are responsible for verification laboratory tests and ITD-1044 (Sample Data) ITD-1813 (ITD-838 Lab Report) for welded wire. **IA Inspector** and **IA Inspector** are responsible for independent assurance and observation as per ITD-857.
<table>
<thead>
<tr>
<th>BID ITEM/ MATERIAL</th>
<th>PURPOSE OF TESTING</th>
<th>ITD SPEC. REF.</th>
<th>TEST METHOD</th>
<th>REQUIRED REPORT FORM NO.</th>
<th>MINIMUM REQUIRED FREQUENCY</th>
<th>REMARKS, NOTES, OR ADDITIONAL DIRECTIONS</th>
</tr>
</thead>
<tbody>
<tr>
<td>Grout Type A</td>
<td>ACCEPTANCE</td>
<td>506.03-I 705</td>
<td>AASHTO R 64</td>
<td>ITD-1044</td>
<td>1 per project</td>
<td>The average of three 28-day cubes for Type A or Type B.</td>
</tr>
<tr>
<td>Grout Type B Class I</td>
<td>ACCEPTANCE</td>
<td>701 703 705</td>
<td>AASHTO M85</td>
<td>ITD-851</td>
<td>Total Quantity Paid</td>
<td>See QA Manual Section 230.01</td>
</tr>
<tr>
<td>Grout Type D</td>
<td>ACCEPTANCE</td>
<td>506.03-I 705</td>
<td>AASHTO R 64</td>
<td>ITD-1044</td>
<td>1 per project</td>
<td>The average of three 24-hour cubes for Type C</td>
</tr>
</tbody>
</table>

**STANDARD SPECIFICATION SECTION: 507 - BEARING PADS AND PLATES**

<table>
<thead>
<tr>
<th>BID ITEM/ MATERIAL</th>
<th>PURPOSE OF TESTING</th>
<th>ITD SPEC. REF.</th>
<th>TEST METHOD</th>
<th>REQUIRED REPORT FORM NO.</th>
<th>MINIMUM REQUIRED FREQUENCY</th>
<th>REMARKS, NOTES, OR ADDITIONAL DIRECTIONS</th>
</tr>
</thead>
<tbody>
<tr>
<td>Self-Lubricating Bronze Bearing Plates</td>
<td>ACCEPTANCE</td>
<td>507.02 708.29</td>
<td>AASHTO M 251</td>
<td>ITD-851</td>
<td>Total Quantity Paid</td>
<td>See QA Manual Section 230.01</td>
</tr>
<tr>
<td>Neoprene Bearing Pads</td>
<td>ACCEPTANCE</td>
<td>507.02 720.02</td>
<td>AASHTO M 251</td>
<td>ITD-851</td>
<td>Total Quantity Paid</td>
<td>See QA Manual Section 230.01</td>
</tr>
<tr>
<td>TFE/PTFE Bridge Bearing Pads</td>
<td>ACCEPTANCE</td>
<td>507.02 720.03</td>
<td>AASHTO M 251</td>
<td>ITD-851</td>
<td>Total Quantity Paid</td>
<td>See QA Manual Section 230.01</td>
</tr>
</tbody>
</table>

**STANDARD SPECIFICATION SECTION: 508 - CORRUGATED PLATE PIPE**

<table>
<thead>
<tr>
<th>BID ITEM/ MATERIAL</th>
<th>PURPOSE OF TESTING</th>
<th>ITD SPEC. REF.</th>
<th>TEST METHOD</th>
<th>REQUIRED REPORT FORM NO.</th>
<th>MINIMUM REQUIRED FREQUENCY</th>
<th>REMARKS, NOTES, OR ADDITIONAL DIRECTIONS</th>
</tr>
</thead>
<tbody>
<tr>
<td>Corrugated Plate Pipe Culvert</td>
<td>ACCEPTANCE</td>
<td>508.02 708.20</td>
<td>AASHTO M 167 or AASHTO M 219</td>
<td>ITD-914 with mill test reports attached for steel/iron</td>
<td>Total Quantity Paid</td>
<td>See QA Manual Section 230.01 Section 230.03 and Section 230.07</td>
</tr>
<tr>
<td>Corrugated Plate Pipe Arch</td>
<td>ACCEPTANCE</td>
<td>508.02 708.20</td>
<td>AASHTO M 167 or AASHTO M 219</td>
<td>ITD-914 with mill test reports attached for steel/iron</td>
<td>Total Quantity Paid</td>
<td>See QA Manual Section 230.01 Section 230.03 and Section 230.07</td>
</tr>
<tr>
<td>Corrugated Plate Arch</td>
<td>ACCEPTANCE</td>
<td>508.02 708.20</td>
<td>AASHTO M 167 or AASHTO M 219</td>
<td>ITD-914 with mill test reports attached for steel/iron</td>
<td>Total Quantity Paid</td>
<td>See QA Manual Section 230.01 Section 230.03 and Section 230.07</td>
</tr>
<tr>
<td>BID ITEM/MATERIAL</td>
<td>PURPOSE OF TESTING</td>
<td>ITD SPEC. REF.</td>
<td>TEST METHOD</td>
<td>REQUIRED REPORT FORM NO.</td>
<td>MINIMUM REQUIRED FREQUENCY</td>
<td>REMARKS, NOTES, OR ADDITIONAL DIRECTIONS</td>
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<tr>
<td>STANDARD SPECIFICATION SECTION: 509 - Non-Structural Concrete</td>
<td>Mix Design</td>
<td>REVIEW BY District</td>
<td>509.01</td>
<td>Contractor</td>
<td>Contractor</td>
<td>See Section 260.03.</td>
</tr>
<tr>
<td></td>
<td>Concrete(1)</td>
<td>ACCEPTANCE Certification</td>
<td>509.02</td>
<td>Contractor</td>
<td>Contractor</td>
<td>ITD-875 with QC test results attached (1) Test the first load, then again randomly prior to reaching 50 CY. Test again randomly prior to reaching 100 CY and again randomly within every 100 CY thereafter.</td>
</tr>
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<td></td>
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<td></td>
<td>Total Quantity Paid</td>
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<td></td>
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<td></td>
<td>(2) Unless lack of quality control is evident, plant inspection, aggregate testing, cement &amp; fly ash certs &amp; sampling, field tests and compressive strength tests by the State are not required. See QA Manual Section 230.06 Concrete supplier's certification Note locations on ITD-875</td>
<td></td>
</tr>
</tbody>
</table>

(1) When total is less than 50CY, QC tests can be from previous batches in the 30 days prior to the first placement.

(2) Concrete using sack mixes will NOT require certification (ITD-875) or verification tests. Acceptance will be by inspection on the RE Letter (ITD-854).
<table>
<thead>
<tr>
<th>BID ITEM/MATERIAL</th>
<th>PURPOSE OF TESTING</th>
<th>ITD SPEC. REF.</th>
<th>TEST METHOD</th>
<th>REQUIRED REPORT FORM NO.</th>
<th>MINIMUM REQUIRED FREQUENCY</th>
<th>REMARKS, NOTES, OR ADDITIONAL DIRECTIONS</th>
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</thead>
<tbody>
<tr>
<td>Mix Design</td>
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<tr>
<td>Aggregate</td>
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<td>Portland Cement</td>
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</tr>
<tr>
<td>Curing Compound</td>
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<tr>
<td>FOLLOW MTR TABLE STANDARD SPECIFICATION SECTION 502</td>
<td></td>
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<tr>
<td>Silicone Fume</td>
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<tr>
<td>Concrete</td>
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</table>

Latex Modified Concrete

<table>
<thead>
<tr>
<th>ACCEPTANCE (Latex Modifier) Certification</th>
<th>510.02</th>
<th>FOP for Idaho IR 121</th>
<th>ITD-851 with test results attached</th>
<th>Total Quantity Paid</th>
<th>See QA Manual Section 230.01</th>
</tr>
</thead>
<tbody>
<tr>
<td>Manufacturer</td>
<td>Manufacturer</td>
<td></td>
<td></td>
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<td></td>
</tr>
</tbody>
</table>

| ACCEPTANCE (Concrete) Field Tests          | 510.02 | FOP for AASHTO T 119  |                                   |                     |                              |
|                                          |        | FOP for AASHTO T 152  |                                   |                     |                              |
|                                          |        | FOP for AASHTO T 309  |                                   |                     |                              |
|                                          |        | FOP for AASHTO T 309  |                                   |                     |                              |
| ITD Project Personnel                    | ITD Project Personnel |                          | First load, then randomly each 50 CY until quantity reaches 100 CY, thereafter randomly each 100 CY. |                     |                              |

<table>
<thead>
<tr>
<th>INDEPENDENT ASSURANCE Field Tests</th>
<th>IA Inspector</th>
<th>IA Inspector</th>
<th>ITD-857</th>
<th>Each 2,000 CY</th>
</tr>
</thead>
</table>

| ACCEPTANCE (Concrete) Compressive Strength | 510.03 | AASHTO T 22  | ITD-1044 (Sample Data) | 1 set of 3 28-day cylinders per day |
|                                           |        | FOP for AASHTO T 23 | ITD-845 (Lab Report) |                              |
|                                           |        | ITD Project Personnel | ITD District or Central Lab |                              |
|                                           |        | IA Inspector | IA Inspector | ITD-857 | 1 observation per project |

<table>
<thead>
<tr>
<th>INDEPENDENT ASSURANCE Making Cylinders</th>
<th>IA Inspector</th>
<th>IA Inspector</th>
<th>ITD-857</th>
<th>Each 2,000 CY</th>
</tr>
</thead>
</table>

| ACCEPTANCE (Silica Fume) Certification   | 510.02 | AASHTO M 307  | ITD-851 with test results attached | Total Quantity Paid | See QA Manual Section 230.01 |
|                                           |        | Manufacturer | Manufacturer |                          |                     |-------------------------------|

| VERIFICATION Laboratory Test             | 510.02 | AASHTO M 307  | ITD-1044 (Sample Data) | 1 per project | 1 Cylinder Can |
|                                           |        | ITD Project Personnel | ITD Central Lab |                          |                     |                              |

| ACCEPTANCE (Concrete) Field Tests        | 510.02 | FOP for AASHTO T 119  | ITD-70 | First load, then randomly each 50 CY until quantity reaches 100 CY, thereafter randomly each 100 CY. |
|                                           |        | FOP for AASHTO T 152  |                                   |                     |                              |
|                                           |        | FOP for AASHTO T 309  |                                   |                     |                              |
|                                           |        | FOP for AASHTO T 121  |                                   |                     |                              |
| ITD Project Personnel                    | ITD Project Personnel |                          |                     |                              |                              |

<table>
<thead>
<tr>
<th>INDEPENDENT ASSURANCE Field Tests</th>
<th>IA Inspector</th>
<th>IA Inspector</th>
<th>ITD-857</th>
<th>Each 2,000 CY</th>
</tr>
</thead>
</table>

Standard Specification Section: 510 - Concrete Overlay
<table>
<thead>
<tr>
<th>BID ITEM/MATERIAL</th>
<th>PURPOSE OF TESTING</th>
<th>ITD SPEC. REF.</th>
<th>TEST METHOD</th>
<th>REQUIRED REPORT FORM NO.</th>
<th>MINIMUM REQUIRED FREQUENCY</th>
<th>REMARKS, NOTES, OR ADDITIONAL DIRECTIONS</th>
</tr>
</thead>
<tbody>
<tr>
<td>Silica Fume Concrete (Continued)</td>
<td>ACCEPTANCE (Concrete) Compressive Strength</td>
<td>510.03</td>
<td>AASHTO T 22 FOP for AASHTO T 23</td>
<td>ITD-1044 (Sample Data) ITD-845 (Lab Report)</td>
<td>1 set of 3 28-day cylinders per day</td>
<td></td>
</tr>
<tr>
<td></td>
<td>INDEPENDENT ASSURANCE Making Cylinders</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>Identify any delaminations for removal.</td>
</tr>
<tr>
<td>Finished Overlay</td>
<td>ACCEPTANCE (Smoothness)</td>
<td>409-K 510.03-F</td>
<td>Idaho IT 87</td>
<td>ITD-854 ITD-769</td>
<td>As required</td>
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<tr>
<td></td>
<td>ACCEPTANCE (Final Finish)</td>
<td>510.03-E</td>
<td>Idaho IT 147</td>
<td>ITD-797</td>
<td>Once per structure</td>
<td></td>
</tr>
</tbody>
</table>

**STANDARD SPECIFICATION SECTION: 511 - CONCRETE WATERPROOFING SYSTEMS**

<table>
<thead>
<tr>
<th>Material</th>
<th>ACCEPTANCE Certification</th>
<th>ITD SPEC. REF.</th>
<th>TEST METHOD</th>
<th>REQUIRED REPORT FORM NO.</th>
<th>MINIMUM REQUIRED FREQUENCY</th>
<th>REMARKS, NOTES, OR ADDITIONAL DIRECTIONS</th>
</tr>
</thead>
<tbody>
<tr>
<td>Liquid Asphalt Sealant Type A System</td>
<td>511.02</td>
<td>ASTM D3406</td>
<td>ITD-51</td>
<td>Total Quantity Paid</td>
<td>See QA Manual Section 230.01</td>
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<tr>
<td></td>
<td>Manufacturer</td>
<td>Manufacturer</td>
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<tr>
<td>Asphalt Roll Roofing Type A System</td>
<td>511.02</td>
<td>ASTM D224 TYPE II</td>
<td>ITD-51</td>
<td>Total Quantity Paid</td>
<td>See QA Manual Section 230.01</td>
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<tr>
<td></td>
<td>Manufacturer</td>
<td>Manufacturer</td>
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</tr>
<tr>
<td>Primer Type A System</td>
<td>702.03</td>
<td></td>
<td>ITD-51</td>
<td>Total Quantity Paid</td>
<td>See QA Manual Section 230.01</td>
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<tr>
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<td>Manufacturer</td>
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<tr>
<td>Asphalt Cement Type B System</td>
<td>702.01</td>
<td></td>
<td>ITD-51</td>
<td>Total Quantity Paid</td>
<td>See QA Manual Section 230.01</td>
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<tr>
<td></td>
<td>Manufacturer</td>
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<tr>
<td>Fabric Type B System</td>
<td>718.02</td>
<td></td>
<td>ITD-51</td>
<td>Total Quantity Paid</td>
<td>See QA Manual Section 230.01</td>
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<tr>
<td></td>
<td>Manufacturer</td>
<td>Manufacturer</td>
<td></td>
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</tr>
<tr>
<td>Sand Membrane Protection Blanket</td>
<td>703.02</td>
<td>FOP for AASHTO T 27 FOP for AASHTO T 11 FOP for AASHTO T 176 Alt. Method 2, Mechanical</td>
<td>ITD-901</td>
<td>1 per project</td>
<td>If test fails immediately, perform check test. If check test fails, reject material.</td>
<td></td>
</tr>
<tr>
<td></td>
<td>Manufacturer</td>
<td>Manufacturer</td>
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</tr>
<tr>
<td>Membrane Sheet Type D System</td>
<td>511.02 511.03</td>
<td></td>
<td>ITD-51</td>
<td>Total Quantity Paid</td>
<td>See QA Manual Section 230.01</td>
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</tr>
<tr>
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<td>Manufacturer</td>
<td>Manufacturer</td>
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<tr>
<td>Water Repellant Type C System</td>
<td>511.02 511.03</td>
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<td>ITD-51</td>
<td>Total Quantity Paid</td>
<td>See QA Manual Section 230.01</td>
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<td>Manufacturer</td>
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</tr>
<tr>
<td>BID ITEM/MATERIAL</td>
<td>PURPOSE OF TESTING</td>
<td>ITD SPEC. REF.</td>
<td>TEST METHOD</td>
<td>REQUIRED REPORT FORM NO.</td>
<td>MINIMUM REQUIRED FREQUENCY</td>
<td>REMARKS, NOTES, OR ADDITIONAL DIRECTIONS</td>
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<tr>
<td><strong>STANDARD SPECIFICATION SECTION:</strong></td>
<td><strong>512 – GABION STRUCTURE</strong></td>
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<tr>
<td>Wire Mesh</td>
<td>ACCEPTANCE Certification</td>
<td>715.01</td>
<td>ASTM A370 ASTM A641 ASTM A90 ASTM A185</td>
<td>ITD-914 with mill test reports attached for steel/iron</td>
<td>Total Quantity Paid</td>
<td>See QA Manual Section 230.01 and Section 230.03</td>
</tr>
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<td></td>
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<td>Manufacturer</td>
<td>Manufacturer</td>
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<tr>
<td>Joints</td>
<td>ACCEPTANCE Certification</td>
<td>715.05</td>
<td>ASTM A641 ASTM A370 ASTM A641 ASTM A90 ASTM A764</td>
<td>ITD-851 ITD-914 with mill test reports attached for steel/iron</td>
<td>Total Quantity Paid</td>
<td>See QA Manual Section 230.01 and Section 230.03</td>
</tr>
<tr>
<td></td>
<td></td>
<td>Manufacturer</td>
<td>Manufacturer</td>
<td></td>
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</tr>
<tr>
<td>Gabion Fill Material</td>
<td>ACCEPTANCE Inspection</td>
<td>715.06</td>
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<td>ITD-854</td>
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</tr>
<tr>
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<td>No sample required</td>
<td>No testing required</td>
<td></td>
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</tr>
<tr>
<td>Compacting Backfill</td>
<td>ACCEPTANCE In-Place Density</td>
<td>512.03-C</td>
<td>FOP for AASHTO T 99 Method C or A FOP for AASHTO T 310 Method B</td>
<td>ITD-850</td>
<td>Each 2,500 CY or 4,000 tons</td>
<td>Document compaction effort for each lift. After remedial efforts, obtain check tests within 10 feet and at same depth as original test. See QA Manual Section 215.00</td>
</tr>
<tr>
<td></td>
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<td>ITD Project Personnel</td>
<td>ITD Project Personnel</td>
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<tr>
<td>Geotextile</td>
<td>FOLLOW MTR TABLE STANDARD SPECIFICATION SECTION 640</td>
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<tr>
<td>BID ITEM/ MATERIAL</td>
<td>PURPOSE OF TESTING</td>
<td>ITD SPEC. REF.</td>
<td>TEST METHOD</td>
<td>REQUIRED REPORT FORM NO.</td>
<td>MINIMUM REQUIRED FREQUENCY</td>
<td>REMARKS, NOTES, OR ADDITIONAL DIRECTIONS</td>
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</tr>
<tr>
<td>Corrugated Metal Pipe and Pipe Arches</td>
<td>ACCEPTANCE Certification</td>
<td>706.06</td>
<td>AASHTO M 36 or AASHTO M 196</td>
<td>ITD-914 with mill test reports attached for steel/iron &amp; ITD-851 for aluminum</td>
<td>Total Quantity Paid</td>
<td>See QA Manual Section 230.01, Section 230.03, and Section 230.07</td>
</tr>
<tr>
<td>Structural Plate Pipe, Pipe Arches and Arches</td>
<td>ACCEPTANCE Certification</td>
<td>706.06</td>
<td>AASHTO M 36 Galvanized Coating</td>
<td>ITD-914 with QC results attached</td>
<td>Total Quantity Paid</td>
<td>See QA Manual Section 230.07</td>
</tr>
<tr>
<td>Concrete Pipe for Sewer, Irrigation or Drainage (Non-Reinforced)</td>
<td>ACCEPTANCE Certification</td>
<td>706.01, 706.02, 706.03</td>
<td>AASHTO M 86, ASTM C118</td>
<td>ITD-851 or ITD-914 with mill test reports attached for steel/iron</td>
<td>Total Quantity Paid</td>
<td>See QA Manual Sections 230.01, Section 230.03 and Section 230.04 ITD-914 is not required if metal reinforcement is not used</td>
</tr>
<tr>
<td>Reinforced Concrete Culvert, Storm Drain and Sewer Pipe</td>
<td>ACCEPTANCE Certification</td>
<td>706.01, 706.04</td>
<td>AASHTO M 170</td>
<td>ITD-851 or ITD-914 with mill test reports attached for steel/iron</td>
<td>Total Quantity Paid</td>
<td>See QA Manual Section 230.01, Section 230.03 and Section 230.04</td>
</tr>
<tr>
<td>Pipe Underdrains (metallic coated corrugated steel, corrugated aluminum pipe, corrugated PE drainage tubing PVC pipe)</td>
<td>ACCEPTANCE Certification</td>
<td>706.07, 706.08, 706.10, 706.14</td>
<td>AASHTO M 36, AASHTO M 196, AASHTO M 252, AASHTO M 278</td>
<td>ITD-851 or ITD-914 with mill test reports attached for steel/iron</td>
<td>Total Quantity Paid</td>
<td>See QA Manual Section 230.01 and Section 230.03</td>
</tr>
<tr>
<td>BID ITEM/ MATERIAL</td>
<td>PURPOSE OF TESTING</td>
<td>ITD SPEC. REF.</td>
<td>TEST METHOD</td>
<td>REQUIRED REPORT FORM NO.</td>
<td>MINIMUM REQUIRED FREQUENCY</td>
<td>REMARKS, NOTES, OR ADDITIONAL DIRECTIONS</td>
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</tr>
<tr>
<td>ABS or PVC or PE Pipe</td>
<td>ACCEPTANCE Certification</td>
<td>706.13 706.14 706.15 706.16 706.17</td>
<td>ASTM D2680 AASHTO M 278 ASTM F794 AASHTO M 294 ASTM F894</td>
<td>ITD-851</td>
<td>Total Quantity Paid</td>
<td>See QA Manual Section 230.06</td>
</tr>
<tr>
<td>Metal Aprons</td>
<td>ACCEPTANCE Certification</td>
<td>608 708.21</td>
<td>AASHTO M 36 or AASHTO M 196</td>
<td>ITD-914</td>
<td>Total Quantity Paid</td>
<td>See QA Manual Section 230.01 and Section 230.03</td>
</tr>
<tr>
<td>Concrete Aprons</td>
<td>ACCEPTANCE Certification</td>
<td>608 509.01-B</td>
<td></td>
<td>ITD-875 with QC test reports attached</td>
<td>Total Quantity Paid</td>
<td>See QA Manual Section 230.01 Section 230.03, and Section 230.06 Manufacturer certification Note locations on ITD-875</td>
</tr>
<tr>
<td>Gaskets for Concrete Pipe</td>
<td>ACCEPTANCE Certification</td>
<td>706.11</td>
<td>ASTM C990</td>
<td>ITD-851</td>
<td>Total Quantity Paid</td>
<td>See QA Manual Section 230.01</td>
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(1) Fabrication Inspection by ITD Central Lab required when quantities over 16 Tons.
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<th>MINIMUM REQUIRED FREQUENCY</th>
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<td>Bolts, Nuts, Washers, and Fittings</td>
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<td>Standard Drawings Section G</td>
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<td>Type 5 and Type 10 are certified as complete units, all other types need certifications for each component. See QA Manual Section 230.01 and Section 230.03</td>
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<td>Impact Attenuator (Temporary or Permanent)</td>
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</table>

(2) Manufacturer’s certification must indicate item meets Manual for Assessing Safety Hardware (MASH) or National Cooperative Highway Research Program (NCHRP) Report 350 requirements on all portions of the NHS and State Highway System. See QA Manual 270.08.
<table>
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<tr>
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<th>MINIMUM REQUIRED FREQUENCY</th>
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(3) Manufacturer’s certification must indicate item meets Manual for Assessing Safety Hardware (MASH) or National Cooperative Highway Research Program (NCHRP) report 350 requirements on all portions of the NHS and State Highway System. See QA Manual 270.08.

* When total is less than 50CY, QC tests can be from previous batches in the 30 days prior to the first placement.
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<tr>
<th>BID ITEM/ MATERIAL</th>
<th>PURPOSE OF TESTING</th>
<th>ITD SPEC. REF.</th>
<th>TEST METHOD</th>
<th>REQUIRED REPORT FORM NO.</th>
<th>MINIMUM REQUIRED FREQUENCY</th>
<th>REMARKS, NOTES, OR ADDITIONAL DIRECTIONS</th>
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**STANDARD SPECIFICATION SECTION: 614 - SIDEWALKS, DRIVEWAYS, CURB RAMPS**

**STANDARD SPECIFICATION SECTION: 615 - CURB AND GUTTER**

<table>
<thead>
<tr>
<th><strong>Class 30 Concrete (cast-in-place, precast, extruded)</strong></th>
<th><strong>ACCEPTANCE Certification</strong></th>
<th>509</th>
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<th>ITD-875</th>
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<th>See QA Manual Section 230.06 Concrete Supplier's certification Note locations on ITD-875.</th>
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<tr>
<td><strong>Superpave HMA ½ SP 2 or 3, Non-structural</strong></td>
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<td>RE Letter-See QA Manual Section 250.00</td>
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<td><strong>Metal Reinforcement</strong></td>
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<td>708.02</td>
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<td>ITD-914</td>
<td>Total Quantity Paid</td>
<td>See QA Manual Section 230.01 and Section 230.03 No samples required.</td>
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* When total is less than 50CY, QC tests can be from previous batches in the 30 days prior to the first placement.*
<table>
<thead>
<tr>
<th>BID ITEM/ MATERIAL</th>
<th>PURPOSE OF TESTING</th>
<th>ITD SPEC. REF.</th>
<th>TEST METHOD</th>
<th>REQUIRED REPORT FORM NO.</th>
<th>MINIMUM REQUIRED FREQUENCY</th>
<th>REMARKS, NOTES, OR ADDITIONAL DIRECTIONS</th>
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<td>ACCEPTANCE</td>
<td>Steel and</td>
<td>708.17-A</td>
<td>ITD-851 or</td>
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<td>supports</td>
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<td>ITD-914</td>
<td>With no mill test</td>
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<td>Type E signs</td>
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<td>reports for</td>
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<td>Plywood for</td>
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Sign Material
All materials for signs and sign supports require certification for acceptance. Acceptance of all components on one ITD-851 certification form is acceptable as long as the components are listed on the ITD-851.
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<tr>
<th>BID ITEM/MATERIAL</th>
<th>PURPOSE OF TESTING</th>
<th>ITD SPEC. REF.</th>
<th>TEST METHOD</th>
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<th>MINIMUM REQUIRED FREQUENCY</th>
<th>REMARKS, NOTES, OR ADDITIONAL DIRECTIONS</th>
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<tr>
<td>Overhead Sign Structures</td>
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<td>Breakaway Wood Posts</td>
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<td>710.02 710.09</td>
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<td>See QA Manual Section 230.01 The manufacturer must provide a copy of the wood treatment certification to ITD Central Laboratory.</td>
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<td>Steel Brackets and Brace angles</td>
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<td>Concrete Specified strength of 3,000 psi or less</td>
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<td>509.01-B</td>
<td>Concrete Supplier</td>
<td>ITD-875 with QC test results attached</td>
<td>Total Quantity Paid</td>
<td>See QA Manual Section 230.06 Concrete Supplier’s certification Note locations on ITD-875</td>
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<td>Concrete Specified strength of 3,500 psi or greater</td>
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<td>Metal Reinforcement [with concrete of specified strength of 3,000 psi or less]</td>
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<td>Manufacturer</td>
<td>ITD-914 with mill test reports attached for steel/iron</td>
<td>Total Quantity Paid</td>
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<td>Silk Screen Paste</td>
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<td>ITD-854 or ITD-914 with mill test reports attached for steel/iron</td>
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<td>RE Letter-See QA Manual Section 250.00 and Section 230.03</td>
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<td><strong>Witness Posts</strong></td>
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<td>Erosion Control Products (RECP), Turf Reinforcement Mats, Irrigation Water, Mulch Tackifier</td>
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<td>Plants, Commercial Fertilizer, Soil Conditioner, Topsoil, Mulch</td>
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<td>711.05, 711.07, 711.10, 711.11, 711.12, 711.16</td>
<td>AOSA</td>
<td>Total Quantity Paid</td>
<td>See QA Manual Section 230.12Note: State furnished seed is accepted to use on projects but MUST be sampled and tested. Unless it meets all the parameters in QA Manual 230.12. Include completed ITD-1044 to test lab with seed sample. Send copy of ITD-1044 to HQ Highway Operations, Attention: Roadside Program Administrator *ITD 851 for Contractor supplied seed and not needed for State furnished seed.</td>
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<td>Hot Poured Elastic Type Concrete Joint Sealer Acceptance Certification</td>
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<td>Neoprene Compression Seal Acceptance Certification</td>
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STANDARD SPECIFICATION SECTION: 626 – TEMPORARY TRAFFIC CONTROL
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<th>ITD SPEC. REF.</th>
<th>TEST METHOD</th>
<th>REQUIRED REPORT FORM NO.</th>
<th>MINIMUM REQUIRED FREQUENCY</th>
<th>REMARKS, NOTES, OR ADDITIONAL DIRECTIONS</th>
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<tr>
<td>Painting Steel(4)</td>
<td>ACCEPTANCE Pre-Tests(4)</td>
<td>707.02</td>
<td>Coordinate with ITD Central Lab</td>
<td>ITD-1832</td>
<td>All lots (1-quart can sample size)</td>
<td>Record lot numbers and lab numbers of approved pre-tested paint from ITD Central Lab letter and/or ITD-1832.</td>
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<td>Painting Wood(4)</td>
<td>ACCEPTANCE Pre-Tests(4)</td>
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<td>Record lot numbers and lab numbers of approved pre-tested paint from ITD Central Lab letter.</td>
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<td>Painting Concrete(4)</td>
<td>ACCEPTANCE Pre-Tests(4)</td>
<td>707.02</td>
<td>Coordinate with ITD Central Lab</td>
<td>ITD-1832</td>
<td>All lots (1-quart can sample size)</td>
<td>Record lot numbers and lab numbers of approved pre-tested paint from ITD Central Lab letter and/or ITD-1832.</td>
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<td>ACCEPTANCE Certification</td>
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<td>Total Quantity Paid</td>
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(4) Acceptance by Manufacturer’s Certification when total project quantity is less than 25 gallons.
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<th>MINIMUM REQUIRED FREQUENCY</th>
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<td><strong>STANDARD SPECIFICATION SECTION:</strong> 628 - SNOW POLES</td>
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<tr>
<td>Rigid Posts for Delineators, Snow Poles, and Mileposts</td>
<td>ACCEPTANCE Inspection or Certification for steel/iron</td>
<td>708.16</td>
<td>ITD-854 or ITD-914 with mill test reports attached for steel/iron</td>
<td>Total Quantity Paid</td>
<td>RE Letter-See QA Manual Section 250.00 See QA Manual Section 230.01 and Section 230.03</td>
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<td>Reflector Units for Delineators</td>
<td>ACCEPTANCE Inspection</td>
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<td>Flexible Snow Poles</td>
<td>ACCEPTANCE Approved List</td>
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<td>Mailbox</td>
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<td>Aggregate (Production)</td>
<td>ACCEPTANCE Gradation</td>
<td>703.10</td>
<td>FOP for AASHTO T 2 FOP for AASHTO R 76 FOP for AASHTO T 11 FOP for AASHTO T 27</td>
<td>ITD-901</td>
<td>Each 1,000 Tons</td>
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<td>ITD-857</td>
<td>Each 20,000 Tons</td>
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1/18
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<th>REMARKS, NOTES, OR ADDITIONAL DIRECTIONS</th>
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<tr>
<td>Drainage Geotextile</td>
<td>ACCEPTANCE Certification</td>
<td>718.05</td>
<td>ASTM D4632 ASTM D6241 ASTM D4751 ASTM D4491</td>
<td>ITD-849 with QC test results attached</td>
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<td>VERIFICATION Laboratory Tests(5)</td>
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<td>1 sample per lot (5B)</td>
<td>See QA Manual Section 230.09</td>
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<td>1 sample per lot (5B)</td>
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<td>Pavement Overlay Geotextile</td>
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<td>ITD Central Lab</td>
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(5) No Samples required for quantities less than 600 square yards.
(5A) Include acceptance certification documents with ITD-1044 and sample.
(5B) A lot is defined as geotextile or geogrid rolls within the same consignment or shipment that a manufacturer produced with the same product name or designation (Section 718.03 Samples of ITD Standard Specifications).

The following geosynthetic materials cannot be tested by ITD and will be accepted by certifications with required Form No. ITD-849 with QC test results attached:
- Prefabricated Vertical Drain (Wick Drain), Prefabricated Drainage Mat (Geocomposite Drainage System), Edge Drain, Geonet.
- Geocell (Cellular Confinement System).
- Geomembrane, Geosynthetic Clay Liner.
<table>
<thead>
<tr>
<th>BID ITEM/ MATERIAL</th>
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<th>ITD SPEC. REF.</th>
<th>TEST METHOD</th>
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<th>MINIMUM REQUIRED FREQUENCY</th>
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<td><strong>656</strong></td>
<td><strong>STANDARD SPECIFICATION SECTION:</strong> 656 - TRAFFIC SIGNAL INSTALLATION</td>
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<td>Signal Poles and Mast Arms</td>
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<td>ITD-914 with mill test reports attached</td>
<td>Total Quantity Paid</td>
<td>See QA Manual Section 230.03</td>
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<tr>
<td>Signal Components</td>
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<td>No Testing Required</td>
<td>ITD-854 or ITD-914 no mill test reports for steel/iron</td>
<td>Total Quantity Paid</td>
<td>RE Letter-See QA Manual Section 250.00 See QA Manual Section 230.01 and Section 230.03</td>
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<td>HQ or District Traffic</td>
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<td>Signal Cabinet Electrical Components</td>
<td>ACCEPTANCE PRE-TEST</td>
<td>ITD-500 memo</td>
<td>Post acceptance memo on MSR</td>
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<td>509.01(B)</td>
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<td>See QA Manual Section 230.06 Note locations on ITD-875</td>
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<td>Concrete Specified strength of 3,500 psi or greater</td>
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<td>Metal Reinforcement [with concrete of specified strength of 3,500 psi or greater]</td>
<td>FOLLOW MTR TABLE STANDARD SPECIFICATION SECTION 503</td>
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<td>Metal Reinforcement [with concrete of specified strength of 3,000 psi or less]</td>
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<td>503.02 708.02</td>
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<td>Total Quantity Paid</td>
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<td>FOP for AASHTO T 310 Method B</td>
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<td>Non-Structural Concrete (Sidewalks, Driveways, Slabs)</td>
<td>ACCEPTANCE Certification</td>
<td>502.02 (B)</td>
<td>ITD-875 with QC test results attached</td>
<td>Total Quantity Paid</td>
<td>See QA Manual Section 230.06 Concrete Supplier's certification Note locations on ITD-875</td>
<td></td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>Concrete Supplier</td>
<td>Concrete Supplier</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Metal Reinforcement (for structural concrete-footings, foundations, piers)</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>
| Paint              |                          |                |              |                          |                           | FOLLOW MTR TABLE STANDARD SPECIFICATION SECTION 627

(No sampling or testing required when total project quantity is less than 25 gallons.)
<table>
<thead>
<tr>
<th>BID ITEM/MATERIAL</th>
<th>PURPOSE OF TESTING</th>
<th>ITD SPEC. REF.</th>
<th>TEST METHOD</th>
<th>REQUIRED REPORT FORM NO.</th>
<th>MINIMUM REQUIRED FREQUENCY</th>
<th>REMARKS, NOTES OR ADDITIONAL DIRECTIONS</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>MISCELLANEOUS ITEMS</strong></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Magnesium Chloride for Dust Control</td>
<td>ACCEPTANCE Laboratory Tests</td>
<td>[Special Provision]</td>
<td>Per Specs</td>
<td>ITD-1044</td>
<td>Each 100 tons or 1 per project</td>
<td>Follow Special Provision requirements for acceptance; either by test or by certification. See QA Manual Section 230.01 for certification requirements.</td>
</tr>
<tr>
<td></td>
<td>ACCEPTANCE Certification</td>
<td>[Special Provision]</td>
<td></td>
<td>ITD Central Lab</td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td></td>
<td>Manufacturer</td>
<td>Manufacturer</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Epoxies</td>
<td>ACCEPTANCE Certification</td>
<td>720.04</td>
<td></td>
<td>ITD-851</td>
<td>Total Quantity Paid</td>
<td>See QA Manual Section 230.01</td>
</tr>
<tr>
<td></td>
<td>Manufacturer</td>
<td>Manufacturer</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Traffic Line Paint(6)</td>
<td>ACCEPTANCE Laboratory Tests</td>
<td></td>
<td></td>
<td>ITD-1830</td>
<td>Each lot used on Project</td>
<td>Record lot numbers and lab numbers of approved pre-tested paint from ITD Central Lab letter and/or ITD-1830 or ITD-1831. Do not collect sample from striper paint guns. (Not project specific.) Reject if totes do not match lot numbers.</td>
</tr>
<tr>
<td></td>
<td></td>
<td>ITD Project Personnel</td>
<td>ITD Central Lab</td>
<td>Or ITD-1831 (Others)</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Methyl Methacrylate (MMA) Pavement Markings (8)</td>
<td>ACCEPTANCE Laboratory Tests</td>
<td>Manufacturer</td>
<td></td>
<td>ITD-1831</td>
<td>Each lot used on Project</td>
<td>Manufacturer provides samples to Central Laboratory. Allow 14 days for pre-test results.</td>
</tr>
<tr>
<td></td>
<td>ACCEPTANCE Certification(6)</td>
<td>Manufacturer</td>
<td>Manufacturer</td>
<td></td>
<td></td>
<td>See QA Manual Section 230.01</td>
</tr>
<tr>
<td>Thermoplastic Pavement Markings</td>
<td>ACCEPTANCE Certification</td>
<td>Manufacturer</td>
<td>Manufacturer</td>
<td></td>
<td></td>
<td>See QA Manual Section 230.01</td>
</tr>
<tr>
<td>Glass Beads (7)</td>
<td>ACCEPTANCE Laboratory Tests</td>
<td>ITD Project Personnel</td>
<td>ITD Central Lab</td>
<td>ITD-1828</td>
<td>Each lot used on Project</td>
<td>Record lot numbers and lab numbers of approved pre-tested paint from ITD Central Lab letter and/or ITD-1828. (Not project specific.)</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

(6) Acceptance by manufacturer’s certification when total project quantity is less than 55 gallons.
(7) Acceptance by manufacturer’s certification when total project quantity is less than 350 pounds.
(8) When warranty applies, no samples or certifications required. A copy of the warranty must be in the project files; post a remark on MSR.
275.01 Miscellaneous.
275.01 Miscellaneous. For purposes of determining conformance with these specifications, an observed value or a calculated value shall be rounded “to the nearest unit” in the last right digit used in expressing the specification limit, in accordance with Section 6, Rounding Method of ASTM E29-13, “Using Significant Digits in Test Data To Determine Conformance With Specifications”, except when the digit next beyond the last place to be retained is 5, and there are no digits beyond this 5, or only zeros, or non-zeros, increased by 1 digit in the last place retained (regardless if it is odd or even).

Use Table 275.05.1 to determine conformance with these specifications.

Table 275.01.1

<table>
<thead>
<tr>
<th>Title</th>
<th>Calculate To:</th>
<th>Report To:</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Idaho Standards – Idaho Standard Method of Test (IT)</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Idaho IT-61 Seal Coat Emulsion Acceptance Viscosity Testing</td>
<td>1.0</td>
<td>1</td>
</tr>
<tr>
<td>Idaho IT-72 Evaluating Cleanness of Cover Coat Material</td>
<td>1</td>
<td>1</td>
</tr>
<tr>
<td>Idaho IT-74 Instruction on Use of AKDOT&amp;PF ATM-212, ITD IT-74, WSDOT TM 606, or WFLHD Humphreys Curves</td>
<td>0.01</td>
<td>0.1</td>
</tr>
<tr>
<td>Idaho IT-144 Fine Aggregate Specific Gravity by CoreLok</td>
<td>Gsb: 0.001</td>
<td>Gsb: 0.001</td>
</tr>
<tr>
<td></td>
<td>Absorption: 0.001%</td>
<td>Absorption: 0.1%</td>
</tr>
<tr>
<td><strong>AASHTO FOP</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>AASHTO T 11 Materials Finer Than 75 µm (No. 200) sieve in Mineral Aggregates by Washing</td>
<td>#200 sieve: 0.1</td>
<td>#200 sieve: 0.1</td>
</tr>
<tr>
<td></td>
<td>All other sieves: 1%</td>
<td>All other sieves: 1%</td>
</tr>
<tr>
<td>AASHTO T 27 Sieve Analysis of Fine and Coarse Aggregates</td>
<td>#200 sieve: 0.1</td>
<td>#200 sieve: 0.1</td>
</tr>
<tr>
<td></td>
<td>All other sieves: 1%</td>
<td>All other sieves: 1%</td>
</tr>
<tr>
<td>AASHTO T 30 Mechanical Analysis of Extracted Aggregate</td>
<td>#200 sieve: 0.1</td>
<td>#200 sieve: 0.1</td>
</tr>
<tr>
<td></td>
<td>All other sieves: 1%</td>
<td>All other sieves: 1%</td>
</tr>
<tr>
<td>AASHTO T 85 Specific Gravity and Absorption of Coarse Aggregate</td>
<td>Gsb: 0.001</td>
<td>Gsb: 0.001</td>
</tr>
<tr>
<td></td>
<td>Absorption: 0.001%</td>
<td>Absorption: 0.1%</td>
</tr>
<tr>
<td>AASHTO T 89 Determining the Liquid Limit of Soils</td>
<td>0.1%</td>
<td>1%</td>
</tr>
<tr>
<td>AASHTO T 90 Determining the Plastic Limit and Plasticity Index of Soils</td>
<td>0.1%</td>
<td>1%</td>
</tr>
<tr>
<td>AASHTO T 99 Moisture-Density Relations of Soils Using a 2.5-kg (5.5-lb) Rammer and 305-mm (12-in.) Drop</td>
<td>0.01</td>
<td>0.1</td>
</tr>
<tr>
<td>Specification</td>
<td>Description</td>
<td>Range 1</td>
</tr>
<tr>
<td>---------------</td>
<td>-------------</td>
<td>---------</td>
</tr>
<tr>
<td>AASHTO T 119</td>
<td>Slump of Hydraulic Cement Concrete</td>
<td>% inch</td>
</tr>
<tr>
<td>AASHTO T 121</td>
<td>Mass per Cubic Meter (Cubic Foot), Yield, and Air Content (Gravimetric) of Concrete</td>
<td>Air: 0.01</td>
</tr>
<tr>
<td></td>
<td>Yield: 0.01</td>
<td>0.1</td>
</tr>
<tr>
<td>AASHTO T 152</td>
<td>Air Content of Freshly Mixed Concrete by the Pressure Method</td>
<td>0.01</td>
</tr>
<tr>
<td>AASHTO T 166</td>
<td>Bulk Specific Gravity of Compacted Bituminous Mixtures Using Saturated Surface-Dry Specimens</td>
<td>0.001</td>
</tr>
<tr>
<td>AASHTO T 176</td>
<td>Plastic Fines in Graded Aggregates and Soils by Use of the Sand Equivalent Test</td>
<td>0.1</td>
</tr>
<tr>
<td>AASHTO T 180</td>
<td>Moisture-Density Relations of Soils Using a 4.54-kg (10-lb) Rammer and 457-mm (18-in.) Drop</td>
<td>0.01</td>
</tr>
<tr>
<td>AASHTO T 209</td>
<td>Theoretical Maximum Specific Gravity and Density of Bituminous Paving Mixtures</td>
<td>0.001</td>
</tr>
<tr>
<td>AASHTO T 255</td>
<td>Total Moisture Content of Aggregate by Drying</td>
<td>0.01</td>
</tr>
<tr>
<td>AASHTO T 265</td>
<td>Laboratory Determination of Moisture Content of Soils</td>
<td>0.01</td>
</tr>
<tr>
<td>AASHTO T 308</td>
<td>Determining the Asphalt Binder Content of Hot Mix Asphalt (HMA) by the Ignition Method</td>
<td>0.01</td>
</tr>
<tr>
<td>AASHTO T 309</td>
<td>Temperature of Freshly Mixed Portland Cement Concrete</td>
<td>1</td>
</tr>
<tr>
<td>AASHTO T 310</td>
<td>In-Place Density and Moisture Content of Soil and Soil-Aggregate by the Nuclear Method</td>
<td>0.01</td>
</tr>
<tr>
<td>AASHTO T 329</td>
<td>Moisture Content Of Hot Mix Asphalt (HMA) By Oven Method</td>
<td>0.01</td>
</tr>
<tr>
<td>AASHTO T 335</td>
<td>Determining the Percentage of Fracture in Coarse Aggregate</td>
<td>1%</td>
</tr>
<tr>
<td>AASHTO T 331</td>
<td>Bulk Specific Gravity and Density of Compacted Asphalt Mixtures Using Automatic Vacuum Sealing Method</td>
<td>0.001</td>
</tr>
<tr>
<td>AASHTO T 355</td>
<td>In-Place Density of Asphalt Mixtures by Nuclear Methods</td>
<td>0.01</td>
</tr>
</tbody>
</table>

**Idaho FOP**

<table>
<thead>
<tr>
<th>Specification</th>
<th>Description</th>
<th>Range 1</th>
<th>Range 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>ASTM D 4791</td>
<td>Flat and Elongated Particles in Coarse Aggregate</td>
<td>0.01</td>
<td>0.1</td>
</tr>
<tr>
<td>AASHTO T 304</td>
<td>Uncompacted Void Content Of Fine Aggregate</td>
<td>0.01</td>
<td>0.1</td>
</tr>
<tr>
<td>AASHTO T 343</td>
<td>Density of In-Place Hot Mix Asphalt (HMA) Pavement by Electronic Surface Contact Devices</td>
<td>0.01</td>
<td>0.1</td>
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<tr>
<td>AASHTO T 359</td>
<td>Pavement Thickness by Magnetic Pulse Induction</td>
<td>0.05</td>
<td>0.1</td>
</tr>
</tbody>
</table>
SECTION 300.00 – INDEPENDENT ASSURANCE PROGRAM

300.01 Administration of Independent Assurance Program.

SECTION 310.00 – INDEPENDENT ASSURANCE EVALUATIONS.

SECTION 320.00 – DISTRICT INDEPENDENT ASSURANCE INSPECTOR.

SECTION 330.00 – SELECTION AND FREQUENCY OF INDEPENDENT ASSURANCE EVALUATIONS.

330.01 Independent Assurance Evaluation by Split Samples.

330.02 Independent Assurance Evaluation by Observation.


SECTION 340.00 – TESTING OF DUPLICATE INDEPENDENT ASSURANCE SAMPLES.

SECTION 350.00 – NUMBERING INDEPENDENT ASSURANCE EVALUATIONS.

SECTION 360.00 – REVIEW OF INDEPENDENT ASSURANCE RESULTS.

360.01 Sample Test Results.

360.02 Review of Observation Results.

360.03 Close-out Comments and Resolution Statement.

SECTION 370.00 – INDEPENDENT ASSURANCE TEST LOG (ITD-860).

SECTION 380.00 Minimum Frequency for IA Evaluations (split samples)

SECTION 390.00 – ACCEPTABLE VARIATIONS IN SPLIT TEST RESULTS.

390.01 Aggregate.

390.02 Concrete.
SECTION 300.00 – INDEPENDENT ASSURANCE PROGRAM

The Independent Assurance (IA) Program provides an unbiased and independent evaluation of all sampling and testing procedures used in the acceptance program. The basis for the program is 23 CFR, Part 637. Additional information is provided in AASHTO R 44.

300.01 Administration of Independent Assurance Program. The Department’s Headquarters Construction/Materials section is responsible for:

1. Developing the policies and procedures to be used in the administration of the IA Program
2. Monitoring the IA program

The District Engineer is responsible for ensuring the following conditions are met:

1. Each District will provide at least one properly qualified and experienced employee for the permanent duties of District IA Inspector. The District may assign assistant or part-time IA Inspectors that are properly qualified and experienced.

2. The District IA Inspector(s), assistants, or part-time IA Inspectors may not be associated with any project construction office or crew per Federal Code 23 CFR 637. The District IA Inspector’s activities must be unbiased and independent of all sampling and testing procedures used in the acceptance program.

3. No permanent or part time District IA Inspector may perform any Acceptance Program sampling and testing for any project.

4. Each District IA Inspector, assistants, or part-time IA Inspectors must be qualified in all WAQTC modules along with the Concrete Laboratory Testing Technician (CLTT).

District IA Inspector(s) are assigned to the District Materials Engineer or District Engineer.
SECTION 310.00 – INDEPENDENT ASSURANCE EVALUATIONS. IA evaluates sampling and testing procedures, personnel and equipment used in the acceptance program. IA testing is a procedure, personnel, and equipment check and is not part of the acceptance program.

IA is not required on the Contractor’s quality control tests unless the quality control test results are used for acceptance. IA may be performed, when requested, for the Contractor’s quality control as time and resources permit.

Acceptance and verification samples and tests are the basis of materials acceptance. IA evaluations are used to assure that sampling and testing procedures are being followed correctly by project personnel and that, test equipment is providing results that are within allowable tolerances. A comparison of the project test results with IA test results, when in close conformity, gives assurance that project sampling and testing is valid. If the results are not within the allowable tolerances, corrective action must be taken by project personnel, such as checking equipment for damage, reviewing sampling and testing procedures, or other corrective action as necessary. Independent Assurance testing must be done in the district and documented in the project files.

The Resident Engineer or project inspector will notify the IA Inspector as soon as possible before production startup and throughout the project so the required IA evaluations can be scheduled.
SECTION 320.00 – DISTRICT INDEPENDENT ASSURANCE INSPECTOR. The IA Inspector is part of the ITD District Materials staff. This inspector must have experience in all phases of testing and inspection.

The duties of the District IA Inspector include:

1. Independent Assurance evaluations according to the IA Program.
2. Spot check during normal IA evaluations that project testing laboratories have a current certificate of qualification issued per the ITD Laboratory Qualification Program.
3. Spot check during normal IA evaluations that samplers and testers are WAQTC qualified and the samplers and testers are including their qualification number on test forms.
4. Spot check during normal IA evaluations and during intermediate and final record reviews that acceptance sampling and testing is being conducted randomly in accordance with contract specifications.
5. Evaluate Department samplers and testers for miscellaneous field test methods and required qualifications not covered under WAQTC. See Section 380.00 for procedures and examples.
6. Conduct intermediate and final records reviews.
9. Assist in training samplers and testers and WAQTC tester training as time permits.
10. Serve as District Radiation Safety Officer (DRSO) according to the ITD Radiation Program.
SECTION 330.00 – SELECTION AND FREQUENCY OF INDEPENDENT ASSURANCE EVALUATIONS. Independent Assurance evaluations should commence in accordance with the frequencies in the MTR tables (Section 270.00), IA Table 380.00.1, and Table 380.00.2. Independent Assurance evaluations are accomplished by split sample testing or by observation. The Department uses a modified project approach to measure whether IA requirements have been met, meaning each project must have evidence the required IA evaluations have been performed.

The IA evaluation should include all test methods performed, including sampling and splitting, during performance of the actual project tests whenever possible. Occasionally, it may be necessary for the project testing technician to obtain an additional sample or perform an additional test exclusively for IA evaluation.

The IA evaluation must accurately follow the specified test methods and procedures as closely as possible. The WAQTC performance checklists may be used as guides for evaluation of each test method. All deviations should be pointed out to the testing technician to ensure accurate and consistent test results, as well as accurate field equipment evaluations.

The IA Inspector may be called upon to evaluate test methods and field test equipment when a dispute arises from the test results or during a QC/QA project when there is a t-test failure. Additional samples and observations may be necessary for resolution.

330.01 Independent Assurance Evaluation by Split Samples. The minimum frequency for IA evaluation for each project using split samples is summarized in Table 380.00.1 and included in the MTR tables (Section 270.00) under each standard specification item. Test methods evaluated by split samples are those where the IA Inspector has dedicated equipment to perform an independent test.

Samples are collected and split under the District IA Inspector’s observation and taken to the District Materials Laboratory for testing

One IA split sample may apply to multiple items and projects provided the items are being tested by the same tester and using the same test methods and equipment. As long as the test method, tester, and equipment are the same, IA test results within the frequency interval may apply to any number of projects and any number of items. An IA test report must be completed for each project and list each item to which the IA test or evaluation applies.

For example, Project A, Project B, and Project C each have several concrete items. The IA Inspector performs a split air, slump, and unit weight test for the testing technician on Project A. The following week the same testing technician is performing the same air, slump, and unit weight tests with the same equipment on Project B. At the end of the month the inspector performs the same tests with the same equipment on Project C. The total quantity of all of the concrete items is 960 CY. The frequency limit from Table 380.00.1 is 2000 CY, therefore the IA test performed on Project A will apply to Project B and Project C. The IA Inspector completes a test report for Project B listing the concrete bid items and
another report for Project C, also listing the concrete bid items. These reports reference the actual IA test performed on Project A.

The following procedures are to be followed on IA split samples of aggregate:

1. The testing technician will take a single sample large enough to provide not less than two minimum-size samples after splitting. Sampling is to be observed by the District IA Inspector in accordance with FOP for AASHTO T 2.

2. The sample will be mixed and quartered or split into two approximately equal size samples. The District IA Inspector is to observe this procedure in accordance with FOP for AASHTO R 76.

3. One of the samples is to be tested by the testing technician for complete gradation, sand equivalent, cleanness value, or other specification field tests as applicable. The District IA Inspector is to carefully observe techniques employed by the testing technician during the testing of the field sample as often as scheduling permits. The District IA Inspector may need to review sampling and testing procedures with the testing technician and offer helpful suggestions at this time. The second portion of the sample is to be taken to the District Laboratory by the District IA Inspector and tested for the same series of tests.

4. The testing technician's results are submitted to the District Laboratory as soon as the tests are completed, giving complete identification of the sample, date sampled, testing technician's name, District IA Inspector's name, and identifying the test results as one of the split samples taken in the presence of the District IA Inspector.

5. The District Laboratory will issue form ITD-857, Independent Assurance Test Report, showing both test results for comparison. In addition to the standard laboratory report distribution, additional copies will be provided for the testing technician and the testing laboratory. The ITD Laboratory Qualification Program requires testing laboratories to keep a copy of each IA evaluation. Therefore, every effort should be made by project personnel to deliver a copy of the IA report to the testing laboratory.

6. See Section 360.00 Review of Independent Assurance Results for procedures for the test result comparisons.

330.02 Independent Assurance Evaluation by Observation. It is necessary to evaluate some test methods by observation since the IA Inspector does not have dedicated equipment to perform an independent test. IA observation evaluation frequencies for each project are summarized in Table 380.00.2 and included in the MTR tables (Section 270.00) under each standard specification item.

An IA observation may be valid for up to 90 days. A single IA observation may apply to multiple items and projects, provided the items are being tested by the same tester and using the same test methods regardless of quantity of material for up to 90 days. An IA test report must be completed for each project and list each item to which the IA observation evaluation applies.
The IA Inspector must use judgment in applying the 90-day rule and thoroughly evaluate the testing technician performing each test method involved. The IA Inspector is encouraged to use the WAQTC performance checklists as a guide for the evaluation. The 90-day rule would apply to only those test methods evaluated.

After the initial thorough IA observation evaluation is complete, the level of oversight and observation required for use of the 90-day rule is at the discretion of the IA Inspector. There should be a remark on the IA evaluation form, ITD-857, to indicate the IA Inspector’s decision when applying the 90-day rule. The remark may be based on the experience level of the testing technician, consistency of the material being tested, or other information to support the IA Inspector’s decision to apply the 90-day rule.
SECTION 340.00 – TESTING OF DUPLICATE INDEPENDENT ASSURANCE SAMPLES.

The testing of IA samples is to be done at the District Materials Laboratory, except for tests such as concrete slump and air tests that are performed in the field immediately after the sample is taken. IA samples must be tested with equipment other than that used for project acceptance testing.
SECTION 350.00 – NUMBERING INDEPENDENT ASSURANCE EVALUATIONS. IA tests will be numbered according to the first 3 or 4 characters of the bid schedule item, such as 205F, 303, or 405, followed by the letters IA and ending with the sequential number, starting at 1 and corresponding to the number of IA tests for the contract item. The sequential numbering will begin over with each contract. Contract special provision items will use the SP number for the bid schedule item number and change order items will use the CO number for the bid schedule item number.
SECTION 360.00 – REVIEW OF INDEPENDENT ASSURANCE RESULTS. The IA results are evaluated to assure the dependability and accuracy of the project sampling and testing, and to evaluate the test equipment.

360.01 Sample Test Results. The IA test results and the field test results from the other half of the split sample are reported on form ITD-857 and compared. The comparison is made to determine whether the results are within allowable variations per Section 390.00. When the test result comparison indicates the results are within allowable tolerances, the ITD-857 form is printed on white paper and distributed as shown on the form.

If the evaluation indicates the results are not within allowable variation, another sample is obtained as soon as possible for a retest. The retest must be performed by the same testing technician and the same testing equipment must be used. The retest results will be reported on the same ITD-857 form as the original test and then compared. If the comparison indicates the retest results are within allowable tolerances, the retest ITD-857 form is printed on white paper and distributed as shown on the form.

If the comparison indicates the retest results continue to not be within allowable tolerances, the ITD-857 form will be printed on buff-colored paper and immediately forwarded to the Department project representative or Resident/Regional Engineer for close-out with the IA Inspector.

When it is not possible to obtain another sample for retest, the ITD-857 form showing the first test will be printed on buff paper and immediately forwarded to the Department project representative or Resident/Regional Engineer for close-out with the IA Inspector.

360.02 Review of Observation Results. IA observations are documented on the ITD-857 form. The evaluation report is completed as an observation with a duplicate sample taken or as an observation alone. Any deviations in the sampling and testing procedures observed will be documented by the IA Inspector. The report will then immediately be forwarded to the project office for close-out with the IA Inspector.

Completed and signed copies of all IA reports will immediately be sent to the project engineer, personnel responsible for sampling and testing, and the laboratory performing the testing.

360.03 Close-out Comments and Resolution Statement. When a deviation or out-of-tolerance result is identified, a close-out will be held with personnel performing the sampling and testing and a Department project person responsible for the testing technicians. A resolution statement signed by project personnel, as indicated below, is required when an IA evaluation indicates any of the following deviations:

- Split sample test results are not within acceptable variation.
- Deviations in sampling and testing procedures observed.
- Nonqualified samplers and testers are identified performing tests on a project.
• Nonqualified laboratories are identified in use on a project.

• Acceptance sampling and testing is not being conducted randomly in accordance with contract specifications.

The IA Inspector identifies deviations and works with project personnel to identify the cause of the variation. The project personnel are responsible to institute corrective action to resolve the deviations. A resolution statement will be written, or concurred with by signature, by a Department project person responsible for the sampling and testing procedures and personnel. Usually this will be an on-site project inspector, but may also be the Resident Engineer. The resolution statement will indicate the corrective action that will take place or the corrective action that has already been enacted to prevent the deviation on subsequent sampling and testing. The action may include replacing faulty equipment, additional supervision of testing technicians, and/or suspension of testing until necessary qualifications are met.

The Independent Assurance Inspector should review any statement that does not indicate satisfactory resolution of the deviation with the District Materials Engineer. The District Materials Engineer should work with the Resident Engineer or other District Management as necessary to obtain a satisfactory resolution.

When the resolution statement is provided separately and not written directly on the IA report form, there will be a reference to the statement on the IA report in case the attachment becomes separated from the report form.
SECTION 370.00 – INDEPENDENT ASSURANCE TEST LOG (ITD-860). All IA evaluations are recorded on the ITD-860, Independent Assurance Test Log, for each project by the Resident Engineer’s office. Those IA evaluations identified as out-of-tolerance must have the resolution recorded as well. Use a blank line immediately below the recorded IA evaluation to briefly state the resolution. The IA Test Log is submitted at the completion of the project as part of the Materials Summary Report.
SECTION 380.00 Minimum Frequency for IA Evaluations (split samples)
### 380.00.1: Minimum Frequency for IA Evaluations (split samples)

<table>
<thead>
<tr>
<th>Bid Schedule Item No.</th>
<th>Item Description</th>
<th>Tests (including sampling &amp; splitting)</th>
<th>Frequency Of IA Duplicate Tests Recommended To Test Within The First Five (5) Days</th>
</tr>
</thead>
<tbody>
<tr>
<td>205</td>
<td>Granular Borrow</td>
<td>Sand Equivalent FOP for (AASHTO T 2, R 76, T 176)</td>
<td>200,000 CY</td>
</tr>
<tr>
<td>301</td>
<td>Granular Subbase</td>
<td>Gradation, SE FOP for (AASHTO T 2, R 76, T 27, T 176)</td>
<td>110,000 tons</td>
</tr>
<tr>
<td>302</td>
<td>Emulsion Treated Base</td>
<td>Gradation, SE FOP for (AASHTO T 2, R 76, T 11, T 27, T 176)</td>
<td>14,000 CY /20,000 tons</td>
</tr>
<tr>
<td>303</td>
<td>Aggregate Base</td>
<td>Gradation, SE FOP for (AASHTO T 2, R 76, T 11, T 27, T 176, T 335)</td>
<td>14,000 CY/20,000 tons</td>
</tr>
<tr>
<td>307</td>
<td>Open-Graded Rock Base</td>
<td>Gradation CV, Fracture FOP for (AASHTO R 76, T 27)</td>
<td>14,000 CY/20,000 tons</td>
</tr>
<tr>
<td>403/404</td>
<td>Cover Coat Material</td>
<td>SE, Fine Aggregate Angularity, Flat and Elongated FOP for (AASHTO T 2, R 76, T 176, ASTM D 4791), AASHTO T 304</td>
<td>5,600 CY/8,000 tons</td>
</tr>
<tr>
<td>405</td>
<td>Plant Mix Aggregate at Cold Feed</td>
<td>Gradation, SE, Fracture FOP for (AASHTO T 2, R 76, T 11, T 27, T 176, T 335)</td>
<td>15,000 tons</td>
</tr>
<tr>
<td>406/407</td>
<td>Road Mix /Scrub Coat Aggregate</td>
<td>FOP for (AASHTO T 2, R 76, T 11, T 27, T 176, T 335)</td>
<td>14,000 CY/20,000 tons</td>
</tr>
</tbody>
</table>
### 380.00 Minimum Frequency for IA Evaluations (split samples) (Continued)

<table>
<thead>
<tr>
<th>Bid Schedule Item No.</th>
<th>Item Description</th>
<th>Tests (including sampling &amp; splitting)</th>
<th>Frequency Of IA Duplicate Tests Recommended To Test Within The First Five (5) Days</th>
</tr>
</thead>
<tbody>
<tr>
<td>409</td>
<td>PCC Pavement Aggregate</td>
<td>Gradation, (course and fine plus SE on fine)</td>
<td>13,400 CY</td>
</tr>
<tr>
<td></td>
<td></td>
<td>FOP for (AASHTO T 2, R 76, T 11, T 27, T 176)</td>
<td></td>
</tr>
<tr>
<td></td>
<td></td>
<td>Field tests**</td>
<td></td>
</tr>
<tr>
<td>409</td>
<td>PCC Production</td>
<td>FOP for (WAQTC TM 2, AASHTO T 119, T 152, T 309, T 121)</td>
<td>6,000 CY</td>
</tr>
<tr>
<td>502, 506, 510</td>
<td>Concrete (Production) Aggregate</td>
<td>Gradation, (course and fine plus SE on fine)</td>
<td>6,000 CY</td>
</tr>
<tr>
<td></td>
<td></td>
<td>FOP for (AASHTO T 2, R 76, T 11, T 27, T 176)</td>
<td></td>
</tr>
<tr>
<td></td>
<td></td>
<td>Field Tests**</td>
<td></td>
</tr>
<tr>
<td>502, 506, 510</td>
<td>Concrete (Production)</td>
<td>FOP for (WAQTC TM 2, AASHTO T 119, T 152, T 309, T 121)</td>
<td>2,000 CY</td>
</tr>
<tr>
<td>635</td>
<td>Anti-skid</td>
<td>Gradation, (course and fine)</td>
<td>20,000 Tons</td>
</tr>
<tr>
<td></td>
<td></td>
<td>FOP for (AASHTO T 2, R 76, T 11, T 27)</td>
<td></td>
</tr>
</tbody>
</table>

**Field tests: Air, slump, temperature, and unit weight.
### 380.00.2 Minimum Frequency for IA Evaluations by Observation

<table>
<thead>
<tr>
<th>Bid Schedule Item No.</th>
<th>Item Description</th>
<th>Tests Evaluated</th>
<th>Frequency Of IA Observation Evaluations - * Recommended To Observe Within The First Five (5) Days</th>
</tr>
</thead>
<tbody>
<tr>
<td>205</td>
<td>Excavation, Borrow, Granular Borrow</td>
<td>Development of Density Standard &amp; In-place Density FOP for (AASHTO T 99, T 180, T 272, T 310, R 75)</td>
<td>Every 90 days /One (1) per project</td>
</tr>
<tr>
<td>210</td>
<td>Compacting Backfill for structure, retaining wall, or pipe backfill</td>
<td>Development of Density Standard &amp; In-place Density FOP for (AASHTO T 99, T 180, T 272, T 310, R 75)</td>
<td>Every 90 days /One (1) per project</td>
</tr>
<tr>
<td>301</td>
<td>Granular Subbase</td>
<td>Development of Density Standard &amp; In-place Density FOP for (AASHTO T 180, T 272, T 310, R 75 Idaho IT 74)</td>
<td>Every 90 days /One (1) per project</td>
</tr>
<tr>
<td>302</td>
<td>Emulsified Treated Base</td>
<td>Development of Density Standard &amp; In-place Density FOP for (AASHTO T 180, T 272, T 310, R 75 Idaho IT 74)</td>
<td>Every 90 days /One (1) per project</td>
</tr>
<tr>
<td>303</td>
<td>Aggregate for Base</td>
<td>Development of Density Standard &amp; In-place Density FOP for (AASHTO T 180, T 272, T 310, R 75 Idaho IT 74)</td>
<td>Every 90 days /One (1) per project</td>
</tr>
<tr>
<td>403 / 404</td>
<td>Emulsified Asphalt</td>
<td>Development of Density Standard &amp; In-place Density FOP for (AASHTO T 180, T 272, T 310, R 75 Idaho IT 74)</td>
<td>Every 90 days /One (1) per project</td>
</tr>
<tr>
<td>405</td>
<td>SuperPave HMA Aggregate @ Cold Feed (Acceptance Test Strip)</td>
<td>Fracture (AASHTO T 335)</td>
<td>Every 90 days /One (1) per project</td>
</tr>
<tr>
<td>405</td>
<td>SuperPave HMA Acceptance Test Strip</td>
<td>Fracture (AASHTO T 335)</td>
<td>Every 90 days /One (1) per project</td>
</tr>
<tr>
<td>405</td>
<td>SuperPave HMA Acceptance Test Strip</td>
<td>Sampling Loose Mix, Asphalt Content by Ignition Method,</td>
<td>Every 90 days /One (1) per project</td>
</tr>
<tr>
<td>405</td>
<td>SuperPave HMA Pavement</td>
<td>Gradation, G_mn, G_mb, Moisture FOP for (AASHTO T 30, T 168, T 308, R 47, T 329, T 166 Method C/A) AASHTOT 269</td>
<td>Every 90 days /One (1) per project</td>
</tr>
<tr>
<td>405</td>
<td>SuperPave HMA Pavement</td>
<td>Gradation, G_mn, G_mb, Moisture FOP for (AASHTO T 30, T 168, T 308, R 47, T 329, T 312, T 209)</td>
<td>Every 90 days /One (1) per project</td>
</tr>
<tr>
<td>405</td>
<td>SuperPave HMA Pavement</td>
<td>Density (percent compaction) (Fop for AASHTO T 355)</td>
<td>Every 90 days /One (1) per project</td>
</tr>
<tr>
<td>405</td>
<td>Asphalt Binder</td>
<td>Presence of Anti-Strip Additive (Idaho IT-99)</td>
<td>Every 90 days /One (1) per project</td>
</tr>
<tr>
<td>409 &amp; 502</td>
<td>Concrete Production</td>
<td>Making cylinders (Fop for AASHTO T 23)</td>
<td>Every 90 days /One (1) per project</td>
</tr>
<tr>
<td>409 &amp; 502</td>
<td>Concrete Production</td>
<td>Making cylinders (Fop for AASHTO T 23)</td>
<td>Every 90 days /One (1) per project</td>
</tr>
<tr>
<td>506 &amp; 510</td>
<td>Concrete Production</td>
<td>Making cylinders (Fop for AASHTO T 23)</td>
<td>Every 90 days /One (1) per project</td>
</tr>
</tbody>
</table>

* Refer to Section 330.02 for use of 90-day rule for IA evaluations by observation.
SECTION 390.00 – ACCEPTABLE VARIATIONS IN SPLIT TEST RESULTS. Allowable variations described in Section 390.01 and Section 390.02 applies to the following:

Properly sampled and split material for testing conducted at the same time on the same material.

These variations do not provide for material variations that occur when separate samples are taken some time apart. Variations that exceed the listed duplicate test variations are to be brought to the attention of the Resident Engineer immediately.

THESE VARIATIONS ARE NOT TO BE CONSIDERED ALLOWABLE TOLERANCES TO ACCEPT MATERIALS OUTSIDE SPECIFICATION LIMITS.

390.01 Aggregate. The difference between the split samples should not exceed the gradation variations listed in Table 390.01.1 and the test variations in Table 390.01.2.
### Table 390.01.1: Allowable Aggregate Sample Gradation Variations

<table>
<thead>
<tr>
<th>Material</th>
<th>1&quot; or larger 3/4&quot;</th>
<th>1/2&quot; 3/8&quot;</th>
<th>No. 4</th>
<th>No. 8 No. 16</th>
<th>No. 30</th>
<th>No. 50 No. 100</th>
<th>No.200</th>
</tr>
</thead>
<tbody>
<tr>
<td>Coarse Concrete Aggregate</td>
<td>8%</td>
<td>6%</td>
<td>5%</td>
<td>3%</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Fine Concrete Aggregate</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>3%</td>
<td>3%</td>
<td>2%</td>
</tr>
<tr>
<td>Treated, Untreated Base and Road Mix Surfacing</td>
<td>8%</td>
<td>6%</td>
<td>5%</td>
<td>3%</td>
<td>3%</td>
<td>3%</td>
<td>2%</td>
</tr>
<tr>
<td>Plant Mix Aggregate</td>
<td>8%</td>
<td>6%</td>
<td>5%</td>
<td>3%</td>
<td>3%</td>
<td>3%</td>
<td>2%</td>
</tr>
<tr>
<td>Granular Subbase &amp; Rock Cap</td>
<td>8%</td>
<td></td>
<td>5%</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Cover Coat Material</td>
<td></td>
<td>6%</td>
<td>5%</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Anti-Skid Material</td>
<td>6%</td>
<td>5%</td>
<td></td>
<td>3%</td>
<td>3%</td>
<td>3%</td>
<td></td>
</tr>
</tbody>
</table>

### Table 390.01.2: Allowable Aggregate Sample Test Variations

<table>
<thead>
<tr>
<th>Test</th>
<th>Allowable Variation</th>
</tr>
</thead>
<tbody>
<tr>
<td>Sand Equivalent</td>
<td>8</td>
</tr>
<tr>
<td>Cleanness Value</td>
<td>6</td>
</tr>
<tr>
<td>Fracture Count</td>
<td>5%</td>
</tr>
<tr>
<td>Flat &amp; Elongated</td>
<td>2%</td>
</tr>
<tr>
<td>Fine Aggregate Angularity</td>
<td>1%</td>
</tr>
</tbody>
</table>
390.02 Concrete. When split sample tests on a single sample of concrete are taken, the results should not vary more than shown in Table 390.02.1.

Table 390.02.1: Split Sample Test Variation

<table>
<thead>
<tr>
<th>Test</th>
<th>Allowable Variation</th>
</tr>
</thead>
<tbody>
<tr>
<td>Air Content</td>
<td>0.5%</td>
</tr>
<tr>
<td>Slump</td>
<td>3/4&quot;</td>
</tr>
<tr>
<td>Density for Yield</td>
<td>1.0 lb/ft.³</td>
</tr>
<tr>
<td>Temperature</td>
<td>2°F</td>
</tr>
</tbody>
</table>
SECTION 400.00 – PROJECT MATERIALS CERTIFICATION

400.01 Materials Certification Submittal Requirements by Project Type.

SECTION 410.00 – REPORTS AND DOCUMENTATION.

410.01 Materials Acceptance Plan (MAP) or ITD-862 Sampling Schedule.

410.02 Checking Test Reports and Documents.

SECTION 420.00 – MATERIALS SUMMARY REPORT.

SECTION 425.00 – COMPLETING THE MSR.

SECTION 430.00 – RESIDENT ENGINEER’S LETTER OF INSPECTION (ITD-854).

SECTION 440.00 – INDEPENDENT ASSURANCE TEST LOG (ITD-860).

SECTION 450.00 – MATERIALS CERTIFICATION CHECKLIST (ITD-852).

SECTION 460.00 – DISTRICT AUDIT OF MATERIALS SUMMARY REPORT.

460.10 District Audit of GARVEE and Consultant CE&I projects.

SECTION 470.00 – MATERIALS CERTIFICATION LETTER.

470.01 Exceptions.

470.02 Materials Certification Letter Example (Non-Full Oversight Project Example)

470.03 Materials Certification Letter Example (Full Oversight Project)
SECTION 400.00 – PROJECT MATERIALS CERTIFICATION

The Department has implemented procedures in accordance with State and Federal regulations for ensuring the materials incorporated into highway projects meet the required contract specifications.

400.01 Materials Certification Submittal Requirements by Project Type. The following documents are used for project materials certification to demonstrate that the materials incorporated into the project meet the required contract specifications:

- Materials Certification Letter (See Section 470.00)
- Materials Summary Report, (MSR) (See Section 420.00)
- ITD-852 Materials Certification Checklist (See Section 450.00)
- ITD-854 Resident Engineer’s Letter of Inspection (See Section 430.00)
- ITD-860 Independent Assurance Test Log (See Section 440.00)

Instructions for the above documents are detailed in the indicated Sections.

Table 400.01.1 lists the documents that are required for project materials certification based on funding and project type as shown on the table. The District Engineer’s Final Letter of Acceptance is used to document project materials certification for projects not requiring a Materials Summary Report and Materials Certification Letter.

For all projects, adequate records to document proper testing and inspection are required and must be maintained in the project files.
Table 400.01.1. Project Materials Certification Requirements

<table>
<thead>
<tr>
<th>Type of Project</th>
<th>Are there materials incorporated in the project?</th>
<th>HQ Submittal Materials</th>
<th>Materials Certification Letter and Materials Summary Report (including IA Log &amp; RE Letter)</th>
<th>District Engineer Final Letter of Acceptance</th>
</tr>
</thead>
<tbody>
<tr>
<td>Federal-Aid On State Highway System</td>
<td>Yes</td>
<td>Yes</td>
<td>Yes</td>
<td>Yes</td>
</tr>
<tr>
<td></td>
<td>No</td>
<td>Yes</td>
<td>No</td>
<td>Yes</td>
</tr>
<tr>
<td>Federal-Local On-System No State Funds</td>
<td>Yes</td>
<td>Yes</td>
<td>Yes</td>
<td>Yes</td>
</tr>
<tr>
<td></td>
<td>No</td>
<td>Yes</td>
<td>No</td>
<td>Yes</td>
</tr>
<tr>
<td>Federal-Local Off-System No State Funds</td>
<td>Yes</td>
<td>Yes</td>
<td>Yes</td>
<td>Yes</td>
</tr>
<tr>
<td>Federal-Aid Limit $500k or more</td>
<td>No</td>
<td>Yes</td>
<td>No</td>
<td>Yes</td>
</tr>
<tr>
<td>Federal-Local Off-System No State Funds</td>
<td>Yes</td>
<td>Yes</td>
<td>No</td>
<td>Yes</td>
</tr>
<tr>
<td>Federal-Aid Limit less than $500k</td>
<td>No</td>
<td>Yes</td>
<td>No</td>
<td>Yes</td>
</tr>
<tr>
<td>State-funded on NHS</td>
<td>Yes</td>
<td>Yes</td>
<td>Yes</td>
<td>Yes</td>
</tr>
<tr>
<td></td>
<td>No</td>
<td>Yes</td>
<td>No</td>
<td>Yes</td>
</tr>
<tr>
<td>State-funded off NHS</td>
<td>Yes</td>
<td>Yes</td>
<td>Yes</td>
<td>Yes</td>
</tr>
<tr>
<td></td>
<td>No</td>
<td>Yes</td>
<td>No</td>
<td>Yes</td>
</tr>
</tbody>
</table>
SECTION 410.00 – REPORTS AND DOCUMENTATION. All field test reports, laboratory test reports, certifications, and other miscellaneous reports involving inspection, testing, and acceptance of materials, are a part of the documentation of project records. These reports are considered a permanent record and are to be preserved with other permanent records such as survey notes, quantity measurements, etc. These records form the basis for certifying compliance with specification requirements of the contract to State auditors and the Federal Highway Administration for the materials used in construction.

The project files must sufficiently document that the acceptance of material was performed in accordance with the minimum testing requirements and the contract specifications. Specific instructions for each test report form are to be followed with the understanding that complete documentation is required for each contract. Any reports or records that apply from another contract must be duplicated. There must be no doubt of the validity of the record applying to the pertinent project. Required materials documentation must be in the item files. If the same material is used for another item, an additional copy must be added in the project item file. Add posting in the MSR for each item.

410.01 Materials Acceptance Plan (MAP) or ITD-862 Sampling Schedule. Project personnel must plan ahead using the minimum testing requirements (MTRs) and the contract specifications to determine the requirements for acceptance of all bid items and change orders. Each district must develop a project Materials Acceptance Plan (MAP) or ITD-862 Sampling Schedule for reference by the project personnel before construction and update during construction.

The development of the MAP or Sampling Schedule should be a joint effort by District Materials and project personnel. The final MAP must summarize the acceptance requirements for all items including any small quantities (see Section 270.04), items using nonstandard acceptance (see Section 270.05), or special provision items (see Section 270.06). The final MAP should be reviewed and signed by the Resident Engineer and the District Materials Engineer. When requested by the District, HQ Construction /Materials will review and provide comment on the MAP for non-standard special provision items.

410.02 Checking Test Reports and Documents. Laboratory tests, field tests, and certification reports are forwarded to the Resident Engineer whose staff regularly checks the reports so that deviations from specifications and poor documentation are mitigated. It is required that the person checking test reports have ITD STQP qualification for the test being checked or an Idaho PE license (see Section 210.01). Any discrepancies, lack of information, or incompleteness of the reports must be corrected without delay. After the checks are made, the reports are recorded for the Materials Summary Report (see Section 425.00 for directions) and placed in the project files. Any items receiving less than the minimum requirements of sampling and testing and/or varying from specifications must have the corrective action or remedy efforts explained by the Resident Engineer. The explanation must include the justification for acceptance, rejection, or price adjustment of noncompliant material. The explanation is recorded and noted for the Materials Summary Report.
SECTION 420.00 – MATERIALS SUMMARY REPORT. The Materials Summary Report (MSR) shows the basis for acceptance of all bid items and change orders of the contract as required by the minimum test requirements (MTRs) and contract specifications and includes:

- Acceptance test results.
- Manufacturer's certifications.
- Laboratory acceptance and verification test results.
- Notes to explain the resolution for any failing test results or lack of minimum testing.
- Notes to explain the basis for accepting any material not tested or not certified according to the minimum testing requirements or contract specifications.

The MSR is compiled for each construction contract as indicated in Table 401.00.1 by posting all of the field and laboratory test reports and manufacturer's certifications into the electronic Materials Summary Program. Post data daily to ensure current reporting. Post all test reports as soon as possible after they are received and checked. It is good practice to maintain the MSR so that it is contemporaneous with the most current pay estimate.

See Section 425.00 for the required postings for the MSR.

The MSR must be printed after each pay estimate and kept in a binder or file folder for easy access.

Adequate documentation of failures and/or deviations from specification requirements must be included in the MSR to justify acceptance, rejection, or price adjustment of contract items. Section 215.00 contains details about documentation for non-compliant material.
SECTION 425.00 – COMPLETING THE MSR. The following guidelines are provided for use in typical project situations to accurately complete a project Materials Summary Report (MSR).

The acceptance documents are posted in the MSR under the contract item where the material was paid for. When material is incidental to a contract item, the posting must be shown under the associated contract item.

- The posting must be done using the electronic Materials Acceptance Program.
- Every contract item, including change orders, where there was material used on the project must be included in the MSR.
- Some contract items will have multiple postings in the MSR because there is more than one acceptance requirement as shown in the MTR tables.
- The postings of test result data for items that require statistical analysis (QASP items) must be checked for accuracy by someone other than the person who posted the data.
- Accepted material on ITD-0854 Resident Engineer’s Letter of Inspection of Contract Items must have the required material documentation in the project item file.
- Required materials documentation must be in the item files. If the same material is used for another item, an additional copy must be added in the project item file. Add posting in the MSR for each item.
- Documentation (such as a printout of the QPL page showing approval of the item) must be placed in the project files and posted in the MSR for QPL items that were on ITD’s QPL at the time of the project.
- Documentation of individual sign components (aluminum sheet, reflective coating, etc.) must be listed separately on the ITD-0851 Manufacturer’s Material Certification form.
- Documentation of all steel and iron products must be in compliance with Section 230.03.03.
- ITD-0858 Materials Summary for District IA Audits showing deficiency findings must not be deleted from its record. All resolutions and final determinations must be on the ITD-0858 form for all deficiencies initially found by the District IA.
- All MSR information must be present or documented in the project file
- HQ handles the review and documentation of items such as pre-stressed girders. But the district must review the packets sent from HQ and document them in the MSR like all other project items.
- File memos must present a clear and complete picture of what occurred and how project specifications were met. These explanations must be clear to an individual not associated with the project.
- F&t failures must be addressed in documentation in project item files.
• HMA lot quantities must be based on work shift totals as defined in the QASP.
• Independent assurance testing must be done in the district and documented in the project files.
• Non-standard items must be identified on ITD-0862 form.
• Quality Control, Acceptance, and verification samples must not be collected at the same location. They must be taken independent of one another.
• Document compaction effort (such as bridge abutments, back fill, embankment, etc.) for each lift on the ITD-0850 form. All pertinent information must be filled out completely.
• Records of FOP for AASHTO T 27 must be documented when using “Too Granular to Test” per lift on the ITD-0850 form. Granular Borrow must have the Sand Equivalent test done for ITD-0850 form.

Use Table 425.00.1 to determine the minimum information required in the MSR. Find the contract bid item in the Section 270.00 MTR tables of the Quality Assurance Manual, and then use the MTR tables to identify the type of acceptance requirements. Then, find the type of acceptance in the left column of the table below and provide the required information in the MSR as is described in the corresponding right hand column.

Note: The Acceptance Test Strip is required to be shown on the MSR; post both passing and failing test strips and the disposition of the failing test strip(s). The smoothness results are not required on the MSR.
Table 425.00.1: Minimum Information Required in MSR

<table>
<thead>
<tr>
<th>Acceptance Type from MTR Tables</th>
<th>Postings Required in the MSR</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Statistical Analysis</strong> (QA Special Provisions)</td>
<td>Results of Bonus Summary Report showing the pay factor for each lot</td>
</tr>
<tr>
<td></td>
<td>Remarks explaining actions taken when any lot falls below .85 or below .75</td>
</tr>
<tr>
<td></td>
<td>Copy of F&amp;T report for each day of production testing</td>
</tr>
<tr>
<td></td>
<td>Remarks to indicate evaluation procedures taken when there is a t test failure</td>
</tr>
<tr>
<td><strong>Field Tests</strong> (other than statistical analysis)</td>
<td>Date sampled</td>
</tr>
<tr>
<td></td>
<td>Test number</td>
</tr>
<tr>
<td></td>
<td>Indication of pass or fail test results</td>
</tr>
<tr>
<td></td>
<td>A remark indicating the location of the in-place density test for pipe or structure backfill</td>
</tr>
<tr>
<td></td>
<td>Remarks to indicate tests that are considered check tests for failing tests</td>
</tr>
<tr>
<td></td>
<td>Remarks to indicate the corrective action taken for a failing test</td>
</tr>
<tr>
<td></td>
<td>Remarks to indicate acceptance when testing is not performed, such as, too granular to test</td>
</tr>
<tr>
<td><strong>Manufacturer’s or Fabricator’s Certification</strong></td>
<td>Date certification statement signed</td>
</tr>
<tr>
<td></td>
<td>Quantity of material certified</td>
</tr>
<tr>
<td></td>
<td>Manufacturer or fabricator company signing certification</td>
</tr>
<tr>
<td><strong>Laboratory Verification Tests</strong></td>
<td>Date sampled</td>
</tr>
<tr>
<td></td>
<td>Sample number</td>
</tr>
<tr>
<td></td>
<td>Laboratory number</td>
</tr>
<tr>
<td></td>
<td>Indication of pass or fail test results</td>
</tr>
<tr>
<td></td>
<td>Remarks to indicate corrective action or price adjustment for a failing test</td>
</tr>
<tr>
<td><strong>Laboratory Acceptance Tests</strong></td>
<td>Date sampled</td>
</tr>
<tr>
<td></td>
<td>Sample number</td>
</tr>
<tr>
<td></td>
<td>Laboratory number</td>
</tr>
<tr>
<td></td>
<td>Indication of pass or fail test results</td>
</tr>
<tr>
<td></td>
<td>Remarks to indicate corrective action or price adjustment for a failing test</td>
</tr>
<tr>
<td><strong>Pre-Tested or Pre-Approved Tests (Approved Lists)</strong></td>
<td>Remarks to indicate the material/product used on the project is included on the approved list maintained by HQ Materials Section</td>
</tr>
<tr>
<td><strong>Acceptance by Inspection</strong></td>
<td>Item will be shown on the ITD-854, Resident Engineer’s Letter of Inspection</td>
</tr>
<tr>
<td><strong>Small Quantity or Non-Standard Acceptance</strong> (see Section 270.04 &amp; 270.05)</td>
<td>Remarks to summarize the basis of acceptance including the following where applicable:</td>
</tr>
<tr>
<td></td>
<td>• Remarks to indicate aggregates obtained from approved materials source</td>
</tr>
<tr>
<td></td>
<td>• Remarks to indicate mix design approval for plant mix or concrete</td>
</tr>
<tr>
<td></td>
<td>• Post core test results for plant mix paving on mainlines or intersections</td>
</tr>
<tr>
<td></td>
<td>• Remarks to indicate visual inspection during installation, placement or compaction</td>
</tr>
</tbody>
</table>

1 (field tests are: in-place density, gradation, sand equivalent, fracture count, cleanliness value, field saybolt viscosity, presence of anti-strip additive, asphalt content of plant mix, plant mix test strip, air/slump/temperature/unit weight of concrete)
<table>
<thead>
<tr>
<th>Acceptance Type from MTR Tables</th>
<th>Postings Required in the MSR</th>
</tr>
</thead>
</table>
| Special Provisions (see Section 270.06) | Post acceptance information as indicated in the special provision OR as indicated below if not specified in the special provision.  
When material is included in MTR table and used in a standard application, find MTR acceptance type above and post the same information  
When special provision indicates the material must meet a given specification, such as AASHTO or ASTM: Post same information shown above for manufacturer’s certification.  
When material is not included in MTR tables or not used in standard application: Remarks to summarize basis of acceptance as determined by the Engineer and District Materials Engineer. |
| Change Orders (see Section 270.07) | Post acceptance information as indicated in the change order OR as indicated below if not specified in the change order.  
For standard pay items or when material is included in MTR tables and used in a standard application, find MTR acceptance type above and post the same information  
When change order indicates the material must meet a given specification, such as AASHTO or ASTM: Post same information shown above for manufacturer certification.  
When material is not included in MTR tables or not used in standard application: Remarks to summarize basis of acceptance as determined by the Engineer and District Materials Engineer. |
SECTION 430.00 – RESIDENT ENGINEER’S LETTER OF INSPECTION (ITD-854). The purpose of the Resident Engineer's Letter of Inspection (ITD-854) is for the Resident Engineer to document the inspection of certain materials and to document the materials are acceptable according to the plans and specifications. The form should not be used as a catchall for items usually accepted by sampling and testing. Inclusion on the form does not excuse the inspector from sampling and testing or obtaining manufacturer certifications as required by the Minimum Testing Requirements. A copy of the completed Resident Engineer’s letter must be submitted with the MSR at the completion of the project. The required material documentation must be added to the project item file. See Section 250.00 for complete information on the Resident Engineer’s Letter of Inspection.
SECTION 440.00 – INDEPENDENT ASSURANCE TEST LOG (ITD-860). Independent Assurance tests are not posted in the Materials Summary Report, but are recorded on the IA Test Log (form ITD-860) by the Department project personnel. A copy of the complete IA test log must be submitted with the MSR at the completion of the project. See Section 370.00 for information on completion of the IA Test Log.
SECTION 450.00 – MATERIALS CERTIFICATION CHECKLIST (ITD-852). Resident Engineer’s office prepares the ITD-852 Materials Certification Checklist by completing each checkbox shown on the form. Explanations must be included in the “Remarks” field for any items checked “No.” Known exceptions to the materials acceptance requirements for the project must be identified on the form. Once complete, the checklist is provided to the Resident Engineer and Engineering Manager for review and signature. For projects not requiring a Materials Summary Report, per Table 401.00.1, check the appropriate box to indicate no Materials Summary Report is required and complete the remainder of the form as applicable for the project.
SECTION 460.00 – DISTRICT AUDIT OF MATERIALS SUMMARY REPORT. The District will perform an independent assurance audit of the Materials Summary Report (MSR) for all projects. Independent Assurance audits must be performed by individuals who are:

1) Currently qualified in all WAQTC modules along with the Concrete Laboratory Testing Technician (CLTT)

2) Independent of both the project, other construction projects, and the residency

3) Deemed by the District Engineer as knowledgeable in the preparation and review of Materials Summary Reports.

The audit must be done periodically as the project progresses. The most current pay estimate must be used as a guide to determine that material paid for was accepted in accordance with the contract requirements. Any deviations or exceptions found during the audit must be resolved to the satisfaction of the District Materials Engineer or the District Engineer before issuance of the Materials Certification Letter.

- District audit of MSR report must be completed using the ITD-858 form.

- The District Materials Engineer or the District Engineer will review this MSR audit, make final resolution, and then sign the ITD-858 form.

- A close-out should be held with Department project personnel to discuss any deviations found and to obtain a resolution statement. See Section 360.03 of this manual.

- A copy of the completed ITD-858 must be included in the project files. Any ITD-0858 forms with deficiency findings must not be deleted from record. All resolutions and final determinations must be on the ITD-0858 form for all deficiencies initially found by the District IA.

460.10 District Audit of GARVEE and Consultant CE&I projects. The GARVEE and Consultant CE&I projects have an assigned Department Resident Engineer. The individual assigned to audit the records will contact the assigned Resident Engineer to make arrangements for the on-site review of the project materials records.
SECTION 470.00 – MATERIALS CERTIFICATION LETTER. When the MSR and associated documentation is considered acceptable, the District will prepare the Materials Certification Letter using the inter-department memo (ITD-500) addressed to the Construction/Materials Engineer (see Example 470.02 at the end of this section) for the District’s Engineer signature. The Materials Certification Letter is prepared and submitted to the District Engineer along with a copy of ITD-860, ITD-852, ITD-854, and the Materials Summary Report for review, signature, and distribution.

The Materials Certification Letter must contain the following statement (per 23 CFR 637):

This is to certify that:

The results of the tests used in the acceptance program indicate that the materials incorporated in the construction work, and the construction operations controlled by sampling and testing, were in conformity with the approved plans and specifications. All independent assurance samples and tests are within tolerance limits of the samples and tests that are used in the acceptance program.

Explanations for exceptions to the plans and specifications are as follows:

The Materials Certification Letter must list, by contract item, any exceptions and how they were resolved, which includes an explanation for justification of acceptance of the contract item. See Example 470.02 at the end of this section.

For Federal-aid projects of interest, the FHWA will review the below listed items in order to concur in the Materials Certification.

1. District Engineer Materials Certification Letter.
2. ITD-0858 Materials Summary Report District IA Audit.
3. Final Estimate.
4. ITD-0852 Materials Certification Checklist.
5. ITD-0854 Resident Engineer’s letter of Inspection of Contract Items.
6. ITD-0860 Independent Assurance Log.
7. Materials Summary report for any contract pay items that has exceptions to the contract specifications or plans including the following notes:
   a. Notes to explain the resolution for any failing test results or lack of minimum testing.
   b. Notes to explain the basis for accepting any material not tested or not certified according to the minimum testing requirements or contract specifications.
Submit these documents (via cc) to the FHWA for review and approval. Upon review and approval; submit final non-participation determinations to the Department’s Financial Services. See Example 470.03 at the end of this section.

**470.01 Exceptions.** An exception is considered any instance where non-specification material is identified, the non-specification material is allowed to remain, and corrective action was required. A failing test with an immediate passing check test is not considered non-specification material. Corrective action is remedial methods, such as price adjustments or contractor repair work.

When there are indications of acceptance of non-specification material in the materials summary report, then the corrective action taken must be included in the summary remarks and in the certification letter. For QA Special Provision contract items, non-specification material is a lot where the pay factor for any quality characteristic is below 0.75 and the material was allowed to remain.

An exception is also when contract specifications and/or minimum testing requirements were not met. This may be lack of acceptance testing, lack of IA testing, or lack of manufacturer’s certifications. It is usually not possible to remedy or justify these exceptions, especially if not discovered until the project is complete. A full explanation of the circumstances is necessary to ascertain the consequences of the deviation from the specifications, including the quantities accepted without the required testing or certifications. In some cases, material quantities may not be eligible for Federal-aid participation. The District will determine non-participation using the current memorandum of understanding between the Department and the Federal Highway Administration Idaho Division Office.

Exceptions must be listed by contract item number on the Materials Certification Letter as follows:

- Number of tests representing non-specification material out of the total number of tests performed. This includes remarks for justification that allowed material to remain in place.
- Total number of tests performed and number of tests required by the minimum testing requirements when the number of tests performed is less than the required minimum, including lack of or failure to perform Independent Assurance testing.
- Lack of required manufacturer’s certifications covering the quantity of material paid for.
- QA Special Provision item where the pay factor was less than 0.75 and a description of action taken.
- QA Special Provision item where test failed and there is no indication an evaluation was made.
- Price adjustment, if applied, or justification for acceptance or rejection of material with failing laboratory test.

The items ineligible for Federal-aid participation including the dollar amount must be shown on the Materials Certification Letter.

Exceptions to the Buy America specification must be presented to FHWA for a determination of a resolution, see Section 230.03.03 Buy America.
470.02 Materials Certification Letter Example (Non-Full Oversight Project Example)

IDAHO TRANSPORTATION DEPARTMENT

Department Memorandum

DATE: PROJECT NO.(S):

TO: NAME

CONSTRUCTION/MATERIALS ENGINEER

FROM: NAME:

DISTRICT ___ ENGINEER

RE: MATERIALS CERTIFICATION LETTER (NON-FULL OVERSIGHT PROJECT)

This is to certify that:

The results of the tests used in the acceptance program indicate that the materials incorporated in the construction work, and the construction operations controlled by sampling and testing, were in conformity with the approved plans and specifications. All independent assurance samples and tests are within tolerance limits of the samples and tests that are used in the acceptance program.

Explanations for exceptions to the plans and specifications are as follows:

303-005A 3/4 in. Aggregate Base: Lot #3 had a pay factor of .74 and was removed and replaced by the contractor. 405-025A PL MX PAV CL SP 3: Acceptance Test Strip #1 failed and was paid at 50%.
602-035A 18-in. Pipe Culvert: There are no required manufacturer’s certifications for 500 feet of pipe.
640 Subgrade Geotextile: No required laboratory verification tests were performed. The item was accepted by manufacturer’s certification.
S501-010 MSE Retaining Wall: The Department laboratory test was failing for cement and a price adjustment of 25% was applied.

The original of the Materials Summary Report, correspondence, manufacturer’s certifications, and test reports are on file in the project records.

CC:

DE ___
District ___ Engineering Manager
DMTL w/attach
RE (original attach)
DRI (w/attach)
C/M Engineer (w/attach)
Financial Services
IDAHO TRANSPORTATION DEPARTMENT

Department Memorandum

DATE: PROJECT NO.(S):

TO: NAME

CONSTRUCTION/MATERIALS ENGINEER

FROM: NAME:

DISTRICT ___ ENGINEER

RE: MATERIALS CERTIFICATION LETTER (FULL OVERSIGHT PROJECT)

This is to certify that:

The results of the tests used in the acceptance program indicate that the materials incorporated in the construction work, and the construction operations controlled by sampling and testing, were in conformity with the approved plans and specifications. All independent assurance samples and tests are within tolerance limits of the samples and tests that are used in the acceptance program.

Explanations for exceptions to the plans and specifications are as follows:

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The original of the Materials Summary Report, correspondence, manufacturer’s certifications, and test reports are on file in the project records.

CC:

DE ___
District ___ Engineering Manager
DMTL w/attach
RE (original attach)
DRI (w/attach)
C/M Engineer (w/attach)
FHWA (w/attachment)
SECTION 500.00 – STANDARD METHODS & PRACTICES

IDAHO STANDARD PRACTICE (IR),

IDAHO STANDARD METHOD OF TEST (IT)

SECTION 510.00 - AGGREGATES

IT-13-17  Measuring Mortar-Making Properties of Fine Aggregate
IT-15-04  Idaho Degradation
IT-72-17  Evaluating Cleanness of Cover Coat Material
IT-74-98  Vibratory Spring-Load Compaction for Coarse Granular Material
IT-116-13 Disintegration of Quarry Aggregates (Ethylene Glycol)
IR-142-06 Investigation of Aggregate and Borrow Deposits
IT-144-08 Specific Gravity and Absorption of Fine Aggregate Using Automatic Vacuum Sealing (CoreLok) Method

SECTION 520.00 - BITUMINOUS MATERIALS

IT-61-08  Sampling and Viscosity Testing Emulsified Asphalt Binders in the Field
IR-63-08  Design of Seal Coats and Single Surface Treatments by the McLeod Method
IT-99-17  Detection of Anti-Striping Additive in Asphalt
IR-125-16 Acceptance Test Strip for Hot Mix Asphalt (HMA)
IT-137-17 Effectiveness of Anti-Strip Agents After Hot Storage in Asphalt Binder Using Bottle and Sand
IT-146-16 Determination of Reclaimed Asphalt Pavement (Rap) Aggregate Bulk (Dry) Specific Gravity ($G_{bb}$)
SECTION 530.00 – CONCRETE

IR-128-17 Sampling Concrete for Chloride Analysis
IT-131-17 Total Chloride Content of Hardened Concrete by Gran Plot Method
IT-133-17 Determination of the Rate of Evaporation of Surface Moisture from Concrete
IT-143-17 Field Sampling of the Hydraulic Cement adn Fly Ash
IT-147-17 Measuring Texture Depth of Portland Cement Concrete Using a Tire Tread Depth gauge

SECTION 540.00 - PAINT

IR-7-04 Inspecting/Sampling Paint and Curing Compound
IT-121-98 Determining Total Solids-Latex Percent

SECTION 550.00 - SOILS

IT-8-17 Resistance R-Value and Expansion Pressure of Compacted Soils and Aggregates
IR-62-17 Taking Undisturbed Soil Samples for Laboratory Consolidation, Shear and Permeability Tests

SECTION 560.00 - MISCELLANEOUS

IR-12-07 Calibrating Torque-Wrenches, Tightening and Testing Bolt Tensions
IR-17-98 Calibrating the Skidmore-Wilhelm Torque-Wrench Calibration Unit
IR-87-99 Pavement Straightedge
IT-120-98 Determining Volume of Liquids in Horizontal or Vertical Storage Tanks
SECTION 570.00 – WAQTC / IDAHO FIELD OPERATING PROCEDURES

SECTION 570.01 - AGGREGATE
1. AASHTO T 2 (16) Sampling of Aggregates
2. AASHTO R 76 (16) Reducing Samples of Aggregates to Testing Size
3. AASHTO T 255 (14) Total Evaporable Moisture Content of Aggregate by Drying
4. AASHTO T 27 (16) & AASHTO T 11 (16) Sieve Analysis of Fine and Coarse Aggregates & Materials Finer Than 75 µm (No. 200) Sieve in Mineral Aggregates by Washing
5. AASHTO T 335 (16) Determining the Percentage of Fracture in Coarse Aggregate
6. AASHTO T 176 (16) Plastic Fines in Graded Aggregates and Soils by Use of the Sand Equivalent Test

SECTION 570.02 – ASPHALT I & II
1. AASHTO T 168 (10) Sampling Bituminous Paving Mixtures
2. AASHTO R 47 (12) Reducing Samples of Hot Mix Asphalt (HMA) to Testing Size
3. AASHTO T 329 (16) Moisture Content of Hot Mix Asphalt (HMA) by Oven Method
4. AASHTO T 308 (16) Determining the Asphalt Binder Content of Hot Mix Asphalt (HMA) by the Ignition Method
5. AASHTO T 30 (16) Mechanical Analysis of Extracted Aggregate
6. AASHTO T 209 (16) Theoretical Maximum Specific Gravity and Density of Hot Mix Asphalt Paving Mixtures
7. AASHTO T 166 (16) Bulk Specific Gravity of Compacted Hot Mix Asphalt using Saturated Surface-Dry Specimens
8. AASHTO R 66 (16) Sampling Asphalt Materials
9. AASHTO T 312 (16) Asphalt Mixture Specimens by Means of the Superpave Gyratory Compactor
10. WAQTC TM 13 (13) Volumetric Properties of Hot Mix Asphalt
11. AASHTO R 67 (15) Sampling Hot Mix Asphalt (HMA) After Compaction (Obtaining Cores)

SEE AASHTO TEST MANUALS
SECTION 570.03 – CONCRETE
1. WAQTC TM 2 (14) Sampling Freshly Mixed Concrete
2. AASHTO T 309 (15) Temperature of Freshly Mixed Portland Cement Concrete
3. AASHTO T 119 (16) Slump of Hydraulic Cement Concrete
4. AASHTO T 121 (16) Density (Unit Weight), Yield, and Air Content (Gravimetric) of Concrete
5. AASHTO T 152 (16) Air Content of Freshly Mixed Concrete by the Pressure Method
6. AASHTO T 23 (15) Method of Making and Curing Concrete Test Specimens in the Field

SECTION 570.04 – EMBANKMENT AND BASE
1. AASHTO T 255 (16) Total Evaporable Moisture Content of Aggregate by Drying & AASHTO T 265 (16) Laboratory Determination of Moisture Content of Soils
2. AASHTO T 99 (15) Moisture-Density Relations of Soils Using a 2.5-kg (5.5-lb) Rammer and 305-mm (12-in.) Drop & AASHTO T 180 (15) Moisture-Density Relations of Soils Using a 4.54-kg (10-lb) Rammer and 457-mm (18-in.) Drop
3. AASHTO R 75 (16) Developing a Family of Curves
4. AASHTO T 85 (16) Specific Gravity and Absorption of Coarse Aggregate

Section 570.05 – IN-PLACE DENSITY
1. AASHTO T 355 (16) In-Place Density of Asphalt Mixtures by Nuclear Methods
2. AASHTO T 310 (15) In-Place Density and Moisture Content of Soil and Soil-Aggregate by Nuclear Methods (Shallow Depth)
3. AASHTO T 255 (16) Total Evaporable Moisture Content of Aggregate by Drying & AASHTO T 265 (16) Laboratory Determination of Moisture Content of Soils
4. AASHTO T 272 (16) One-Point Method for Determining Maximum Dry Density and Optimum Moisture Content
5. FOP CURVES (16) Use of AKDOT & PF ATM-212, ITD T-74, WSDOT TM 606, or WFLHD Humphreys Curves
1. **ASTM D4791**  
   Flat and Elongated Particles in Coarse Aggregate

2. **AASHTO T 304**  
   Uncompacted Void Content Of Fine Aggregate

3. **AASHTO T 343**  
   Density of In-Place Hot Mix Asphalt (HMA) Pavement by Electronic Surface Contact Devices

4. **AASHTO R 64**  
   Standard Practice for Field Sampling and Fabrication of 50-mm (2-in) Cube Specimens using Grout (Non-Shrink) or Mortar

5. **AASHTO T 359**  
   Pavement Thickness by Magnetic Pulse Induction
SECTION 590.00 – IDAHO TRANSPORTATION DEPARTMENT (ITD) SAMPLER / TESTER QUALIFICATION PROGRAM (STQP)

590.10 Individual Test Method Qualifications.

590.10.01 Non-ITD Personnel.
Section 590.00 – Idaho Transportation Department (ITD) Sampler / Tester Qualification Program (STQP)

Information found in this section can also be found in the Laboratory Operations Manual, Section 250.

Qualifications are granted by ITD through the STQP. The purpose of the ITD STQP is for conformance to State and Federal requirements. All individuals shall be qualified who sample or test on ITD projects. Valid sampler / tester qualification for ITD projects is only available through this program.

The ITD STQP includes Six (6) Western Alliance for Quality Transportation Construction (WAQTC) modules, two (2) ITD STQP modules, and nineteen (19) individual test method qualifications.

Details on the five WAQTC and three ITD STQP modules are located in the Registration Policies and Information Hand book (RP &IH) which can be downloaded from the Sampler Tester qualification web page. http://itd.idaho.gov/highways/ops/materials/techqual/techqual.asp. Details on individual test method qualifications are found in Section 590.10.

QUALIFICATION(S) ARE VALID WHEN POSTED ON THE ITD’S WEB PAGE UNDER “INSPECTOR AND SAMPLER / TESTER QUALIFICATION (WAQTC).”

590.10 Individual Test Method Qualifications. Table 590.10.1 below lists the individual test methods that require qualification. Prerequisite Sampler / Tester (WAQTC) qualifications are required before any performance examination can occur. Performance exam documentation (Registration Form, Rights and Responsibilities form, and completed Performance Exam Checklist) shall be submitted to HQ Central Laboratory. The Individual Qualification certificate is form ITD-949 for all test methods.

The following performance exam checklists in Table 590.10.1 at to be used along with the appropriate AASHTO Test and Idaho Test methods.

QUALIFICATION(S) ARE VALID WHEN POSTED ON ITD WEB PAGE UNDER “IDAHO INDIVIDUAL QUALIFICATIONS.”

The individual qualification is valid for five (5) years.

The District Independent Assurance Inspector (I.A.I.) or an I.A.I. assigned ITD qualified person with 5 years experience will provide individual qualifications unless otherwise specified. Performance exam checklist must be used.

590.10.01 Non-ITD Personnel. The Laboratory Manager will notify the ITD representative who qualifies the laboratory or the District I.A.I. which testing personnel will require individual qualification. Notification shall be made a minimum of 14 calendar days in advance.
Table 590.10.1: Individual Test Methods & Performance Exam Check Lists

<table>
<thead>
<tr>
<th>Test Method</th>
<th>Test Reference</th>
<th>Notes For Pre-Qualification</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Aggregates</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Cleanness Value</td>
<td>Idaho IT 72</td>
<td>AgTT Qualification is required.</td>
</tr>
<tr>
<td>Specific Gravity and Absorption of Fine Aggregate</td>
<td>Idaho IT 144</td>
<td>AgTT Qualification is required.</td>
</tr>
<tr>
<td>Bulk Density (&quot;Unit Weight&quot;) and Voids in Aggregate</td>
<td>AASHTO T 19</td>
<td>AgTT Qualification is required.</td>
</tr>
<tr>
<td>Specific Gravity and Absorption of Fine Aggregate</td>
<td>AASHTO T 84</td>
<td>AgTT Qualification is required.</td>
</tr>
<tr>
<td>Uncompacted Void Content Of Fine Aggregate</td>
<td>AASHTO T 304</td>
<td>AgTT Qualification is required.</td>
</tr>
<tr>
<td>Flat and Elongated Particles in Coarse Aggregate</td>
<td>ASTM D4791</td>
<td>AgTT Qualification is required</td>
</tr>
<tr>
<td><strong>Bituminous Materials</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Saybolt Viscosity</td>
<td>Idaho IT 61</td>
<td>AsTT or AsTT II Qualification is required.</td>
</tr>
<tr>
<td>Anti-strip Detection</td>
<td>Idaho IT 99</td>
<td></td>
</tr>
<tr>
<td>Effect of Water on Compressive Strength of Compacted Bituminous Mixtures</td>
<td>ASTM D1075 (Formerly AASHTO T 165)</td>
<td>AsTT or AsTT II Qualification is required. Performance exam administered by HQ Central Laboratory</td>
</tr>
<tr>
<td>Density of In-place HMA Pavement by Electronic Surface Contact Device</td>
<td>AASHTO T 343</td>
<td>AsTT or AsTT II Qualification is required.</td>
</tr>
<tr>
<td>Bulk Specific Gravity and Density of Compacted Hot Mix Asphalt (HMA) using Automatic Vacuum Sealing Method (CoreLok)</td>
<td>AASHTO T 331</td>
<td>AsTT or AsTT II Qualification is required.</td>
</tr>
<tr>
<td>Field Sampling Asphalt Mixtures after Compaction (Obtaining Cores)</td>
<td>AASHTO R 67</td>
<td></td>
</tr>
<tr>
<td><strong>Soils</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Determining the Plastic Limit and Plasticity Index of Soils</td>
<td>AASHTO T 90</td>
<td>EbTT Qualification is required.</td>
</tr>
<tr>
<td>Determining the Liquid Limit of Soils</td>
<td>AASHTO T 89</td>
<td>EbTT Qualification is required.</td>
</tr>
<tr>
<td>Specific Gravity of Soils</td>
<td>AASHTO T 100</td>
<td>EbTT Qualification is required.</td>
</tr>
<tr>
<td><strong>Concrete</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Sampling &amp; Fabrication of 2” Cube Specimens using Grout or Mortar</td>
<td>AASHTO R 64</td>
<td>CTT Qualification is required.</td>
</tr>
</tbody>
</table>
Idaho Standard Practice for

Investigation of Aggregate and Borrow Deposits

IDAHO Designation: IR-142-06

1. SCOPE

1.1. This method sets forth the accepted procedures to be used in investigating sources of sand, gravel and rock for aggregates, borrow, and granular borrow for use in highway construction. It also includes accepted procedures for sampling, testing, and source plan development.

1.2. This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.

2. REFERENCE DOCUMENTS

2.1. Idaho Standards

- ITD Standard Specifications for Highway Construction.
- ITD Materials Manual, Section 270.00, Materials Sources.
- Idaho Code, Sections 54-2081 and 54-2802.

2.2. AASHTO Standards

- T 2, Sampling of Aggregates, Appendix X2

2.3. ASTM Standards


3. TERMINOLOGY

3.1. For the purpose of this test method, the term "Contractor" shall be defined as any individual(s) or company interested in investigating a materials source with the intent of meeting Idaho Transportation Department specifications.

4. GENERAL

4.1. The Contractor shall comply with the provisions of ITD Standard Specifications, including requirements necessary prior to beginning any work or investigation with equipment within any source. Reference ITD Materials Manual, Section 300.13, Aggregate Materials Sources.
5. **INVESTIGATION AND SAMPLING**

5.1. Materials source investigation and sampling shall include the following:

5.2. Sand and gravel deposits shall be investigated by excavating test pits located 150 ft. to 200 ft. on centers. The test pits shall be selected to form an effective grid over the entire area to be investigated. The test pits shall represent the materials present to the full depth intended to be mined. In lieu of test pits, large diameter drilling may be acceptable if the drilling method collects a representative sample and is submitted for pre-approval by the District Materials Engineer.

5.2.1. If the sand/gravel deposit has an exposed face, the Contractor may elect to replace the first row of test pits by sampling from the face. Sample locations shall be selected forming a grid pattern over the exposed face, and extending into the face to undisturbed material, to represent the area investigated. A minimum of three sample locations shall be selected along any exposed face. Any source sampled at the face will require, in addition, a minimum of one row of test pits at a maximum of 150 ft. from the face. The test pits and samples shall represent the materials present to the full depth intended to be mined.

5.3. Rock deposits shall be investigated using core drilling equipment. Drill holes shall be spaced no more than 200 ft. on center to form an effective grid covering the entire area investigated. Drill holes shall be deep enough to represent the full depth of the excavation.

5.3.1. Bulk samples may be taken from blasted areas in lieu of core drilling. The samples may be collected from the blasted rock pile if the blasted materials accurately represent the entire area investigated and the full depth of the excavation. Additional sampling and testing of the quarry face or core drilling shall be required if additional material is required beyond the materials represented by the blasting. Samples from blasted rock piles shall not be used to characterize the materials more than 200 feet beyond the blasted rock face.

5.3.2. If the rock quarry has an exposed face, the Contractor may elect to replace the first row of rock cores by sampling from the face. Sample locations shall be selected forming a grid pattern over the exposed face and extending into the face to represent the area investigated. A minimum of three sample locations shall be selected along any exposed face. Any source sampled at the face will require a minimum of one row of rock cores at a maximum of 200 ft. from the face. The rock cores shall represent the intended materials present to the full depth intended to be mined.

5.4. For project-specific sources consisting of either sand/gravel deposits or rock deposits, sample location spacing shall be adjusted to form an effective grid over the area to be worked. A minimum of three samples shall be taken. The grid shall represent the intended depth of excavation, as well as the area to be worked, to produce the required quantities. Samples from an exposed face shall meet the requirements of Paragraph 4.1 or 4.2.

5.5. The investigator shall keep an accurate, detailed record of each sample, test pit, and boring location and detailed descriptions of all materials present in the proposed source. The detailed descriptions shall include but not limited to: geologic descriptions, scaled boring logs, and 4 inch by 5 inch minimum size color photographs of the materials, cores, and samples in the moist condition. Detailed descriptions of the source materials shall be made by direct, hands-on observations. Material descriptions taken from or referenced from published or non-published documents will not be accepted in lieu of a materials source investigation in accordance with this procedure but may be used to supplement the investigation. Descriptions of bedrock materials shall be provided by a qualified Professional Geologist. Clear copies of the original records shall be provided to the Engineer for source approval.

5.6. All investigations shall be performed under the direction of or by a qualified Professional Engineer or Professional Geologist licensed in the state of Idaho. All sample locations shall be selected by the
Professional Engineer or Professional Geologist and shall be in accordance with the current version of AASHTO T 2, Sampling of Aggregates, Appendix X2; and ASTM D 420 Standard Guide to Site Characterization for Engineering, Design, and Construction Purposes.

5.6.1. For the purpose of this test method, direct supervision shall include the Professional Engineer or Professional Geologist having intimate knowledge of the source so as to be able to determine the sample locations and sampling methods as well as sufficient knowledge of the site to meet the descriptive requirements herein.

5.7. Sampling shall be performed under the direct supervision of a qualified Professional Engineer or Professional Geologist licensed in the state of Idaho. Sampling procedures shall be performed in accordance with the current version of AASHTO T 2, Sampling of Aggregates, Appendix X2; and ASTM D 420-98, Standard Guide to Site Characterization for Engineering, Design, and Construction Purposes. Though the actual sample size may vary due to the gradation of the materials being sampled, the minimum sample size shall be 100 lbs. and shall be representative of the aggregate being mined. Multiple samples may be required to accurately represent the distribution of materials in the source. Each sample shall represent one test. The entire sample shall be crushed, blended and split into appropriate portions for the tests required.

6. TESTING

6.1. Required test data for aggregate sources shall conform to Standard Specifications Section 703 – Aggregates, and ITD Contract Specifications.


6.2. The laboratory used to perform the tests shall be qualified under the Idaho Transportation Department’s Lab Qualification Program or be AASHTO accredited. All individuals that perform laboratory tests for source approval shall be qualified by the Registered Engineer in charge of the laboratory.

6.3. Copies of all test results shall be furnished by the independent laboratory to the Engineer. Copies of all test results shall be furnished by the independent laboratory to the Engineer.

7. MATERIALS SOURCE PLAN

7.1. A Materials Source Plan shall be prepared and submitted to the Engineer. At a minimum, the plan shall contain the following:

7.2. A vicinity sketch in enough detail that the source can be located.

7.3. A legal description of the source.

7.4. A sketch of the source depicting the boundary dimensions and drawn to scale.

7.5. A north arrow.

7.6. The test pits, sample locations, borings, active or working faces shall be depicted on the sketch relative to their location in the source.

7.7. The area to be worked shall be delineated with test pits, sample locations, and borings representing the material shown.
8. QUALIFIED AGGREGATE MATERIAL SUPPLIERS

8.1. Upon completion of the requirements outlined in this test method, the Contractor's source may be included on the Idaho Transportation Department (ITD) list of Qualified Aggregate Materials Suppliers as defined in the ITD Quality Assurance Manual (Section 265.00, Qualified Aggregate Materials Suppliers).
Idaho Standard Method of Test for

Measuring Mortar-Making Properties of Fine Aggregate)

IDAHO Designation: IT-13-17

1. SCOPE

1.1. This method provides a means of determining whether a natural, unproven fine aggregate meets the minimum strength requirements for mortar making properties in concrete by comparing the compressive strength to the compressive strength of Ottawa Sand, the standard.

1.2. This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.

2. REFERENCE DOCUMENTS

2.1 AASHTO Standards

- M 152, Flow Table for Use in Tests of Hydraulic Cement
- T 22, Compressive Strength of Cylindrical Concrete Specimens
- T 71, Effect of Organic Impurities in Fine Aggregate on Strength of Mortar
- T 84, Specific Gravity and Absorption of Fine Aggregate
- T 106, Compressive Strength of Hydraulic Cement Mortar (Using 50-mm or 2-in. Cube Specimens)

2.2 ASTM Standards

- C778, Standard Specification for Standard Sand

3. APPARATUS

3.1. Flow Table (drop table), flow mold, caliper, and

3.2. 1” x 5/8” hard rubber tamper as described in AASHTO T 106

3.3. Cylinder molds, 2”x4”, either plastic single use, or brass, (waxed to a glass plate).

3.4. Mixing bowl and spoon. Small trowel and scoop.

3.5. Tamping rod, (3/8” diameter x 8”) with spherically rounded ends.

3.6. Balance, capable of reading to the nearest gram.

3.7. Capping compound and fixture for 2” diameter specimens.
3.8. Compression testing machine with proper sized spherical test head.

3.9. Moist Closet and lime saturated water bath

4. **TEMPERATURE AND HUMIDITY**

4.1. The temperature of the mixing water, the Moist Closet, and the storage tank water shall be maintained at 73.4 ±3 °F (23.0 ±1.7 °C).

4.2. The relative humidity of the Moist Closet shall not fall below 95%

4.3. During mixing and molding of test specimens, the laboratory shall be maintained at 50% or greater relative humidity.

5. **SAMPLE PREPARATION**

5.1. **Natural Sand Mortar** - (AASHTO T 84) this mortar shall be made using a representative sample of natural sand from the unproven source (3,000 to 5,000 grams).

5.1.1. The sand is moistened to a point past SSD, then covered and kept moist for a minimum of 15 hours to allow the sand to reach total saturation.

5.1.2. Dry the sand to an SSD condition per AASHTO T 84, being careful not to segregate material while constantly mixing.

5.1.3. Weigh 2,500.0 grams, being careful to get a representative sample. Cover this sample to keep it in an SSD condition until needed.

5.1.4. Cement: Weigh 700.0 grams of Portland cement, either Type I & II or Type III.

5.1.5. Water: Measure 420.0 ml of conditioned water.

**Note 1** — Conditioned water is distilled water at 73.4 ±3 °F (23.0 ±1.7 °C).

5.2. **Ottawa Sand Mortar** – This mortar is the standard of comparison.

5.2.1. Blend natural Ottawa sands, combined weight 2,500.0 grams. Combine 1,225.0 grams of graded sand, and 1,275.0 grams of 20-30 sand, both conforming to ASTM C778, and thoroughly blend.

5.2.2. Cement: Weigh 700.0 grams of Portland cement, either Type I & II or Type III.

5.2.3. Water: Measure 420.0 ml of conditioned water.

**Note 2** — All tests shall be run using the same cement Type, Manufacturer, and Lot. The amounts of water and cement used in this method are never varied. All of the water and cement must be used to maintain a consistent W/C ratio (0.60) between all samples. The amount of sand added to the mixture is varied to get the proper flow.

5.3. If brass molds are to be used, apply a light coating of release agent or light oil to molds. This will allow for removal of specimens without damage.

5.4. Start with a **damp bowl** and add 420.0 ml of conditioned water.

5.5. Add 700.0 grams of cement and let it absorb for 1 minute.
5.6. Stir by hand into a smooth paste.

5.7. Add the sand while stirring continuously until the desired consistency of the mix has been reached. Note: Normally, the mix will achieve the required consistency before all of the sand (2,500 grams) is used.

5.8. Stir the mixture vigorously for 30 seconds, and then perform a flow test.

6. **FLOW TEST**

6.1. Fill the cone in two layers, 20 blows per layer with the hard rubber tamping tool. The mixture should overfill the cone at this point.

6.2. Cut the excess mortar off using the edge of a trowel creating a plane surface.

6.3. Carefully lift the cone off the mixture leaving the molded specimen on the table. The entire process to this point should be performed in one minute.

6.4. At exactly one minute, start flow table and drop 10 times. The mortar shall be proportioned to produce a consistency of 95-105 in 10 drops of the flow table.

**Note 3** — Allowance for flow trial – One free trial may be performed, but only if mix is too wet and the only ingredient that may be added is sand, to stiffen the mix. Then remix (5.7), and perform flow again starting with (6.1).

6.5. After flow measurement, immediately place the mortar back in the bowl and remix vigorously for 15 seconds.

6.6. Fill cylinder molds (brass or plastic) in three layers, each layer receiving 25 blows using the tamping rod with spherical end. Make two sets of 3 cylinders, (6 total). One set for 3 days and one set for 7 days if Type III cement is used, or one set for 7 days and one set for 28 days if Type I and II cement is used.

6.7. Cut off the mortar to a plane surface, flush with the top of the mold, by drawing the straight edge of a trowel with a sawing motion across the top of the mold.

6.8. Place the cylinders in the Moist Closet for curing.

7. **CURING SPECIMENS**

7.1. After 20 to 24 hours of curing in the Moist Closet, the specimens shall be removed from the molds, marked for identification, and immediately placed in a temperature controlled, lime saturated water bath for final curing.

7.2. Cylinders shall remain in the water bath to cure for a period of 3 days and 7 days, or 7 days and 28 days, depending on the cement type used. They will be removed from the water bath in sufficient time to perform the capping procedure and allow for curing of capping compound prior to testing. Testing shall be performed within ±1 hour for 3 day tests, ±2 hours for 7 day tests, and ±20 hours for 28 day tests, from the time of molding.

8. **CAPPING SPECIMENS**

8.1. Cylinders shall be capped before testing in such a manner that the ends will be plane and at right angles to the axis of the cylinder. While cylinders are in the capping process, they shall be maintained in a moistened condition by covering with wet towels. Any conventional capping material may be used.
9. TESTING SPECIMENS

9.1. Cylinders shall be tested for compressive strength at 3 days and 7 days, or 7 days and 28 days after molding. Testing age of cylinders depends on cement Type used to make test specimens.

9.2. If more than one specimen is removed from the storage water for testing, these specimens shall be covered with a wet towel to keep specimens in a moistened condition until time of testing.

9.3. Before placing the test cylinders in the compression test machine, they shall be wiped to a surface dry condition and have any loose sand and/or debris removed from the bearing test surfaces.

9.4. Place the cylinder carefully in the test machine centering it on the upper bearing block. Check the spherical head (upper) for freedom of movement prior to the beginning of each test. A constant load shall be applied without interruption until failure, at a rate of 20 psi to 50 psi per second, (standard loading rate for cylindrical specimens, AASHTO T 22). No adjustment shall be made in the controls of the testing machine while a specimen is yielding rapidly just prior to failure.

10. ACCEPTANCE

10.1. Acceptance is based on a comparative strength between the two mortars. The natural sand mortar must be at least 90% of the strength that is achieved by the standard sand mortar.
Idaho Standard Method of Test for

Idaho Degradation

IDAHO Designation: IT-15-04

1. SCOPE

1.1. This test method is intended as a quantitative measure of the resistance of a graded aggregate to production of fines by abrasion in the presence of water. The test provides a means by which it is possible to evaluate how the aggregate may perform in the road.

1.2. This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.

2. APPARATUS

2.1. Idaho Degradation Machine. The Idaho Degradation Machine is equipped with an electric motor with gear reduction. The machine shall maintain a substantially uniform speed of 30 to 33 rpm. Metal cans equipped with spring tension handles to securely hold one-gallon (3.8 liter) jars in place are so positioned that the jars rotate end over end. Diameter of the metal cans shall be such that the jars are a snug fit, but can be inserted and removed without binding. The cans shall be deep enough so that the straight portion of the jar is completely within the can.

2.2. Containers. Wide mouth one-gallon (3.8 liter) jars with lids. The lids are fitted with solid 1/8 in. (3 mm) thick rubber gaskets.

2.3. Sieves. A set of U.S. Standard, 8 in. (200) mm diameter sieves 3/4 in. (19 mm) through No. 200 (0.075mm). These sieves shall meet AASHTO M 92 specifications.

2.4. Sand Equivalent apparatus as described in AASHTO T 176.

2.5. Scoop, brush and rust proof drying container approximately 18 in. x 12 in. x 2 in. (460 mm x 300 mm x 50 mm) deep.

2.6. Drying Oven - 140°F (60º C) maximum.

2.7. Balance with a 2,000 g capacity sensitive to 0.1 g.

3. PREPARATION OF SAMPLE

3.1. Sample makeup (Oven-dry at 140°F (60º C) max.)

3.1.1. The sample for testing with 1/2 in (12.5 mm) or larger size aggregate shall have the following gradation:

- 16.7% passing the 3/4 in. (19 mm) and retained on the 1/2 in (12.5 mm) 183 g.
- 16.6% passing the 1/2 in. (12.5 mm) and retained on the 3/8 in (9.5 mm) 183 g.
- 16.7% passing the 3/8 in. (9.5 mm) and retained on the No. 4 (4.75 mm) 184 g.
- 50% passing the No. 4 (4.75 mm) 550 g.

Total 1100 g.
3.1.2. The sample for testing with 3/8” (9.5 mm) size aggregate shall have the following gradation:

- 25% passing the ½” (12.5 mm) and retained on the 3/8 in. (9.5 mm) 275 g.
- 25% passing the 3/8 in. (9.5 mm) and retained on the No. 4 (4.75 mm) 275 g.
- 50% passing the No. 4 (4.75 mm) 550 g.

Total 1100 g.

3.1.3. The sample for testing with No. 4 (4.75 mm) size aggregate shall have the following gradation:

- 50% passing the 3/8 in. (9.5 mm) and retained on the No. 4 (4.75 mm) 550 g.
- 50% passing the No. 4 (4.75 mm) 550 g.

Total 1100 g.

3.2. Combine oven dried original and crushed portions representative of the gradation of the material as intended for use. For material coarser than the No. 4 (4.75 mm) sieve, thoroughly mix original and crushed portions and weigh out exactly the specified amount. Obtain the specified amount of No. 4 (4.75 mm) materials by the method of quartering or by the use of a sample splitter as described in AASHTO R 76.

3.3. **Note 1** — The coarse portion of the sample shall be hand shaken to refusal on each specified sieve size before make-up. Hand shaking shall continue until not more than 1% by weight of the residue passes any sieve during one minute.

### 4. PROCEDURE

4.1. Place the prepared oven dried material (maximum temperature 140°F (60º C) in a wide mouth jar and enough water to cover the aggregate to a depth of approximately 1/2 in. (13mm)

4.2. Allow the sample to soak at least 16 hours.

4.3. If necessary, after the soaking period adjust the water in the jar so the aggregate is barely covered.

4.4. Place lid with rubber gasket on jar and seal tightly. Fit the jar into the Idaho Degradation Machine making certain that the spring tension handle is securely holding the jar.

4.5. Start the Idaho Degradation Machine and allow the jar to make 1,850 revolutions. The tumbling action of the aggregate as the jar rotates end over end produces the degradation.

4.6. At the end of the test period empty the contents of the jar over a No. 4 (4.75 mm) sieve placed over a container to catch all the No. 4 (4.75 mm) material and water.

4.7. Wash out the jar using as little water as possible. Wash the plus No. 4 (4.75 mm) material until all the fines sticking to the aggregate are washed into the minus No. 4 (4.75 mm) portion of the sample. Place the container with the minus No. 4 (4.75 mm) portion in the oven for drying.

4.8. Oven dry the plus No. 4 (4.75 mm) material and then shake to refusal over the appropriate coarse sieves. If any material passes the No. 4 (4.75 mm) sieve, it is to be added to the minus No. 4 (4.75 mm) portion.

4.9. Stir the minus No. 4 (4.75 mm) portion occasionally and remove from oven when a cast point is reached. A cast point is defined as the point when a portion tightly squeezed in the palm of the hand will form a cast which will bear very careful handling without breaking.

4.10. When the cast point is reached, run sand equivalent on the minus No. 4 (4.75 mm) material according to AASHTO T 176.

4.11. Retain the material from the sand equivalent test and return it to the minus portion.
4.12. Wash entire minus No. 4 (4.75 mm) portion over No. 200 (0.075 mm), dry and sieve as described in AASHTO T 11.

4.13. Compute the total gradation based on initial oven dry weight of 1100 g. This becomes the gradation after degradation.

Note 2—Weights should be recorded to the nearest gram.

5. REPORT

5.1. The before-test gradation and sand equivalent together with the after-test gradation and sand equivalent are reported. The amount of degradation is indicated by the difference in test values.

Note 3—If the before-test gradation of material passing the No. 4 (4.75 mm) sieve is measured by sieve analysis of a representative sample for which the % Passing No. 4 (4.75 mm) is 50%, the before test percentages for No. 4 (4.75 mm) and finer sieve from the analysis are recorded directly in the "BEFORE TEST" column on Form ITD-895. Otherwise, all before test percentages for No. 4 (4.75 mm) and finer sieves must be multiplied by an adjustment factor before recording on the form. The adjustment factor is 50 divided by the percentage of material passing No. 4 (4.75 mm) in the representative before-test gradation sample. For example, if the No. 4 (4.75 mm) and finer before-test percentages are determined on a sample consisting of 100% minus No. 4 (4.75 mm) material, the adjustment factor is 50/100 = .050. Similarly, if the sample for determining before-test gradation has 40% minus 4.75 mm, the adjustment factor for No. 4 (4.75 mm) and finer sieves is 50/40 = 1.25.

5.2. The test results shall be reported on Form ITD-802.

6. PRECAUTIONS

6.1. Avoid baking sample during drying period prior to sand equivalent test.

6.2. Be sure to return all of the material from the sand equivalent test back into the minus No. 4 (4.75 mm) portion.
Idaho Standard Method of Test for

Evaluating Cleanness of Cover Coat Material

IDAHO Designation: IT-72-17

1. SCOPE

1.1. The cleanness test indicates the relative amount, fineness and character of clay-like materials present in aggregate as coatings or otherwise.

1.2. This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.

2. REFERENCE DOCUMENTS

2.1. AASHTO Standards
   - M 92, Wire Cloth Sieves for Testing Purposes
   - M 231, Weighing Devices Used in the Testing of Materials
   - T 176, Plastic Fines in Graded Aggregates and Soils by Use of the Sand Equivalent Test.
   - R 76, Reducing Field Samples of Aggregates to Testing Size.

2.2. Other Standards
   - California Test 227 – Method of Test for Evaluating Cleanness of Coarse Aggregate.

3. APPARATUS

3.1. Balance – Capacity sufficient for the sample mass, accurate to 0.1 percent of the sample mass or readable to 0.1g. Meets the requirements of AASHTO M 231.

3.2. Sample Splitter – Meets the requirements of AASHTO R 76.

3.3. Graduate assembly – Consists of:

3.3.1. funnel large enough to hold 8 inch brass wire sieves at the large end and necked down to approximately 2 in. diameter at the other end,

3.3.2. No. 8 (2.36mm) & No. 200 (0.75mm) 8 inch brass wire sieves, Meeting the requirements of AASHTO M 92.

3.3.3. 500 ml graduate cylinder.

3.4. Washing vessel (as described in Figure 1) or wide-mouth 3.8 L jar with lid and rubber gasket.

3.5. Mechanical shaker – Uses oscillation or orbital action capable of securely holding the washing vessel.

3.6. Sand equivalent (SE) cylinder – Conforming to AASHTO T 176 with rubber stopper.

3.7. Graduate cylinders – 10 ml and 500 ml.
3.8. Sand equivalent (SE) solution (Stock) Conforming to AASHTO T 176

3.9. Syringe or spray attachment.

3.10. Potable water, i.e., tap water or bottled water at approximately the same temperature as the stock solution, but not at a higher temperature than the maximum temperature allowed by AASHTO T 176.

4. **SAMPLE PREPARATION**

4.1. Obtain a sample of cover coat material (CCM) in accordance with the FOP for AASHTO T 2 and reduce to 1000 ±50 grams in accordance with the FOP for AASHTO R 76.

4.2. **Note 1** — Sample shall be placed in a sealed container, such as concrete cylinder mold, to prevent loss of moisture. Sample shall be run in condition of placement on roadway i.e. moist. Sample shall not be allowed to dry.

4.3. Using a 10 ml graduate cylinder, obtain 7 ml of SE solution.

4.4. Pour the 7 ml of SE solution into the SE cylinder.

4.5. Assemble the graduate assembly (#8 (2.36mm) sieve, #200 (0.75mm) sieve, funnel, 500 ml graduate cylinder).

5. **PROCEDURE**

5.1. Place the 1000 ±50 gram CCM sample in the washing vessel or wide-mouth jar. Spread the material evenly across the bottom of the vessel or jar. Add only enough water to cover the aggregate.

5.2. Allow the sample to soak for one minute from the introduction of wash water into the vessel or jar.

5.3. Agitate the sample by either mechanical or hand method

5.4. **Mechanical Method.**

5.4.1. Seal and secure the wash vessel in the mechanical shaker.

5.4.2. Agitate the vessel for two (2) minutes, without using the hammer if the shaker has one.
Figure 1—Washing Vessel

5.5. **Hand Method.**

5.5.1. Seal the jar with lid and rubber gasket.

5.5.2. Hold the jar vertical with both hands either by the sides or by the top and bottom. Agitate the sample in the vessel, creating an arm motion that causes the jar to describe a circle with at least a 6 in. (150 mm) radius. See the sketch showing the path of the jar during the agitation period. Use of a countertop with a 6 in (150 mm) radius drawn on the surface will help in this operation.
Figure 2—Path of Jar During Agitation Period

**Note 2** — The jar itself does not turn on its vertical axis. The jar’s vertical axis describes a circle with a 6 in. (150 mm) radius as near as possible.

**Note 3** — Side F always faces the operator.

5.5.3. Continue this agitation at the rate of three (3) complete rotations per second for one minute.

6. **MEASURE FOR CLEANNESS**

6.1. Remove the lid from the vessel or jar. Continue agitating the vessel by hand to keep the fine contents in suspension. Pour all contents over the graduate assembly.

6.2. Wash out the vessel or jar over the graduate assembly using the syringe or spray attachment until the graduate cylinder is filled to 500 ml. mark.

6.3. Remove the sieves and funnel portion for the graduate assembly from the 500 ml graduate cylinder. Bring the solids into suspension by capping the cylinder with the palm of the hand and turning the cylinder upside down then right side up, 10 times, through an 180° arc as rapidly as possible.

6.4. Immediately pour the thoroughly mixed liquid into the SE cylinder until the 15 inch mark is reached. Cap the SE cylinder with a rubber stopper.

6.5. Mix the contents of the SE cylinder by alternately turning the cylinder upside down and right side up, allowing the air bubble to completely traverse the length of the cylinder. Repeat this cycle 10 times. A cycle is from right side up to upside down to right side up.

6.6. On a worktable that is not subject to vibrations allow the SE cylinder and contents to stand undisturbed for 20 minutes ± 15 seconds.

6.7. After 20 minutes, read and record to the nearest 0.1 inch the height of the column of sediment.

7. **CALCULATIONS**

7.1. Compute the cleanness value to the nearest whole number.

\[ CV = \frac{3.214 - (0.214 \times H)}{3.214 + (0.786 \times H)} \times 100 \]

Where:

*CV* = Cleanness Value

\( H \) = Height of Sediment in inches.
QUALIFICATION CHECKLIST

CLEANNESS VALUE – IDAHO T 72

Record the symbols “P” for passing or “F” for failing on each step of the checklist.

<table>
<thead>
<tr>
<th>Procedure Element</th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>General</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>1. The sample was maintained moist in sealed container.</td>
<td>1</td>
<td></td>
</tr>
<tr>
<td>2. The sample is equal to 1000 ± 50 grams.</td>
<td>2</td>
<td></td>
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<tr>
<td>3. There is 7 ml of SE solution in SE tube.</td>
<td>3</td>
<td></td>
</tr>
<tr>
<td>4. The graduate assembly including sieves, funnel and 500 ml graduate cylinder is properly put together.</td>
<td>4</td>
<td></td>
</tr>
<tr>
<td>5. CCM sample was placed in washing vessel or jar and water was added just covering the aggregate.</td>
<td>5</td>
<td></td>
</tr>
<tr>
<td><strong>Mechanical Method</strong></td>
<td></td>
<td></td>
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<tr>
<td>6. The vessel was secure in the shaker.</td>
<td>6</td>
<td></td>
</tr>
<tr>
<td>7. Agitation was started after one (1) minute.</td>
<td>7</td>
<td></td>
</tr>
<tr>
<td>8. The vessel was agitated for two minutes.</td>
<td>8</td>
<td></td>
</tr>
<tr>
<td><strong>Hand Method</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>9. Agitation was started after one (1) minute.</td>
<td>9</td>
<td></td>
</tr>
<tr>
<td>10. The vessel was properly rotated with 150mm radius.</td>
<td>10</td>
<td></td>
</tr>
<tr>
<td>11. Vessel was agitated 3 complete rotations per second.</td>
<td>11</td>
<td></td>
</tr>
<tr>
<td>12. Vessel was agitated for one (1) full minute.</td>
<td>12</td>
<td></td>
</tr>
<tr>
<td><strong>Measure for Cleanness</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>13. All contents of vessel or jar were washed over sieves into the 500 ml graduate cylinder.</td>
<td>13</td>
<td></td>
</tr>
<tr>
<td>14. Cylinder was rapidly turned upside down at 180°, ten (10) times.</td>
<td>14</td>
<td></td>
</tr>
<tr>
<td>15. Mixture was poured into SE cylinder to 15 inch mark.</td>
<td>15</td>
<td></td>
</tr>
<tr>
<td>16. SE Cylinder was rotated at least ten (10) complete cycles. Bubble traveled full length of tube.</td>
<td>16</td>
<td></td>
</tr>
<tr>
<td>17. Cylinder was allowed to stand 20 minutes on work table free from vibrations.</td>
<td>17</td>
<td></td>
</tr>
<tr>
<td>18. The sediment reading was to the nearest 0.1 inch.</td>
<td>18</td>
<td></td>
</tr>
<tr>
<td>19. Calculations were accurate to the nearest whole number.</td>
<td>19</td>
<td></td>
</tr>
</tbody>
</table>

Comments: First Attempt: Pass ☐ Fail ☐ Second Attempt: Pass ☐ Fail ☐

Testing Technician’s Name: _________________________ WAQTC #: ______________ Date: ____________

Examiner’s Name: _______________________________ Signature _______________________________
Idaho Standard Method of Test for

Vibratory Spring-Load Compaction for Coarse Granular Material

Idaho IT-74-98

Idaho IT-74 is identical to WSDOT Test Method No. 606, "Method of Test for Compaction Control of Granular Materials," with the following exceptions.

A. Delete 1.1b and replace as follows: When Idaho IT-74 is specified as an alternative to AASHTO T 99 or AASHTO T 180, Idaho IT-74 should be used if the material has more than about 10% retained on the 3/4 in. (19 mm) screen.

B. Use of the WSDOT forms included in Test Method No. 606 is optional. ITD forms may be substituted.
WSDOT Test Method T 606  
*Method of Test for Compaction Control of Granular Materials*

1. Scope

a. This test method is used to establish the theoretical maximum density of granular materials and non-granular materials with more than 30% by weight of the original specimen is retained on the No. 4 Sieve or more than 30% by weight of the original specimen is retained on the ¾” sieve.

b. There are three separate tests in this method which present a method for establishing the proper theoretical maximum density values to be used for controlling the compaction of granular materials. These tests account for variations of the maximum obtainable density of a given material for a given compactive effort, due to fluctuations in gradation.

c. By splitting the material on the U.S. No. 4 (4.75 mm) sieve and determining the specific gravity, the compacted density, and the loose density of each of the two fractions, a curve of theoretical maximum density versus percent passing the U.S. No. 4 (4.75 mm) sieve can be plotted. These curve values will correlate closely with the densities obtained in the field; using modern compaction equipment.

d. Table 1 identifies the Test, Method or Procedure to use in performing T 606. The table is divided into the Fraction of the split (Fine or Coarse) and the material type of that Fraction.

<table>
<thead>
<tr>
<th>Test Method Selection Table</th>
</tr>
</thead>
<tbody>
<tr>
<td>Fine Material</td>
</tr>
<tr>
<td><strong>Soil Type</strong></td>
</tr>
<tr>
<td>Sandy, Non Plastic, Permeable</td>
</tr>
<tr>
<td>Silt, Some Plasticity, Low Permeability</td>
</tr>
<tr>
<td>Sandy Silt, Some Plasticity, Permeable</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Coarse Material</th>
</tr>
</thead>
<tbody>
<tr>
<td>No more than 15% by weight of original aggregate specimen exceeds ¾” (19 mm)</td>
</tr>
<tr>
<td>15% or more by weight of original aggregate specimen is greater than ¾” (19 mm), but does not exceed 3 in. (76 mm)</td>
</tr>
</tbody>
</table>

Table 1

e. The test methods are applicable either to specifications requiring compacting to a given percentage of theoretical maximum density, or to specifications requiring compaction to a given compaction ratio.
f. Use of these test methods eliminates the danger of applying the wrong “Standard” to compaction control of gravelly soils.

g. Native soils within the contract limits to be used for embankment construction and/or backfill material do not require the sampling by a qualified tester. For material that requires gradation testing such as but not limited to manufactured aggregates and Gravel Borrow, a qualified tester shall be required for sampling.

1.1 Scope

Test No. 1  
(Fine Fraction-100 Percent Passing U.S. No. 4 (4.75 mm) Sieve)

a. This test was developed for the sandy, non-plastic, highly permeable soils which normally occur as the fine fraction of granular base course and surfacing materials.

b. When the fine fraction is primarily a soil having some plasticity and low permeability, AASHTO T 99 (Standard Proctor Test) may be used. With borderline soils, both tests should be applied and the one yielding the highest density value should be used.

1.2 Apparatus

a. Vibratory, Spring Load Compactor — Specifications for vibratory spring load compactor can be obtained from the State Materials Lab.

b. Mold — Molds can be fabricated from standard cold drawn-seamless piles or tubes. The dimensions for the small mold are; height 8 in (± 0.002 in), ID 6 in (± 0.002 in). The wall thickness of the mold shall be no less than ¼ in. The mold has a bottom plate which attaches to the mold and is slightly larger than the outer diameter of the mold. The small button at the center of the small mold follower is a measuring point. The height of this button should be adjusted so the machine follower does not bear on it during compaction.

c. Mold Piston — A piston which has a bottom face diameter of 5 ⅞ in (150 mm) OD and an overall height of 2 in. The top of the piston shall have a 2 ¼ in ID.

d. Height-Measuring Device — A scale with an accuracy of 0.01 in (0.25 mm).

e. Tamping Hammer — As specified in AASHTO T 99, Section 2.21.

f. Sieve — U.S. No. 4 (4.75 mm) sieve.

g. Oven — Capable of maintaining a temperature of 230° ± 5°F (110 ± 5° C) for drying moisture specimens.

h. Balance — A balance having a capacity of 100 lbs (45 kg) and a minimum accuracy of 0.1 lbs (50 g).

i. Tamping Rod — ⅜ in (16 mm) spherical end.
1.3 Procedure

a. Oven-dry the total original sample at a temperature not to exceed 140°F (60°C).

b. Obtain tare weight of mold and bottom plate, record weight (mass) to the nearest 0.01 lb (5 g) or less if using a balance that is more accurate than 0.1 lbs.

c. Sieve the entire specimen over a No. 4 (4.75 mm) sieve to separate the fine and coarse material. Retain the coarse material for the second half of the procedure (T 606 Test 2).

d. Split the No. 4 minus material in accordance with WSDOT FOP for AASHTO R76 to obtain a representative specimen of approximately 13 lbs (6 kg). (This mass can be adjusted after the first compaction run to yield a final compacted specimen approximately 6 in (150 mm) high.)

e. Estimate the optimum moisture for the material. Calculate the mass of water required for optimum moisture and add water to specimen.

Weight of Water

Equation: \[ \text{Wt. of water} = (\text{decimal percent water})(\text{mass dry sample}) \]

f. Mix the specimen until the water and dry material are thoroughly and completely mixed.

g. Place the specimen in the mold in three layers. Rod each layer 25 times and tamp with 25 blows of the tamping hammer. The blows of the hammer should produce a 12 in (305 mm) free fall provided severe displacement of the specimen does not occur. In such cases, adjust the blow strength to produce maximum compaction. The surface of the top layer should be finished as level as possible.

h. Place the piston on top of the specimen in the mold, and mount the mold on the jack in the compactor. Elevate mold with the jack until the load-spring retainer seats on top of the piston. Apply initial seating load of about 100 lbs (45 kg) on the specimen.

i. Start the compactor hammers and, at the same time, gradually increase the spring load on the specimen to 2,000 lbs (908 kg) by elevating the jack in accordance with Table 2.

j. Check the mold for specimen saturation. The specimen is considered saturated when, free water (a drop or two of water) shows at the base of the mold. If water is not present at the base of the mold within the first 1½ minutes stop the test, remove the specimen from the mold and repeat 1.3 e-j. The specimen can be reused for subsequent water contents providing it is not a fragile material.

k. Caution: Most materials will yield the highest density at the moisture content described above. Some materials may continue to gain density on increasing the moisture above that specified; however, severe washing-out of the fines will occur, which will alter the character of the sample and void the test results.
Idaho Standards

1. If moisture is observed at the base of the mold continue applying loads at the following rates:

<table>
<thead>
<tr>
<th>Load in lbs (kg)</th>
<th>Time in Minutes</th>
</tr>
</thead>
<tbody>
<tr>
<td>100 to 500 lbs (45 to 227)</td>
<td>1</td>
</tr>
<tr>
<td>500 lbs to 1,000 lbs (227 to 454)</td>
<td>1/2</td>
</tr>
<tr>
<td>1,000 lbs to 2,000 lbs (454 to 908)</td>
<td>1/2</td>
</tr>
</tbody>
</table>

*Table 2: Rate of Load Application*

m. After reaching 2,000 lbs (908 kg), stop the hammers, release the jack, and return to zero pressure.

n. Repeat step h. four additional times; remove the mold from the compactor.

o. Measure and record the height of the compacted specimen to the nearest 0.01 in (.25 mm) and calculate the volume (see Section 1.4)

p. Remove the specimen from the mold, weigh it, and record its mass (weight) to the nearest 0.01 lbs (5 g), and calculate the wet density.

q. Vertically slice through the center of the specimen, take a representative specimen (at least 1.1 lbs (500 g)) of the materials from one of the cut faces (using the entire specimen is acceptable), weigh immediately, and dry in accordance with AASHTO T 255 to determine the moisture content, and record the results. Calculate and record the dry density.

r. Repeat steps d. through m. at higher or lower moisture contents, on fresh specimen if needed, to obtain the theoretical maximum density value for the material, three tests are usually sufficient.

1.4 Calculations

a. The formula for calculating the volume and dry and wet densities are as follows:

\[ V = \frac{(1 - H_2)(B)}{1728} \]

Where:

- \(V\) = Volume, ft\(^3\)
- \(H_1\) = Inside height of the mold, in
- \(H_2\) = Height from top of the specimen to the top of the mold, in
- \(B\) = Inside bottom area of the mold, in\(^2\)

\[ \text{Wet Density (pcf)} = \frac{\text{Wet Mass (Weight, lbs.)}}{\text{Volume (cu. ft.)}} \]

\[ \text{Dry Density (pcf)} = \frac{\text{Wet Density (pcf)}}{1 + \text{Moisture Content (in decimal)}} * \]

*Note: See AASHTO T 255-00“Total Moisture Content of Aggregate by Drying,” for moisture content calculations.*
Test No. 2
(Coarse Fraction-100 Percent Retained on the U.S. No. 4 (4.75 mm) Sieve)

2.1 Scope

a. This test is used when there is 100 percent retained on the U.S. No. 4 (4.75 mm) sieve. There are two separate procedures based on the maximum size of the aggregate being tested. Procedure 1 is used when no more than 15% by weight of the original specimen of the coarse aggregate exceeds ¾ in (19 mm). Procedure 2 is used when 15% or more by weight of the original specimen of the aggregate is greater than ¾ in (19 mm), but does not exceed 3 in (76 mm). If there is any aggregate greater than 3 in (76 mm), it has to be removed before proceeding with the test.

Procedure 1
(Aggregate Size: No. 4 to ¾ in (19 mm))

2.2 Equipment

a. The apparatus for this test is the same as that used in Test No. 1

2.3 Procedure

a. From the coarse split obtained in Test No. 1, Section 1.3(C), separate a representative specimen of 10 to 11 lbs (4.5 to 5 kg) and weigh to 0.01 lbs (5 g), or less if using a balance that is more accurate than 0.1 lbs.

b. Dampen the specimen to 2½% moisture and place it in a 0.1 ft³ (0.0028 m³) mold, in three lifts. Tamp each lift lightly to consolidate the material to achieve a level surface. Omit rodding. Avoid loss of the material during placement.

c. Place the piston on top of the specimen in the mold, and mount the mold on the jack in the compactor. Elevate mold with the jack until the load-spring retainer seats on top of the piston. Apply initial seating load of about 100 lbs (45 kg) on the sample.

d. Start the compactor hammers and, at the same time, gradually increase the spring load on the sample to 2,000 lbs (908 kg) by elevating the jack in accordance with the Table 2.

e. Follow procedure described in Test No. 1 Section 1.3 m through 1.3 r.

f. Using the original dry weight value, calculate the dry density in lb/ft³ (kg/m³). Use the formula for dry density described in Test No.1, Section 1.4.
2.4 Equipment

Procedure 2
(Aggregate Size: No. 4 to 3 in (76 mm))

a. ½ ft³ (0.014 m³) standard aggregate measure.

b. A metal piston having a diameter ⅛ in (3 mm) less than the inside diameter of the ½ ft³ (0.014 m³) measure.

2.5 Procedure

a. From the coarse fraction in Test No. 1, Section 1.3c., separate a representative specimen of 45 lbs (20 kg) and weigh to 0.1 lb. (50 g), or less if using a balance that is more accurate than 0.1 lbs.

b. Split the specimen into five representative and approximately equal parts.

c. Place the specimen in the mold in five separate lifts after each lift is placed in the mold, position the piston on the specimen, mount the mold in the compactor, and compact as described in Table 2, Section 1.3h. Spacers between the load spring and piston must be used to adjust the elevation of the mold to the height of the lift being compacted.

d. After the final lift is compacted, remove the mold from the compactor, determine the height of the compacted specimen, and calculate the volume (see Test No. 1, Section 1.4(a)).

e. Calculate the dry density in lbs/ft³ (kg/m³) (see Test No. 1, Section 1.4(a)).

Test No. 3
Specific Gravity Determination for Theoretical Maximum Density Test

3.1 Equipment

a. Pycnometer calibrated at the test temperature having a capacity of at least 1 quart (100 ml).

b. One vacuum pump or aspirator (pressure not to exceed 100 mm mercury).

c. One balance accurate to 0.1 g.

3.2 Material

a. Fine fraction U.S. No. 4 (4.75 mm) minus 1.1 lbs (500 g) minimum.

b. Coarse fraction U.S. No. 4 (4.75 mm) plus 2.2 lbs (1,000 g) minimum.
3.3 Procedure

a. Place dry material, either fine or coarse fraction, in pycnometer, add water. Put pycnometer jar top in place and connect to vacuum apparatus. Apply vacuum for at a minimum of 20 minutes until air is removed from specimen. Slight agitation of the jar every 2 to 5 minutes will aid the de-airing process. If the material boils too vigorously, reduce the vacuum. Remove vacuum apparatus, fill pycnometer with water, dry outside of jar carefully and weigh. Water temperature during test should be maintained as close to 68° ± 1° F (20° ± 0.5° C) as possible.

Calculate Specific Gravity as follows:

\[
\text{SP. GR.} = \frac{a}{a + b - c}
\]

Where:

- \(a\) = Weight of dry material, grams
- \(b\) = Weight of pycnometer + water, grams
- \(c\) = Weight of pycnometer + material + water, grams

3.4 Reports

a. All test results are recorded on the theoretical maximum density work sheet.

b. Use the appropriate computer program to determine the theoretical maximum density.
Idaho Standard Method of Test for

DISINTIGRATION OF QUARRY AGGREGATES (ETHYLENE GLYCOL)

IDAHO Designation: IT-116-13

1. SCOPE

1.1. This method outlines the preparation and test procedure for measuring the presence of deleterious clay in quarry aggregates.

1.2. *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

2. REFERENCE DOCUMENTS

2.1. *AASHTO Standards*
   - M 231, Weighing Devices Used in the Testing of Materials

2.2. *ASTM Standards*
   - E11, Woven wire Test Sieve Cloth and Test Sieves

2.3. *Other Standards*
   - Standard Specifications, Subsection 703.01

3. APPARATUS

3.1. Oven 60 ± 2°C

3.2. Balance —A balance conforming to the requirements of M 231, Class G2.

3.3. Sieves conforming to ASTM E11 Specifications.

3.4. Technical Grade Ethylene Glycol

4. PROCEDURE

4.1. Wash and dry enough material passing the 12.5 mm and retained on the 9.5 mm sieve to provide 500 grams of material when shaken to refusal.

4.2. Immerse in technical grade ethylene glycol for a period of 15 days.

4.3. Decant and dry the aggregate. Shake to refusal over a 9.5 mm sieve and calculate the percent retained.
Idaho Standard Method of Test for

Specific Gravity and Absorption of Fine Aggregate Using Automatic Vacuum Sealing (CoreLok) Method

IDAHO Designation: IT-144-08

1. SCOPE

1.1. This standard covers the determination of specific gravity and absorption of fine aggregates.

1.2. The values are stated in SI units and are regarded as the standard units.

1.3. This standard may involve hazardous materials, operations and equipment. This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.

2. REFERENCE DOCUMENTS

2.1. AASHTO Standards

- M 231, Weighing Devices Used in the Testing of Materials
- T 2, Standard Practice for Sampling of Aggregates
- T 19, Standard Test Method for Bulk Density (Unit Weight) and Voids in Aggregate
- T 255, Total Evaporable Moisture Content of Aggregate by Drying
- R 76, Reducing Samples of Aggregate to Testing Size

2.2. ASTM Standards

- E1547, Standard Terminology Relating to Industrial and Specialty Chemicals

2.3. OTHER Standards

- CoreLok Operational Instructions (InstrTek, Inc.)

3. TERMINOLOGY

3.1. Absorption—the increase in the mass of aggregate due to water in the pores of the material, but not including water adhering to the outside surface of the particles, expressed as a percentage of the dry mass. The aggregate is considered “dry” when it has been maintained at a temperature of 110 ± 5°C for sufficient time to remove all uncombined water.
3.2. **Specific gravity**—the ratio of the mass (or weight in air) of a unit volume of a material to the mass of the same volume of water at stated temperatures. Values are dimensionless.

3.3. **Apparent specific gravity**—the ratio of the weight in air of a unit volume of the impermeable portion of aggregate at a stated temperature to the weight in air of an equal volume of gas-free distilled water at a stated temperature.

3.4. **Bulk specific gravity**—the ratio of the weight in air of a unit volume of aggregate (including the permeable and impermeable voids in the particles, but not including the voids between particles) at a stated temperature to the weight in air of an equal volume of gas-free distilled water at a stated temperature.

3.5. **Bulk specific gravity (SSD)**—the ratio of the mass in air of a unit volume of aggregate, including the mass of water within the voids filled to the extent achieved by vacuum saturating (but not including the voids between particles) at a stated temperature, compared to the weight in air of an equal volume of gas-free distilled water at a stated temperature.

4. **SUMMARY OF METHOD**

4.1. Sufficient fine aggregate sample is dried to constant mass and representative dry fine aggregate samples of the same material are selected for testing. One sample is sealed in a vacuum chamber inside a plastic bag and opened under water for rapid saturation of the aggregate. The dry mass and submerged mass of the sample is used for calculation of apparent specific gravity. Other samples of the same aggregate are tested in a known volume metal pycnometer. The known mass of the pycnometer with water, mass of the dry aggregate, and mass of the dry aggregate and pycnometer filled with water is averaged and used for calculation of bulk specific gravity oven dry (OD.) The results from the samples tested are used to calculate absorption, and bulk specific gravity saturated-surface-dry (SSD).

5. **APPARATUS**

5.1. **Balance**—A balance that conforms to AASHTO M 231. The balance shall be sensitive, readable and accurate to 0.1% of the test sample mass. The balance shall be equipped with suitable apparatus for suspending the sample in water.

5.2. **Water Bath**—A large container that will allow for completely submerging the sample in water while suspended, equipped with an overflow outlet for maintaining a constant water level. Temperature controls may be used to maintain the water temperature at 25 ± 1° C (77 ± 2 °F).

   **Note 1** — It is preferable to keep the water temperature constant by using a temperature controlled heater. Also, to reduce the chance for the bag to touch the sides of the water tank, it is preferable to elevate the water tank to a level at which the sample can be placed on the weighing mechanism while the operator is standing up (waist height), and the placement of the sample and the bag in the water tank can easily be inspected.

5.3. Sample holder for water displacement of the sample, having no sharp edges.

5.4. **Vacuum Chamber**—with a pump capable of evacuating a sealed and enclosed chamber to a pressure of 6 mm Hg, when at sea level. The device shall automatically seal the plastic bag and exhaust air back into the chamber in a controlled manner to ensure proper conformance of the plastic to the specimen. The air exhaust and vacuum operation time shall be set at the factory so that the chamber is brought to atmospheric pressure in 80 to 125 seconds, after the completion of the vacuum operations.
5.5. *A Vacuum Measurement Gauge*, independent of the vacuum sealing device, that could be placed directly inside the chamber to verify vacuum performance and the chamber door sealing condition of the unit. The gauge shall be capable of reading down to 3 mm Hg and readable to ± 1 mm Hg. The gauge shall be NIST traceable.

5.6. *Plastic Bags*, used with the vacuum device, shall have a minimum opening of 235 mm (9.25 in.) and maximum opening of 260 mm (10.25 in.). The bags shall be of plastic material, shall be puncture resistant, and shall be impermeable to water. The bags shall have a minimum thickness of 0.127mm (0.005 in.). The manufacturer shall provide the apparent specific gravity for the bags.

5.7. *Metal pycnometer and lid*, with 137 ± 0.13 mm (5.375 ± 0.005 in.) inside diameter (ID) and 89 ± 0.41 mm (3.5 ± 0.016 in.) height, for testing fine aggregates. The pycnometer shall be machined to be smooth on all surfaces. The inside of the lid shall be machined at a 5° angle to create an inverted conical surface.

5.8. *Pycnometer clamping device* to hold and secure the lid on the metal pycnometer from lifting during fine aggregate tests. The device shall be provided with a level indicator.

5.9. *Syringe* with a needle no larger in diameter than 3 mm (0.125 in.)

5.10. Thermometer or other temperature device with range to 40ºC (100ºF) accurate to ±1º.

5.11. *Isopropyl alcohol – Technical Grade.*

5.12. *Accessories*— A bag cutting knife or scissors, spray bottle for the isopropyl alcohol, a bucket large enough to allow the pycnometer to be fully submerged in water, water containers to dispense water into pycnometer during testing, small paint brush and 25 mm (1 in.) wide aluminum spatula.

### 6. VERIFICATION

6.1. System Verification: The vacuum settings of the vacuum chamber shall be verified once every 12 months and after major repairs and after each shipment or relocation.

6.1.1. Place the gauge inside the vacuum chamber and record the setting, while the vacuum unit is operating. The gauge should indicate a pressure of 6 mm Hg or less. The unit shall not be used if the gauge reading is above 6 mm Hg.

**Note 2**— In line vacuum gauges, while capable of indicating vacuum performance of the pump, are not suitable for use in enclosed vacuum chambers and cannot accurately measure vacuum levels.

6.2. Calibration of Pycnometer:

6.2.1. Prior to testing, condition the pycnometer to 25 ± 1ºC (77 ± 2ºF) by placing it inside a bucket of water that is maintained at 25 ± 1ºC (77 ± 2ºF). Place the pycnometer clamping device on a level surface. Use a level indicator or the provided level to level the device.

**Note 3** – The clamping device must be protected from hot or cold ambient laboratory temperatures that are more or less than 25 ± 1ºC (77 ± 2ºF).

6.2.2. Remove the pycnometer from the water bucket and dry it with a towel. Place the pycnometer in the device and push it back until it makes contact with the stops.
6.2.3. Fill the pycnometer with 25 ± 1°C (77 ± 2°F) water to approximately 10 mm (0.375 in.) from the top. Using the alcohol spray bottle, spray the surface of the water to remove bubbles.

6.2.4. Gently place the lid on the pycnometer and close the clamps on the device.

6.2.5. Using a syringe filled with 25 ± 1°C (77 ± 2°F) water, slowly fill the pycnometer through the large fill hole on the lid post. Make sure the syringe tip is far enough in the pycnometer to be below the water level. Gentle application in this step prevents formation of air bubbles inside the pycnometer.

6.2.6. Fill the pycnometer until water comes out of the 3 mm (1/8-in.) hole on the surface of the lid.

6.2.7. Wipe any remaining water from the top of the lid with a towel.

6.2.8. Place the entire device with the pycnometer on the scale and record the mass. Record the mass to 0.1 in the top portion of the Aggregate Worksheet. (See Appendix 1)

6.2.9. Clean the pycnometer and repeat steps 6.2.1 to 6.2.8 two more times and average the calibration masses obtained in 6.2.8.

6.2.10. If the range for the 3 calibration masses is larger than 0.5 grams, then the test is not being run correctly. Check to see if the device is level. Make certain the water injection with the syringe is done below the pycnometer water surface and is applied gently. Check the water temperature. Check the pycnometer temperature. Repeat the above procedure until you have three masses that are within a 0.5 gram range.

6.2.11. The pycnometer must be re-calibrated daily prior to testing.

7. **SAMPLING**

   7.1. Sampling shall be performed in accordance with AASHTO T 2.

   7.2. Samples shall be dried to constant mass in accordance with AASHTO T 255.

   7.3. Samples shall be reduced in accordance with AASHTO R 76.

8. **PROCEDURES**

   8.1. *Equipment Preparation*

      **Note 4** – Make certain water temperature used for this test remains at 25 ± 1°C (77 ± 2°F).

   8.1.1. Prior to testing, condition the pycnometer to 25 ± 1°C (77 ± 2°F) by placing it inside a bucket of water that is maintained at 25 ± 1°C (77 ± 2°F).

   8.1.2. Remove the pycnometer from the water bucket and dry thoroughly with a towel.

   8.1.3. Place the pycnometer clamping device on a level surface. Use a level indicator or the provided level to level the device.

   8.1.4. Place the empty pycnometer in the pycnometer clamping device and push it back until it makes contact with the stops.

   8.2. *Determine Bulk Specific Gravity*
8.2.1. Oven dry to constant mass according to AASHTO T 255, enough fine aggregate to obtain three 500 gram samples and one 1000 gram sample, reduced according to AASHTO R 76.

8.2.2. Allow the sample to cool to 25 ± 1°C (77 ± 2°F).

8.2.3. Determine the mass of a 500 ± 1 gram dry sample, Trial 1, that is at 25 ± 1°C (77 ± 2°F) and record to 0.1 on the Aggregate Worksheet.

8.2.4. Steps 8.2.5 to 8.2.13 shall be completed in less than 2 minutes.

8.2.5. Place approximately 500 ml of 25 ± 1°C (77 ± 2°F) water in the pycnometer (halfway full).

8.2.6. Slowly and evenly pour the sample into the pycnometer. Make certain aggregate is not lost in the process of filling the pycnometer. Use a brush if necessary to sweep any remaining fines into the pycnometer. If any aggregate is lost during the process of filling the pycnometer, start the test over.

8.2.7. Use a metal spatula and push it to the bottom of the pycnometer against the inside circumference. Slowly and gently drag the spatula to the center of the pycnometer, removing the spatula after reaching the center. Repeat this procedure in eight equal increments until the entire circumference is covered. If necessary, use a squeeze water bottle to rinse any sample residue off the spatula into the pycnometer.

8.2.8. Fill the pycnometer with 25 ± 1°C (77 ± 2°F) water to approximately 10 mm (0.375 in.) of the pycnometer rim. It is important the water level be kept at or below the 10 mm line to avoid spills during lid placement.

8.2.9. Use the spray bottle filled with isopropyl alcohol to spray the top of the water to remove air bubbles.

8.2.10. Gently place the lid on the pycnometer and lock the clamping device. Using the syringe, slowly fill the pycnometer through the center hole on top of the lid post. Make sure the syringe tip is far enough in the pycnometer to be below the water level. Gentle application in this step will prevent formation of air bubbles inside the pycnometer.

8.2.11. Fill the pycnometer until water comes out of the 3 mm (1/8-in.) hole on the surface of the lid.

8.2.12. Wipe any remaining water from around the 3 mm (1/8-in.) hole with a towel.

Note 5 – Do not wipe water from the rim of the pycnometer if it seeps between the lid and the pycnometer. Allow this water to remain.

8.2.13. Determine the mass of the sample, the pycnometer and the device. Record the mass to 0.1 in B of the Aggregate Worksheet.

8.2.14. Discard the sample and prepare the equipment according to step 8.1.1 to 8.1.4.

8.2.15. Repeat steps 8.2.3 to 8.2.13 for another 500 ± 1 gram sample, Trial 2.

8.2.15.1. The difference in the mass of Trial 1 and Trial 2 recorded in B must be 1.0 gram or less. If the difference is greater than 1.0, then repeat steps 8.2.14 and 8.2.15 using another 500 ±1 gram dry sample.

8.2.16. Calculate the average mass for the two trials that are within 1 gram; record to 0.1 on Aggregate Worksheet.
8.2.17. Record the average weight of the pycnometer from section 6.2.9 on Aggregate Worksheet.

8.3. Determine Apparent Specific Gravity

8.3.1. Set the vacuum device according to manufacturer’s recommendation.

8.3.2. Tare the immersed weighing basket in the water bath.

8.3.3. Use a small plastic bag and inspect the bag to make sure there are no holes, stress points or side seal discontinuities in the bag. If any of the above conditions are noticed, use another bag.

8.3.4. Determine the mass of the bag and record to 0.1 on Aggregate Worksheet.

Note 6—Always handle the bag with care to avoid creating weak points and punctures.

8.3.5. Determine the mass of a 1000 ± 1 gram sample of oven dry aggregate and record 0.1 at E on Aggregate Worksheet.

8.3.6. Place the sample in the bag. Support the bottom of the bag on a smooth tabletop when pouring the aggregate to protect against punctures and impact points.

8.3.7. Place the bag containing the sample inside the vacuum chamber.

8.3.8. Grab the two sides of the bag and spread the sample flat by gently shaking the bag side to side. Do not press down or spread the sample from outside the bag. Pressing down on the sample from outside the bag will cause the bag to puncture and will negatively impact the results. Lightly spray mist aggregates with high minus 75-μm (No. 200) sieve material to hold down dust prior to sealing.

8.3.9. Place the open end of the bag over the seal bar and close the chamber door. The unit will draw a vacuum and seal the bag, before the chamber door opens.

8.3.10. Gently remove the sample from the chamber and immediately (within 5 seconds) submerge the sample in the water bath equipped with a balance for water displacement analysis.

Note 7 - It is extremely important the bag be removed from the vacuum chamber and immediately placed in the water bath. Leaving the bag in the vacuum chamber or on a bench top after sealing can cause air to slowly enter the bag and can result in low apparent specific gravity results.

8.3.11. Completely submerge the bag at least 2-inches below the surface of the water during cutting.

8.3.12. Make a small cut across the top edge of the immersed bag approximately 25 to 50 mm (1 to 2 in.).

8.3.13. Hold the immersed bag open at the cut for approximately 45 seconds allowing the water to freely flow into the bag. Allow any small residual air bubbles to escape. Do not shake or squeeze the sample, as these actions will cause the fines to escape from the bag.

8.3.14. After water has filled in, make another cut on the opposite side of the immersed bag approximately 25 to 50 mm (1 to 2 in.). Squeeze any residual air bubbles on top portion of the bag through the openings by running your fingers across the top of the bag. Do not completely remove any portion from the bag nor allow any portion of the bag to reach the surface of the water. Keep the sample and bag at least 2-inches below the surface of the water at all times.
8.3.15. Place the bag containing the sample in the immersed weighing basket to obtain the underwater mass. Allow water to freely flow into the bag. Make certain the bag or the sample are not touching the bottom, the sides, or floating out of the water bath.

8.3.16. Allow the sample to stay in the water bath for a minimum of fifteen (15) minutes but not more than 20 minutes.

8.3.17. Record the submerged mass on the Aggregate Worksheet and wait one minute. If after this time the mass increases by more than one-gram, wait an additional five minutes. Record the mass and continue this process until the mass stops increasing.

9. **CALCULATIONS**

9.1. Test result calculations for percent absorption, apparent specific gravity and bulk specific gravity will be obtained from the software supplied by the manufacturer. Use the data from the Aggregate Worksheet. The software will provide a report of the test results.

9.2. The final test result will be determined from an average of two laboratory specimens.
### Appendix 1
Aggregate Worksheet

**Weight of pycnometer and clamping device filled with water.**

<table>
<thead>
<tr>
<th>Sample Number or Label</th>
<th>Trial Number</th>
<th>A</th>
<th>B</th>
<th>C</th>
<th>D</th>
<th>E</th>
<th>F</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td>Dry Sample Mass (500 g)</td>
<td>Mass of pycnometer with sample and water (g)</td>
<td>Plastic Bag Mass (g)</td>
<td>Mass of two rubber sheets (g)</td>
<td>Dry Sample Mass (1000 g)</td>
<td>Mass of Sealed sample opened under water</td>
</tr>
<tr>
<td>1</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>2</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>3*</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Avg</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>1</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>2</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>3*</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Avg</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

* Trial 3 is only necessary if the mass in B for the first 2 trials is larger than 1.0 grams.
## PERFORMANCE EXAM CHECKLIST

### SPECIFIC GRAVITY AND ABSORPTION OF FINE AGGREGATE USING AUTOMATIC VACUUM SEALING (CORELOK) METHOD

**IDAHO IT-144-08**

<table>
<thead>
<tr>
<th>Verification Element</th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>1. Pycnometer and lid placed inside a bucket of water at 25 ± 1C (77 ± 2F)</td>
<td>______</td>
<td>______</td>
</tr>
<tr>
<td>2. Pycnometer and lid removed from water dried well and placed on clamping device until it makes contact with stops?</td>
<td>______</td>
<td>______</td>
</tr>
<tr>
<td>3. Pycnometer filled with 25 ± 1C (77 ± 2F) water to 10mm (3/8&quot;) of top, sprayed with Isopropyl alcohol to remove air?</td>
<td>______</td>
<td>______</td>
</tr>
<tr>
<td>4. Lid gently placed on Pycnometer and clamped?</td>
<td>______</td>
<td>______</td>
</tr>
<tr>
<td>5. A syringe filled with 25 ± 1C (77 ± 2F) inserted in top of lid and gently added until water is expelled through the 3mm (1/8&quot;) hole?</td>
<td>______</td>
<td>______</td>
</tr>
<tr>
<td>6. Water wiped from lid, device water and pycnometer weighed and recorded to</td>
<td>______</td>
<td>______</td>
</tr>
<tr>
<td>7. Procedure repeated two additional times (no greater than 0.5 g difference)</td>
<td>______</td>
<td>______</td>
</tr>
<tr>
<td>recorded to work sheet and averaged?</td>
<td>______</td>
<td>______</td>
</tr>
</tbody>
</table>

### Procedure Element

<table>
<thead>
<tr>
<th>Procedure Element</th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>8. Representative samples obtained per FOP for AASHTO T 2?</td>
<td>______</td>
<td>______</td>
</tr>
<tr>
<td>9. Reduced per FOP for AASHTO R 76?</td>
<td>______</td>
<td>______</td>
</tr>
<tr>
<td>10. Dried per FOP for AASHTO T 255?</td>
<td>______</td>
<td>______</td>
</tr>
<tr>
<td>11. Samples cooled to 25 ±1C (77 ± 2F)?</td>
<td>______</td>
<td>______</td>
</tr>
<tr>
<td>12. Three samples obtained @ 500g ±1g and one @ 1000g ± 1g?</td>
<td>______</td>
<td>______</td>
</tr>
<tr>
<td>13. Pycnometer and lid removed from water, dried and pycnometer placed on clamping device until it makes contact with stops?</td>
<td>______</td>
<td>______</td>
</tr>
<tr>
<td>14. Water added to pycnometer (at 25 ± 1C, 77 ± 2F) to approximately half full?</td>
<td>______</td>
<td>______</td>
</tr>
</tbody>
</table>

Record ‘P’ For Passing “F” for failing each step of the checklist.
<table>
<thead>
<tr>
<th>Procedure Element</th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>15. Sample at 500 g ± 1g slowly added to pycnometer?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>16. Metal spatula inserted against side of pycnometer and slowly pushed to center</td>
<td></td>
<td></td>
</tr>
<tr>
<td>removed, repeated in eight equal increments?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>17. Water added at 25 ± 1C (77 ± 2F) to within 10mm (3/8”) of rim?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>18. Sprayed with isopropyl alcohol to remove air?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>19. Lid gently placed on pycnometer with 3mm (1/8”) hole to the front and</td>
<td></td>
<td></td>
</tr>
<tr>
<td>clamped?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>20. Syringe filled with 25 ± 1C (77 ± 2F) water inserted in top of lid and water</td>
<td></td>
<td></td>
</tr>
<tr>
<td>slowly added until it is expelled through 3mm (1/8”) hole?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>21. Excess water wiped from lid?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>22. Clamping device, pycnometer and sample mass recorded to 0.1 g?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>23. Clamping device, pycnometer and sample mass determined no more than 2 minutes</td>
<td></td>
<td></td>
</tr>
<tr>
<td>from time sample was submerged?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>24. Second 500g ± 1 g sample tested and mass recorded?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>25. If recorded mass of first and second sample greater than 1 g, was a third 500</td>
<td></td>
<td></td>
</tr>
<tr>
<td>g ± 1 g sample tested?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>26. Vacuum device set at manufacture’s recommended setting?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>27. Small plastic bag inspected and mass determined to 0.1 g and recorded?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>28. 1000 g ± 1 g sample mass determined and recorded?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>29. 1000 g ± 1 g sample placed in the bag, supported by a smooth surface to</td>
<td></td>
<td></td>
</tr>
<tr>
<td>prevent punctures?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>30. Sample placed in vacuum device and spread flat by grasping both sides of</td>
<td></td>
<td></td>
</tr>
<tr>
<td>bag and gently shaking?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>31. Open end of bag placed over seal bar and closed?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>32. Sample removed from vacuum chamber when door opens and submerged in 25 ± 1C</td>
<td></td>
<td></td>
</tr>
<tr>
<td>(77 ± 2F) water bath within 5 seconds?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>33. Bag maintained at a minimum depth of two inches?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>34. A small cut made at corner of bag approximately 25 to 50mm (1” to 2”)?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>35. Submerged bag held open until water flows freely into bag (approximately 45</td>
<td></td>
<td></td>
</tr>
<tr>
<td>seconds)</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Procedure Element</td>
<td>Trial 1</td>
<td>Trial 2</td>
</tr>
<tr>
<td>----------------------------------------------------------------------------------</td>
<td>---------</td>
<td>---------</td>
</tr>
<tr>
<td>36. A second cut approximately 25 to 50mm (1” to 2”) made to opposite side of bag?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>37. Residual air removed from bag by running fingers across top of submerged bag?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>38. Bag placed in weighing basket and water allowed to flow freely into bag?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>39. Sample mass determined and recorded after 15 minutes but not more than 20 minutes and recorded to 0.1g?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>40. Test data entered into manufacture’s software to obtain test results?</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

**COMMENTS:** First Attempt: Pass ☐ Fail ☐  Second Attempt: Pass ☐ Fail ☐

Examiner Signature: ___________________________  Sampler / Tester Qualification # ____________

Examiner Signature: ___________________________  Sampler / Tester Qualification # ____________
Idaho Standard Practice for

Design of Seal Coats and Single Surface Treatments by the McLeod Method

Idaho IR-63-13

1. Scope

In the late 1960's Norman McLeod (1969) presented the following design method which was later adapted by the Asphalt Institute (1979, 1983) and the Asphalt Emulsion Manufacturers Association (1981). In this method, the aggregate application rate depends on the aggregate gradation, shape, and specific gravity. The binder application rate depends on the aggregate gradation, absorption and shape, traffic volume, existing pavement condition, and the residual asphalt content of the binder. It should be noted that this method was developed primarily for use with emulsion binders and has not been verified in Idaho.

The McLeod method is based on two basic principles:

<p>| | |</p>
<table>
<thead>
<tr>
<th></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>1.</td>
<td>The application rate of a given aggregate should be determined such that the resulting seal coat will be one-stone thick. This amount of aggregate will remain constant, regardless of the binder type or pavement condition.</td>
</tr>
<tr>
<td>2.</td>
<td>The voids in the aggregate layer need to be 70 percent filled with asphalt for good performance on pavements with moderate levels of traffic.</td>
</tr>
</tbody>
</table>

---

2. Design Procedure Components

2.1 Median Particle Size. The Median Particle Size (M) is determined from the aggregate gradation chart. It is the theoretical sieve size through which 50 percent of the material passes. The following sieve sizes should be used:

<table>
<thead>
<tr>
<th>Sieve Sizes</th>
</tr>
</thead>
<tbody>
<tr>
<td>1 inch</td>
</tr>
<tr>
<td>¼ inch</td>
</tr>
<tr>
<td>½ inch</td>
</tr>
<tr>
<td>Inch</td>
</tr>
<tr>
<td>¼ inch</td>
</tr>
<tr>
<td>No. 4</td>
</tr>
<tr>
<td>No. 8</td>
</tr>
</tbody>
</table>
2.2 Flakiness Index. The flakiness index ($F$) is a measure of the percent, by weight, of flat particles. It is determined by testing a sample of the aggregate particles for their ability to fit through a slotted plate (Idaho IR-64-09).

2.3 Average Least Dimension. The Average Least Dimension, or ALD ($H$), is determined from the Median Particle Size and the Flakiness Index. It is a reduction of the Median Particle Size after accounting for flat particles. It represents the expected seal coat thickness in the wheel paths where traffic forces the aggregate particles to lie on their fattest side. The ALD is calculated as follows:

$$H = \frac{M}{1.139285 + 0.011506 \cdot FI}$$

Where:
- $H$ = Average Least Dimension, inches
- $M$ = Median Particle Size, inches
- $FI$ = Flakiness Index, percent

2.4 Loose Unit Weight of the Cover Aggregate. The dry loose unit weight ($W$) is determined according to AASHTO T-19 and is needed to calculate the voids in the aggregate in a loose condition. The loose unit weight is used to calculate the air voids expected between the stones after initial rolling. It depends on the gradation, shape, and specific gravity of the aggregate.

2.5 Voids in the Loose Aggregate. The voids in the loose aggregate ($V$) approximate the voids present when the stones are dropped from the spreader onto the pavement. Generally, this value will be near 50 percent for one size of aggregate, less for graded aggregate. After initial rolling, the voids are assumed to be reduced to 30 percent and will reach a low of about 20 percent after sufficient traffic has oriented the stones on their fattest side. However, if there is very little traffic, the voids will remain 30 percent, and the seal will require more binder to ensure good aggregate retention. The following equation is used to calculate the voids in the loose aggregate:

$$V = 1 - \frac{W}{62.4G}$$

Where:
- $V$ = Voids in the loose aggregate, in percent expressed as a decimal
- $W$ = Loose unit weight of the cover aggregate, lbs/ft$^3$
- $G$ = Bulk specific gravity of the aggregate (AASHTO T 19).
**2.6 Aggregate Absorption.** Most aggregates absorb some of the binder applied to the roadway. The design procedure should be able to correct for this condition to ensure enough binder will remain on the pavement surface. McLeod suggests an absorption correction factor, A or 0.02 gal/SY if the aggregate absorption is around 2 percent (as determined from AASHTO T-84). In the Minnesota Seal Coat Handbook, it is recommended that a correction factor of 2 percent be used if the absorption is 1.5 percent or higher.

**2.7 Traffic Volume.** The traffic volume, in terms of vehicles per day, plays a role in determining the amount of asphalt binder needed to sufficiently embed the aggregate. Typically, the higher the traffic volume, the lower the binder application rate. At first glance, this may not seem correct. However, remember that traffic forces the aggregate particles to lie on their flattest side. If a roadway had no traffic, the particles would be lying in the same orientation as when they were first rolled during construction. As a result, they would stand taller and need more asphalt binder to achieve the ultimate 70 percent embedment. With enough traffic, the aggregate particles will be laying as flat as possible causing the seal coat to be as thin as possible. If this is not taken into account, the wheelpaths will likely bleed. The McLeod procedure uses Table 63-1 to estimate the required embedment, based on the number of vehicles per day on the roadway.

<table>
<thead>
<tr>
<th>Table 63-1, Traffic Correction Factor, T</th>
</tr>
</thead>
<tbody>
<tr>
<td>Traffic Factor*</td>
</tr>
<tr>
<td>Traffic – Vehicles per day</td>
</tr>
<tr>
<td>Under 100</td>
</tr>
<tr>
<td>100 to 500</td>
</tr>
<tr>
<td>500 to 1000</td>
</tr>
<tr>
<td>1000 to 2000</td>
</tr>
<tr>
<td>Over 2000</td>
</tr>
</tbody>
</table>

*The percentage, expressed as a decimal, of the ultimate 20 percent void space in the aggregate to be filled with asphalt.

**Note:** The factors above do not make allowance for absorption by the road surface or by absorptive aggregate.

**2.8 Traffic Whip-Off.** The McLeod method also recognizes that some of the aggregate will get thrown to the side of the roadway by passing vehicles as the seal coat is curing. This loss is related to the speed and number of vehicles on the new seal coat. To account for this, a traffic whip-off factor (E) is included in the aggregate design equation. A reasonable value is to assume 5 percent for low volume, residential type and 10 percent for higher speed roadways. The traffic whip-off factor is shown in Table 63-2.

<table>
<thead>
<tr>
<th>Table 63-2. Aggregate Wastage Factor, E*</th>
</tr>
</thead>
<tbody>
<tr>
<td>Percentage Waste Allowed for Traffic Whip-Off and Handling</td>
</tr>
<tr>
<td>1</td>
</tr>
<tr>
<td>2</td>
</tr>
<tr>
<td>3</td>
</tr>
<tr>
<td>4</td>
</tr>
</tbody>
</table>
2.9 Existing Pavement Condition. The condition of the existing pavement plays a major role in the amount of binder required to obtain proper embedment. A new smooth pavement with low air voids will not absorb much of the binder applied to it. Conversely, a dry porous and pocked pavement surface can absorb much of the applied binder. Failure to recognize when to increase or decrease binder application rate to account for the pavement condition can lead to excessive stone loss or bleeding. The McLeod method uses the descriptions and factors in Table 63-3 to add or reduce the amount of binder to apply in the field.

<table>
<thead>
<tr>
<th>Existing Pavement Texture</th>
<th>Correction, S</th>
</tr>
</thead>
<tbody>
<tr>
<td>Black, flushed asphalt surface</td>
<td>-0.01 to 0.06</td>
</tr>
<tr>
<td>Smooth, nonporous surface</td>
<td>0.00</td>
</tr>
<tr>
<td>Slightly porous, oxidized surface</td>
<td>+ 0.03</td>
</tr>
<tr>
<td>Slightly pocked, porous, oxidized surface</td>
<td>+ 0.06</td>
</tr>
<tr>
<td>Badly pocked, porous, oxidized surface</td>
<td>+0.09</td>
</tr>
</tbody>
</table>

These surface conditions may vary throughout the project, and adjustments should be made accordingly.

3. McLeod Seal Coat Design Equations

The following equations are used to determine the aggregate and binder application rates. While the results may need adjustment in the field, especially the binder application rate, they have been shown to provide a close approximation of the correct material quantities.

3.1 Aggregate Design Equation. The aggregate application rate is determined from the following equation:

*Equation 63-3*  
\[ C = 46.8 \left(1 - 0.4V \right) \text{ HGE} \]
Where:
C = Aggregate application rate, lbs/SY
V = Voids in the loose aggregate, in percent expressed as a decimal (Eq. 63-2)
H = Average least dimension, inches
G = Bulk specific gravity of the aggregate
E = Wastage factor for traffic whip-off (Table 63-2)

3.2 Binder Design Equation. The binder application rate is determined as follows:

Equation 63-4 \[ B = \frac{2.244HTV + S + A}{R} \]

Where:
B = Binder application rate, gal/SY
H = Average least dimension, inches
T = Traffic Correction Factor (based on vehicles per day, Table 63-1)
V = Voids in loose aggregate, percent expressed as decimal (Eq. 63-2)
S = Surface condition factor, gal/SY (based on existing surface, Table 63-3)
A = Aggregate absorption factor, gal/SY
R = Percent residual asphalt in the emulsion expressed as a decimal. Check with supplier to determine percent residual asphalt content of emulsion. For asphalt cement, R = 1.
Idaho Standard Practice for

Acceptance Test Strip for Hot Mix Asphalt (HMA) Pavement

IDAHO Designation: IR-125-16

1. SCOPE

1.1. This Standard Practice is used to:

1.1.1. obtain density gauge readings to establish density gauge correlation factors (State and Contractor)

1.1.2. obtain cores for determining the density gauge correlation factors

1.1.3. obtain loose mix samples for test strip acceptance testing (Contractor)

1.1.4. obtain cold feed aggregate samples for test strip acceptance testing (Contractor)

1.1.5. confirm the HMA can be compacted to the minimum of 92.0% but not in excess of 96.0% density

1.1.6. develop a roller pattern to achieve the specified density

1.2. This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.

2. REFERENCE DOCUMENTS

2.1 AASHTO Standards

- FOP for T 168, Sampling Bituminous Paving Mixtures
- FOP for T 2, Sampling Aggregates
- FOP for T 343, Density of In-Place Hot Mix Asphalt (HMA) Pavement by Electronic Surface Contact Devices, Method C
- FOP for T 355, In-Place Density of Asphalt Mixtures by Nuclear Methods
- FOP for R 67, Sampling Asphalt Mixtures After Compaction (Obtaining Cores)

2.2 Standard Specifications, Subsection 405.03-A.

3. SUMMARY OF THE PRACTICE

3.1. This practice describes the testing and analysis needed to develop an Acceptance Test Strip to allow the Contractor to verify the mixture properties of the approved Job Mix Formula; establish density gauge correlation factors; develop a roller pattern that achieves the specified field density.
4. **APPARATUS**

4.1. **Sampling Device.**— As specified in FOP for AASHTO T 168.

4.2. **Density Gauge.**— With accessory equipment as specified in FOP for AASHTO T 355 or FOP for AASHTO T 343.

4.3. **Coring Equipment**— With accessories as specified in FOP for AASHTO R 67 for collecting six-inch diameter pavement cores.

4.4. **Measuring Device**— Approved measuring device capable of measuring test strip length.

5. **TERMINOLOGY**

5.1. **Acceptance Test Strip**— One or more Test Sections, the total length not less than 1,000 feet or more than 2,500 feet. The Acceptance Test Strip shall be constructed to the same placement width and thickness as the course it represents. (Figure 1)

5.2. **Test Section**— A minimum of 500 feet (continuous) in length within the Acceptance Test Strip, constructed with a single asphalt binder content. A separate Test Section is required for each asphalt binder content used in the Acceptance Test Strip. (Figure 1)

5.3. **Roller Pass Density**— An uncorrected density reading determined using a density gauge in backscatter mode following a roller pass. The Roller Pass Density shall consist of one one-minute count with the density gauge placed parallel to the direction of travel. Filler material is not required and a core correlation will not be applied to these density readings.

5.4. **Maximum Roller Pass Density**— The uncorrected density reading following the roller pass which adds no more than 1/2 pound per cubic foot (8 kg/m³) to the previous density value. This shall be accomplished during the intermediate rolling. Sufficient roller passes shall be made to determine that a "false" break or leveling-off point is not used for the Maximum Roller Pass Density.

5.5. **Test Site Density**— The uncorrected density reading taken on the compacted pavement after finish rolling is complete at a Test Site for correlation to cores. It is obtained by using the test procedure specified in FOP for AASHTO T 355 or FOP for AASHTO T 343, without applying a gauge correlation factor. Filler material shall be applied as required in procedure before taking Test Site Density readings.

5.6. **Roller Pass**— The passing of the roller over an area (roller width) one time.

5.7. **Roller Coverage**— The rolling of the entire width of the pavement one time, including roller overlap.

5.7.1. **Breakdown Rolling**— Constitutes the first roller coverage.

5.7.2. **Intermediate Rolling**— Constitutes all rolling after the breakdown rolling and prior to the mix reaching the minimum temperature specified by the contract for such rolling.

5.7.3. **Finish Rolling**— Constitutes the roller coverage, after intermediate rolling, required to bring the mix into a smooth, tight, hard surface without the presence of fatigue or cold-brittle cracking.

5.8. **Roller Pattern**— The number of roller passes necessary to achieve the specified density.
5.9. *Stratified Random Sampling of HMA* — method used to ensure the specimens for the sample are obtained from throughout the Test Section, and are not concentrated in one portion of the Test Section. All sample locations will be determined by the Engineer using a random sampling system.

5.10. *Off Site JMF Verification* — off-project site location selected by the Contractor to verify aggregate and mixture parameter testing for contract requirements at a location and time agreed upon by the Engineer.

5.11. *Density Gauge Correlation Section for Off Site JMF Verification* — the first one-thousand feet of the first day’s paving used to determine the properties and density gauge correlation when an Off Site JMF Verification location is used. (Figure 2)

6. **PROCEDURE**

6.1. An Acceptance Test Strip shall be constructed after a uniform asphalt mix is being produced. The Acceptance Test Strip may be constructed using one or more Test Sections. The asphalt binder content of each Test Section must meet all specification requirements.

6.2. The Contractor shall obtain cold feed aggregate samples in accordance with the Specifications. Sampling will be determined by the Engineer using a random sampling system.

6.3. The Contractor shall obtain three loose mix samples from each Test Section in accordance with the specifications. Each Test Section will be divided into 3 segments of equal length and a loose mix sample will be obtained randomly from each segment by the contractor for acceptance testing. Exclude the first and last 30 feet of each section when selecting sample locations. (See Figure 1)

6.4. Each test section will be divided into 5 segments of equal length and test sites for cores and density reading will be obtained randomly from each segment. A minimum of five cores will be required to correlate the density gauges for a test strip. (See FOP for AASHTO T 355 or FOP for AASHTO T 343).

6.5. Standardize the density gauge. Refer to FOP for AASHTO T 355 or FOP for AASHTO T 343.

6.6. The Contractor shall compact each Test Section and record Roller Pass Densities in at least one location within each Test Section but no less than two per Test Strip. When density gauge readings indicate the Maximum Roller Pass Density has been achieved in a Test Section, compaction shall proceed in turn to each of the remaining Test Sections, if applicable, in the Acceptance Test Strip.

6.7. The Contractor shall record the temperature of the pavement following each roller pass on ITD Form ITD 891 to monitor the drop in mix temperature as rolling progresses in at least one location within each Test Section. Temperature readings shall be taken at the mid-point of the depth of pavement being tested.

6.8. Upon completion of all Test Sections in the Acceptance Test Strip, Test Site Densities (Subsection 5.5) shall be taken for each gauge to be used on the project for Quality Control or Acceptance Testing to determine a correlation factor according to FOP for AASHTO T 355 or FOP for AASHTO T 343. Form ITD-820 will be used by the Contractor and ITD project personnel to record the Test Site Densities for each gauge at each Test Site in each Test Section.

6.8.1. A correlation factor is valid only for the particular gauge, gauge thickness settings, gauge mode setting and at the probe depth used in the correlation procedure. Multiple gauges may be correlated from the same series of cores if done at the same time. (See FOP for AASHTO T 355 or FOP for AASHTO T 343)
6.8.2. Additional core correlation factors may be required to adjust for changes in the HMA pavement.

6.8.3. Re-correlation of the gauges is necessary on each lift of pavement.

6.9. After the pavement has cooled sufficiently to avoid deformation during coring, the Contractor shall obtain one core at each Test Site in accordance with FOP for AASHTO R 67. Pavement cores shall meet the criteria under the Correlation section of AASHTO T 355 or FOP for AASHTO T 343.

6.10. **Off-Site JMF Verification.** The Contractor, at no cost to the State, may elect to perform off-site Job Mix Formula Verification testing for contract requirements at a location and time agreed upon by the Engineer. Off-Site JMF Verification must occur within 14 calendar days prior to the anticipated start of production paving.

6.10.1. The Off-Site JMF Verification Section will verify aggregate and mixture parameters only (Subsection 6.1-6.3). All other properties will be determined during a Density Gauge Correlation Section placed on the prepared surface of the project.

6.10.2. The Density Gauge Correlation Section shall follow the procedure outlined in Subsection 6.8 to 6.9 and Figure 2. Break-over patterns, density gauge correlation factors, density acceptance of the placement, and Contractor's workmanship will be verified during the Density Gauge Correlation Section. The Density Gauge Correlation Section shall be the first 1000 feet of the first day's production.

6.10.3. The Maximum Theoretical Specific Gravity, $G_{mm}$ used in the density determination will be determined from the State’s two Verification Tests on the first day’s paving plus one additional random sample.

6.10.4. The Contractor may continue production paving after completing the Density Gauge Correlation Section. The first day’s production paving is the first lot and subject to statistical analysis. Pavement placed in the Density Gauge Correlation Section may be tested for volumetric properties.

6.10.5. Materials from Department controlled sources cannot be used for Off-Site JMF Verification. The Off-Site JMF Verification location shall be accessible to ITD personnel at all times. If other than ITD property is used, written permission from the property owner shall be given for ITD employees to observe the work.

7. **REPORT**

7.1. The Contractor shall record the location, the number of roller passes, the corresponding Roller Pass Density reading, and pavement temperature following each roller pass in at least one location in each Test Section. This information shall be recorded on Form ITD-891 (Figure 2).

7.2. The Contractor shall plot Roller Pass Density readings and temperatures vs. roller passes on Form ITD-891 concurrently with the rolling. A copy of each completed Form ITD-891 shall be furnished to the Engineer upon completion of finish rolling.

7.2.1. From the cores, the Engineer will determine the density gauge correlation factors for each State gauge and core densities, percent compaction for each Test Section. Laboratory core test results will be provided to the Contractor prior to the startup of production paving for correlation of Contractor gauges. Density gauge correlation data shall be recorded on Form ITD-820 for each gauge.
Take mix samples at three stratified random locations. Take one core sample from random test sites selected in each of five stratified segments of the Acceptance Test Strip. The Contractor shall obtain three mix samples and five core samples. Exclude the first and last 30’ sections from the generation of the stratified sections.

**Figure 1: Acceptance Test Strip.**

The Contractor shall obtain one core sample from random test sites selected in each of five stratified segments of the Density Gauge Correlation Section.

**Figure 2: Density Gauge Correlation Section.**
# Plant Mix Pavement Test Strip Density Worksheet

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Distribution: White (Original) – Tester  Pink/Yellow (2 copies) – Engineer

Page _____ of _____
Idaho Standard Method of Test for

Sampling and Viscosity Testing of Emulsified Asphalt Binders in the Field

IDAHO Designation: IT-61-08

1. SCOPE

1.1. This method covers field sampling and field testing of emulsified asphalt binders used for seal coats. Testing is performed using the Saybolt Furol Viscometer.

1.2. This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.

2. REFERENCE DOCUMENTS

2.1. AASHTO Standards

- R 66, Sampling Bituminous Materials
- T 72, Saybolt Viscosity
- T 59, Testing Emulsified Asphalts (“Consistency” – “Viscosity”, Sections 34-38)

3. APPARATUS

3.1. Saybolt Furol Viscometer with Bath, conforming to the requirements of T 72 with an oil or water bath capable of maintaining the required testing temperature.

3.2. Receiving Flask - see Figure# 1

3.3. Sieve – No. 20 (850 μm) sieve or a 20-mesh strainer of wire cloth framed or unframed.

3.4. Thermometers – ASTM No. 19°F or 19°C for tests at 122°F (50°C) conforming to the requirements of ASTM No. E1.

3.5. Thief Sampling Device – Capable of obtaining a sample from mid-depth of tanker/ tank.

3.6. Timer – Capable of measuring to the nearest 0.1 second.

3.7. Sample Can - 1-quart (1 liter) small-mouth


3.9. Sample bottle -8 fl. oz. (265 mL) plastic dairy bottle

3.10. Sample bottle Stopper- with an opening to insert a dial thermometer through it and sized to fit the opening in the dairy bottle
Figure 1: Receiving Flask
Figure 2: Thief Sampling Device (Dip Method Device)
4. **SAMPLING**

4.1. The emulsified asphalt binder sample may be obtained by either of two methods. These methods are covered in R 66 but will also be covered here. They are; the “Valve method” and “Thief Method.” Samples shall be obtained before any material is unloaded.

**Note 1**—A safe means of sampling shall be provided by the contractor / supplier. With the “Thief method” proper fall protection must be provided.

4.1.1. Valve Method: A recommended design for the valve is shown in R 66.

4.1.1.1. In order to clear the line, draw and discard 4 L (1 gal) of emulsified Asphalt using a valve located in the center of the tank.

4.1.1.2. After clearing the line, immediately draw the emulsified Asphalt sample into a large mouthed 1 L (1 quart) plastic jar.

4.1.2. Thief Method (Dip Method): This method shall only be used when a truck tanker or distributor does not have a valve available to obtain the sample.

4.1.2.1. Attach the 1 L (1 quart) can at the bottom of the Thief device (see figure# 2). Stopper the can with a # 7 or #7-1/2 rubber stopper. The stopper shall have a way to remove it from the can once the can has been submerged on the thief device.

**Note 2**—Before sampling, a careful observation of the material shall be made to detect the presence of foam or free water on top of the load. Care should be taken to immerse sampling device deep enough to pass through any foam or free water that may exist on top of material.

4.1.2.2. Lower the attached stoppered 1 L (1 quart) can to mid-depth of the tanker/ tank.

4.1.2.3. Pull the stopper from the can. Allow the can to fill.

4.1.2.4. Withdraw the Thief device along with the sample and sample can from the tanker/ tank.

4.2. Immediately transfer approximately 204 mL (6 to 7 oz.) of emulsified asphalt into a 265 mL (8 fl. oz) plastic dairy bottle. Seal the container securely to eliminate the chance of evaporation of water in the sample with a rubber stopper having a small dial thermometer through its center.

**Note 3**—It is recommended that while the sample is cooling for testing clean the thief device and can stopper.

5. **TESTING**

5.1. Preheat the Sabolt Furol Viscometer bath to testing temperature 50 ± 0.05°C (122 ± 0.09°F).

5.2. Insure that the brass viscometer tube is clean and dry and that the cork inserted into the bottom of the tube.

5.3. Cool the emulsified asphalt sample to 51.7 ± 0.3°C (125 ± 0.5°F).

**Note 4**—The bottom of the sealed plastic bottle containing the emulsified asphalt sample may be immersed into a cold-water bath to cool it more quickly. Insure that thermometer is not touching the bottom of the bottle.
5.4. Once cooled, immediately pour the emulsified asphalt through a No. 20 (850 mm) sieve and into the brass viscometer tube until the sample is above the overflow rim.

5.5. Stir the emulsified asphalt sample in the brass viscometer tube at 60 RPM with a thermometer until it is at a temperature of 50°C ± 0.3°C (122°F ± 0.5°F). Avoid bubble formation while stirring. Once the test temperature is attained, withdraw the thermometer.

5.6. Place the tip of a suction pipette into the viscometer tube gallery. The gallery is the area where the overflow is contained. Quickly remove the excess emulsified asphalt from the gallery until the level in the gallery is below the overflow rim. Remove the pipette without touching the overflow rim.

5.7. Immediately cover the top of the viscometer tube.

5.8. Place the receiving flask in the proper position under the viscometer tube. Proper placement will insure that the sample will roll down the inside lip of the receiving flask.

5.9. Remove the cork from the viscometer tube and immediately start the timer.

5.10. Stop the timer when the emulsified asphalt meniscus bottom reaches the graduation mark.

5.11. Clean the viscometer tube, screen, cork, thermometer, and receiving flask.

5.12. If the initial tanker / tank sample fails to meet specified limits, a second sample will be obtained using the “Thief Method.” When the test results on the second sample also fail to meet specifications the tanker / tank will be rejected.

6. REPORT

6.1. Record the results to the nearest 1 second.

6.2. Results shall be reported on an ITD-1045, Sample Data Sheet Emulsified Asphalt and Cutbacks.
QUALIFICATION CHECKLIST
FIELD VISCOSITY – IDAHO IT 61

Record the symbols “P” for passing or “F” for failing on each step of the checklist.

### Procedure Element

#### Sampling

1. Sample taken using a valve:
   - a. Minimum of 4 L (1 gal) allowed to flow before sample taken? 
     - Trial 1: _____  
     - Trial 2: _____
   - b. Sample taken in clean 1 L (1 quart) wide mouth jar? 
     - Trial 1: _____  
     - Trial 2: _____
2. Sample taken with Thief device:
   - a. Sample can immersed approximately to middle of tanker? 
     - Trial 1: _____  
     - Trial 2: _____
   - b. Rubber stopper removed from can and sample taken from the middle of the tanker / tank? 
     - Trial 1: _____
     - Trial 2: _____
3. A portion of the sample transferred to a one (1) half pint plastic bottle and sealed with a stopper having a thermometer in the center? 
   - Trial 1: _____  
   - Trial 2: _____

#### Equipment

4. Temperature of the viscometer bath at 50°C (122°F)?  
   - Trial 1: _____  
   - Trial 2: _____
5. Viscosity tube clean and dry and cork installed?  
   - Trial 1: _____  
   - Trial 2: _____

#### Testing

6. Sample cooled to 51.7 ±0.3°C (125 ±0.5°F)?  
   - Trial 1: _____  
   - Trial 2: _____
7. Sample poured through a #20 sieve prior to entering the brass viscosity tube?  
   - Trial 1: _____  
   - Trial 2: _____
8. Enough sample poured into the tube to allow overflow into gallery?  
   - Trial 1: _____  
   - Trial 2: _____
9. Thermometer placed into tube and sample stirred slowly until testing temperature reached?  
   - Trial 1: _____  
   - Trial 2: _____
10. Thermometer withdrawn and excess in the overflow gallery siphoned out using a pipette without touching overflow rim?  
    - Trial 1: _____  
    - Trial 2: _____
11. Emulsified asphalt sample in viscometer immediately covered?  
    - Trial 1: _____  
    - Trial 2: _____
12. Cork pulled allowing the sample roll down the inside lip of the receiving flask?  
    - Trial 1: _____  
    - Trial 2: _____
13. Timer immediately started when cork is pulled?  
    - Trial 1: _____  
    - Trial 2: _____
14. Timer stopped when bottom of sample meniscus reaches graduation mark?  
    - Trial 1: _____  
    - Trial 2: _____
15. Test results reported to nearest 1 second on ITD-1045 form?  
    - Trial 1: _____  
    - Trial 2: _____

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Examiner’s Name: __________________________ Signature __________________________

WAQTC #: ______________
Idaho Standard Method of Test for

Detection of Anti-Stripping Additive in Asphalt Binder

IDAHO Designation: IT-99-17

1. SCOPE

1.1. This method covers field procedures for verifying the presence of amine based anti-stripping additives in asphalt binder. This test is qualitative only and does not indicate percentage of anti-strip.

1.2. This standard may involve hazardous materials, operations and equipment. This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.

2. SUMMARY AND SIGNIFICANCE OF METHOD

2.1. A small amount of asphalt is heated in a solution of Isopropyl Alcohol. The decanted alcohol is tested with an indicator solution of Bromophenol Blue. A visual color change indicates the presence of amine based anti-stripping additives.

3. REFERENCE DOCUMENTS


4. APPARATUS

4.1. Hotplate

4.2. 50 ml Repipet fitted for a 4L Bottle, or a 50 ml Graduated Cylinder

4.3. Glass beakers of approximately 50 ml capacity and disposable aluminum cups of approximately 120 ml capacity.

4.4. Glass stirring rods or new disposable wooden stirring sticks approximately 6 inches long

5. REAGENTS AND SOLUTIONS

5.1. Reagent Grade Isopropyl Alcohol (minimum 99.7% water free,)

   Warning - Isopropyl Alcohol is a flammable solvent and should not be used around any open flame.

   USE THE ISOPROPYL ALCOHOL DIRECTLY FROM ITS ORIGINAL BOTTLE.

5.2. Bromophenol Blue, Certified ACS Grade
5.3. The bromophenol blue indicator shall be prepared to a concentration of 0.2% (wt/vol) in reagent grade isopropyl alcohol. The indicator, a flammable solution, should be a clear, orange color and not more than two years old. The indicator solution can be obtained from the Central Laboratory.

6. SAMPLES

6.1. The asphalt binder test sample should be taken in accordance with the sampling methods described in AASHTO R 66. Allow the sample to soak for one minute from the introduction of wash water into the vessel or jar.

7. PREPARATION OF TEST SAMPLE

7.1. Heat the sample of asphalt binder with care to prevent local overheating until it has become sufficiently fluid to pour. Occasionally stir the sample to aid in heating and assure uniformity. Maximum temperature should not exceed 325°F.

   Note 1: Keep any water source or steam away from the testing area, water/water vapor will alter the test results.

8. PROCEDURE

8.1. Control Blank

8.1.1. Add 40 ml of Reagent Grade Isopropyl Alcohol into a 50 ml glass beaker or a 120 ml aluminum cup.

8.1.2. Warm the beaker and alcohol control blank on a hotplate until small boiling bubbles appear.

8.1.3. Remove beaker and alcohol from the hot plate and add 5 drops of the Bromophenol Blue Indicator solution and stir with a glass rod or wooden stick. A definite yellow color should appear. In some cases, additional drops may need to be added to achieve the yellow color. The same number of additional drops added to achieve the yellow color in the control blank must be added to the test sample to normalize the visual standard comparison.

8.1.4. A Control Blank color other than yellow indicates a contaminated blank. First verify that the alcohol is not contaminated by testing the alcohol again in different cleaned glassware. If contamination of the alcohol is verified obtain new alcohol. Provided the alcohol is acceptable, clean all testing equipment with the verified Isopropyl Alcohol again prior to testing. Replace alcohol and clean equipment as necessary until the control blank is successfully established.

8.2. Test Sample

8.2.1. Place approximately 1 g of well mixed asphalt binder to be tested into a 120 ml aluminum cup.

8.2.2. Add 40 ml of Reagent Grade Isopropyl Alcohol to the beaker or cup.

   Note 2—1 g of asphalt binder is about the size of a quarter and can be placed in the container with a glass rod or a wooden stick.

8.2.3. Warm the test sample, stirring occasionally, until the liquid portion becomes approximately the same shade of yellow as the Control Blank. Do not allow the sample to become too dark since this will interfere with the color interpretation.

8.2.4. Immediately pour the liquid portion of the mixture into a clean 50 ml glass beaker and add the same number of drops of Bromophenol Blue Indicator as was added to the Control Blank and stir.
8.2.5. Allow the sample to develop for 5 minutes before determining the color. The presence of an amine based anti-stripping additive is verified when the test solution turns green to blue and will be reported as “Positive”. Any other color shall be reported as “Negative”.

8.2.6. A negative IT-99 test result can be validated for sufficient anti-strip presence using IT-137 “Effectiveness of Anti-Strip Agents After Hot Storage In Asphalt Binder – Using Bottle and Sand” (excluding the 96 hr cure time). Validation testing for acceptance will be performed at the Central Laboratory.

8.2.7. Properly discard the liquid (alcohol and indicator) used for the Control Blank and the test sample.

**9. REPORT**

9.1. Report green to blue color as positive; report any other color as negative.
## QUALIFICATION CHECKLIST

**DETECTION OF ANTI-STRIP ADDITIVE IN ASPHALT - IDAHO IT-99**

Record the symbols "P" for passing or "F" for failing on each step of the checklist.

### Procedure Element

**General**

<table>
<thead>
<tr>
<th>Procedure Element</th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>1. All containers and or stir sticks were clean and chemical solutions were fresh.</td>
<td>______</td>
<td>______</td>
</tr>
</tbody>
</table>

**Detection test by Color Method only**

<table>
<thead>
<tr>
<th>Procedure Element</th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>2. A control blank was performed.</td>
<td>______</td>
<td>______</td>
</tr>
<tr>
<td>3. 40ml of Reagent Isopropyl Alcohol or equivalent was used.</td>
<td>______</td>
<td>______</td>
</tr>
<tr>
<td>4. The asphalt mixture was heated on a hot plate.</td>
<td>______</td>
<td>______</td>
</tr>
<tr>
<td>5. Heating of sample was stopped before mixture became too dark.</td>
<td>______</td>
<td>______</td>
</tr>
<tr>
<td>6. The same amount of Bromphenol Blue Indicator was added to both mixtures.</td>
<td>______</td>
<td>______</td>
</tr>
<tr>
<td>7. Test results were accurately interpreted and recorded on the proper ITD form. (Blue color as positive; report any other color change as negative).</td>
<td>______</td>
<td>______</td>
</tr>
</tbody>
</table>

Comments: First Attempt: Pass [ ] Fail [ ] Second Attempt: Pass [ ] Fail [ ]

Testing Technician's Name: __________________________ WAQTC #: ______ Date: ______

Examiner's Name: __________________________ Signature __________________________
Idaho Standard Method of Test for

Effectiveness of Anti-Strip Agents After Hot Storage in Asphalt Binder Using Bottle and Sand

IDAHO Designation: IT-137-17

1. SCOPE

1.1. This procedure provides results for anti-strip agent effectiveness in asphalt binder after hot storage.

1.2. This method is applicable on asphalt binders that become liquid at temperatures above 100°F.

1.3. This method is for acceptance of amine based anti-strip additives.

1.4. *This standard may involve hazardous materials, operations and equipment. This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

2. SUMMARY AND SIGNIFICANCE OF METHOD

2.1. This test will confirm the presence of anti-strip agents to withstand hot storage without conducting the immersion compression testing. The test results from this method and the IT-99 test method will confirm the effective presence of anti-strip additive in received and stored asphaltic binders.

2.2. Approval will be based on a concentration of 0.5 % (wt/wt) anti-strip to asphalt binder.

3. REFERENCE DOCUMENTS

3.1. *AASHTO Standards*

   - M 231, Weighing Devices Used in the Testing of Materials

3.2. *ASTM Standards*

   - C778, Standard Specification for Standard Sand
   - D1193, Standard Specification for Reagent Water

3.3. *Idaho Test Methods*

   - IT-99, Detection of Anti-Stripping Additive in Asphalt Binder

3.4. *Standard Specifications for Highway Construction*

   - Subsection 702.04.
4. REAGENTS AND MATERIALS


4.2. Distilled Water—ASTM D1193, Type I.

4.3. Toluene—Technical Grade

4.4. Asphalt binder

4.5. Anti-strip Additive

5. APPARATUS

5.1. Oven capable of maintaining a temperature of 325°F ± 5°F

5.2. A new one quart metal can, dimension: L= 4.625” W= 2.375” H= 7.25” with opening of 1.75”. There shall be a tightly fitting screw top lid with an air hole 0.25” in diameter punched in it.

5.3. White Paper towels

5.4. Spatula, glass stir rod, new disposable wooden stick or other utensil for mixing purposes

5.5. Plastic bottles with snap top cap, approximately 2 oz. (60 ml) capacity (Polystyrene containers: 15 dram, I.D. 32 mm X H 64 mm)

5.6. Tinfoil cup of approximately 4 fl. oz. (115 ml) capacity

5.7. Balance conforming to AASHTO M 231 Class G 2.

6. PROCEDURE

6.1. Heat the sample of asphalt binder until it has become sufficiently fluid to pour. Take care to prevent local overheating. Occasionally stir the binder to aid heat transfer and assure uniformity. The maximum temperature shall not exceed 330°F.

6.2. Heat the anti-strip additive, do not exceed 100°F or manufacturers recommended temperature and mix thoroughly.

6.3. Place 796 ± 1.0 g of asphalt binder into the one-quart metal can container.

6.4. Add 4 ± 0.1 g of anti-strip additive and mix thoroughly.

6.5. Place the lid (with air hole) tightly on the container and place the sample in a preconditioned oven at 325 ± 5°F for 96 hours.

6.6. Remove the sample from the oven and stir.

6.7. Pour 25 ± 1.0 g of the binder and additive mixture into the 4 oz. tin container. Allow the liquid to cool to below 140°F but still remaining mixable.

6.8. Carefully add 4.5 ± 0.1 g of toluene and mix thoroughly.

Note 1—Polymerized asphalts may require additional toluene to thin the mixture.
**Warning**—Be sure that the asphalt binder has cooled to less than 140°F before the toluene is added. The solvent will still vaporize rapidly at this temperature, so this step should be performed under ventilation. No open flames or smoking can be permitted near the mixing operation.

6.9. Place 20 ± 1 g of Ottawa sand in the 2 oz. (60 ml) plastic bottle.

6.10. Add distilled water sufficient to cover the sand to a depth of approximately 1/2 inch above the surface of the sand in the bottle.

**Note 2**—Approximately 16 ml if using the 15 dram container

6.11. Add 1 ± 0.2 g of the asphalt/toluene mix liquid by dripping it from a spatula onto the surface of the water in the bottle.

6.12. Attach the top cap on the bottle and shake vigorously for 15 seconds.

6.13. Remove the top cap and pour off excess water and solvent.

**Note 3**—The water solvent mixture contains toluene which is a hazardous waste.

6.14. Gently tap the asphaltic wet sand onto a white paper towel, spread into a thin layer (not in a cone-shaped mound), and visually inspect the coating of the sand.

**Note 4**—Validation testing for acceptance of anti-strip when a field test result for IT-99 is Negative- The sample that was negative for IT-99 shall be heated until the material is pourable. Then follow the procedures from 6.6 through 6.14.

### 7. REPORT

7.1. Anti-stripping additive is effective after hot storage provided the wet sand and asphalt mixture combine into a homogeneous well-coated mixture having a uniform asphaltic color. Report the test results as "Positive." See Figure 1.

7.2. Anti-stripping additive is not effective after hot storage provided the wet sand and asphalt mixture is not homogeneous and well coated, globules of asphalt are apparent, and the mass is distinctly non-uniform in appearance. Report the test result as "Negative." See Figure 2.
Figure 1: Passing test result.

Figure 2: Negative test result.
Idaho Standard Method of Test for

DETERMINATION OF RECLAIMED ASPHALT PAVEMENT (RAP) AGGREGATE BULK (DRY) SPECIFIC GRAVITY (Gsb)

IDAHO Designation: IT-146-16

1. SCOPE

1.1. This method covers the procedure for determining the Bulk (Dry) Aggregate Specific Gravity, (Gsb) of a Recycled Asphalt Pavement, (RAP) aggregate from Maximum Theoretical Specific Gravity (Gmm) tests of the RAP. An Effective Specific Gravity of Aggregate, (Gse) is calculated and used to determine the Gsb of the RAP after adjusting the Gse for asphalt absorption.

1.2. This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.

2. REFERENCE DOCUMENTS

2.1. AASHTO Standards

- M 231, Weighing Devices Used in the Testing of Materials
- R 76, Reducing Samples of Aggregate to Testing Size
- T 2, Sampling Aggregates
- T 85, Specific Gravity and Absorption of Coarse Aggregate
- T 209, Theoretical Maximum Specific Gravity (Gmm) and Density of Hot Mix Asphalt (HMA)
- T 308, Determining the Asphalt Binder Content of Hot Mix Asphalt (HMA) by the Ignition Method

2.2. Idaho Standards

- IT-144, Specific Gravity and Absorption of Fine Aggregate Using Automatic Vacuum Sealing (CoreLok) Method

2.3. Other Documents:


2.4. Standard Specifications, Subsection 720.07.
3. **SUMMARY OF METHOD**

3.1. A representative RAP sample is prepared prior to testing by reheating and remixing the reclaimed material. Determine binder content and gradation, per FOP for AASHTO T 308, and apply the chemical extraction/ignition furnace correlation factor to the result. Perform a minimum of two maximum theoretical specific gravity (Gmm) tests so that an effective specific gravity (Ge) can be calculated. Use the calculated Ge value and the assumed asphalt binder absorption of the RAP to determine the bulk (dry) specific gravity (Gsb) of the RAP.

4. **APPARATUS**

4.1. *Drying Oven.* Oven of sufficient capacity for containing the sample and capable of maintaining a temperature of 230 ± 9°F.

4.2. *Balance.* Of sufficient capacity and conform to the requirements of M 231, Class G2.

4.3. *Sample Pans.* Large, flat and capable of holding 20,000 grams of RAP material.

4.4. *Chopping Utensil* – Blade trowel or other utensil used to separate the large conglomerations of a RAP sample into a loose-flowing condition.

4.5. *Vacuum Setup* – Associated with T 209

5. **SAMPLING**

5.1. Sample the RAP stockpile, in its final usable form, by obtaining a minimum of six representative locations from the RAP stockpile. Obtain 22 lb (10,000 grams) of RAP from each location. Thoroughly blend all the samples and reduce per R 76 to produce a 20,000-gram sample.

*Note 1*—NCHRP Report 673 includes a recommended RAP Sampling Plan in Chapter 9.

6. **PREPARATION OF SAMPLE**

6.1. Place the entire 20,000-gram sample into a large flat pan(s).

6.1.1. Place sample into a preheated oven at 230 ± 9° F. and heat for 30 to 45 minutes.

6.1.2. Remove the sample from the oven and begin breaking up the larger conglomerations of RAP with the chopping utensil.

6.1.3. Blend the heated RAP by mixing the freshly chopped material with the fines in the pan, as the material begins to soften.

6.1.4. Return the RAP into the oven and continue heating for another 15 - 20 minutes.

6.1.5. Remove the RAP from the oven and repeat the chopping of the conglomerations and blending of the fines until the RAP sample is homogeneous and conglomerations of fine aggregate complies with T 209.

6.1.6. Thoroughly blend the loose RAP sample and reduce to testing size per R 76. Testing sizes are stated in Section 7.
7. PROCEDURE

7.1. Percent Asphalt Binder, $P_b$, using Chemical Extraction/Ignition Furnace Correlation Factor:

7.1.1. Determine the $P_b$ of two dried RAP increments according to T 308. Calculate the uncorrected asphalt content of the two increments and if the difference exceeds 0.2 perform another pair of T 308 tests. Throw out the high and low values, and average the two remaining results.

7.1.2. Compare the average uncorrected asphalt binder content with the Contractor’s average uncorrected binder content value from Form ITD 1044 or Mix Design. If the algebraic difference exceeds 0.33 request new samples from the Contractor and repeat steps 5.1 through 7.1, otherwise accept the Contractor’s asphalt binder correlation factor (from the average of 6 chemical and 6 ignition furnace tests).

7.1.3. Calculate the RAP asphalt binder content using the average uncorrected T 308 results from step 7.1.1 and apply the Contractor furnished asphalt binder correlation.

7.1.4. Record the $P_b$ and the aggregate gradation.

7.2. Maximum Specific Gravity determination, $G_{mm}$:

7.2.1. Split out a minimum of three increments of the prepared RAP sample according to the mass requirements of T 209.

7.2.2. Dry the sample to a constant mass in an oven at 230 ±9°F. While drying, chop and break up the sample as you would with a standard $G_{mm}$ sample. Record as “dry RAP mass”.

7.2.3. Place the sample in 295° ± 5° F. oven for one hour.

7.2.4. Add 2 percent virgin asphalt binder (for example PG 64-28 or PG 58-28) at 295° ± 5° F. based on the “dry RAP mass” from step 7.2.2, to the RAP and thoroughly mix at 295° ± 5° F. to ensure uniform coating of all particles.

Note 1—In some instances, more than 2% additional virgin binder may be required to ensure complete coating.

7.2.5. Determine the $G_{mm}$ of two of the prepared RAP samples according to T 209 and keep the remaining sample(s) in reserve.

7.2.6. Calculate the individual $G_{mm}$ values. The average result will be used in the calculation provided the individual results do not vary by more than 0.010. If the individual results vary more than 0.010, repeat steps in 7.2., discard the high and low values and average the remaining individual results provided they do not vary more than 0.010. If remaining individual results vary more than 0.010 repeat steps in 7.2. until individual results compare within 0.010.

7.2.7. Estimate the asphalt binder absorption of the RAP, $P_{ba}$, from the water absorption of virgin aggregates used in the project.

8. CALCULATIONS

8.1. Calculate the “adjusted $P_b$” of the RAP to account for the addition of the 2 percent virgin asphalt binder as follows:

8.1.1. Calculate “mass of RAP Asphalt Cement (AC)”. 
8.1.1. Mass of RAP AC = Dry RAP mass x $P_b$

8.1.2. Calculate “mass of virgin AC added”

8.1.2.1. Mass of virgin AC added = 0.02 x Dry RAP mass

8.1.3. Determine “New RAP mass”:

8.1.3.1. New RAP mass = Dry RAP mass + Mass of virgin AC added

8.1.4. Calculate “Adjusted $P_b$”:

\[
Adjusted \ P_b = \frac{\text{Mass of RAP AC} + \text{Mass of Virgin AC added}}{\text{New RAP Mass}} \times 100
\]

8.2. Assume the Specific Gravity of Binder, $G_b$. Use 1.040.

8.3. Calculate the effective specific gravity ($G_{se}$) of the RAP:

\[
G_{se(RAP)} = \frac{100 - Adjusted \ P_b}{(\frac{100}{G_{mm}} - Adjusted \ P_b)} 
\]

8.4. Estimate or assume the asphalt binder absorption of the RAP, $P_{ba}$

8.4.1. Asphalt absorption of RAP is assumed to be two-thirds of the water absorption of virgin aggregates used in the project.

8.4.2. Determine the water absorption values by T 85 and Idaho IT-144 and calculate the total water absorption for the virgin aggregate by proportionately combining the coarse and fine absorption by the percent of each aggregate.

8.4.3. Calculate $P_{ba}$:

\[
P_{ba} = \text{water absorption} \times 0.667
\]

8.5. Calculate the stone bulk gravity ($G_{sb}$) of the RAP:

\[
G_{sb(RAP)} = \frac{G_{se(RAP)}}{\left(\frac{P_{ba(RAP)} \times G_{se(RAP)}}{100 \times G_{b(RAP)}}\right) + 1}
\]

9. **EXAMPLE**

9.1. Example with 2% virgin asphalt binder added:

9.1.1. Dry RAP mass = 3,000 g

9.1.2. $P_b$ (% AC) in RAP = 4.9%

9.2. Determine “mass of RAP AC”:

9.2.1. Mass of RAP AC = Dry RAP mass x $P_b$

\[
=3,000 \times 4.9\%
=147 \text{ grams}
\]
9.3. Add 2 percent virgin AC:

9.3.1. Determine “mass of virgin AC added”:
Mass of virgin AC added = 0.02 x Dry RAP mass
= 0.02 x 3,000 grams
= 60 grams

9.3.2. Determine “New RAP mass”
New RAP mass = Dry RAP mass + Mass of virgin AC added
= 3,000 + 60
= 3,060 grams

9.4. Calculate “Adjusted $P_b$”:

$$Adjusted \ P_b = \frac{Mass \ of \ RAP \ AC + Mass \ of \ Virgin \ AC}{New \ RAP \ Mass} \times 100$$

$$= \frac{147 \ grams + 60 \ grams}{3,060 \ grams} \times 100$$

= 6.8%

9.5. Calculate $G_{se}$:

$$G_{se(RAP)} = \frac{(100 - P_b)}{\left(\frac{100}{G_{mm}} - \frac{P_b}{1.040}\right)}$$

Adjusted $P_b = 6.8$
Rice Test, $G_{mm} = 2.455$

$$G_{se(RAP)} = \frac{(100 - 6.8)}{\left(\frac{100}{2.455} - \frac{6.8}{1.040}\right)}$$

$$= \frac{93.2}{(40.73 - 6.54)}$$

= 2.726

9.6. Calculate $P_{ba}$ from water absorption of the virgin aggregate:
Water Absorption = 1.2%

$$P_{ba} = 1.2 \times 0.667$$

= 0.80% asphalt absorption

9.7. Calculate RAP $G_{sb}$:

$$G_{sb(RAP)} = \frac{G_{se(RAP)}}{\left(\frac{P_{ba(RAP)} \times G_{se(RAP)}}{100 \times G_{b(RAP)}}\right) + 1}$$

$G_{se(RAP)} = 2.726$
$P_{ba} = 0.80$
$G_{b} = 1.040$

$$G_{sb(RAP)} = \frac{2.726}{\left(\frac{0.80 \times 2.726}{100 \times 1.040}\right) + 1}$$

$G_{sb(RAP)} = 2.670$
Idaho Standard Practice for

Sampling Concrete for Chloride Analysis

IDAHO Designation: IR-128-17

1. SCOPE

1.1. This procedure explains methods to be used in sampling concrete for chloride analysis.

1.2. Follow the general guidelines in the Bridge Deck Evaluation and Test Procedure Guideline Manual and AASHTO T 260. Specific and special guidelines are described below.

1.3. This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.

2. REFERENCE DOCUMENTS

2.1 AASHTO Standards
   - T 260, Sampling and Testing for Chloride Ion in Concrete and Concrete Raw Materials

3. GENERAL SAMPLING INFORMATION

3.1. Lay out the test area to be sampled for a minimum of one sample location per 1,000 square feet (100 square meters) and a minimum of three sample locations per deck. Samples should be taken at points of probable high concentration, i.e., curb lines and lower side of super-elevated decks. Samples should not be taken at points where delamination or spalling has occurred since corrosion is obvious at these locations. Spalling or delamination can be located by performing a chain drag evaluation of a bridge deck, which can be valuable if the deck is bare or has a single seal coat. A seal coat of plant mix may give inaccurate information from a chain drag evaluation since the asphalt attenuates the sounds.

3.2. The best way to identify chloride sample depths and locations is to refer to the bridge plans for descriptions of the rebar location and depth, span size, and number of spans. A pachometer can also be used to locate the rebar depths and locations.

4. SAMPLING PROCEDURES AND GUIDELINES

4.1. For sampling, a rotary hammer is recommended with a 1 inch by 12 inches (25 mm by 300 mm) carbide-tipped bit and various thin wall electrical conduit depth sleeves. Also needed for sampling are a sampling spoon or spatula, 20-dram plastic vials or other sample containers, nylon bristle brushes, paper towels, and 2-Propanol (Isopropyl alcohol). In addition, some means of a "blowout" bulb, a portable air compressor, or other device is needed to clean out the holes after each test depth has been drilled and sampled.
Illustration A: Electrical conduit pipe cut for use as depth sleeves; 2-Propanol and a nylon brush are used to clean between samples.

Illustration B: Portable Air Compressor for Cleaning Between Samples.
4.1.1. Samples are usually taken at three separate depths predetermined according to the depth of the rebar in the bridge deck. In addition, a sample taken at or just below the rebar can be informative for severe chloride penetration. The samples are taken at approximately even increments of 1/2 inch (15 mm). See Table 1 below.

<table>
<thead>
<tr>
<th>ENGLISH MEASUREMENT</th>
<th>METRIC MEASUREMENT</th>
</tr>
</thead>
<tbody>
<tr>
<td>From 1/4 inch</td>
<td>To 3/4 inch</td>
</tr>
<tr>
<td>5 mm</td>
<td>20 mm</td>
</tr>
<tr>
<td>From 3/4 inch</td>
<td>To 1 1/4 inch</td>
</tr>
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<td>20 mm</td>
<td>35 mm</td>
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<td>65 mm</td>
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<td>80 mm</td>
<td>95 mm</td>
</tr>
<tr>
<td>From 3 1/4 inch</td>
<td>To 3 3/4 inch</td>
</tr>
<tr>
<td>95 mm</td>
<td>110 mm</td>
</tr>
</tbody>
</table>

Note—Millimeters (mm) are the metric sample depths and are based upon approximations of the English measurements.

Illustration C: Chloride Sampling Kit.

4.2. Using the rotary hammer, scar the surface approximately 1/4 inch (6 mm) deep. This assures that the samples will be taken below the surface dirt and other possible sources of erroneously high salt content. Drill three holes within a 6-inch (150 mm) diameter to obtain enough sample from each sampling depth. See Illustration E below.
**Illustration D**: Rotary hammer for sampling concrete for chloride testing. Hammer with depth sleeve set 2 1/4 inches (65 mm) sample depth.

**Illustration E**: Illustration is not drawn to scale.
- Suggested sampling area for one chloride sample location.
- Large circle diameter 6 inches (150 mm).
- Drill hole diameter 1 inch (25 mm).
4.2.1. Blow out the hole and the surrounding area using an air compressor, blowout bulb, or some other means that is suitable. Do not use alcohol to clean out the sample holes. Clean sampling tools: rotary hammer drill bit, depth sleeve, spoon, etc., using a nylon brush, paper towels, and 2-Propanol (Isopropyl alcohol) between samples to assure no contamination between samples. The rotary hammer drill bit and depth sleeves must be completely dry before proceeding with the next sample.

4.2.2. Place the first depth sleeve on the drill bit and drill in the three established holes with the rotary hammer. See Illustration F below.

**Illustration F**: Rotary hammer with depth sleeve in place. Ready to drill sample. Clean drill bit, depth sleeve, and sampling spoon between sample depths with 2-Propanol.

4.2.3. Drill until the depth sleeve seats itself on the concrete surface. Pull out the drill bit and, using a sampling spoon, carefully gather the pulverized sample out of the three drilled holes. Collect the pulverized sample material carefully and completely. Approximately 15 grams (or a 20-gram vial 3/4 full) is needed for each sample depth. Label the sample container for location and depth. The resulting pulverized concrete represents the first sample depth. See Illustration G below.

4.2.4. Clean the sampling tools: Drill bit, depth sleeves, spoons, etc., using a nylon brush, paper towels, and 2-Propanol (Isopropyl alcohol) to assure no contamination between samples. Rotary hammer and depth indicators must be completely dry before proceeding with the next sample. Blow out the hole and the surrounding area using an air compressor, blowout bulb, or some other suitable means using air.

4.2.5. Place the next sleeve guide on the rotary hammer for the next sampling depth. Drill and pulverize the concrete until the depth sleeve again seats itself on the concrete.

4.3. Continue with steps 4.2.3 through 4.2.5 until all desired sample depths have been drilled and sampled.
4.4. Identify the sampling locations on the ITD-404 Standard Computation Sheet or ITD-2680 Standard Computation Sheet-Large or use a created map drawn to scale. Please include with the samples the completed ITD-1044 forms for the samples, identifying specific holes and depths, and a copy of the Bridge Deck Survey Map or created map with information about the areas of delamination.

![Illustration G: An example of a pulverized chloride sample.](image)

4.5. The test hole may be patched with suitable patching material such as Set-45 or mortar (a combination of cement and clean sand) if appropriate.
Idaho Standard Practice for

Field Sampling of Hydraulic Cement and Fly Ash

IDAHO Designation: IR-143-17

1. SCOPE

1.1. This method covers obtaining the required field samples of hydraulic cement and fly ash from bulk shipments by means of the ITD in-line sampler.

1.2. This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.

2. APPARATUS

2.1. In-line sampler with couplers fitting a 4” line

2.2. 5” coupler adaptor

2.3. In-line sample container

2.4. Two 4” to 5” hose adaptors (1 female, 1 male)

2.5. Rubber mallet

2.6. 4” pipe brush

2.7. ½” pipe brush

2.8. Manual for assembly and cleaning of in-line sampler

Note 1—Refer to the Manual for details on assembly.

2.9. Pelican 1650 transport & storage case.

3. PROCEDURE

3.1. After the trailer has discharged for 5 to 10 minutes, have the truck depressurize and connect the sampler to the discharge tube on the trailer of the bulk truck and secure with the Kam-Loc levers.

3.1.1. Connect the rubber hose / line which feeds cement into the silo or bins to the sampler and secure with Kam-Loc levers.

3.1.2. Strike Kam-Loc levers with rubber hammer until connectors are secure.

Note 2—The ring on the lever must be toward the outside in order to open the lever.
3.2. Have the truck re-pressurize and continue to discharge for a minimum of 15 minutes.

3.3. Allow the truck to depressurize.

3.4. Remove sampler after the line has been depressurized.

3.5. Remove container portion of the sampler and pour sample into a suitable sample container.

3.6. Properly label sample container with a permanent marker and complete the ITD-1044 Sample Data form with a copy of the mill analysis certification attached.

3.7. The sampler must be thoroughly cleaned after each sample is taken by following the directions in the sampler manual.
Idaho Standard Method of Test for

Acid Soluble Chloride Content of Hardened Concrete by Gran Plot Method

IDAHO Designation: IT-131-17

1. SCOPE

1.1. This method describes the laboratory analysis of chloride ion in hardened concrete.

1.2. This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.

2. REFERENCE DOCUMENTS

2.1. AASHTO Standards

   - M231, Weighing Devices Used in the Testing of Materials
   - T 260, Sampling and Testing for Chloride Ion in Concrete and Concrete Raw Materials

3. SUMMARY OF METHOD

3.1. Test according to T 260 "Sampling and Testing for Chloride Ion in Concrete and Concrete Raw Materials" using Procedure A for acid-soluble chloride ions and Method II: Gran Plot method for analysis.

3.2. A standard solution containing 1 milliliter of known concentration of chloride ion (1000 ppm) and a blank of distilled water are also tested for percent recovery and to obtain a high degree of precision.

4. APPARATUS

4.1. Equipment for Chemical Testing.

4.1.1. Chloride ion or silver/sulfide ion selective electrode and manufacturer-recommended filling solutions.

    Note 1—Suggested electrodes are the Orion 96-17 or Orion 94-6 used with Orion 90-02 or equivalent.

4.1.2. A millivoltmeter compatible with the ion electrode.

    Note 2—Suggested millivoltmeter is the Orion Model 901A Specific Ion meter or equivalent.

4.1.3. Magnetic stirrer and teflon stirring bars.
4.1.4. A 25 ml buret with 0.1 ml graduations.
4.1.5. Analytical Balance complying with M 231, Class A.
4.1.7. Hot plate, 250°C to 400°C heating surface temperature.
4.1.8. Glassware 150 and 250 ml beakers, filter funnels, stirring rods, watch glasses, dropper, Guth wash bottles.
4.1.9. Sieve, U.S. Standard No. 50 (0.300 mm).
4.1.10. Whatman No. 40 and No. 41 filter papers (or equivalent).

Note 3—If equivalent filter papers are used, they should be checked to confirm they do not contain chloride that will contaminate the sample.

5. REAGENTS

5.1. Reagents for Chemical Testing.

5.1.1. Concentrated HNO₃ (specific gravity 1.42).

5.1.2. Sodium chloride, NaCl, reagent grade (primary standard).

5.1.3. Standard 0.01 normality NaCl solution. Dry reagent grade NaCl in an oven at 105°C. Cool, in a desiccator, weigh out approximately 0.5844 to the nearest 0.0001 gram, dissolve in distilled H₂O, and transfer to a 1 liter volumetric flask. Make up to the mark with distilled H₂O and mix. Calculate the exact normality as follows:

\[ N_{NaCl} = 0.0100 \left( \frac{W_{\text{actual}}}{0.5844} \right) \]

where:

\( W_{\text{actual}} \) = actual weight of NaCl

\( N_{NaCl} \) = normality of NaCl solution

5.1.4. Standard 0.01 Normality AgNO₃. Weigh 1.7 grams of reagent AgNO₃, transfer to 1000 ml volumetric flask and dissolve in distilled water. Dilute to volume and mix thoroughly. Standardize by the titration method given in Section 5.4.2.

5.1.5. Distilled/Demineralized Water.

Note 4—Deionized water may be used in place of distilled water for samples where extreme precision and accuracy are not demanded.

5.1.6. Methyl orange indicator.

5.1.7. Ethanol—denatured or methanol, technical.
5.2. **AASHTO T 260 Procedure and Modifications.**

5.2.1. Weigh to the nearest milligram a 3 gram powdered sample representative of the material under test.

**Note 5**—Some users dry the sample to constant weight in a 105°C oven and determine the dry sample weight prior to analysis. This optional procedure provides a constant base for comparison of all results by eliminating moisture content as a variable. It is generally believed that drying is only necessary when very high accuracy is desired.

5.2.2. Transfer the sample quantitatively to a 150 ml beaker, add 10 ml of distilled H₂O swirling to bring the powder into suspension. Add 3 ml of concentrated HNO₃ with continued swirling until the material is completely decomposed. Break up any lumps with a stirring rod and dilute with hot H₂O to 50 ml. Stir thoroughly to ensure complete sample digestion. Add five (5) drops of methyl orange indicator and stir. If yellow to yellow-orange color appears, solution is not sufficiently acidic. Add additional concentrated HNO₃ drop-wise with continuous stirring until a faint pink or red color persists in the solution. Cover with a watch glass. Heat the acid solution or slurry to boiling on a hot plate at medium heat (250°C to 400°C) and boil for about 1 minute. Remove from the hot plate, filter through double filter paper (Whatman No. 41 over No. 40 filter paper or equivalent), into a 250 ml beaker which has been pre-weighed with the tare weight recorded.

**Note 6**—A blank and a known chloride concentration standard are run every 10 samples for internal Quality Assurance. The blank and known are made using only reagents and distilled H₂O. The known contains 10 ml of 100 ppm chloride (Cl⁻) standard.

**Note 7**—Due to the presence of relatively insoluble materials in the sample, the solution generally will have a strong gray color, making the detection of indicator color difficult at times. Running of several trial samples is suggested to give the analyst practice in detecting the indicator color.

**Note 8**—A sample prepared to 100 percent passing No. 50 sieve (0.300 mm) should generally allow determination of any expected chloride level with adequate precision and accuracy. Samples containing highly siliceous aggregates may require finer grinding to minimize solution bumping during boiling. This may also be the case when the concrete contains modifiers such as latex or polymer.

5.2.3. Transfer solution and wash the filter papers thoroughly with hot distilled H₂O 3 to 5 times. After washing is complete, lift the filter paper carefully from the funnel and wash the outside surface of the paper with hot distilled H₂O; then wash the tip of the funnel. The final volume of the filtered solution should be less than 100 ml. Cover with a watch glass and allow to cool to room temperature in the HCl fume-free atmosphere. Remove the watch glass and place the beaker on the balance. Add sufficient distilled water to bring the weight of solution to 100 ± 1 grams. This eliminates the need for the volume corrections.

Weigh the filtrate solution and beaker without the watch glass and record the weight.

5.3. **Method II Gran Plot Method with Cl⁻ selective ion electrode.**

5.3.1. Setup and Calibration.

5.3.1.1. Polish the chloride electrode according to manufacturer's recommendations and attach to the Orion 901 Ionanalyzer. Fill the double junction reference electrode with inner and outer solutions according to manufacturer's instructions and attach to Ionanalyzer. Perform slope calibration as follows.
5.3.1.2. Prepare 150 ml beaker with 87 ml distilled water, 3 ml concentrated HNO₃, and 10 ml 100 PPM-Cl⁻ standard solution for calibration standard. Set instrument to mV and put electrodes in calibration solution, wait for a steady reading. Press "set conc." button on instrument and leave on. Add 10 ml 1000 ppm-Cl⁻ standard solution, wait for a steady reading. Final reading on digital readout is the daily slope along with standard value of 10.00. Slope reading is read as negative number. Record slope setting in instrument notebook and on chloride sample worksheet.

5.3.2. Calibration of AgNO₃.

Rinse electrodes with distilled water and dry. Fill a 25 ml buret with AgNO₃ solution. Prepare a 250 ml beaker with 10 ml 0.01N NaCl solution, 3 ml conc. HNO₃, 87 ml distilled water, and stir bar. Place sample on magnetic stirplate with electrode in solution and while stirring record initial mV reading. Add AgNO₃ until mV reading is between 300 and 310 mV, record reading. Continue to titrate in 0.50 ml increments recording volume added and mV reading for each increment for at least five increments. Calculate the exact normality as follows:

\[
N_{AgNO_3} = \frac{(V_{NaCl})(N_{NaCl})}{V_{AgNO_3}}
\]

Where:

\(N_{AgNO_3}\) = normality of AgNO₃ Solution
\(V_{NaCl}\) = volume (ml) of NaCl Solution
\(N_{NaCl}\) = normality of NaCl Solution
\(V_{AgNO_3}\) = volume (ml) of AgNO₃ Solution (Use blank and volume corrected end point) Follow steps 5.4.1 through 5.4.3 for correct calculation of \(V_{AgNO_3}\).

5.4. Chloride Sample Instrumental Analysis.

After calibration of Ionanalyzer and AgNO₃ solution prepare sample filtrate for mV readings. Weigh filtrate, record weight and add distilled water to bring volume to 100 ± 1 grams. Place rinsed and dry electrodes in sample solution. Read and record millivolt reading for sample before AgNO₃ is added. Using the 25 ml buret, titrate the sample between 300-310 mV with standard 0.01 NAgNO₃ solution to the nearest 0.50 ml increment. Record the volume added and the millivoltmeter reading on the chloride work sheet.

Continue to titrate in 0.50 ml increments, recording volume added and the millivoltmeter reading for each increment. Add and record the data for at least five increments on the chloride work sheet.

5.4.1. Gran Plot Method Calculations.

Calculate corrected values for each of the volumes recorded in Section 5.4 by the equation:

If filtrate weight is >101 grams, then:

\[
V_{Correct} = \frac{V_{record}}{Wt./100}
\]

Where:

\(Wt\) = original solution weight in grams.
\(V_{record}\) = volumes recorded in ml.

If filtrate weight is 100 ± 1 grams, then \(V_{correct} = V_{record}\).
Proceed to 5.4.2.

5.4.2. Titration Volume Plotting & Calculation.

If any of the $V_{\text{correct}}$ values are greater than 10, see Section 5.4.3. If less than 10, plot these corrected values versus the corresponding millivolt readings on Orion Gran Plot Paper (10 percent volume corrected type with each major vertical scale division equal to 5 millivolts) or equivalent. Draw the best straight line through the points and read the endpoint at the intersection of the line with the horizontal axis of the graph. Calculate the actual endpoint by the equation:

$$E_a = \left( \frac{E_g}{100} \right) \left( \frac{W_T}{100} \right)$$

Where:
- $E_a$ = actual endpoint
- $E_g$ = endpoint determined from graph in ml. The reagent blank endpoint ml will be subtracted from all sample and standard endpoints before ppm-Cl⁻ or final lb. Cl⁻/c.y. concrete calculations.
- $W_T$ = weight of solution in grams.

5.4.3. Volume Correction.

When the $V_{\text{Correct}}$ volumes determined during titration are greater than 10, discard the values and follow the following procedure.

Choose a constant which, when subtracted from all $V_{\text{record}}$ volumes, yields values less than 10 ml.

Note 9—This constant, designated as $X$ in the formulas below, is normally assigned an even value such as 5, 10, 15, 20, etc.

Calculate a revised solution weight $W_{T'}$ as:

$$W_{T'} = W_T + X$$

Where:
- $W_T$ = original solution weight in grams
- $X$ = the constant

Then calculate corrected volumes for each recorded volume as:

$$V_{\text{Correct}} = \frac{V_{\text{record}} - X}{W_{T'} / 100}$$

Plot these values and determine the graph endpoint $E_g$, as described in Section 5.4.2, above.

5.5. The actual endpoint $E_a$ is then:

$$E_a = \left( \frac{E_g}{100} \right) \left( \frac{W_{T'}}{100} \right) + X$$

where:
- $E_a$ = actual endpoint in ml.
- $E_g$ = endpoint from graph in ml with blank subtracted.
- $W_{T'}$ = revised solution weight in grams.
\( X \) = the constant chosen above.

Calculate the chloride content using the formula given below.

Calculation or ppm recovery of Cl\(^{-}\) standard:

\[
\left( N_{AgNO_3} \right) \left( \frac{mwCl^-}{35.453} \right) (1000)(E_a) = ppmCl^- 
\]

Percent Cl\(^{-}\) is calculated as follows:

\[
\text{PercentCl}^- = \left( \frac{3.5453}{Wt_c} \right) (E_a)(N)
\]

where:

\( E_a \) = actual endpoint, in ml.
\( N \) = normality of AgNO\(_3\) solution.
\( Wt_c \) = concrete sample weight in grams.

The percent chloride may be converted to pounds of Cl\(^{-}\) per cubic yard of concrete as follows:

\[
\frac{lb.\ Cl^-}{yd^3} = \left( \frac{3.5453}{3.0000} \right) (N)(E_a) \left( \frac{3,915}{100} \right)
\]

where:

\( Wt_u \) = unit weight of concrete per cubic yard

**Note 10**—A unit weight of 3,915 lb./yd\(^3\) is often assumed for normal structural weight concrete when the actual unit weight is unknown.

Results are reported as lb. Cl\(^{-}\)/yd\(^3\) concrete as follows for 3.0000 gram sample:

\[
\frac{lb.\ Cl^-}{yd^3} = \left( \frac{3.5453}{3.0000} \right) (N)(E_a) \left( \frac{3,915}{100} \right)
\]

Which reduces to: (factor)

\[
\frac{lb.\ Cl^-}{yd^3} = 46.27(N)(E_a)
\]

where:

\( N \) = normality of AgNO\(_3\)
\( E_a \) = actual endpoint in ml \( (E_b) \left( \frac{Wt_c}{100} \right) - blank \)

Idaho specifications for Cl\(^{-}\) value = 2 lb. Cl\(^{-}\)/yd\(^3\) max.

Precision and Accuracy Data – As documented in AASHTO T 260.
Idaho Standard Method of Test for

Determination of the Rate of Evaporation of Surface Moisture from Concrete

IDAHO Designation: IT-133-17

1. SCOPE

1.1. This method shall be used to determine the rate of evaporation of surface moisture from concrete surfaces.

1.2. This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.

2. REFERENCE DOCUMENTS

2.1. ACI Manual of Concrete Practice, Section 305R.

3. APPARATUS

3.1. Thermometer, 0°F to 180°F, Dial Type.

3.2. Wind meter.

3.3. Hygrometer, stationary mason's form.

4. TEST PROCEDURE

4.1. Determine the ambient air temperature by reading the dry-bulb on the hygrometer. For example, 80°F.

4.2. Determine the relative humidity by reading both the dry-bulb and the wet-bulb on the hygrometer.

4.2.1. Then, using the Relative Humidity Table (Figure 1), locate in the margin the reading corresponding to the dry-bulb indication.

4.2.2. Locate in the other margin the reading corresponding to the wet-bulb indication. The relative humidity is read at the intersection of these two columns. For example, given dry-bulb temperature 80°F and wet-bulb temperature 67°F, the relative humidity is 50 percent.

4.3. Determine the concrete temperature by placing the dial thermometer into a sample of the concrete. For example, 88°F.

4.4. Determine the wind velocity by using the wind meter.

4.4.1. Face the wind. Hold the meter in front of you in a vertical position with the scale side facing you.
4.4.2. Do not block the bottom holes.

4.4.3. The height of the ball indicates the wind velocity. 

   **Note 1**—For winds in excess of 10 mph, use the high scale. For high scale, cover the hole at the extreme top of the wind meter with a finger. For example, 12 mph.

4.5. Determine the evaporation rate by using the chart (Figure 2).

4.5.1. Enter the chart at air temperature, degrees F. For example, 80°F.

4.5.2. Move up to relative humidity. For example, 50 percent.

4.5.3. Move right to the concrete temperature. For example, 88°F.

4.5.4. Move down to wind velocity. For example, 12 mph.

4.5.5. Move left and read approximate rate of evaporation. For example, 0.25 lb/sq ft/hr.

**5. PRECAUTIONS**

5.1. Read the instructions furnished with both the hygrometer and wind meter for accurate operation of both instruments.

5.2. In determining the evaporation rate of surface moisture, keep in mind that later in the day the air temperature, relative humidity, and wind velocity may change drastically, causing a considerable increase in the evaporation rate.

**6. RATE OF EVAPORATION**

6.1. The rate of evaporation is influenced by the relative humidity, concrete and air temperature, and wind velocity. Even relatively small changes in these atmospheric conditions may have a pronounced effect on the rate of evaporation, especially if they occur simultaneously.

   **Note 2**—For example, when the relative humidity changes from 90 to 50 percent, the rate of evaporation is increased five times. If further reduced to 10%, evaporation is increased nine times.

6.2. When both concrete and air temperature increase from 50°F to 70°F, evaporation is doubled. If further increased to 90°F, evaporation is increased four times.

6.3. With an air temperature of 40°F, the rate of evaporation is tripled when the concrete temperature is raised from 60°F to 80°F.

6.4. The rate of evaporation is four times greater when the wind velocity increases from 0 to 10 mph and is nine times greater when the wind velocity further increases to 25 mph.

6.5. It is apparent, then, that the rate of evaporation is highest when the relative humidity is low, when concrete and air temperatures are high, when the concrete temperature is higher than the air temperature and when the wind is blowing over the concrete surface. The combination of hot, dry weather and high winds often prevailing during summer months removes moisture from the surface faster than it can be replaced by normal bleeding; but even in cold weather rapid drying is possible if the temperature of concrete, when placed, is high compared to the air temperature.
Figure 1: Relative Humidity Table
Figure 2: Evaporation Rate
Idaho Standard Method of Test for

Measuring Texture Depth of Portland Cement Concrete Using a Tire Tread Depth Gauge

IDAHO Designation: IT-147-17

1. SCOPE

1.1. This method describes the procedure for depth measuring texture depth of fresh or hardened portland cement concrete by use of a tire tread gauge.

1.2. This standard may involve hazardous materials, operations, and equipment. This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.

2. REFERENCED DOCUMENTS

2.1. AASHTO Standards
   ■ T 261-78 (1999), Discontinued

3. APPARATUS

3.1. Tire Tread Depth Gauge – A tire tread depth gauge with 1/32-in. graduations. The gauge end may be modified to a shape suitable for the measurement.

3.2. Wire or stiff bristle brush, carborundum stone.

3.3. Steel straightedge approximately 1/4 by 1 by 12 in.

3.4. 100 ft. Tape measure.

4. SELECTION OF TEST LOCATIONS

4.1. One test area shall be identified by ITD at a stratified random location transversely and longitudinally every 1,000 linear feet in each lane or fraction thereof as specified.

4.2. For bridge decks, urban concrete paving, and concrete overlays, a minimum of five test areas shall be identified as described in 4.1 unless otherwise specified.

5. PROCEDURE

5.1. At each test area measure the texture depth of 10 consecutive grooves. The test location shall be in a line perpendicular to the grooves, starting at the point randomly located in accordance with Section 4.

5.2. The texture depth shall be measured from the original concrete surface. Any projections above the original surface shall be removed by brushing with a wire brush or carborundum stone as necessary to remove ridges adjacent to grooving, or with the steel straightedge prior to taking a
measurement on hardened concrete. If measurements are made on fresh concrete, the depth gauge guide shall be pressed down to the level of the original concrete surface.

5.3. With the depth gauge guides in contact with the original concrete surface, the plunger is depressed until contact is made with the bottom of the groove in the concrete. The gauge is then removed without disturbing the plunger. The texture depth is read to the nearest 1/32-in. on the calibrated plunger. The plunger is then zeroed and the procedure is repeated until all measurements are completed.

5.3.1. Make adjustments to the tining operation when more than three readings in a set of ten are outside the intended depth range.

6. **CALCULATIONS**

6.1. Calculate the average groove depth for each test area to the nearest 1/32-in.

7. **REPORT**

7.1. Report test results on Form ITD-798. See Figure 7.1.1
Figure 7.1.1: P.C.C. Pavement Texture Depth Using Tire Tread Depth Gauge Recording Form
Idaho Standard Practice for

Inspecting / Sampling Paint and Curing Compound

IDAHO Designation: IR-7-04

1. SCOPE

1.1. This method is intended to cover the inspection and sampling of product components and production batches of paints and curing compounds.

1.2. This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.

2. REFERENCE DOCUMENTS

2.1. ASTM Standards


2.2. Federal Standard Test Methods 141

- Method 1022 Sampling for Inspection and Testing

3. TERMINOLOGY

3.1. Batch – A batch is defined as a unit or quantity of material produced at one operation, the weight and volume of which may vary, depending on the manufacturing facilities. As an example, a number of small mill grinds may be combined together in a larger mixer. This material will be considered as one batch and should be labeled as such. Similarly, when a number of varnish cooks are reduced in the same tank the combined reduced material shall be considered as one batch.

3.2. Boxing – Boxing is a method by which a product that is exhibiting settlement is uniformly remixed without the use of power agitation equipment. (Boxing is accomplished by pouring approximately 60% of the liquid portion of the material into a new clean container that is the same size or larger than the package product. Stir the remaining liquid and the settled portions of the material into a uniform thin paste.) The previously removed liquid portion is then poured slowly and with constant stirring back into the original container. The contents are finally poured back and forth from container to container until the product is uniformly mixed and a representative sample can be taken.

3.3. Inspection – Refers to the collection of documentation and visual observation of materials. Inspection does not necessitate the destruction of the packaging or physical alteration of the product. Inspection should include the examination and reporting of the condition of the material in containers, number of units involved, type, class, grade, color, review of manufacturer’s documentation, or other visual considerations of the units as may be called out in the product.
specifications. Inspection may also include the witnessing of a sample being taken by an authorized manufacturer’s representative.

3.4. **Cake** – Dry settlement found in the bottom of a container.

## 4. APPARATUS

4.1. One quart metal cans for solvent based curing compounds and paints.

4.2. One quart lined metal cans for water based curing compounds and paints.

4.3. Mixing equipment consisting of stir paddles, jiffy mixers, shakers, air stirrers, mechanical roller mixers, recirculation pumps, and buckets for boxing.

4.4. Dry pigment sampling equipment consists of Keystone Sampler and Splitter.

## 5. SAMPLING AT LOCATIONS

5.1. **Manufacturing Plant**

5.1.1. Materials are generally packaged and ready for shipment at the time of arrival of the inspector. However, in some instances when large amounts of material are involved, the manufacturer may not have filled the containers, but will hold the material in a large tank until the inspector arrives. Samples will be collected from either the containerized products or from the holding tanks.

5.2. **Project Site or Fabrication Plant**

5.2.1. The packaged materials are at the project site or fabrication plant and will be sampled by the inspector.

## 6. INSPECTION AND SAMPLING PROCEDURES

6.1. Products are inspected for uniformity and samples are taken for the purpose of having a representative quantity, from each batch of material, for physical examination and laboratory testing. The samples will be analyzed to ascertain if the materials meet the specification requirements, the covering product specification, and to determine uniformity within a batch.

6.2. No set of directions for sampling, however explicit, can take the place of judgment, skill and previous experience on the part of a person actually engaged in the sampling and in the supervision of the sampling. These directions are intended to supplement this experience and to serve as a guide in the selection of the sampling method.

6.3. All containers shall be marked with the production batch number, date of manufacture, and product name. At least one sample shall be taken from each batch.

6.4. For all grades of materials, precautions shall be taken to assure the sampling apparatus and the samples themselves are not contaminated and are clean and dry. Slight contamination of the product may lead to false test results. Use the appropriate container for the type of material that is being sampled (Refer to Section 3.1 and 3.2, above).

6.5. The batches shall be sampled according to the applicable plan as describe within this method. Samples shall be selected at random so that they are representative of the batch.
6.6. The samples shall be of such size as to permit the performance of all inspections and laboratory tests. In most cases, one quart of liquid or one pound of dry material is sufficient.

6.7. To the extent possible, it is advisable that original, unopened containers within each batch be selected as samples. When individual containers are less than the one quart or one pound size a sufficient number of containers shall be selected to achieve the required size. Obviously it is not always convenient or economical to have samples of very large size be submitted for testing. In these cases, care must be exercised so that samples are uniform and representative of the batch of material.

6.8. For dry pigments and resins, the package shall be opened by the inspector and a representative sample taken at random from the contents. This sample shall be placed in a clean, dry, metal container closed with an air tight cover, sealed, marked and sent to the Central Laboratory.

6.9. For liquid material the original unopened containers shall be sent to the Central Laboratory. When this is not applicable the inspector shall determine, by thorough testing with a paddle or spatula, if the material meets the absence of caking requirements in the container. The inspector shall thoroughly mix the contents of the container and draw a sample as specified, normally not less than one (1) quart. This sample shall be placed in a suitable clean and dry container. The sample should be filled as full as possible to minimize air contact within the container. The container is then closed with a tight cover, sealed, marked and sent to the Central Laboratory for testing.

6.9.1. With material that has a significant amount of pigment added such as single component zinc paint the zinc settles out rather quickly. The zinc needs to be mixed extensively by the use of a jiffy mixer so that the zinc is suspended back into the binder. Continue agitation with the mixer while taking a sample to insure proper sampling of the material.

6.10. The sample container should be dry and not cooler than room temperature. Because pigmented products are dispersions and not solutions, finely divided pigment particles may settle upon standing. Consequently, thorough and careful agitation of the product before sampling is necessary to restore the product to its original, uniform condition. The method of agitation or stirring is therefore of prime importance.

6.11. Do not place samples in plastic bottles because volatile solvents may diffuse through the walls. Loss of the solvents may introduce errors in such tests as viscosity, weight per gallon and nonvolatile content as well as other properties. (Refer to Section 3.1 and 3.2 for the appropriate containers.) Place either safety clips or a safety ring on the lid of the sample container prior to shipping.

6.12. When representative samples have been obtained and packaged in clean closed containers send them promptly to the Central Laboratory for testing along with all the batch and product information.

6.13. During the period between sampling and delivery, it is important that samples be kept at temperatures from 40 to 90°F. Extreme temperatures may change the properties of some products.

7. **UNIFORMITY OF SAMPLES**

7.1. *Clear Liquid Products.* Clear liquid products require stirring prior to sampling to achieve uniformity and a representative sample. Care must be taken so that any separation, sediment, gel or other matter indicative of non-uniformity is reincorporated back into the product prior to sampling.

7.2. *Pigment Liquid Products.* Pigmented liquid products require stirring prior to sampling to achieve uniformity and a representative sample. Where there is settling, or separation of constituents, these
should be reincorporated by “boxing” or other means of agitation that will sufficiently homogenize the sample to uniformity prior to sampling.

7.3. *Dry Pigments and Powders.* Ordinarily dry pigments, powders, hard resins, etc. are more likely to be uniform than pigmented liquids. Care must be exercised to ensure that samples of these materials are representative of the batch being sampled. For sampling very large containers of these materials a Keystone Sampler and Sample Splitter should be used.

8. **SAMPLING ACCORDING TO CONTAINER SIZE**

8.1. *Containers Smaller Than 5 Gallons.*

8.1.1. When the batch to be sampled is contained in multiple small containers and batch numbers are marked on the containers, put all containers from the same batch together. From each batch select at random one percent (1%) of the containers, but not more than five containers, for sampling. For example, if there are 275 containers in a batch, randomly select three for sampling. A minimum of one sample is required per batch.

8.1.2. After selection of the containers to be sampled, thoroughly agitate or stir the contents. Acceptable methods of mixing are mechanical shaking or stirring, or hand stirring with a paddle, followed by boxing. Mechanical shakers are desirable for most materials since there is thorough agitation in a closed container. Before mechanical shaking, open the container and check to be sure that the pigment has not caked on the bottom of the container. If caking exists, stir manually or with a jiffy mixer to break up the hard settling and then put the containers on the mechanical shaker again. Agitate products having a weight per gallon of 11 lbs/gal or less on the shaker for 5 minutes and those with a weight per gallon of more than 11 lbs/gal for 10 minutes. After agitation, check the products for uniformity again before sampling. If the product is not uniform repeat the process until the product is brought into uniform consistency. After thorough agitation decant a one quart can full and send to the Central Laboratory for testing.

8.2. *Containers Larger than 5 Gallons.*

8.2.1. From each batch select at random five percent (5%) of the containers, but not more than three containers, for sampling. A minimum of one sample is required per batch. Drums may be stirred satisfactorily by several means. With open-head types, mechanical or manual stirring may be used. Some drums contain their own agitators; drum shakers or rollers may also be used. After agitation, check the products for uniformity again before sampling. If the product is not uniform repeat the process until the product is brought into uniform consistency. After thorough agitation decant a one quart can full and send to the Central Laboratory for testing.

8.3. *Containers from 250 to 500 Gallons (Totes)*

8.3.1. From each batch randomly select one tote per 5000 gallons of material for testing. For example if the batch represents 12,000 gallons take three samples from three separate totes within the batch. The material shall be thoroughly agitated by using mechanical mixers or recirculating the material. Recirculating the material shall be done until the entire contents have been turned over within the tote a minimum of three times. The pump rate shall be adequate to achieve this recirculation rate of the material within 1 hour. Alternatively the material may be pump into an empty tote and then pumped back and forth, a minimum of three times, similarly to boxing the material until the material is thoroughly agitated and mixed. Once complete mixing has been accomplished open the valve of the tote and allow a minimum of 2 gallons of product to flow into a 5 gallon bucket. Examine the product for uniformity and then take a one quart sample from the 5 gallon bucket and send it to the Central Laboratory for testing.
8.3.1.1. Care should be used in pump selection as the gear driven pumps can cause shearing in waterborne products causing the emulsion components to separate.

8.4. *Alternative Sampling Procedure.*

8.4.1. When it is impractical, inconvenient, or dangerous to take samples as described above, and where permitted, samples may be taken in the manufacturer’s plant during filling operations or in the production line as applicable. In such cases samples should be taken near the beginning, in the middle, and near the end of the operation. These individual samples should be a minimum of one quart each. Sampling in this manner must be supervised by a representative of the purchaser. Once the three samples have been collected mix them together uniformly, decant the product into a one quart can and send the sample to the Central Laboratory.

8.5. *Composite Samples.*

8.5.1. While not recommended, occasionally composite samples may be permitted for economy in testing. The use of composite samples requires prior approval of the Central Laboratory. When permitted a composite sample shall be used to represent the batch of material in its final state.

9. **DISPOSITION OF SAMPLES**

9.1. Unless otherwise specified each sample taken as directed herein shall be sealed in a clean, dry one quart size container and marked so as to clearly identify the batch number of material involved. Unless otherwise specified, each sample shall be inspected and sampled in accordance with these specifications. Failures of any sample to meet the product specification requirements shall be cause for rejection of the material.

10. **TERMINATION OF SAMPLING**

10.1. When in the course of sampling, the material is found to have serious and obvious defects sampling shall be terminated and resumed only after defects have been corrected or the defective material is replaced.

11. **TIME OF SAMPLING**

11.1. Samples shall be taken as soon as possible after manufacturing or delivery to a site location.

12. **LABORATORY TESTING TIME**

12.1. Allow a minimum of two weeks for test results on all products after they have been received into the Central Laboratory.
Idaho Standard Method of Test for

Determining Total Solids-Latex Percent

IDAHO Designation: IT-121-98

1. SCOPE

1.1. This involves the determination of the percent of solids on all latex samples. It involves weighing a sample of wet latex, drying it in an oven, and expressing the weight ratio of dry/wet in percent.

1.2. This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.

2. PROCEDURE

2.1. All samples to be tested must be at room temperature. If the sample is warm, it can be cooled in a pan of cold tap water.

2.2. Weigh three aluminum cups and record the weight of each (tare weight).

Note 1—Every sample tested must be done in triplicate.

2.3. Mix by hand each sample when cool by inverting the container five to ten times.

2.4. Weigh approximately one gram of latex to the nearest milligram into each pre-weighed aluminum cup.

2.5. Place all three samples in the oven to dry for 120 minutes at a temperature of 285°F ± 2°F (140°C ± 1°C).

2.6. Remove the samples from the oven and place immediately in a desiccator for a few minutes or until cool. This prevents moisture pick-up from the air while cooling.

2.7. Reweigh each sample out of the desiccator to the nearest milligram and record.

3. CALCULATIONS AND REPORT

\[
Total \ Solids \ in \ percent = \frac{(C - A)}{(B - A)} \times 100
\]

Where

A = The weight of the empty cup
B = The weight of the aluminum cup and the wet sample
C = The weight of the aluminum cup and the dried sample
3.1. Example:

If \( A = 1.374 \text{ g} \)
\( B = 2.356 \text{ g} \)
\( C = 1.779 \text{ g} \)

Then \( C-A = 1.779 \) and \( B-A = 2.356 \)
\( -1.374 \)
\( 0.405 \text{ g} \)
\( 0.982 \text{ g} \)

Therefore:
\[
\frac{(C - A) \times 100}{(B - A)} = \frac{0.405}{0.982} \times 100 = 41.2\% \text{ solids}
\]

3.2. If all three samples are within 2%, average the three samples to obtain the percent solids.

3.3. If all three samples are not within 2%, but two samples are within 1%, report the average between the two samples within 1% as the percent solids and discard the third determination.

3.4. If all three samples are not within 2% and no two are within 1%, discard all the values and repeat the solids procedure.
Idaho Standard Practice for

Taking Undisturbed Soil Samples for Laboratory Consolidation, Shear and Permeability Tests

IDAHO Designation: IR-62-17

1. SCOPE

1.1. This method of sampling is designed to secure relatively undisturbed soil samples for laboratory tests. Only soils relatively free of gravel and other rock fragments are considered suitable for this type of sampling.

1.2. This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.

2. APPARATUS

2.1. Mobile drill or diamond drill with standard attachments.

2.2. Clean-out device to assure a clean hole.

2.3. A 2 1/2-in. I.D. sample barrel with a supply of 1-in. high brass liner rings and/or a supply of 2- to 3-in. diameter Shelby thin-wall tubes, 18 to 36 in. in length with a wall thickness not greater than No. 16 gage.

3. PROCEDURE

3.1. The boring should be cleaned out either by hand auger or air jetting to the sampling elevation. Make sure that the bottom of the boring is free of excess loose material.

3.2. With the sampling device resting on the bottom, push it into the soil by a continuous and rapid motion using the hydraulic ram on the mobile drill or diamond drill. The penetration should be approximately five times the diameter of the tube. Do not push the tube farther than the length provided for the sample. The time and pressure required, when measured, should be noted.

3.2.1. If driving is required, the number of blows, driving weight, drop, and penetration should be recorded. Heavy driving weights are preferable to light driving weights because they cause less sample disturbance.

3.3. Before pulling the sample, turn it two revolutions by hand to shear it on the bottom. Pull the sample tube to the surface.

3.4. After pulling the sample, measure and record the length of sample in the tube and also the length penetrated. If the ring-lined sampler is used, select a central portion of the sample and place it in the watertight containers. If the Shelby tube is used, discard the disturbed soil in the upper end.
Ream the lower end to a depth of at least 1 in., seal both ends with wax or other approved methods, and secure with masking tape.

3.5. Containers and/or tubes should be clearly labeled as to project, boring number and location, sample number, depth taken, date taken, and personnel.

3.6. Samples should be taken to supplement in-place vane shear tests or standard penetration tests. The number taken is left to the discretion of the investigator. Generally, enough samples should be taken to provide information on each soil type encountered.

3.7. Samples should not be shipped to the Central Laboratory by common carrier, but should be delivered by state vehicle. Sedans are preferred, as the sample can be laid on the seat and cushioned. Deliver as soon as possible. No storage is permitted. Protection should be provided for heat and cold.

3.8. Dropped samples or frozen samples are of no value. Thus, precautions must be taken to eliminate mishandling.

4. RECORDS

4.1. The following information should be taken in the field and transmitted with the samples.

4.1.1. Date of boring and project identification.

4.1.2. Location of boring, including offset distance.

4.1.3. Boring number.

4.1.4. Collar elevation.

4.1.5. Log of the boring.

4.1.6. Location of the samples taken in profile.

4.1.7. Water data.

4.2. Information regarding the present topography and landform, as well as dimensions of the proposed structure or embankment, should be noted. This, plus the estimated weight per ft$^3$ of a proposed embankment, should be recorded and the information supplied to the Central Materials Laboratory with the undisturbed sample.
Idaho Method of Test for
Resistance R-Value and Expansion Pressure of
Compacted Soils and Aggregates

IDAHO Designation: IT-8-17

1. SCOPE

1.1. This method covers the procedures for determination of Resistance R-value and Expansion Pressure for compacted soils or aggregates. This test method is divided into the following parts:

   I. Method of Preparation of Materials
   II. Method of Compaction for Test Specimen
   III. Method of Determination of Exudation Pressure
   IV. Method of Determination of Expansion Pressure
   V. Method of Determination of Resistance R-value by Means of the Hveem Stabilometer
   VI. Method of Calculating the Densities of Test Specimens

1.2. This standard may involve hazardous materials, operations, and equipment. This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.

2. PART I. METHOD OF PREPARATION OF MATERIALS

2.1. Scope

2.1.1. This part of the procedure describes the methods of batching, mixing and curing of the materials.

2.2. Apparatus

2.2.1. Mechanical mixer.

2.2.2. Scales, 5000 g. capacity, accurate to 1.0 g.

2.2.3. Scales, 175 lb. capacity, with 0.1 lb. graduations.

2.2.4. Set of screens, 3", 2", 1", 3/4", 1/2", and No. 4.

2.2.5. Fiberglass pans and cover.

2.2.6. Vinyl plastic sheets large enough to cover fiberglass pans.

2.2.7. Burette or graduated cylinder for measuring water.
2.2.8. Riffle splitter with chutes 3/4" wide.

2.3. Test Record Form

2.3.1. Keep all pertinent data regarding the soil sample on a preliminary soils worksheet.

2.4. Preparation of Sample

2.4.1. Refer to Test Method AASHTO R 58 for preparation of samples.

2.4.2. The preparation of test samples must include removal of coatings from coarse aggregates, and clay lumps must be broken down to pass the No. 4 sieve. This is important because relatively small test samples are used. It is also important that the test sample be accurately prepared.

2.5. Determining of Grading and Batch Weights Used in Preparing Test Samples

2.5.1. Definitions of "Original" and "As used" grading:

2.5.1.1. "Original": Original grading is grading on a sample prior to any adjustment such as scalping, wasting, or crushing.

2.5.1.2. "As used": As used grading is the grading after the material has been adjusted as necessary to meet the specifications or to eliminate material too large to test. This adjusted grading is referred to as the "As used" grading. In cases where 100% of the material as received passes the 3/4" sieve and no adjustments are necessary, the "Original" and the "As used" grading will be the same.

2.5.2. Criteria for scalping (removing the oversize material) samples containing oversize material.

2.5.2.1. If 75% or more of the sample as received passes the 3/4" sieve, scalp the sample on the 3/4" sieve.

2.5.2.2. If less than 75% of the sample as received passes the 3/4" sieve, scalp the sample on the 1" sieve.

2.5.3. A total of 13 lb. is used to ensure sufficient material for five specimens and a moisture sample.

2.5.4. Calculations required for determining the "As used" grading are as in the following example:

Given an aggregate with the following grading:

More than 75% of the sample as received passes the 3/4" sieve, so scalp materials above the 3/4" sieve.

<table>
<thead>
<tr>
<th>Sieve</th>
<th>Original % Passing</th>
<th>Corrected % Passing</th>
<th>Corrected % Retained</th>
<th>Accumulated Weight, Lb.</th>
</tr>
</thead>
<tbody>
<tr>
<td>1&quot;</td>
<td>90</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>3/4&quot;</td>
<td>85</td>
<td>100</td>
<td>0</td>
<td>0</td>
</tr>
<tr>
<td>1/2&quot;</td>
<td>75</td>
<td>88</td>
<td>12</td>
<td>1.6</td>
</tr>
<tr>
<td>No. 4</td>
<td>65</td>
<td>77</td>
<td>23</td>
<td>3.0</td>
</tr>
</tbody>
</table>

Weight of Sample 13.0 lb.
Using the above example, weigh out 1.6 lb. (13 x 12/100) of retained 1/2" materials; add to this 1.4 lbs (13 x (23-12)/100) of retained No. 4 material and 10.0 lb. of minus No. 4 material to make a total of 13.0 lb.

If the corrected percent retained on the No. 4 sieve is less than 6%, no plus No. 4 material need be added and the sample is treated as though 100% passed the No. 4 sieve.

2.5.5. Add to the sample enough water to approach optimum. This operation is performed by placing the 13.0 lb. sample in the mechanical mixer and adding water. The amount of water added is left to the discretion of the operator and need not be recorded. Continue mixing for at least 30 seconds after the water has been added. The period of mixing given is a minimum requirement. Place the sample in a large fiberglass pan and cover with a plastic sheet in order to prevent moisture loss. Allow to stand overnight.

2.5.6. Before preparing the individual test specimens, an initial moisture sample of approximately 500 g having the same grading as the test sample is taken. The moisture content is determined by weighing before and after drying to constant weight at temperature of 220-230°F.

2.5.7. The R-value test requires the preparation of three or four test specimens at different moisture contents. The first specimen is used as a pilot specimen. After completing the pilot specimen, it can be used as a guide in the preparation of the other three specimens, which shall conform to the following limitations:

2.5.7.1. Height = 2.5 ± 0.05 inches

2.5.7.2. Exudation: One should be above and two below the 2,500 lb. exudation load (200 psi pressure) or two above and one below 2,500 lb. load. The exudation load should be between 1000 and 5000 lbs.

2.5.7.3. Should the pilot specimen satisfy both height and exudation load requirements, it may be used as one of the sample specimens and only three (two additional) specimens need be fabricated. It often requires about 1000 g to 1100 g of material to produce a specimen of proper height. Experience will help in amount selection. Any correction of amount necessary may be made by use of the chart in Figure A2.1.

2.5.8. The amount of water needed to bring the exudation pressure into one of the above ranges is added to the soil and mixed in the mechanical mixer. Very granular and sandy materials can be mixed as thoroughly and as easily with a pan and trowel. It is necessary here to record the amount of water added.

2.5.8.1. With the use of the mixing machine, about 30 seconds at a moderate speed is ample time to mix the material. Any amount of time over this may cause excessive loss of water due to evaporation.

2.5.9. To obtain a representative test specimen when the sample contains plus No. 4 material, proceed as follows:

2.5.9.1. Roll the 13.0 lb. sample on a plastic splitting cloth.

2.5.9.2. From the thoroughly rolled and mixed material, scoop out a representative portion for the test specimen.

2.5.9.3. Thoroughly roll the sample again and scoop out the material for the next specimen.

2.5.9.4. Obtain all additional specimens in this manner.

2.5.10. To prevent evaporation loss of moisture, keep samples covered at all times except during immediate processing.
3. **PART II. METHOD OF COMPACTION FOR TEST SPECIMEN**

3.1. **Scope**

3.1.1. This part of the method describes the compaction procedure for test specimens using a kneading compactor. The kneading compactor densifies the material without depending on straight compression or damaging impact, but rather by a series of individual impressions made with a ram having a face shaped as a sector of a 4" diameter circle. The kneading action is developed by the application of pressures alternately to small localized areas of the specimen while the remainder of the surface is free to move.

3.2. **Apparatus**

3.2.1.1. Kneading compactor (Figure A2.2).

3.2.1.2. Tared steel molds 4" height.

3.2.1.3. Mold holders.

3.2.1.4. Basket fabrication equipment.

3.2.1.5. Paper strips for making baskets.

3.2.1.6. Supply of phosphor-bronze perforated disks.

3.2.1.7. Supply of 4" diameter manila disks.

3.2.1.8. Weighted brass rod.

3.2.1.9. Trowel shaped to fit trough on compactor.

3.2.1.10. Separate trough and trowel for use with soils requiring baskets.

3.2.1.11. 1/2" x 4" steel disk.

3.3. **Preparation of Sample**

3.3.1.1. Sample is prepared as in Part I.

3.4. **Procedure**

3.4.1. Place mold in mold holder with 1/4" thick shims between bottom of mold and base of mold holder. Place 4" diameter manila disk over 3 15/16" diameter and 1/8" thick rubber disk in bottom of mold. Place the assembled mold and holder on the compactor turntable and tighten with thumb screws.

3.4.2. Place well mixed sample in compactor feeder trough with the loose material distributed evenly along the full length.

3.4.3. Using trowel formed to fit feeder trough, push the lower three inches of material in the trough into the mold. Start compactor and maintain 75 psi foot pressure, if possible. The compactor is adjusted to give 30 blows per minute. Push the remainder of the material into the mold in 20 equal parts, using two blows of the compactor for each part of material, for a total of 40 blows. Constant adjustment of the mold stage must be made to obtain the correct length of stroke. The correct length of stroke does not allow the piston to strike the base of the cylinder, thus ensuring continuous pressure on the specimen during the loading part of the cycle. A mark is scribed on the foot guide.
giving a 3/4" clearance between the piston and the cylinder base. When all the material is in the mold, raise and clean the compactor foot. Remove the shims beneath the mold. Put a 4" diameter, 1/8" thick rubber disk on top of the soil and tamp 100 more times while maintaining the pressure at 100 psi for these 100 blows, if possible.

3.4.4. Clays and clean sands may require lower compaction pressures. In these cases, use the greatest compaction pressure possible, but do not allow the foot to penetrate over 1/4" into the surface after all the material is in the mold. If the pressure is reduced, record the pressure used.

3.4.5. If free water appears around the bottom of the mold during compaction, stop the compactor immediately and note the number of blows. In all probability, the sample is too wet.

3.4.6. If the surface is left uneven by the action of the compactor foot, smooth and level the surface by gently tamping with the weighted rod. A square tipped spatula is helpful in removing the accumulation of material around the edge of the mold. Return the mold to the compactor with a 1/2" thick and 4" diameter steel disk on top of the specimen. Lower the stage 1/2" and apply about 10 additional blows without changing foot pressure. This additional leveling aids in more consistent exudation readings.

3.4.7. Granular materials are very difficult to handle without damage and require a paper basket to keep the specimen intact. Baskets prevent the specimen from falling out of the mold and from crumbling when transferred from the mold to the stabilometer. When a basket is used, place the specimen in four approximately equal layers in a mold before compacting by use of the portable trough. Tamp each layer lightly with about ten strokes of the weighted brass rod to arrange the coarser particles in the mold. Apply 140 blows to the specimen with compactor maintaining 100 psi foot pressure. Then remove mold from compactor keeping it upright so specimen will not fall out. (To fabricate paper basket, see Annex A1, Method of Fabricating Paper Baskets)

3.4.8. Record test data into an R-value worksheet

3.5. Precautions

3.5.1. It is important that the operator feed the material into the mold uniformly. Differences in the compactive effort can cause variation in the exudation pressures.

3.5.2. Even distribution of the coarse aggregates throughout the length of the feeder trough is important in order to avoid segregation in the compacted specimen. The material should be evened out and leveled manually with the fingers or spatula along the trough before starting the feeding operations.

3.5.3. The decision whether to use baskets on a given material must be based on experience. They should not be used if they are not needed. If baskets are not used and the specimen breaks up while being transferred into the stabilometer, the fact may not be apparent at the time, but it will result in both excessive stabilometer pressure readings and excessive displacement readings. Both of these errors tend to lower the R-value, and a group of four tests will be erratic with respect to one another. When this happens, the test must be repeated using baskets.

3.5.4. Care must be taken to select the proper amount of material to produce a 2.5" pat. No material shall be removed from the trough or mold in order to produce the correct height.

3.5.5. Precautions should be taken to avoid any drying of material during mixing, in the feed trough or in the mold.

3.6. Hazards

3.6.1. Caution must be used to make certain nothing comes in contact with the compactor foot while it is in operation. A finger caught between the edge of the mold and the compactor foot will receive serious injury.
4. PART III. METHOD OF DETERMINATION OF EXUDATION PRESSURE

4.1. Scope

4.1.1. This part of the method describes the procedure used to determine the pressure required to exude water from the compacted specimen. This pressure is the "Exudation Pressure" for the specimen at that particular moisture content.

4.2. Apparatus

4.2.1. Compression testing machine, 10,000 lb. minimum capacity with solid head (Figure A2.3). If head is spherically seated, use proper shims to lock it in such a manner that the contact face is fixed firmly in a horizontal plane.

4.2.2. Perforated phosphor-bronze disks, 4" diameter and 28 gage.

4.2.3. Moisture exudation device (Figure A2.4).

4.2.4. Press. A level equipped with a 4" diameter foot.

4.2.5. Filter paper. Smooth type, 4" diameter BKH qualitative, Catalog No. 28310, or equivalent.

4.2.6. Height gage.

4.2.7. Follower ram, 4" outside diameter and 6" height.

4.2.8. Supply of 4" diameter manila disks.

4.3. Sample

4.3.1. The specimens as prepared in Part II.

4.4. Procedure

4.4.1. Place perforated phosphor-bronze disk directly on tamped surface of specimen in mold and place a single piece of filter paper on the disk.

4.4.2. Invert mold with specimen so that filter paper is on the bottom, and place mold on the moisture exudation device. Place 4" manila disk on top surface. Then push specimen through to other end with press. It is very important that the mold be centered on the exudation device; this is accomplished by viewing in the mirror and adjusting as necessary. In the case of a basket specimen, do not invert the sample prior to placing on the exudation device; simply center a filter paper on the contact plate and wipe moisture from bronze disk. Then place mold containing basket and material on filter paper.

4.4.3. Insert the follower ram in top of the mold on the specimen. Attach battery clamp to mold and place exudation device with mold in the testing machine and center to ensure even loading.

4.4.4. Use the testing machine to apply an increasing load at the rate of 2,000 lb. per minute until there are lights on in five of the six sections of the moisture exudation indicator device (Figure A2.5). Note and record the load at this point. However, if free moisture becomes visible around the bottom of the mold, covering an area approximately 2" in length (which should touch four contact points) and there are lights on in at least three of the six sections, record the load at that moment in lieu of waiting for five sections.
4.4.5. Discard the specimen if the exudation load does not fall within the required range. A low of 1,000 lb and a high of 5,000 lb may be accepted if necessary.

4.4.6. Leave the mold with follower in place on the exudation device and then place the height gage over mold and follower. Allow dial to come to rest, then read and record. A constant of 2" is understood; that is, if the dial was to read 0.460, the actual height would be $2 + 0.460 = 2.460"$.

4.4.7. Record all test data on a preliminary soils worksheet.

4.4.8. Next, remove height gage, follower, manila paper, bronze disk, and filter paper and weigh the mold with specimen and record. In the cases where a basket is used, the weight of the basket must be taken into consideration and accounted for by adding its weight to the weight on the mold. The basket's average weight is about 33 g.

4.5. Precautions

4.5.1. When the exudation contact plate becomes worn or grooved and the contact points become raised or depressed, the plate should be machined to a plane surface or replaced.

4.5.2. The operator must wipe the contact plate dry between tests, since any moisture remaining will prematurely dampen the new filter paper and cause erroneous exudation pressure results.

4.5.3. The height gage must be checked and reset daily to ensure correct readings.

4.5.4. Wipe plate of basket prior to contact with filter paper.

4.6. Notes

4.6.1. Occasionally material from exceptionally heavy clay test specimens will extrude from under the mold and around the follower ram during the loading operation. Yet, when the 5,000 lb load point is reached, less than five sections are lit. When this occurs, the soil is of very poor quality and should be reported as having R-value less than 5.

4.6.2. There are many cases where high quality materials of a gravelly, sandy or silty nature will have exudation pressures that are extremely sensitive to slight changes in moisture content. Very often these pressures will appear erratic and out-of-step with the sequence of moistures. However, these materials generally exhibit uniform R-values having small variation throughout the entire range of exudation pressures and moisture contents. The R-value versus exudation curve is drawn as an average value in these cases.
5. **PART IV. METHOD OF DETERMINATION OF EXPANSION PRESSURE**

5.1. **Scope**

5.1.1. The expansion test is used to determine the amount of ballast required to prevent a reduction in density of a soil due to expansion when the soil becomes saturated.

5.2. **Apparatus**

5.2.1. Swell frames (Figure A2.6)

5.2.2. Micrometer dial calibrated to 0.0001" mounted on a tripod designed to fit the swell frame.

5.2.3. Proving ring for adjusting swell frames

5.2.4. Perforated disks with screw stems.

5.2.5. 5/16" open-end wrench.

5.3. **Sample**

5.3.1. The samples are the soil specimens as removed from the exudation device. Each specimen should be allowed to rebound for at least 30 minutes after the exudation test before assembling in the swell frame.

5.4. **Procedure**

5.4.1. Place micrometer dial in position on swell frame. Using the 5/16" open-end wrench, adjust the swell frame for an initial reading of minus (-) 0.0016" (the dial will read 0.0084"). You may notice a variance in the dial as there is a slight amount of play as the dial sits on the swell frame, so for the sake of uniformity, the dial is placed as far to the right as possible. The swell frames should be checked periodically with the proving ring and adjusted.

5.4.2. Place one of the perforated plates with screw stems on top of specimen. Place the mold in the swell frame, making sure the base of the frame is dry and free of dirt and sand. After the 30-minute rebound period, adjust the screw stem on the disk until the micrometer dial reads 0.000" with the dial placed as far to the right as possible. This is equivalent to a surcharge pressure of 0.5 psi. It is necessary that the pointed end on the screw stem makes contact with the elastic steel bar exactly in the center. This can be accomplished by visually sighting it in from two different angles. Add water to a depth of approximately 3/4" above the perforated disk and allow the mold to remain in the swell frame overnight or a period of at least 16 hours. Do not readjust the screw stem after adding the water to the mold.

5.4.3. After the 16-hour waiting period, read the deflection of the steel bar by means of the micrometer dial and record on the work sheet. It is again important that the dial be pushed as far to the right as possible. The amount of drainage should also be indicated by the presence or absence of free water at the base of the mold. No drainage at all is indicated by a zero. Slight drainage will be denoted by "SL," and is recognized by a small amount of free water at the base of the mold. Moderate drainage will be "MOD" and is recognized by free water at the base of the mold and a definite drop of the water level inside the mold. Free drainage, denoted as "FD," will be completely void of standing water inside the mold. If the specimen is free draining, a little water must be added and allowed to percolate through in case the sample has dried out considerably.

5.4.4. The next step is to remove the mold from the swell frame, drain off the remaining water, and replace the perforated disk with a 4" Manila paper disk. Save the specimen for the R-value test.

5.4.5. Determine the expansion pressure in psi by multiplying the dial reading by 0.0308. Record the Expansion pressures on a preliminary soils worksheet.
6. PART V. METHOD OF DETERMINATION OF RESISTENCE R-VALUE BY HVEEM STABILOMETER

6.1. Scope

6.1.1. This method covers the procedure for determining the Resistance R-value of compacted soils or aggregates.

6.2. Apparatus

6.2.1. Hveem stabilometer (Figure A2.7) complete with standard metal specimen and follower.

6.2.2. Compression testing machine with spherically seated head.

6.2.3. Press. A lever equipped with a 4" diameter foot to push soil specimens from mold into stabilometer.

6.2.4. Dial on testing machine to measure head speed.

6.2.5. Stop watch.

6.2.6. Drying oven thermostatically controlled to maintain a temperature of 220-230°F.

6.3. Sample

6.3.1. The specimens as removed from the swell test frames.

6.4. Procedure

The correct volumetric adjustment of the air cell in the hydraulic chamber of the stabilometer is necessary in order to establish standardized horizontal pressure and displacement readings. The following is an outline of this calibration procedure.

6.4.1. Adjust the bronze nut on the stabilometer base so that the top of the stage is 3" below the bottom of the upper tapered ring. Perform all tests at this setting. The object is to have the entire briquette surface in contact with the diaphragm and any surplus diaphragm above the sample restrained by the follower.

6.4.2. Put standard metal specimen (4" diameter steel tube) in place in the stabilometer. Seat it firmly on the stage and by holding it in place with either the hand or a confining load of 100 lb. in the testing machine, turn the pump to cause a pressure of exactly 5.0 psi on the stabilometer gage. Adjust the turn indicator dial to zero. Turn pump handle at an approximate rate of two turns per second until the stabilometer dial reads 100 psi. The turns indicator dial should read 2.00 ± 0.05 turns. If it does not, the air in the cell must be adjusted. Remove or add air by means of the valve and repeat the displacement measurement after each air change until the proper number of turns is obtained. This initial displacement should be checked after each 3 or 4 specimens have been run through the stabilometer.

6.4.3. Place the mold containing the soil specimen on the stabilometer and push the specimen into the stabilometer using the press. The displacement pump should be backed off a sufficient number of turns to ensure no friction between the specimen and the diaphragm wall. Be certain free diaphragm is exposed above the top edge of specimen. All free diaphragm surface must be in contact with follower. Place the follower on top of the specimen and put the stabilometer in the testing machine with spherically seated head. Lower the testing machine head until it just engages the follower, but does not apply any load to the specimen.
6.4.4. Apply an initial reading of 5.0 psi on the stabilometer gage with the displacement pump. Then start the testing machine and adjust for a head speed of 0.05" per minute. The head speed must be checked and may need readjusting while the test is being made.

6.4.5. Record the stabilometer gage readings at loads of 500, 1,000, 1,500, and 2,000 lb, respectively, on the testing machine gage. In the case of a very expansive soil, a reading somewhat over 140 psi on the stabilometer gage at 2,000 lb. load may be encountered. In any case where 140 psi is reached before the 2,000 lb. is applied, do not continue to the 2,000 lb. point. Simply record the pressure at the 2,000 lb. load level as 140+ psi.

6.4.6. Vertical loading by the testing machine must cease at 2,000 lb. and the load must immediately be reduced to 1,000 lb. Turn the displacement pump so that the stabilometer gage reading is reduced to 5.0 psi. This will result in a further reduction in the applied testing machine load, which is normal and should be ignored. Set the displacement dial indicator to zero and turn the displacement pump handle to the right at a speed of 2 turns per second until the stabilometer gage reads 100 psi. During this operation, the applied testing machine load will increase and in some cases exceed the initial 1,000 lb. load. As before, these changes in testing machine loadings are normal and should be ignored.

6.4.7. Record the number of turns indicated on the dial as the displacement of the specimen. The turn indicator dial reads in 0.001" and each 0.1" is equal to one turn. Thus a net reading of 0.250" indicates that 2.50 turns were made and should be recorded as such on an R Value worksheet.

6.4.8. Remove the stabilometer from the testing machine and release the lateral pressure. Then remove the follower and the specimen from the stabilometer.

6.4.9. The Resistance R-value is computed from the following equation:

\[ R - Value = 100 - \frac{100}{\left(\frac{2.5}{D}\right) \left(\frac{P_v}{P_h}\right)} + 1 \]

Where:
- \( R \) = Resistance R-value
- \( D \) = Turn Displacement
- \( P_v \) = 160 psi (Vertical pressure)
- \( P_h \) = Horizontal pressure, psi (at vertical pressure of 160 psi)

6.4.9.1. This value may also be taken from the chart shown in Figure A2.8. Another chart is shown in Figure A2.9 that can be used to correct the R-value of any specimen that must be used but exceed the height limits of 2.45" - 2.55". These R-values are then plotted against the corresponding exudation pressures and connected with a smooth curve.

6.4.9.2. Determine the point where the curve crosses the 2,500 lb. exudation load line (200 psi exudation pressure) and record it as the Resistance R-value for the tested material (see Example in Figure A2.10).
7. PART VI. METHOD OF CALCULATING THE DENSITIES OF TEST SPECIMENS

7.1. Scope

7.1.1. This part of the test method covers the procedure for calculating the densities of R-value test specimens.

7.2. Sample

7.2.1. The measurements of height and weight of the test specimen necessary for the density determination are made immediately after the determination of exudation pressure of R-value test specimens according to Part III of this test method and they are recorded on a preliminary soils worksheet.

7.3. Procedure

7.3.1. A moisture sample of approximately 500 g is taken from the original 13 lb. sample, as explained in Part I, and the data entered into an R Value worksheet.

The Moisture Content or Percent Water is computed by the following equation:

\[
\% \text{ Water} = \frac{\text{Wt. of Water (g)}}{\text{Wt. of Dry Soil (g)}} \times 100
\]

7.3.2. The Weight of Water is determined as follows:

\[
\text{Dry Weight (g)} = \frac{\text{Original Weight (wet, g)}}{1 + \frac{\% \text{ Water}}{100}}
\]

\[
\text{Weight of Water (g)} = \text{Original Weight (g)} - \text{Dry Weight (g)}
\]

The Weight of Water is carried over to the line labeled "Wt. of Water" and entered for each specimen on an R Value worksheet. This is then added to the figures on the next line labeled "Water Added" giving the Total Water for each specimen. The Total Percent of Water is calculated as follows:

\[
\% \text{ Water} = \frac{\text{Total Water (g)}}{\text{Dry Weight (g)}} \times 100
\]

7.3.3. The densities of the specimen are then computed from the following equations:

\[
\text{Wet Density (pcf)} = \frac{\text{Net Weight of Soil, Wet (g)}}{\text{height, (inch)}} \times 100
\]

\[
\text{Dry Density (pcf)} = \frac{\text{Wet Density(pcf)}}{1 + \frac{\% \text{ Water}}{100}}
\]

8. REPORT

8.1. Report Test Results on Form ITD-803.
ANNEX

(Mandatory Information)

A1. METHOD OF FABRICATING PAPER BASKETS FOR R-VALUE SPECIMENS

A1.1. Scope:

A1.1.1. This method covers the procedure for fabricating paper baskets that are used in Test Methods No. California 301 and 304.

A1.2. Procedure:

A1.2.1. Apparatus

A1.2.1.1. Basket making device consisting of a 3 7/8" diameter cylindrical wooden block and a 1/2" masking tape dispenser (see Figure A2.11).

A1.2.2. Materials

A1.2.2.1. Strips of notched paper: 60 lb. brown Kraft paper 2 1/2" x 13 3/8" with slots 1 7/8" in length and 3/4" apart down the center of the strip (see Figure A2.12).

A1.2.2.2. 4" diameter phosphor-bronze perforated exudation pressure disks.

A1.2.3. 1/2" width masking tape.

A1.3. Fabrication Procedure

A1.3.1. Take a piece of slotted paper and fold around the cylindrical wooden block, hooking the slotted ends together. See photos B and C of Figure A2.11.

A1.3.2. Using four strips of 1/2" masking tape, tape phosphor-bronze disk to the paper so that the holes in the disk are not obscured in the process. See photos D and E of Figure A2.11.

A2. FIGURES DESCRIBED IN THIS METHOD

A2.1. This annex contains charts, photos of the apparatus, and worksheets used in this standard.
Figure A2.1— Chart for Determining Proper Amount of Material for 2-1/2" R-Value Briquette
Figure A2.2— Kneading Compactor

Figure A2.3— Compression Testing Machine
Figure A2.4—Moisture Exudation Device

Figure A2.5—Moisture Exudation Indicator Device
With 6 Light Sections
Figure A2.6— Swell Frames for Measuring Expansion Pressure

Figure A2.7— Hveem Stabilometer
Figure A2.8—Chart for Determining Resistance R-Value

\[ R = \frac{100 - \frac{3}{5} \frac{P_H}{D}}{P_H} + 1 \]

\[ D = \text{TURNS DISPLACEMENT} \]
\[ P_H = \text{GAUGE PRESSURE IN LB./SQ. IN.} \]
CHART FOR CORRECTING R-VALUES TO SPECIMEN HEIGHT OF 2.50"

HEIGHT CORRECTION SHOULD BE MADE USING THE CHART BELOW.

NOTE: NO CORRECTION FOR SPECIMEN HEIGHTS BETWEEN 2.45" AND 2.55". INTERPOLATE R-VALUE CORRECTIONS FOR OTHER HEIGHTS.

EXAMPLE: OVERALL HEIGHT OF 2.65"
R-VALUE (UNCORRECTED) = 50
R-VALUE (CORRECTED) = 54

Figure A2.9—Chart for Correcting R-Value to Specimen Height of 2.5"
### R-Value Worksheet

**Lab Number:**

**Project No.:**

**Key Number:**

#### Coarse R-value Make up Calculations

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</table>

#### Make Up Moisture Content Calculations

To Achieve: % Moisture, Add Grams of Water

#### Comments:

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**Figure A2.10— Example of R-Value Test Worksheet**
Figure A2.11— Fabricating Paper Basket for Test Specimen
SPECIFICATIONS FOR THE SLOTTED PAPER USED IN FABRICATING PAPER BASKETS FOR STABILOMETER SPECIMENS

Figure A2.12—Specifications for Paper Used To Fabricate Basket
Idaho Standard Practice for

**Calibrating Torque Wrenches, Tightening and Testing Bolt Tension**

IDAHO Designation: IR-12-17

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### 1. SCOPE

1.1. This method is intended to provide a standard procedure for the calibration of torque wrenches.

1.2. *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

---

### 2. REFERENCE DOCUMENTS

2.1. *ASTM Standards*

   - E4-16, Standard Specification for Force Verification of Testing Machines

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### 3. PROCEDURE

3.1. Before proceeding with calibration, assure that the tension measuring device has been calibrated by an approved testing agency within the last year in accordance with ASTM E4.

3.1.1. Prior to each day’s activities, verify the calibration of the wrench or wrenches being used. If a parameter is found to be out of calibration, adjust the wrench to assure the parameter is within the tolerable range. Report all calibration measurements including the date, out of tolerance values, and adjusted values.

---

### 4. CALIBRATION OF TORQUE WRENCH

4.1. Clamp the calibration unit on a solid immovable mount (e.g., beam, column, etc.)

4.2. Install front plate and matching rear bolt bushing for bolt size being used

4.3. Insert bolt from bushing side; washer and nut from plate side.

4.4. *Torque Control Impact Wrenches:*

4.4.1. Run up nut with impact wrench until wrench stalls. Read the dial for pounds tension. If reading is too high or low, adjust torque setting accordingly and repeat using new bolt and nut.

4.5. *Conventional Impact Wrenches:*

4.5.1. Set wrench air line regulator at desired power value. Run up nut until it stops rotating. Again, read the dial for pounds tension. Adjust regulator as necessary until wrench delivers desired bolt-tension dial reading.

4.6.1.  Run up nut with wrench until reaching desired tension. Adjust ratchet release as necessary until wrench delivers desired bolt tension dial reading. For dial gage wrenches, document the dial reading to achieve the appropriate tension on the calibration unit, or adjust the dial gage if applicable.

4.7.  Wrenches shall be calibrated to induce approximately 105 – 110% of the installation bolt tension listed in the ITD Standard Specifications Subsection 708.06 for the given bolt size, and in no case exceed 125% of the listed bolt tension. Acceptable calibration will consist of three (3) bolt assemblies testing within 10% of each other.
Idaho Standard Practice for

Calibrating the Skidmore-Wilhelm Torque-Wrench Calibration Unit

IDAHO Designation: IR-17-98

1. SCOPE

1.1. This method is intended to provide a standard procedure for the calibration of the Skidmore-Wilhelm Torque Wrench Calibration Unit.

1.2. *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

2. REFERENCE DOCUMENTS

2.1. *ASTM Standards*


2.2. *OTHER Standards*

   - Manufacturer’s Pamphlet

3. EQUIPMENT

3.1. Testing machine with a capacity of at least as high as the Skidmore unit and calibrated to ± 1%.

3.2. Steel pressure plates (two each to fit piston No. 3 and inside plate screens No. 16).

4. PROCEDURE

4.1. Place torque-wrench calibration unit in the testing machine with the bolt plate No. 5 centered directly under the upper compression head. In centering the unit in the testing machine, make sure the steel pressure plates are in place. One pressure plate fits the piston No. 3 from the back sides, making sure it clears the snap ring No. 7. The other steel pressure plate fits over bolt plate No. 5 and inside the plate screws No. 16.

4.2. After the foregoing has been accomplished, apply pressure with the testing machine to the torque-wrench calibration unit.

   *Note 1— Before mating surfaces of the torque calibration unit with the testing machine heads, retain a small clearance. This clearance is then taken up with the hydraulic head of the testing machine. This step must be accomplished to prevent locking the heads of the testing machine together.*

4.3. This pressure shall be at a slow, even rate so readings can be taken from both the testing machine dial and the torque-wrench calibration unit dial. This speed should not exceed 0.3125 in./minute.
The Skidmore unit is read at 5,000-lb. (20 kN) increments through the total range of the Skidmore unit.

4.4. The object of this calibration procedure is to relate the pounds pressure indicated by the torque-wrench calibration unit with the pounds pressure indicated by the calibrated testing machine in exact increments of pounds to each other. If there is any deviation between the two devices, the torque-wrench calibration unit must be sent to the manufacturer for repair, unless the repair is deemed minor and can be done by the laboratory accomplishing the calibrating.
Figure 1—Skidmore-Wilhelm Torque-Wrench Calibration Unit
Idaho Standard Practice for

Pavement Straightedge Procedures

IDAHO Designation: IR-87-17

1. SCOPE

1.1. This method establishes procedures for making straightedge measurements on the riding surfaces of pavements and is intended for use with the hand-held 10 ft. straightedge.

1.2. This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.

2. APPARATUS

2.1. The apparatus shall consist of a 10 ft. straightedge. The straightedge shall be visually straight when checked periodically against a taut fine (about 1/64 in. diameter) wire.

3. PROCEDURE

3.1. Surface irregularities shall be measured from the straightedge to various points on the pavement surface below the straightedge. The straightedge shall be firmly supported by the pavement.

3.2. Tests for surface irregularities shall be made parallel to centerline and normal (transverse) to centerline as required to verify conformance with specified limits.

3.3. All transverse construction joints shall be measured. Make these measurements with the straightedge centered on each joint.

3.4. Individual judgment shall be exercised when taking measurements on short, steep, super-elevated sections and crowned sections of short radii such as at intersections of city streets, etc.

3.5. On bridge decks where the specifications require 90 percent of the readings to be less than 1/8 in., measurements shall be taken in each wheel path in continuous lines as provided in paragraph 3.2 above for the full length of the structure. In addition, at locations determined by the Engineer, straightedge measurements are to be taken perpendicular to centerline. These transverse measurements may be made either in continuous lines or as individual 10 ft. samples at selected locations. Measure the lengths of irregularities, which are less than 1/8 in. below the straightedge, to the nearest 1 in. Add up the lengths having less than 1/8 in. deviation within each 10 ft. increment, divide by the straightedge length and multiply by 100 to obtain the percentage less than 1/8 in. Also measure any deviations greater than 1/4 in. when the specification requires. Measure joints separately as provided in Paragraph 3.3 above.
Idaho Standard Method of Test for

Determining Volume of Liquids in horizontal or Vertical Storage Tanks

IDAHO Designation: IT-120-17

1. **SCOPE**

1.1. This method is used to determine the volume of liquids in horizontal and vertical storage tanks. It is usually called "sticking" the tank.

1.2. This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.

2. **PURPOSE**

2.1. The quantity of liquid materials at the beginning and end of shifts are needed to determine approximately how much material is being used each day and to compare with invoice totals at specific intervals when the tank is empty, full, etc.

3. **APPARATUS**

3.1. A 50-foot flexible steel tape graduated in inches or tenths of feet.

3.2. Graduated wooden rod made for tank measurements, if available.

3.3. Rags.

3.4. Insulated gloves (see Section 5, Safety Precautions).

3.5. Ladder, string, flashlight, etc., as found necessary.

**Note 1**—Many tanks have some indicator showing the height of liquid in the tank. This indicator may be a glass sight gauge; a permanently installed metal ladder gauge inside, visible from the top or through windows; a float with a pulley and indication on the outside; or other method. In case of doubt about the accuracy of these indicators, they should be calibrated using the data in this Test Method.

4. **TEST PROCEDURE**

4.1. *Horizontal Tanks*

4.1.1. The volume of the tank must be known or calculated as follows.

4.1.2. Determine the length and the diameter of the tank using calculated inside measurements. Calculate the volume:
\[ V(\text{gallons}) = \frac{\pi D^2}{4} \times L \times 7.48 \]

Where:

\( D = \) Diameter of the tank, in feet and tenths of feet
\( L = \) Length of the tank, in feet and tenths of feet

4.1.3. Measure the depth of the liquid (h) in the tank by use of the "stick" or a weighted tape.

4.1.3.1. Divide (h) by the diameter of the tank and multiply by 100 to get the percent depth filled.

4.1.3.2. Using this percent depth filled value from Table 1, obtain the percent of capacity.

4.1.4. Multiply the known volume of the tank, (V) by the percent capacity just obtained and divide by 100 to give the volume of hot liquid.

\[ \text{Total Volume Liquid (hot)} = \frac{V(\text{gallons}) \times \% \text{ of Capacity}}{100} \]

4.2. \( \text{Vertical Tanks} \)

4.2.1. Measure the inside diameter of the tank. Calculate the volume per foot as follows.

\[ V(\text{gallons}) = \frac{\pi D^2}{4} \times 7.48 \]

Where:

\( D = \) Diameter of the tank, in feet and tenths of feet

4.2.2. Measure the depth of liquid (h) in feet to the nearest tenth.

4.2.3. Calculate the volume of hot liquid as follows:

\[ \text{Total Volume Liquid (hot)} = V(\text{gallons}) \times h \]

4.2.4. Convert the volume of hot liquid obtained from Paragraph 4.1.4 or 4.2.3 to standard 60°F volume using standard temperature conversion charts such as Tables IV-1, 2, and 3 of the Asphalt Institute Manual Number MS-6.

4.2.5. Convert standard temperature volume in gallons to English tons using Table 2.

5. \( \text{SAFETY PRECAUTIONS} \)

5.1. Materials being sampled are usually hazardous. They may be hot (asphalt), flammable (gas, fuel oil, or solvents), caustic (lime solutions), poison (weed killers), etc., and every care must be taken to protect the person sampling. Protective clothing should be worn. Hard hats, goggles or safety glasses, insulated gloves, long-sleeved shirts, heavy shoes, and face masks, if necessary, should be used.
Table 1—Quantities for Various Depths of Cylindrical Tanks in a Horizontal Position

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<th>% of Capacity</th>
<th>% Depth Filled</th>
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Asphalt Institute MS-6
### Table 2 — Weight and Volume Relations [60°F]

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<tr>
<th>SP. GR.</th>
<th>Pounds per Gallon</th>
<th>Gallons per Ton</th>
<th>SP. GR.</th>
<th>Pounds per Gallon</th>
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</table>
AGGREGATE

FIELD OPERATING PROCEDURES - SHORT FORM

<table>
<thead>
<tr>
<th>Chapter</th>
<th>AASHTO T 2 (16)</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Sampling of Aggregate</td>
</tr>
<tr>
<td>2</td>
<td>AASHTO R 76 (16)</td>
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<tr>
<td></td>
<td>Reducing Samples of Aggregate to Testing Size</td>
</tr>
<tr>
<td>3</td>
<td>AASHTO T 255 (14)</td>
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<tr>
<td></td>
<td>Total Evaporable Moisture Content of Aggregate by Drying</td>
</tr>
<tr>
<td>4</td>
<td>AASHTO T 27 (16)</td>
</tr>
<tr>
<td></td>
<td>Sieve Analysis of Fine and Coarse Aggregates, and</td>
</tr>
<tr>
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<td>AASHTO T11 (16)</td>
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<td></td>
<td>Materials Finer than 75 µm (No. 200) sieve in Mineral Aggregates by Washing</td>
</tr>
<tr>
<td>5</td>
<td>AASHTO T 335 (16)</td>
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<tr>
<td></td>
<td>Determining the Percentage of Fracture in Coarse Aggregate</td>
</tr>
<tr>
<td>6</td>
<td>AASHTO T 176 (16)</td>
</tr>
<tr>
<td></td>
<td>Plastic Fines in Graded Aggregates and Soils by Use of the Sand Equivalent Test</td>
</tr>
</tbody>
</table>
REDUCING SAMPLES OF AGGREGATES TO TESTING SIZE
FOP FOR AASHTO R 76 (16)

Scope

This procedure covers the reduction of samples to the appropriate size for testing in accordance with AASHTO R 76-16. Techniques are used that minimize variations in characteristics between test samples and field samples. Method A (Mechanical Splitter) and Method B (Quartering) are covered.

This FOP applies to fine aggregate (FA), coarse aggregate (CA), and mixes of the two (FA / CA), and may also be used on soils.

Apparatus

Method A – Mechanical Splitter

Splitter chutes:

- Even number of equal width chutes
- Discharge alternately to each side
- Minimum of 8 chutes total for CA and FA / CA, 12 chutes total for FA
- Width:
  - Minimum 50 percent larger than largest particle
  - Maximum chute width of 19 mm (3/4 in.) for fine aggregate passing the 9.5 mm (3/8 in.) sieve

Feed control:

- Hopper or straightedge pan with a width equal to or slightly less than the overall width of the assembly of chutes
- Capable of feeding the splitter at a controlled rate

Splitter receptacles / pans:

- Capable of holding two halves of the sample following splitting

The splitter and accessory equipment shall be so designed that the sample will flow smoothly without restriction or loss of material.
Method B – Quartering

- Straightedge scoop, shovel, or trowel
- Broom or brush
- Canvas or plastic sheet, approximately 2 by 3 m (6 by 9 ft)

**Method Selection**

Samples of CA may be reduced by either Method A or Method B.

Samples of FA which are drier than the saturated surface dry (SSD) condition, as described in AASHTO T 84, shall be reduced by a mechanical splitter according to Method A. As a quick approximation, if the fine aggregate will retain its shape when molded with the hand, it is wetter than SSD.

Samples of FA / CA which are drier than SSD may be reduced by Method A or Method B.

Samples of FA and FA / CA that are at SSD or wetter than SSD shall be reduced by Method B, or the entire sample may be dried to the SSD condition – using temperatures that do not exceed those specified for any of the tests contemplated – and then reduced to test sample size using Method A.

<table>
<thead>
<tr>
<th></th>
<th>Drier than SSD</th>
<th>Wetter than SSD</th>
</tr>
</thead>
<tbody>
<tr>
<td>Fine Aggregate (FA)</td>
<td>Method A (Mechanical)</td>
<td>Method B (Quartering)</td>
</tr>
<tr>
<td>Mixture of FA/CA</td>
<td>Either Method</td>
<td>Method B (Quartering)</td>
</tr>
<tr>
<td>Coarse Aggregate (CA)</td>
<td>Either Method</td>
<td>Either Method</td>
</tr>
</tbody>
</table>

**Procedure**

**Method A – Mechanical Splitter**

1. Place the sample in the hopper or pan and uniformly distribute it from edge to edge so that approximately equal amounts flow through each chute. The rate at which the sample is introduced shall be such as to allow free flowing through the chutes into the pans below.
2. Reduce the sample from one of the two pans as many times as necessary to reduce the sample to meet the minimum size specified for the intended test. The portion of the material collected in the other pan may be reserved for reduction in size for other tests.

3. As a check for effective reduction, determine the mass of each reduced portion. If the percent difference of the two masses is greater than 5 percent, corrective action must be taken. In lieu of the check for effective reduction, use the method illustrated in Figure 1.

**Figure 1**

Sample (S) is an amount greater than or equal to twice the mass needed for testing. Sample (S) is reduced in a mechanical splitter to yield parts (1) and (2).

Part (1) is further reduced yielding (A) and (B) while part (2) is reduced to yield (B) and (A).

Final testing sample is produced by combining alternate pans, i.e. A/A or B/B only.

**Calculation**

\[
\frac{Smaller \ Mass}{Larger \ Mass} = \text{Ratio} \quad (1 - \text{ratio}) \times 100 = % \text{Difference}
\]

Splitter check: 5127 g total sample mass

Splitter pan #1: 2583 g

Splitter pan #2: 2544 g

\[
\frac{2544 \text{ g}}{2583 \text{ g}} = 0.985 \quad (1 - 0.985) \times 100 = 1.5\%
\]
Procedure

Method B – Quartering

Use either of the following two procedures or a combination of both.

Procedure # 1: Quartering on a clean, hard, level surface:

1. Place the sample on a hard, clean, level surface where there will be neither loss of material nor the accidental addition of foreign material.

2. Mix the material thoroughly by turning the entire sample over a minimum of four times. With the last turning, shovel the entire sample into a conical pile by depositing each shovelful on top of the preceding one.

3. Flatten the conical pile to a uniform thickness and diameter by pressing down with a shovel. The diameter should be four to eight times the thickness.

4. Divide the flattened pile into four approximately equal quarters with a shovel or trowel.

5. Remove two diagonally opposite quarters, including all fine material, and brush the cleared spaces clean.

6. Successively mix and quarter the remaining material until the sample is reduced to the desired size.

7. The final test sample consists of two diagonally opposite quarters.

Procedure # 2: Quartering on a canvas or plastic sheet:

1. Place the sample on the sheet.

2. Mix the material thoroughly a minimum of four times by pulling each corner of the sheet horizontally over the sample toward the opposite corner. After the last turn, form a conical pile.

3. Flatten the conical pile to a uniform thickness and diameter by pressing down with a shovel. The diameter should be four to eight times the thickness.

4. Divide the flattened pile into four approximately equal quarters with a shovel or trowel, or, insert a stick or pipe beneath the sheet and under the center of the pile, then lift both ends of the stick, dividing the sample into two roughly equal parts. Remove the stick leaving a fold of the sheet between the divided portions. Insert the stick under the center of the pile at right angles to the first division and again lift both ends of the stick, dividing the sample into four roughly equal quarters.
5. Remove two diagonally opposite quarters, being careful to clean the fines from the sheet.

6. Successively mix and quarter the remaining material until the sample size is reduced to the desired size.

7. The final test sample consists of two diagonally opposite quarters.
PERFORMANCE EXAM CHECKLIST

REDUCING FIELD SAMPLES OF AGGREGATES TO TESTING SIZE
FOP FOR AASHTO R 76

Participant Name ______________________________ Exam Date ______________

Record the symbols “P” for passing or “F” for failing on each step of the checklist.

Trial 1 Trial 2

Method A - Splitting

1. Material spread uniformly on feeder? _____ _____
2. Rate of feed slow enough so that sample flows freely through chutes? _____ _____
3. Material in one pan re-split until desired mass is obtained? _____ _____

Method B - Quartering

1. Sample placed on clean, hard, and level surface? _____ _____
2. Mixed by turning over 4 times with shovel or by pulling sheet horizontally over pile? _____ _____
3. Conical pile formed? _____ _____
4. Diameter equal to about 4 to 8 times thickness? _____ _____
5. Pile flattened to uniform thickness and diameter? _____ _____
6. Divided into 4 equal portions with shovel or trowel? _____ _____
7. Two diagonally opposite quarters, including all fine material, removed? _____ _____
8. Cleared space between quarters brushed clean? _____ _____
9. Process continued until desired sample size is obtained when two opposite quarters combined? _____ _____

The sample may be placed upon a sheet and a stick or pipe may be placed under the sheet to divide the pile into quarters.

Comments: First attempt: Pass____ Fail____ Second attempt: Pass____ Fail____

________________________________________________________________________
________________________________________________________________________
________________________________________________________________________
________________________________________________________________________
________________________________________________________________________

Examiner Signature ____________________________ WAQTC #: ______________

SAMPLING OF AGGREGATES
FOP FOR AASHTO T 2 (16)

Scope

This procedure covers sampling of coarse, fine, or a combination of coarse and fine aggregates (CA and FA) in accordance with AASHTO T 2-91. Sampling from conveyor belts, transport units, roadways, and stockpiles is covered.

Apparatus

- Shovels or scoops, or both
- Sampling tubes of acceptable dimensions
- Mechanical sampling systems: normally a permanently attached device that allows a sample container to pass perpendicularly through the entire stream of material or diverts the entire stream of material into the container by manual, hydraulic, or pneumatic operation
- Belt template
- Sampling containers

Procedure – General

Sampling is as important as testing. The technician shall use every precaution to obtain samples that are representative of the material. Determine the time or location for sampling in a random manner.

1. Wherever samples are taken, obtain multiple increments of approximately equal size.

2. Mix the increments thoroughly to form a field sample that meets or exceeds the minimum mass recommended in Table 1.
### TABLE 1
Recommended Sample Sizes

<table>
<thead>
<tr>
<th>Nominal Maximum Size* mm (in.)</th>
<th>Minimum Mass g (lb)</th>
</tr>
</thead>
<tbody>
<tr>
<td>2.36 (No. 8)</td>
<td>10,000 (25)</td>
</tr>
<tr>
<td>4.75 (No. 4)</td>
<td>10,000 (25)</td>
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<tr>
<td>9.5 (3/8)</td>
<td>10,000 (25)</td>
</tr>
<tr>
<td>12.5 (1/2)</td>
<td>15,000 (35)</td>
</tr>
<tr>
<td>19.0 (3/4)</td>
<td>25,000 (55)</td>
</tr>
<tr>
<td>25.0 (1)</td>
<td>50,000 (110)</td>
</tr>
<tr>
<td>37.5 (1 1/2)</td>
<td>75,000 (165)</td>
</tr>
<tr>
<td>50 (2)</td>
<td>100,000 (220)</td>
</tr>
<tr>
<td>63 (2 1/2)</td>
<td>125,000 (275)</td>
</tr>
<tr>
<td>75 (3)</td>
<td>150,000 (330)</td>
</tr>
<tr>
<td>90 (3 1/2)</td>
<td>175,000 (385)</td>
</tr>
</tbody>
</table>

*One sieve larger than the first sieve to retain more than 10 percent of the material using an agency specified set of sieves based on cumulative percent retained. Where large gaps in specification sieves exist, intermediate sieve(s) may be inserted to determine nominal maximum size. Maximum size is one size larger than nominal maximum size.

**Note 1:** Sample size is based upon the test(s) required. As a general rule the field sample size should be such that, when split twice will provide a testing sample of proper size. For example the sample size may be four times that shown in Table 2 of the FOP for AASHTO T 27/T 11, if that mass is more appropriate.

### Procedure – Specific Situations

**Conveyor Belts**

Avoid sampling at the beginning or end of the aggregate run due to the potential for segregation. Be careful when sampling in the rain. Make sure to capture fines that may stick to the belt or that the rain tends to wash away.

**Method A (From the Belt)**

1. Stop the belt.

2. Set the sampling template in place on the belt, avoiding intrusion by adjacent material.

3. Remove the material from inside the template, including all fines.

4. Obtain at least three approximately equal increments.

5. Combine the increments to form a single sample.
Method B (From the Belt Discharge)

1. Pass a sampling device through the full stream of the material as it runs off the end of the conveyor belt. The sampling device may be manually, semi-automatic or automatically powered.

2. The sampling device shall pass through the stream at least twice, once in each direction, without overfilling while maintaining a constant speed during the sampling process.

3. When emptying the sampling device into the container, include all fines.

4. Combine the increments to form a single sample.

Transport Units

1. Visually divide the unit into four quadrants.

2. Identify one sampling location in each quadrant.

3. Dig down and remove approximately 0.3 m (1 ft.) of material to avoid surface segregation. Obtain each increment from below this level.

4. Combine the increments to form a single sample.

Roadways

Method A (Berm or Windrow)

1. Obtain sample before spreading.

2. Take the increments from at least three random locations along the fully-formed windrow or berm. Do not take the increments from the beginning or the end of the windrow or berm.

3. Obtain full cross-section samples of approximately equal size at each location. Take care to exclude the underlying material.

4. Combine the increments to form a single sample.

Note 2: Obtaining samples from berms or windrows may yield extra-large samples and may not be the preferred sampling location.

Method B (In-Place)

1. Obtain sample after spreading and before compaction.
2. Take the increments from at least three random locations.

3. Obtain full-depth increments of approximately equal size from each location. Take care to exclude the underlying material.

4. Combine the increments to form a single sample.

**Stockpiles**

**Method A – Loader sampling**

1. Direct the loader operator to enter the stockpile with the bucket at least 150 mm (6 in.) above ground level without contaminating the stockpile.

2. Discard the first bucketful.

3. Have the loader re-enter the stockpile and obtain a full loader bucket of the material, tilt the bucket back and up.

4. Form a small sampling pile at the base of the stockpile by gently rolling the material out of the bucket with the bucket just high enough to permit free-flow of the material. (Repeat as necessary.)

5. Create a flat surface by having the loader back drag the small pile.

6. Visually divide the flat surface into four quadrants.

7. Collect an increment from each quadrant by fully inserting the shovel into the flat pile as vertically as possible, take care to exclude the underlying material, roll back the shovel and lift the material slowly out of the pile to avoid material rolling off the shovel.

**Method B – Stockpile Face Sampling**

1. Create horizontal surfaces with vertical faces in the top, middle, and bottom third of the stockpile with a shovel or loader.

2. Prevent continued sloughing by shoving a flat board against the vertical face. Sloughed material will be discarded to create the horizontal surface.

3. Obtain sample from the horizontal surface as close to the intersection as possible of the horizontal and vertical faces.

4. Obtain at least one increment of equal size from each of the top, middle, and bottom thirds of the pile.
5. Combine the increments to form a single sample.

**Method C – Alternate Tube Method (Fine Aggregate)**

1. Remove the outer layer that may have become segregated.

2. Using a sampling tube, obtain one increment of equal size from a minimum of five random locations on the pile.

3. Combine the increments to form a single sample.

*Note 3:* Obtaining samples at stockpiles should be avoided whenever possible due to problems involved in obtaining a representative gradation of material.

**Report**

- On forms approved by the agency
- Date
- Time
- Sample ID
- Location
- Quantity represented
## PERFORMANCE EXAM CHECKLIST

**SAMPLING OF AGGREGATES**  
**FOP FOR AASHTO T 2**

Participant Name ______________________________ Exam Date ______________

Record the symbols “P” for passing or “F” for failing on each step of the checklist.

<table>
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<tr>
<th>Procedure Element</th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Conveyor Belts – Method A (From the Belt)</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>1. Belt stopped?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>2. Sampling template set on belt, avoiding intrusion of adjacent material?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>3. Sample, including all fines, scooped off?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>4. Samples taken in at least three approximately equal increments?</td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>Conveyor Belts – Method B (From the Belt Discharge)</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>5. Sampling device passed through full stream of material twice (once in each direction) as it runs off end of belt?</td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>Transport Units</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>6. Unit divided into four quadrants?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>7. Increment obtained from each quadrant, 0.3 m (1ft.) below surface?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>8. Increments combined to make up the sample?</td>
<td></td>
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</tr>
<tr>
<td><strong>Roadways Method A (Berm or Windrow)</strong></td>
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<td></td>
</tr>
<tr>
<td>9. Sample taken prior to spreading?</td>
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<td></td>
</tr>
<tr>
<td>10. Full depth of material taken?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>11. Underlying material excluded?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>12. Samples taken in at least three approximately equal increments?</td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>Roadways Method B (In-place)</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>13. Sample taken after spreading?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>14. Full depth of material taken?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>15. Underlying material excluded?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>16. Samples taken in at least three approximately equal increments?</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

OVER
Stockpile Method A—(Loader sampling)

17. Loader operator directed to enter the stockpile with the bucket at least 150 mm (6 in.) above ground level without contaminating the stockpile?  

18. First bucketful discarded?  

19. The loader re-entered the stockpile and obtained a full loader bucket of the material with the bucket tilted back and up?  

20. A small sampling pile formed at the base of the stockpile by gently rolling the material out of the bucket with the bucket just high enough to permit free-flow of the material?  

21. A flat surface created by the loader back dragging the small pile?  

22. Increment sampled from each quadrant by fully inserting the shovel into the flat pile as vertically as possible, care taken to exclude the underlying material?  

Stockpile Method B (Stockpile Face)

23. Created horizontal surfaces with vertical faces?  

24. At least one increment taken from each of the top, middle, and bottom thirds of the stockpile.  

Stockpile Method C – Alternate Tube Method (Fine Aggregate)

25. Outer layer removed?  

26. Increments taken from at least five locations with a sampling tube?  

General

27. Increments mixed thoroughly to form sample?  

Comments:  First attempt:  Pass____ Fail____  Second attempt:  Pass____ Fail____

Examiner Signature ______________________ WAQTC #: ______________________
### PERFORMANCE EXAM CHECKLIST (ORAL)

**SAMPLING OF AGGREGATES**  
**FOP FOR AASHTO T 2**

Participant Name ______________________________ Exam Date ______________

Record the symbols “P” for passing or “F” for failing on each step of the checklist.

<table>
<thead>
<tr>
<th>Procedure Element</th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>1. How is a sample obtained from a conveyor belt using Method A?</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>a) Stop the belt.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>b) Set the sampling template on belt, avoiding intrusion of adjacent material.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>c) All the material is removed from belt including all fines.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>d) Take at least approximately three equal increments.</td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>2. How is a sample obtained from a conveyor belt using Method B?</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>a) Pass the sampling device through a full stream of material as it runs off the end of the belt.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>b) The device must be passed through at least twice (once in each direction).</td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>3. How is a sample obtained from a Transport Unit?</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>a) Divide the unit into four quadrants.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>b) Dig 0.3 m (1 ft.) below surface.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>c) Obtain an increment from each quadrant.</td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>4. Describe the procedure for sampling from roadways Method A (Berm or Windrow).</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>a) Sample prior to spreading</td>
<td></td>
<td></td>
</tr>
<tr>
<td>b) Sample the material full depth without obtaining underlying material.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>c) Take at least three approximately equal increments.</td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>5. Describe the procedure for sampling from roadway Method B (In-place).</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>a) Sample after spreading, prior to compaction.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>b) Sample the material full depth without obtaining underlying material.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>c) Take at least three approximately equal increments.</td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>6. Describe the procedure for sampling a stockpile Method A (Loader Sampling).</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>a) Loader creates sampling pile with a flat surface.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>b) Divide the flat surface into four quadrants.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>c) Take an approximately equal increment from each quadrant, excluding the underlying material.</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

OVER
7. **Describe the procedure for sampling a stockpile Method B (Stockpile Face Sampling).**
   a) Create horizontal surfaces with vertical faces and at least one increment taken from each of the top, middle, and bottom thirds of the stockpile.

8. **Describe the procedure for sampling a stockpile Method C – Alternate Tube Method (Fine Aggregate).**
   a) Remove the outer layer and increments taken from at least five locations.

9. **After obtaining the increments what should you do before performing R 76?**
   a) Increments mixed thoroughly to form sample.

Comments: First attempt: Pass Fail Second attempt: Pass Fail

Examiner Signature ______________________ WAQTC #: _____________________
SIEVE ANALYSIS OF FINE AND COARSE AGGREGATES
FOP FOR AASHTO T 27 (16)

MATERIALS FINER THAN 75 µm (No. 200) SIEVE IN MINERAL AGGREGATE
BY WASHING
FOP FOR AASHTO T 11 (16)

Scope

Sieve analysis determines the gradation or distribution of aggregate particle sizes within a given sample.

Accurate determination of material smaller than 75 µm (No. 200) cannot be made with AASHTO T 27 alone. If quantifying this material is required, it is recommended that AASHTO T 27 be used in conjunction with AASHTO T 11.

This FOP covers sieve analysis in accordance with AASHTO T 27-14 and materials finer than 75 µm (No. 200) in accordance with AASHTO T 11-05 performed in conjunction with AASHTO T 27. The procedure includes three method choices: A, B, and C.

Apparatus

- Balance or scale: Capacity sufficient for the masses shown in Table 1, accurate to 0.1 percent of the sample mass or readable to 0.1 g, and meeting the requirements of AASHTO M 231
- Sieves: Meeting the requirements of AASHTO M 92
- Mechanical sieve shaker: Meeting the requirements of AASHTO T 27
- Suitable drying equipment (see FOP for AASHTO T 255)
- Containers and utensils: A pan or vessel of a size sufficient to contain the sample covered with water and to permit vigorous agitation without loss of any part of the sample or water
- Optional mechanical washing device

Sample Sieving

- In all procedures, it is required to shake the sample over nested sieves. Sieves are selected to furnish information required by specification.
- The sieves are nested in order of decreasing size from the top to the bottom and the sample, or a portion of the sample, is placed on the top sieve.
- Sieves are shaken in a mechanical shaker for approximately 10 minutes, or the minimum time determined to provide complete separation for the sieve shaker being used. As established by the Time Evaluation.

**Time Evaluation**

The sieving time for each mechanical sieve shaker shall be checked at least annually to determine the time required for complete separation of the sample by the following method:

1. Shake the sample over nested sieves for approximately 10 minutes.

2. Provide a snug-fitting pan and cover for each sieve, and hold in a slightly inclined position in one hand.

3. Hand-shake each sieve by striking the side of the sieve sharply and with an upward motion against the heel of the other hand at the rate of about 150 times per minute, turning the sieve about one sixth of a revolution at intervals of about 25 strokes.

If more than 0.5 percent by mass of the total sample prior to sieving passes any sieve after one minute of continuous hand sieving adjust shaker time and re-check.

In determining sieving time for sieve sizes larger than 4.75 mm (No. 4), limit the material on the sieve to a single layer of particles.

**Overload Determination**

- For sieves with openings smaller than 4.75 mm (No. 4), the mass retained on any sieve shall not exceed 7 kg/m² (4 g/in²) of sieving surface.

- For sieves with openings 4.75 mm (No. 4) and larger, the mass, in grams shall not exceed the product of 2.5 × (sieve opening in mm) × (effective sieving area). See Table 1.

Additional sieves may be necessary to keep from overloading sieves or to provide other information, such as fineness modulus. The sample may also be sieved in increments to prevent overload.
TABLE 1
Maximum Allowable Mass of Material Retained on a Sieve, g
Nominal Sieve Size, mm (in.)
Exact size is smaller (see AASHTO T 27)

<table>
<thead>
<tr>
<th>Sieve Size mm (in.)</th>
<th>203 dia (8)</th>
<th>305 dia (12)</th>
<th>305 by 305 (12 × 12)</th>
<th>350 by 350 (14 × 14)</th>
<th>372 by 580 (16 × 24)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Sieving Area m²</td>
<td>0.0285</td>
<td>0.0670</td>
<td>0.0929</td>
<td>0.1225</td>
<td>0.2158</td>
</tr>
<tr>
<td>90 (3 1/2)</td>
<td>*</td>
<td>15,100</td>
<td>20,900</td>
<td>27,600</td>
<td>48,500</td>
</tr>
<tr>
<td>75 (3)</td>
<td>*</td>
<td>12,600</td>
<td>17,400</td>
<td>23,000</td>
<td>40,500</td>
</tr>
<tr>
<td>63 (2 1/2)</td>
<td>*</td>
<td>10,600</td>
<td>14,600</td>
<td>19,300</td>
<td>34,000</td>
</tr>
<tr>
<td>50 (2)</td>
<td>3600</td>
<td>8400</td>
<td>11,600</td>
<td>15,300</td>
<td>27,000</td>
</tr>
<tr>
<td>37.5 (1 1/2)</td>
<td>2700</td>
<td>6300</td>
<td>8700</td>
<td>11,500</td>
<td>20,200</td>
</tr>
<tr>
<td>25.0 (1)</td>
<td>1800</td>
<td>4200</td>
<td>5800</td>
<td>7700</td>
<td>13,500</td>
</tr>
<tr>
<td>19.0 (3/4)</td>
<td>1400</td>
<td>3200</td>
<td>4400</td>
<td>5800</td>
<td>10,200</td>
</tr>
<tr>
<td>16.0 (5/8)</td>
<td>1100</td>
<td>2700</td>
<td>3700</td>
<td>4900</td>
<td>8600</td>
</tr>
<tr>
<td>12.5 (1/2)</td>
<td>890</td>
<td>2100</td>
<td>2900</td>
<td>3800</td>
<td>6700</td>
</tr>
<tr>
<td>9.5 (3/8)</td>
<td>670</td>
<td>1600</td>
<td>2200</td>
<td>2900</td>
<td>5100</td>
</tr>
<tr>
<td>6.3 (1/4)</td>
<td>440</td>
<td>1100</td>
<td>1500</td>
<td>1900</td>
<td>3400</td>
</tr>
<tr>
<td>4.75 (No. 4)</td>
<td>330</td>
<td>800</td>
<td>1100</td>
<td>1500</td>
<td>2600</td>
</tr>
<tr>
<td>-4.75 (-No. 4)</td>
<td>200</td>
<td>470</td>
<td>650</td>
<td>860</td>
<td>1510</td>
</tr>
</tbody>
</table>

Sample Preparation

Obtain samples in accordance with the FOP for AASHTO T 2 and reduce to the size shown in Table 2 in accordance with the FOP for AASHTO R 76. These sample sizes are standard for aggregate testing but, due to equipment restraints, samples may need to be partitioned into several “subsamples.” For example, a gradation that requires 100 kg (220 lbs) of material would not fit into a large tray shaker in one batch.

Some agencies permit reduced sample sizes if it is proven that doing so is not detrimental to the test results. Some agencies require larger sample sizes. Check agency guidelines for required or permitted test sample sizes.
TABLE 2
Sample Sizes for Aggregate Gradation Test

<table>
<thead>
<tr>
<th>Nominal Maximum Size* mm (in.)</th>
<th>Minimum Dry Mass g (lb)</th>
</tr>
</thead>
<tbody>
<tr>
<td>4.75 (No. 4)</td>
<td>500 (1)</td>
</tr>
<tr>
<td>6.3 (1/4)</td>
<td>1000 (2)</td>
</tr>
<tr>
<td>9.5 (3/8)</td>
<td>1000 (2)</td>
</tr>
<tr>
<td>12.5 (1/2)</td>
<td>2000 (4)</td>
</tr>
<tr>
<td>19.0 (3/4)</td>
<td>5000 (11)</td>
</tr>
<tr>
<td>25.0 (1)</td>
<td>10,000 (22)</td>
</tr>
<tr>
<td>37.5 (1 1/2)</td>
<td>15,000 (33)</td>
</tr>
<tr>
<td>50 (2)</td>
<td>20,000 (44)</td>
</tr>
<tr>
<td>63 (2 1/2)</td>
<td>35,000 (77)</td>
</tr>
<tr>
<td>75 (3)</td>
<td>60,000 (130)</td>
</tr>
<tr>
<td>90 (3 1/2)</td>
<td>100,000 (220)</td>
</tr>
<tr>
<td>100 (4)</td>
<td>150,000 (330)</td>
</tr>
<tr>
<td>125 (5)</td>
<td>300,000 (660)</td>
</tr>
</tbody>
</table>

*Nominal maximum size: One sieve larger than the first sieve to retain more than 10 percent of the material using an agency specified set of sieves based on cumulative percent retained. Where large gaps between specification sieves exist, intermediate sieve(s) may be inserted to determine nominal maximum size.

Selection of Procedure

Agencies may specify what method will be performed. If a method is not specified method A will be performed.

Overview

Method A
- Determine dry mass of original sample
- Wash through a 75µm (No. 200) sieve
- Determine dry mass of washed sample
- Sieve material

Method B
- Determine dry mass of original sample
- Wash through a 75µm (No. 200) sieve
- Determine dry mass of washed sample
- Sieve coarse material
- Determine dry mass of fine material
- Reduce fine portion
- Determine mass of reduced portion
- Sieve fine portion
Method C

- Determine dry mass of original sample
- Sieve coarse material
- Determine mass of fine material
- Reduce fine portion
- Determine mass of reduced portion
- Wash through a 75 µm (No. 200) sieve
- Determine dry mass of washed sample
- Sieve reduced fine portion

Procedure Method A

1. Dry the sample to a constant mass in accordance with the FOP for AASHTO T 255. Determine and record the total dry mass of the sample to the nearest 0.1 percent or 0.1 g.

2. When the specification requires that the amount of material finer than 75 µm (No. 200) be determined, perform Step 3 through Step 11; otherwise, skip to Step 12.

3. Nest a sieve, such as a 2.0 mm (No. 10), above the 75 µm (No. 200) sieve.

4. Place the test sample in a container and add sufficient water to cover it.

   Note 1: A detergent, dispersing agent, or other wetting solution may be added to the water to assure a thorough separation of the material finer than the 75 µm (No. 200) sieve from the coarser particles. There should be enough wetting agent to produce a small amount of suds when the sample is agitated. Excessive suds may overflow the sieves and carry material away with them.

5. Agitate vigorously to ensure complete separation of the material finer than 75 µm (No. 200) from coarser particles and bring the fine material into suspension above the coarser material. When using a mechanical washing device, exercise caution to avoid degradation of the sample.

6. Immediately pour the wash water containing the suspended and dissolved solids over the nested sieves, being careful not to pour out the coarser particles.

7. Add a second change of water to the sample remaining in the container, agitate, and repeat Step 6. Repeat the operation until the wash water is reasonably clear. If a detergent or dispersing agent is used, continue washing until the agent is removed.

8. Remove the upper sieve, return material retained to the washed sample.

9. Rinse the material retained on the 75 µm (No. 200) sieve until water passing through the sieve is reasonably clear.

10. Return all material retained on the 75 µm (No. 200) sieve to the container by flushing into the washed sample.
**Note 2:** Excess water may be carefully removed with a bulb syringe as long as the removed water is discharged back over the No. 200 sieve to preclude loss of fines.

11. Dry the washed aggregate to constant mass in accordance with the FOP for AASHTO T 255, and then cool prior to sieving. Record the “dry mass after washing.”

12. Select sieves to furnish the information required by the specifications. Nest the sieves in order of decreasing size from top to bottom and place the sample, or a portion of the sample, on the top sieve.

13. Place sieves in mechanical shaker and shake for the minimum time determined to provide complete separation for the sieve shaker being used (approximately 10 minutes).

**Note 3:** Excessive shaking (more than 10 minutes) may result in degradation of the sample.

14. Determine the individual or cumulative mass retained on each sieve and the pan to the nearest 0.1 percent or 0.1 g. Ensure that all material trapped in full openings of the sieve are cleaned out and included in the mass retained.

**Note 4:** For sieves No. 4 and larger, material trapped in less than a full opening shall be checked by sieving over a full opening. Use coarse wire brushes to clean the 600 µm (No. 30) and larger sieves, and soft bristle brushes for smaller sieves.

**Note 5:** In the case of coarse / fine aggregate mixtures, the minus 4.75 mm (No. 4) may be distributed among two or more sets of sieves to prevent overloading of individual sieves.

15. Verify the total mass of material after sieving agrees with the mass before sieving within 0.3 percent. (Check sum). If performing T 11 with T 27, this would be the dry mass after wash. If performing just T 27 this would be the original dry mass. When the masses before and after sieving differ by more than 0.3 percent, the results cannot be used for acceptance purposes.

16. Calculate the total percentages passing, individual or cumulative percentages retained or percentages in various size fractions to the nearest 0.1 percent by dividing the masses on the individual sieve masses or cumulative sieve masses by the total mass of the initial dry sample. If the same test sample was first tested by T 11, use the total dry sample mass before washing in T 11 as the basis for calculating all percentages.

17. Report percent passing as indicated in the “Report” section at the end of this FOP.
Method A Calculations

\[
\text{Check sum} = \frac{\text{dry mass after washing} - \text{total mass after sieving}}{\text{dry mass after washing}} \times 100
\]

Percent Retained

\[
IPR = \frac{IMR}{M} \times 100 \quad \text{or} \quad CPR = \frac{CMR}{M} \times 100
\]

Where:
- IPR = Individual Percent Retained
- CPR = Cumulative Percent Retained
- M = Total Dry Sample mass before washing
- IMR = Individual Mass Retained
- CMR = Cumulative Mass Retained

Percent Passing (Calculated):

\[
PP = PPP - IPR \quad \text{or} \quad PP = 100 - CPR
\]

Where:
- PP = Percent Passing
- PPP = Previous Percent Passing

Method A Example

Dry mass of total sample, before washing: 5168.7 g
Dry mass of sample, after washing out the 75µm (No. 200) minus: 4911.3 g
Amount of 75µm (No. 200) minus washed out: 5168.7 g – 4911.3 g = 257.4 g
<table>
<thead>
<tr>
<th>Sieve Size mm (in.)</th>
<th>Individual Mass Retained g (IMR)</th>
<th>Individual Percent Retained (IPR)</th>
<th>Cumulative Mass Retained g (CMR)</th>
<th>Cumulative Percent Retained (CPR)</th>
<th>Calc'd Percent Passing (CPP)</th>
<th>Reported Percent Passing* (RPP)</th>
</tr>
</thead>
<tbody>
<tr>
<td>19.0 (3/4)</td>
<td>0</td>
<td>0</td>
<td>0</td>
<td>0.0</td>
<td>100.0</td>
<td>100</td>
</tr>
<tr>
<td>12.5 (1/2)</td>
<td>724.7</td>
<td>14.0</td>
<td>724.7</td>
<td>14.0</td>
<td>86.0</td>
<td>86</td>
</tr>
<tr>
<td>9.5 (3/8)</td>
<td>619.2</td>
<td>12.0</td>
<td>1343.9</td>
<td>26.0</td>
<td>74.0</td>
<td>74</td>
</tr>
<tr>
<td>4.75 (No. 4)</td>
<td>1189.8</td>
<td>23.0</td>
<td>2533.7</td>
<td>49.0</td>
<td>51.0</td>
<td>51</td>
</tr>
<tr>
<td>2.36 (No. 8)</td>
<td>877.6</td>
<td>17.0</td>
<td>3411.3</td>
<td>66.0</td>
<td>34.0</td>
<td>34</td>
</tr>
<tr>
<td>1.18 (No. 16)</td>
<td>574.8</td>
<td>11.1</td>
<td>3986.1</td>
<td>77.1</td>
<td>22.9</td>
<td>23</td>
</tr>
<tr>
<td>0.600 (No. 30)</td>
<td>329.8</td>
<td>6.4</td>
<td>4315.9</td>
<td>83.5</td>
<td>16.5</td>
<td>17</td>
</tr>
<tr>
<td>0.300 (No. 50)</td>
<td>228.5</td>
<td>4.4</td>
<td>4544.4</td>
<td>87.9</td>
<td>12.1</td>
<td>12</td>
</tr>
<tr>
<td>0.150 (No. 100)</td>
<td>205.7</td>
<td>4.0</td>
<td>4750.1</td>
<td>91.9</td>
<td>8.1</td>
<td>8</td>
</tr>
<tr>
<td>0.075 (No. 200)</td>
<td>135.4</td>
<td>2.6</td>
<td>4885.5</td>
<td>94.5</td>
<td>5.5</td>
<td>5.5</td>
</tr>
<tr>
<td>Pan</td>
<td>20.4</td>
<td></td>
<td>4905.9</td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

*Report 75 µm (No. 200) sieve to 0.1 percent. Report all others to 1 percent.

Check sum:

\[
\frac{4911.3 \text{ g} - 4905.9 \text{ g}}{4911.3 \text{ g}} \times 100 = 0.1\%
\]

This is less than 0.3 percent therefore the results can be used for acceptance purposes.

Percent Retained:

9.5 mm (3/8) sieve:

\[
\frac{619.2 \text{ g}}{5168.7 \text{ g}} \times 100 = 12.0\%
\]

or

\[
\frac{1343.9 \text{ g}}{5168.7 \text{ g}} \times 100 = 26.0\%
\]

Percent Passing (Calculated):

9.5 mm (3/8) sieve:

\[
86.0\% - 12.0\% = 74.0\%
\]

or

\[
100.0\% - 26.0\% = 74.0\%
\]
Procedure Method B

1. Perform steps 1 through 11 from the “Procedure – Method A,” then continue as follows:

2. Select sieves to furnish information required by the specifications. Nest the sieves in order of decreasing size from top to bottom through the 4.75 mm (No. 4) with a pan at the bottom to retain the minus 4.75 mm (No. 4).

3. Place the sample, or a portion of the sample, on the top sieve. Sieves may already be in the mechanical shaker, or place the sieves in the mechanical shaker and shake for the minimum time determined to provide complete separation for the sieve shaker being used (approximately 10 minutes).

   **Note 3:** Excessive shaking (more than 10 minutes) may result in degradation of the sample.

4. Determine the individual or cumulative mass retained on each sieve to the nearest 0.1 percent or 0.1 g. Ensure that all particles trapped in full openings of the sieve are cleaned out and included in the mass retained.

   **Note 4:** For sieves No. 4 and larger, material trapped in less than a full opening shall be checked by sieving over a full opening. Use coarse wire brushes to clean the 600 µm (No. 30) and larger sieves, and soft hair bristle for smaller sieves.

5. Determine the mass of the material in the pan [minus 4.75 mm (No. 4)] (M₁).

6. Verify the total mass of material after sieving agrees with the mass before sieving within 0.3 percent. (Coarse check sum). If performing T 11 with T 27, this would be the dry mass after wash. If performing just T 27 this would be the original dry mass. When the masses before and after sieving differ by more than 0.3 percent, the results cannot be used for acceptance purposes.

7. Reduce the minus 4.75 mm (No. 4) using a mechanical splitter in accordance with the FOP for AASHTO R 76 to produce a sample with a mass of 500 g minimum. Determine and record the mass of the minus 4.75 mm (No. 4) split (M₂).

8. Select fine sieves to furnish information required by the specifications. Nest the sieves in order of decreasing size from top to bottom through the 75 µm (No. 200) with a pan at the bottom to retain the minus 75µm (No. 200).

9. Repeat steps 3 through 5, Method B, with the minus 4.75 mm (No. 4).

10. Verify the total mass of material after sieving agrees with the mass before sieving within 0.3 percent. (Fine check sum). This would be the dry mass from Step 7. When the masses before and after sieving differ by more than 0.3 percent, the results cannot be used for acceptance purposes.

11. Calculate the Individual Mass Retained (IMR) or Cumulative Mass Retained (CMR) of the size increment of the original sample.
12. Calculate the total percent passing and report as indicated in the “Report” section at the end of this FOP.

**Method B Calculations**

**Coarse check sum** = \[ \frac{\text{dry mass after washing} - \text{total mass after coarse sieving}}{\text{dry mass after washing}} \times 100 \]

**Fine check sum** = \[ \frac{M_2 - \text{total mass after fine sieving}}{M_2} \times 100 \]

**Individual Mass Retained (IMR):**

\[ IMR = \frac{M_1}{M_2} \times B \]

where:
- IMR = adjusted individual mass retained of the size increment on a total sample basis
- M1 = mass of minus 4.75mm (No. 4) sieve in total sample
- M2 = mass of minus 4.75mm (No. 4) sieve actually sieved
- B = individual mass of the size increment in the reduced portion sieved

**Cumulative Mass Retained (CMR):**

\[ CMR = \left( \frac{M_1}{M_2} \times B \right) + D \]

where:
- CMR = Total cumulative mass retained of the size increment based on a total sample
- M1 = mass of minus 4.75mm (No. 4) sieve in total sample
- M2 = mass of minus 4.75mm (No. 4) sieve actually sieved
- B = cumulative mass of the size increment in the reduced portion sieved
- D = cumulative mass of plus 4.75mm (No. 4) portion of sample

**Method B Example**

Dry mass of total sample, before washing: 3214.0 g
Dry mass of sample, after washing out the 75 µm (No. 200) minus: 3085.1 g
Amount of 75 µm (No. 200) minus washed out: 3214.0 g – 3085.1 g = 128.9 g
Gradation on Coarse Sieves

<table>
<thead>
<tr>
<th>Sieve Size mm (in.)</th>
<th>Individual Mass Retained g (IMR)</th>
<th>Individual Percent Retained (IPR)</th>
<th>Cumulative Mass Retained g (CMR)</th>
<th>Cumulative Percent Retained (CPR)</th>
<th>Calculated Percent Passing (CPP)</th>
</tr>
</thead>
<tbody>
<tr>
<td>16.0 (5/8)</td>
<td>0</td>
<td>0</td>
<td>0</td>
<td>0</td>
<td>100</td>
</tr>
<tr>
<td>12.5 (1/2)</td>
<td>161.1</td>
<td>5.0</td>
<td>161.1</td>
<td>5.0</td>
<td>95.0</td>
</tr>
<tr>
<td>9.50 (3/8)</td>
<td>481.4</td>
<td>15.0</td>
<td>642.5</td>
<td>20.0</td>
<td>80.0</td>
</tr>
<tr>
<td>4.75 (No. 4)</td>
<td>475.8</td>
<td>14.8</td>
<td>1118.3</td>
<td>34.8</td>
<td>65.2</td>
</tr>
<tr>
<td>Pan</td>
<td>1966.7 (M₁)</td>
<td></td>
<td>3085.0</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

Coarse check sum:

\[
\frac{3085.1 \ g - 3085.0 \ g}{3085.1 \ g} \times 100 = 0.0\% 
\]

This is less than 0.3 percent therefore the results can be used for acceptance purposes.

**Note 5:** The pan mass determined in the laboratory (M₁) and the calculated mass (3085.1 – 1118.3 = 1966.7) should be the same if no material was lost.

The pan (1966.7 g) was reduced in accordance with the FOP for AASHTO R 76, so that at least 500 g are available. In this case, the mass determined was 512.8 g. This is M₂.

In order to account for the fact that only a portion of the minus 4.75mm (No. 4) material was sieved, the mass of material retained on the smaller sieves is adjusted by a factor equal to M₁/M₂. The factor determined from M₁/M₂ must be carried to three decimal places. Both the individual mass retained and cumulative mass retained formulas are shown.

**Individual Mass Retained:**

\[
M₁ = \text{total mass in the pan of the minus 4.75mm (No. 4) before reducing} \\
M₂ = \text{mass of the split minus 4.75 mm (No. 4)}
\]

\[
\frac{M₁}{M₂} = \frac{1,966.7 \ g}{512.8 \ g} = 3.835
\]

Each “individual mass retained” on the fine sieves must be multiplied by this adjustment factor.
Example:

**Overall mass retained on the 2.00 mm (No. 10) = 3.835 \times 207.1 \, g = 794.2 \, g**

As shown in the following table.

<table>
<thead>
<tr>
<th>Sieve Size mm (in.)</th>
<th>Individual Mass Retained, g (IMR)</th>
<th>Adjusted Individual Mass Retained (AIMR)</th>
<th>Individual Percent Retained (IPR)</th>
<th>Calc’d Percent Passing (CPP)</th>
<th>Reported Percent Passing* (RPP)</th>
</tr>
</thead>
<tbody>
<tr>
<td>16.0 (5/8)</td>
<td>0</td>
<td>0</td>
<td>0.0</td>
<td>100.0</td>
<td>100</td>
</tr>
<tr>
<td>12.5 (1/2)</td>
<td>161.1</td>
<td>161.1</td>
<td>5.0</td>
<td>95.0</td>
<td>95</td>
</tr>
<tr>
<td>9.5 (3/8)</td>
<td>481.4</td>
<td>481.4</td>
<td>15.0</td>
<td>80.0</td>
<td>80</td>
</tr>
<tr>
<td>4.75 (No. 4)</td>
<td>475.8</td>
<td>475.8</td>
<td>14.8</td>
<td>65.2</td>
<td>65</td>
</tr>
<tr>
<td>2.0 (No. 10)</td>
<td>207.1 × 3.835</td>
<td>794.2</td>
<td>24.7</td>
<td>40.5</td>
<td>41</td>
</tr>
<tr>
<td>0.425 (No. 40)</td>
<td>187.9 × 3.835</td>
<td>720.6</td>
<td>22.4</td>
<td>18.1</td>
<td>18</td>
</tr>
<tr>
<td>0.210 (No. 80)</td>
<td>59.9 × 3.835</td>
<td>229.7</td>
<td>7.1</td>
<td>11.0</td>
<td>11</td>
</tr>
<tr>
<td>0.075 (No. 200)</td>
<td>49.1 × 3.835</td>
<td>188.3</td>
<td>5.9</td>
<td>5.1</td>
<td>5.1</td>
</tr>
<tr>
<td>Pan</td>
<td>7.8 × 3.835</td>
<td>29.9</td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

Dry mass of total sample, before washing: 3214.0 g

*Report 75 µm (No. 200) sieve to 0.1 percent. Report all others to 1 percent.

Fine check sum:

\[
\frac{512.8 \, g - 511.8 \, g}{512.8 \, g} \times 100 = 0.2\%
\]

This is less than 0.3 percent therefore the results can be used for acceptance purposes.

**Percent Passing (Calculated)** see “Calculation” under Method A.

**Cumulative Mass Retained:**

\[
M_1 = \text{total mass in the pan of the minus 4.75 mm (No. 4) before split}
\]

\[
M_2 = \text{mass of the split minus 4.75 mm (No. 4)}
\]

\[
\frac{M_1}{M_2} = \frac{1,966.7 \, g}{512.8 \, g} = 3.835
\]

Each “cumulative mass retained” on the fine sieves must be multiplied by this adjustment factor then the cumulative mass of plus 4.75 mm (No. 4) portion of sample is added to equal the adjusted cumulative mass retained.
Example:

Adjusted Cumulative Mass Retained on the 2.00 mm (No. 10) =

\[ 3.835 \times 207.1 \, g = 794.2 \, g \]

Total Cumulative Mass Retained on the 2.00 mm (No. 10) =

\[ 794.2 \, g + 1118.3 \, g = 1912.5 \, g \]

As shown in the following table.

<table>
<thead>
<tr>
<th>Sieve Size mm (in.)</th>
<th>Cumulative Mass Retained g (CMR)</th>
<th>Adjusted Cumulative Mass Retained, g (ACMR)</th>
<th>Total Cumulative Mass Retnd. g (TCMR)</th>
<th>Cumulative Percent Retnd. (CPR)</th>
<th>Calc’d Percent Passing (CPP)</th>
<th>Reported Percent Passing* (RPP)</th>
</tr>
</thead>
<tbody>
<tr>
<td>16.0 (5/8)</td>
<td>0</td>
<td>0</td>
<td>0</td>
<td>0.0</td>
<td>100.0</td>
<td>100</td>
</tr>
<tr>
<td>12.5 (1/2)</td>
<td>161.1</td>
<td>161.1</td>
<td>794.2</td>
<td>5.0</td>
<td>95.0</td>
<td>95</td>
</tr>
<tr>
<td>9.5 (3/8)</td>
<td>642.5</td>
<td>642.5</td>
<td>1912.5</td>
<td>20.0</td>
<td>80.0</td>
<td>80</td>
</tr>
<tr>
<td>4.75 (No. 4)</td>
<td>1118.3</td>
<td>1118.3</td>
<td>794.2 + 1118.3</td>
<td>59.5</td>
<td>40.5</td>
<td>41</td>
</tr>
<tr>
<td>2.0 (No. 10)</td>
<td>207.1 × 3.835</td>
<td>794.2 + 1118.3</td>
<td>1912.5</td>
<td>59.5</td>
<td>40.5</td>
<td>41</td>
</tr>
<tr>
<td>0.425 (No. 40)</td>
<td>395.0 × 3.835</td>
<td>1514.8 + 1118.3</td>
<td>2633.1</td>
<td>81.9</td>
<td>18.1</td>
<td>18</td>
</tr>
<tr>
<td>0.210 (No. 80)</td>
<td>454.9 × 3.835</td>
<td>1744.5 + 1118.3</td>
<td>2862.8</td>
<td>89.1</td>
<td>10.9</td>
<td>11</td>
</tr>
<tr>
<td>0.075 (No. 200)</td>
<td>504.0 × 3.835</td>
<td>1932.8 + 1118.3</td>
<td>3051.1</td>
<td>94.9</td>
<td>5.1</td>
<td>5.1</td>
</tr>
<tr>
<td>Pan</td>
<td>511.8 × 3.835</td>
<td>1962.8 + 1118.3</td>
<td>3081.1</td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

*Report 75 µm (No. 200) sieve to 0.1 percent. Report all others to 1 percent.

Fine check sum:

\[ \frac{512.8 \, g - 511.8g}{512.8 \, g} \times 100 = 0.2\% \]

This is less than 0.3 percent therefore the results can be used for acceptance purposes. For Percent Passing (Calculated) see “Calculation” under Method A.
Procedure Method C

1. Dry sample in accordance with the FOP for AASHTO T 255. Determine and record the total dry mass of the sample to the nearest 0.1 percent or 1 g.

*Note 6:* AASHTO T 27 allows for coarse aggregate to be run in a moist condition unless the nominal maximum size of the aggregate is smaller than 12.5 mm (1/2 in.), the coarse aggregate (CA) contains appreciable material finer than 4.75 mm (No. 4), or the coarse aggregate is highly absorptive.

2. Break up any aggregations or lumps of clay, silt or adhering fines to pass the 4.75 mm (No. 4) sieve. If substantial coatings remain on the coarse particles in amounts that would affect the percent passing any of the specification sieves, the sample should be tested with either Method A or Method B.

3. Select sieves to furnish information required by the specifications. Nest the sieves in order of decreasing size from top to bottom through the 4.75 mm (No.4) with a pan at the bottom to retain the minus 4.75 mm (No. 4).

4. Place the sample, or a portion of the sample, on the top sieve. Sieves may already be in the mechanical shaker or place the sieves in the mechanical shaker and shake for the minimum time determined to provide complete separation for the sieve shaker being used (approximately 10 minutes).

*Note 3:* Excessive shaking (more than 10 minutes) may result in degradation of the sample.

5. Determine the cumulative mass retained on each sieve to the nearest 0.1 percent or 0.1 g. Ensure that all material trapped in full openings of the sieve are cleaned out and included in the mass retained.

*Note 4:* For sieves No. 4 and larger, material trapped in less than a full opening shall be checked by sieving over a full opening. Use coarse wire brushes to clean the 600 µm (No. 30) and larger sieves, and soft bristle brush for smaller sieves.

6. Determine the mass of material in the pan [minus 4.75 mm (No. 4)] (M₁).

7. Verify the total mass of material after sieving agrees with the mass before sieving within 0.3 percent. (Coarse check sum). If performing T 11 with T 27, this would be the dry mass after wash. If performing just T 27 this would be the original dry mass. When the masses before and after sieving differ by more than 0.3 percent, the results cannot be used for acceptance purposes.

8. Reduce the minus 4.75mm (No. 4), using a mechanical splitter in accordance with the FOP for AASHTO R 76, to produce a sample with a mass of 500 g minimum.

9. Determine and record the mass of the minus 4.75mm (No. 4) split (M₃).

10. Perform steps 3 through 11 of Method A (Wash) on the minus 4.75mm (No. 4) split.

11. Select fine sieves to furnish information required by the specifications. Nest the sieves in order of decreasing size from top to bottom through the 75µm (No. 200) with a pan at the bottom to retain the minus 75 µm (No. 200).
12. Repeat steps 4 through 6, Method C, with the minus 4.75 mm (No. 4).

13. Verify the total mass of material after sieving agrees with the mass before sieving within 0.3 percent. (Fine check sum). This would be the dry mass from Step 10. When the masses before and after sieving differ by more than 0.3 percent, the results cannot be used for acceptance purposes.

14. Calculate the Cumulative Percent Retained (CPR) or Cumulative Percent Passing (CPP) for the 4.75 mm (No. 4) and larger.

15. Calculate the Cumulative Percent Retained (CPR-#4) and/or Cumulative Percent Passing (CPP-#4) for the minus 4.75 mm (No. 4).

16. Calculate the CPP for the minus 4.75 mm (No. 4).

17. Report Percent Passing (RPP) as indicated in the “Report” section at the end of this FOP.

**Method C Calculations**

\[
\text{Coarse check sum} = \frac{\text{dry mass after washing} - \text{total mass after coarse sieving}}{\text{dry mass after washing}} \times 100
\]

\[
\text{Fine check sum} = \frac{M_3 - \text{total mass after fine sieving}}{M_3} \times 100
\]

Cumulative Percent Retained (CPR) and Cumulative Percent Passing (CPP)

\[
\text{CPR} = \frac{\text{CMR}}{M} \times 100 \quad \text{CPP} = 100 - \text{CPR}
\]

where:

CMR = Cumulative Mass Retained
CPR = Cumulative Percent Retained
M = Total Dry Sample mass before washing
CPP = Cumulative Percent Passing
Cumulative Percent Retained (CPR_{-#4}) and Cumulative Percent Passing (CPP_{-#4})

\[ CPR_{-#4} = \frac{CMR_{-#4}}{M_3} \times 100 \]
\[ CPP_{-#4} = 100 - CPR_{-#4} \]

\[ CPP = \frac{(CPP_{-#4} \times CPP_{-#4})}{100} \text{ or } CPP = \frac{CPP_{-#4} \times (M_3 - CMR_{-#4})}{M_3} \]

where:

- CMR_{-#4} = Cumulative mass retained for the sieve size based on a minus No. 4 split sample
- CPR_{-#4} = Calculated cumulative percent retained based on the minus No. 4 split
- CPP_{-#4} = Calculated percent passing based on the minus No. 4 split
- M_3 = Total mass of the minus No. 4 split before washing
- CPP_{-#4} = Calculated percent passing the No. 4 sieve

**Method C Example**

Sample calculation for percent retained and percent passing each sieve in accordance with Method C when the minus 4.75mm (No. 4) material is reduced and then washed:

Dry Mass of total sample (M): 3304.5 g

Dry Mass of minus 4.75mm (No. 4) reduced portion before wash (M_3): 527.6 g

Dry Mass of minus 4.75mm (No. 4) reduced portion after wash: 495.3 g

**Gradation on Coarse Sieves**

<table>
<thead>
<tr>
<th>Sieve Size mm (in.)</th>
<th>Cumulative Mass Retained g (CMR)</th>
<th>Cumulative Percent Retained (CPR)</th>
<th>Cumulative Percent Passing (CPP)</th>
<th>Reported Percent Passing* (RPP)</th>
</tr>
</thead>
<tbody>
<tr>
<td>16.0 (5/8)</td>
<td>0</td>
<td>0.0</td>
<td>100.0</td>
<td>100</td>
</tr>
<tr>
<td>12.5 (1/2)</td>
<td>125.9</td>
<td>3.8</td>
<td>96.2</td>
<td>96</td>
</tr>
<tr>
<td>9.50 (3/8)</td>
<td>604.1</td>
<td>18.3</td>
<td>81.7</td>
<td>82</td>
</tr>
<tr>
<td>4.75 (No. 4)</td>
<td>1295.6</td>
<td>39.2</td>
<td>60.8</td>
<td>61</td>
</tr>
<tr>
<td>Pan</td>
<td>2008.9</td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

Total Dry Sample (M) = 3304.5 g

Coarse check sum:

\[ \frac{3304.5 \text{ g} - 3304.5 \text{ g}}{3304.5 \text{ g}} \times 100 = 0.0\% \]

This is less than 0.3 percent therefore the results can be used for acceptance purposes.
The pan (2008.9 g) was reduced in accordance with the FOP for AASHTO R 76, so that at least 500 g are available. In this case, the mass determined was $M_3 = 527.6$ g.

### Gradation on Minus No. 4 Sieves

<table>
<thead>
<tr>
<th>Sieve Size mm (in.)</th>
<th>Cumulative Mass Retained g (CMR-#4)</th>
<th>Cumulative Percent Retained #4 (CPR-#4)</th>
<th>Cumulative Percent Passing #4 (CPP-#4)</th>
<th>Cumulative Percent Passing (CPP)</th>
<th>Reported Percent Passing* (RPP)</th>
</tr>
</thead>
<tbody>
<tr>
<td>2.0 (No. 10)</td>
<td>194.3</td>
<td>36.8</td>
<td>63.2</td>
<td>38.4</td>
<td>38</td>
</tr>
<tr>
<td>0.425 (No. 40)</td>
<td>365.6</td>
<td>69.3</td>
<td>30.7</td>
<td>18.7</td>
<td>19</td>
</tr>
<tr>
<td>0.210 (No. 80)</td>
<td>430.8</td>
<td>81.7</td>
<td>18.3</td>
<td>11.1</td>
<td>11</td>
</tr>
<tr>
<td>0.075 (No. 200)</td>
<td>484.4</td>
<td>91.8</td>
<td>8.2</td>
<td>5.0</td>
<td>5.0</td>
</tr>
<tr>
<td>Pan</td>
<td>495.1</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

Dry mass of minus 4.75 mm (No. 4) sample, before washing $(M_3)$: 527.6 g
Dry mass of minus 4.75 mm (No. 4) sample, after washing: 495.3 g
Calculated percent passing the No. 4 sieve $(CPP_{#4}) = 60.8\%$

Fine check sum:

$$\frac{495.3 \text{ g} - 495.1 \text{ g}}{495.3 \text{ g}} \times 100 = 0.04\%$$

This is less than 0.3 percent therefore the results can be used for acceptance purposes.

### Final Gradation on All Sieves

#### Calculation by Cumulative Mass

<table>
<thead>
<tr>
<th>Sieve Size mm (in.)</th>
<th>Cumulative Mass Retained, g (CMR)</th>
<th>Cumulative Percent Retained (CPR)</th>
<th>Cumulative Percent Passing (CPP)</th>
<th>Reported Percent Passing* (RPP)</th>
</tr>
</thead>
<tbody>
<tr>
<td>16.0 (5/8)</td>
<td>0</td>
<td>0.0</td>
<td>100.0</td>
<td>100</td>
</tr>
<tr>
<td>12.5 (1/2)</td>
<td>125.9</td>
<td>3.8</td>
<td>96.2</td>
<td>96</td>
</tr>
<tr>
<td>9.5 (3/8)</td>
<td>604.1</td>
<td>18.3</td>
<td>81.7</td>
<td>82</td>
</tr>
<tr>
<td>4.75 (No. 4)</td>
<td>1295.6</td>
<td>39.2</td>
<td><strong>60.8</strong></td>
<td><strong>61</strong></td>
</tr>
<tr>
<td>2.0 (No. 10)</td>
<td>194.3</td>
<td>36.8</td>
<td>63.2</td>
<td>38</td>
</tr>
<tr>
<td>0.425 (No. 40)</td>
<td>365.6</td>
<td>69.3</td>
<td>30.7</td>
<td>18.7</td>
</tr>
<tr>
<td>0.210 (No. 80)</td>
<td>430.8</td>
<td>81.7</td>
<td>18.3</td>
<td>11.1</td>
</tr>
<tr>
<td>0.075 (No. 200)</td>
<td>484.4</td>
<td>91.8</td>
<td>8.2</td>
<td>5.0</td>
</tr>
<tr>
<td>Pan</td>
<td>495.1</td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

*Report 75 µm (No. 200) sieve to 0.1 percent. Report all others to 1 percent
**Fineness Modulus**

Fineness Modulus (FM) is used in determining the degree of uniformity of the aggregate gradation in PCC mix designs. It is an empirical number relating to the fineness of the aggregate. The higher the FM the coarser the aggregate. Values of 2.40 to 3.00 are common for FA in PCC.

The sum of the cumulative percentages retained on specified sieves in the following table divided by 100 gives the FM.

### Sample Calculation

<table>
<thead>
<tr>
<th>Sieve Size mm (in)</th>
<th>Percent Retained</th>
<th>On Spec’d Sieves* Percent</th>
<th>Passing</th>
<th>On Spec’d Sieves* Percent</th>
</tr>
</thead>
<tbody>
<tr>
<td>75*(3)</td>
<td>100</td>
<td>0</td>
<td>100</td>
<td>0</td>
</tr>
<tr>
<td>37.5*(11/2)</td>
<td>100</td>
<td>0</td>
<td>100</td>
<td>0</td>
</tr>
<tr>
<td>19*(3/4)</td>
<td>15</td>
<td>85</td>
<td>100</td>
<td>0</td>
</tr>
<tr>
<td>9.5*(3/8)</td>
<td>0</td>
<td>100</td>
<td>100</td>
<td>0</td>
</tr>
<tr>
<td>4.75*(No.4)</td>
<td>0</td>
<td>100</td>
<td>100</td>
<td>0</td>
</tr>
<tr>
<td>2.36*(No.8)</td>
<td>0</td>
<td>100</td>
<td>87</td>
<td>13</td>
</tr>
<tr>
<td>1.18*(No.16)</td>
<td>0</td>
<td>100</td>
<td>69</td>
<td>31</td>
</tr>
<tr>
<td>0.60*(No.30)</td>
<td>0</td>
<td>100</td>
<td>44</td>
<td>56</td>
</tr>
<tr>
<td>0.30*(No.50)</td>
<td>0</td>
<td>100</td>
<td>18</td>
<td>82</td>
</tr>
<tr>
<td>0.15*(100)</td>
<td>0</td>
<td>100</td>
<td>4</td>
<td>96</td>
</tr>
</tbody>
</table>

\[ \sum = 785 \]

\[ \text{FM} = 7.85 \]

In decreasing size order, each * sieve is one-half the size of the preceding * sieve.
Report

- Results on forms approved by the agency
- Sample ID
- Individual mass retained on each sieve
- Individual percent retained on each sieve
- Cumulative mass retained on each sieve
- Cumulative percent retained on each sieve
- FM to the nearest 0.01

Report percentages to the nearest 1 percent except for the percent passing the 75 µm (No. 200) sieve, which shall be reported to the nearest 0.1 percent.
PERFORMANCE EXAM CHECKLIST

METHOD A
SIEVE ANALYSIS OF FINE AND COARSE AGGREGATES
FOP FOR AASHTO T 27
MATERIALS FINER THAN 75 µm (No. 200) SIEVE IN MINERAL AGGREGATE
BY WASHING
FOP FOR AASHTO T 11

Participant Name ____________________________  Exam Date ______________

Record the symbols “P” for passing or “F” for failing on each step of the checklist.

<table>
<thead>
<tr>
<th>Procedure Element</th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>1. Minimum sample mass meets requirement of Table 2?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>2. Test sample dried to a constant mass by FOP for AASHTO T 255?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>3. Test sample cooled and mass determined to nearest 0.1 percent or 0.1 g?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>4. Sample placed in container and covered with water? (If specification requires that the amount of material finer than the 75 µm (No. 200) sieve is to be determined.)</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>5. Contents of the container vigorously agitated?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>6. Complete separation of coarse and fine particles achieved?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>7. Wash water poured through nested sieves such as 2 mm (No. 10) and 75 µm (No. 200)?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>8. Operation continued until wash water is clear?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>9. Material retained on sieves returned to washed sample?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>10. Washed aggregate dried to a constant mass by FOP for AASHTO T 255?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>11. Washed aggregate cooled and mass determined to nearest 0.1 percent or 0.1 g?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>12. Sample placed in nest of sieves specified? (Additional sieves may be used to prevent overloading as allowed in FOP.)</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>13. Material sieved in verified mechanical shaker for proper time?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>14. Mass of residue on each sieve and pan determined to 0.1 g?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>15. Total mass of material after sieving agrees with mass before sieving to within 0.3 percent?</td>
<td>_____</td>
<td>_____</td>
</tr>
</tbody>
</table>

OVER
<table>
<thead>
<tr>
<th>Procedure Element</th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>16. Percentages calculated to the nearest 0.1 percent and reported to the nearest whole number, except 75 µm (No.200) which is reported to the nearest 0.1 percent?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>17. Percentage calculations based on original dry sample mass?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>18. Calculations performed properly?</td>
<td>_____</td>
<td>_____</td>
</tr>
</tbody>
</table>

**Comments:**
- First attempt: Pass Fail
- Second attempt: Pass Fail

Examiner Signature ____________________________        WAQTC #:_________________
**PERFORMANCE EXAM CHECKLIST**

**METHOD B**  
**SIEVE ANALYSIS OF FINE AND COARSE AGGREGATES**  
**FOP FOR AASHTO T 27**  
**MATERIALS FINER THAN 75 µm (No. 200) SIEVE IN MINERAL AGGREGATE BY WASHING**  
**FOP FOR AASHTO T 11**

Participant Name ______________________________ Exam Date ______________

Record the symbols “P” for passing or “F” for failing on each step of the checklist.

<table>
<thead>
<tr>
<th>Procedure Element</th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>1. Minimum sample mass meets requirement of Table 2?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>2. Test sample dried to a constant mass by FOP for AASHTO T 255?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>3. Test sample cooled and mass determined to nearest 0.1 percent or 0.1 g?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>4. Sample placed in container and covered with water? (If specification requires that the amount of material finer than the 75 µm (No. 200) sieve is to be determined.)</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>5. Contents of the container vigorously agitated?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>6. Complete separation of coarse and fine particles achieved?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>7. Wash water poured through nested sieves such as 2 mm (No. 10) and 75 µm (No. 200)?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>8. Operation continued until wash water is clear?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>9. Material retained on sieves returned to washed sample?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>10. Washed aggregate dried to a constant mass by FOP for AASHTO T 255?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>11. Washed aggregate cooled and mass determined to nearest 0.1 percent or 0.1 g?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>12. Sample placed in nest of sieves specified? (Additional sieves may be used to prevent overloading as allowed in FOP.)</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>13. Material sieved in verified mechanical shaker for proper time?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>0.1 Mass of residue on each sieve and pan determined to the nearest percent or 0.1 g?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>15 Total mass of material after sieving agrees with mass before sieving to within 0.3 percent?</td>
<td>_____</td>
<td>_____</td>
</tr>
</tbody>
</table>

**OVER**
**Procedure Element**

<table>
<thead>
<tr>
<th>Procedure</th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>16. Material in pan reduced in accordance with FOP for AASHTO R 76 to a minimum sample size of 500 g and weighed to the nearest 0.1 g?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>17. Sample placed in nest of sieves specified? (Additional sieves may be used to prevent overloading as allowed in FOP.)</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>18. Material sieved in verified mechanical shaker for proper time?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>19. Mass of residue on each sieve and pan determined to the nearest percent or 0.1 g?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>20. Total mass of material after sieving agrees with mass before sieving to within 0.3 percent?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>21. Percentages calculated to the nearest 0.1 percent and reported to the nearest whole number, except 75 µm (No.200) which is reported to the nearest 0.1 percent?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>22. Percentage calculations based on original dry sample mass?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>23. Calculations performed properly?</td>
<td>_____</td>
<td>_____</td>
</tr>
</tbody>
</table>

**Comments:**

First attempt: Pass Fail
Second attempt: Pass Fail

Examiner Signature ____________________________        WAQTC #:_______________
PLASTIC FINES IN GRADED AGGREGATES AND SOILS BY THE USE OF THE SAND EQUIVALENT TEST
FOP FOR AASHTO T 176 (16)

Scope

This procedure covers the determination of plastic fines in accordance with AASHTO T 176-08. It serves as a rapid test to show the relative proportion of fine dust or clay-like materials in fine aggregates (FA) and soils.

Apparatus

See AASHTO T 176 for a detailed listing of sand equivalent apparatus. Note that the siphon tube and blow tube may be glass or stainless steel as well as copper.

- Graduated plastic cylinder.
- Rubber stopper.
- Irrigator tube.
- Weighted foot assembly: Having a mass of 1000 ±5g. There are two models of the weighted foot assembly. The older model has a guide cap that fits over the upper end of the graduated cylinder and centers the rod in the cylinder. It is read using a slot in the centering screws. The newer model has a sand-reading indicator 254 mm (10 in.) above this point and is preferred for testing clay-like materials.
- Bottle: clean, glass or plastic, of sufficient size to hold working solution
- Siphon assembly: The siphon assembly will be fitted to a 4 L (1 gal.) bottle of working calcium chloride solution placed on a shelf 915 ±25 mm (36 ±1 in.) above the work surface.
- Measuring can: With a capacity of 85 ±5 mL (3 oz.).
- Funnel: With a wide-mouth for transferring sample into the graduated cylinder.
- Quartering cloth: 600 mm (2 ft.) square nonabsorbent cloth, such as plastic or oilcloth.
- Mechanical splitter: See the FOP for AASHTO R 76.
- Strike-off bar: A straightedge or spatula.
- Clock or watch reading in minutes and seconds.
• Manually-operated sand equivalent shaker: Capable of producing an oscillating motion at a rate of 100 complete cycles in 45 ±5 seconds, with a hand assisted half stroke length of 127 ±5 mm (5 ±0.2 in.). It may be held stable by hand during the shaking operation. It is recommended that this shaker be fastened securely to a firm and level mount, by bolts or clamps, if a large number of determinations are to be made.

• Mechanical shaker: See AASHTO T 176 for equipment and procedure.

• Oven: Capable of maintaining a temperature of 110 ±5°C (230 ±9°F).

• Thermometer: Calibrated liquid-in-glass or electronic digital type designed for total immersion and accurate to 0.1°C (0.2°F).

Materials

• Stock calcium chloride solution: Obtain commercially prepared calcium chloride stock solution meeting AASHTO requirements.

• Working calcium chloride solution: Dilute one 3 oz. measuring can (85 ±5 mL) of stock calcium chloride solution with 3.8 L (1 gal) distilled or demineralized water. Thoroughly mix the solution by filling the bottle with 2 L (1/2 gal) of water. Add the stock solution and agitate vigorously for 1 to 2 minutes. Add the remainder of the water, approximately 2 L (1/2 gal.). Repeat the agitation process. The shelf life of the working solution is approximately 30 days. Discard working solutions more than 30 days old.

  Note 1: The graduated cylinder filled to 4.4 in. contains 88 mL and may be used to measure the stock solution.

  Note 2: Tap water may be used if it is proven to be non-detrimental to the test and if it is allowed by the agency.

Control

The temperature of the working solution should be maintained at 22 ±3°C (72 ±5°F) during the performance of the test. If field conditions preclude the maintenance of the temperature range, reference samples should be submitted to the Central/Regional Laboratory, as required by the agency, where proper temperature control is possible. Samples that meet the minimum sand equivalent requirement at a working solution temperature outside of the temperature range need not be subject to reference testing.

Sample Preparation

1. Obtain the sample in accordance with the FOP for AASHTO T 2 and reduce in accordance with the FOP for AASHTO R 76.

2. Prepare sand equivalent test samples from the material passing the 4.75 mm (No. 4) sieve. If the material is in clods, break it up and re-screen it over a 4.75 mm (No. 4)
sieve. All fines shall be cleaned from particles retained on the 4.75 mm (No. 4) sieve and included with the material passing that sieve.

3. Split or quarter 1000 to 1500 g of material from the portion passing the 4.75 mm (No. 4) sieve. Use extreme care to obtain a truly representative portion of the original sample.

Note 3: Experiments show that, as the amount of material being reduced by splitting or quartering is decreased, the accuracy of providing representative portions is reduced. It is imperative that the sample be split or quartered carefully. When it appears necessary, dampen the material before splitting or quartering to avoid segregation or loss of fines.

Note 4: All tests, including reference tests, will be performed utilizing Alternative Method No. 2 as described in AASHTO T 176, unless otherwise specified.

4. The sample must have the proper moisture content to achieve reliable results. This condition is determined by tightly squeezing a small portion of the thoroughly mixed sample in the palm of the hand. If the cast that is formed permits careful handling without breaking, the correct moisture content has been obtained.

Note 5: Clean sands having little 75 µm (No. 200), such as sand for Portland Cement Concrete (PCC), may not form a cast.

If the material is too dry, the cast will crumble and it will be necessary to add water and remix and retest until the material forms a cast. When the moisture content is altered to provide the required cast, the altered sample should be placed in a pan, covered with a lid or with a damp cloth that does not touch the material, and allowed to stand for a minimum of 15 minutes. Samples that have been sieved without being air-dried and still retain enough natural moisture are exempted from this requirement.

If the material shows any free water, it is too wet to test and must be drained and air dried. Mix frequently to ensure uniformity. This drying process should continue until squeezing provides the required cast.

5. Place the sample on the quartering cloth and mix by alternately lifting each corner of the cloth and pulling it over the sample toward the diagonally opposite corner, being careful to keep the top of the cloth parallel to the bottom, thus causing the material to be rolled. When the material appears homogeneous, finish the mixing with the sample in a pile near the center of the cloth.

6. Fill the measuring can by pushing it through the base of the pile while exerting pressure with the hand against the pile on the side opposite the measuring can. As the can is moved through the pile, hold enough pressure with the hand to cause the material to fill the tin to overflowing. Press firmly with the palm of the hand, compacting the material and placing the maximum amount in the can. Strike off the can level full with the straightedge or spatula.

7. When required, repeat steps 5 and 6 to obtain additional samples.
Procedure

1. Start the siphon by forcing air into the top of the solution bottle through the tube while the pinch clamp is open.

2. Siphon 101.6 ±2.5 mm (4 ±0.1 in.) of working calcium chloride solution into the plastic cylinder. Pour the prepared test sample from the measuring can into the plastic cylinder, using the funnel to avoid spilling. Tap the bottom of the cylinder sharply on the heel of the hand several times to release air bubbles and to promote thorough wetting of the sample.

3. Allow the wetted sample to stand undisturbed for 10 ±1 minutes. At the end of the 10-minute period, stopper the cylinder and loosen the material from the bottom by simultaneously partially inverting and shaking the cylinder.

4. After loosening the material from the bottom of the cylinder, shake the cylinder and contents by any one of the following methods:

   a. Mechanical Method – Place the stoppered cylinder in the mechanical shaker, set the timer, and allow the machine to shake the cylinder and contents for 45 ±1 seconds. **Caution:** Agencies may require additional operator qualifications for the next two methods.

   b. Manually-operated Shaker Method – Secure the stoppered cylinder in the three spring clamps on the carriage of the manually-operated sand equivalent shaker and set the stroke counter to zero. Stand directly in front of the shaker and force the pointer to the stroke limit marker painted on the backboard by applying an abrupt horizontal thrust to the upper portion of the right hand spring strap.

      Remove the hand from the strap and allow the spring action of the straps to move the carriage and cylinder in the opposite direction without assistance or hindrance. Apply enough force to the right-hand spring steel strap during the thrust portion of each stroke to move the pointer to the stroke limit marker by pushing against the strap with the ends of the fingers to maintain a smooth oscillating motion. The center of the stroke limit marker is positioned to provide the proper stroke length and its width provides the maximum allowable limits of variation.

      Proper shaking action is accomplished when the tip of the pointer reverses direction within the marker limits. Proper shaking action can best be maintained by using only the forearm and wrist action to propel the shaker. Continue shaking for 100 strokes.

   c. Hand Method – Hold the cylinder in a horizontal position and shake it vigorously in a horizontal linear motion from end to end. Shake the cylinder 90 cycles in approximately 30 seconds using a throw of 229 mm ±25 mm (9 ±1 in.). A cycle is defined as a complete back and forth motion. To properly shake the cylinder at this speed, it will be necessary for the operator to shake with the forearms only, relaxing the body and shoulders.
5. Set the cylinder upright on the work table and remove the stopper.

6. Insert the irrigator tube in the cylinder and rinse material from the cylinder walls as the irrigator is lowered. Force the irrigator through the material to the bottom of the cylinder by applying a gentle stabbing and twisting action while the working solution flows from the irrigator tip. Work the irrigator tube to the bottom of the cylinder as quickly as possible, since it becomes more difficult to do this as the washing proceeds. This flushes the fine material into suspension above the coarser sand particles.

Continue to apply a stabbing and twisting action while flushing the fines upward until the cylinder is filled to the 381 mm (15 in.) mark. Then raise the irrigator slowly without shutting off the flow so that the liquid level is maintained at about 381 mm (15 in.) while the irrigator is being withdrawn. Regulate the flow just before the irrigator is entirely withdrawn and adjust the final level to 381 mm (15 in.).

**Note 6:** Occasionally the holes in the tip of the irrigator tube may become clogged by a particle of sand. If the obstruction cannot be freed by any other method, use a pin or other sharp object to force it out, using extreme care not to enlarge the size of the opening. Also, keep the tip sharp as an aid to penetrating the sample.

7. Allow the cylinder and contents to stand undisturbed for 20 minutes ±15 seconds. Start timing immediately after withdrawing the irrigator tube.

**Note 7:** Any vibration or movement of the cylinder during this time will interfere with the normal settling rate of the suspended clay and will cause an erroneous result.

8. Clay and sand readings:

a. At the end of the 20-minute sedimentation period, read and record the level of the top of the clay suspension. This is referred to as the clay reading.

**Note 8:** If no clear line of demarcation has formed at the end of the 20-minute sedimentation period, allow the sample to stand undisturbed until a clay reading can be obtained, then immediately read and record the level of the top of the clay suspension and the total sedimentation time. If the total sedimentation time exceeds 30 minutes, rerun the test using three individual samples of the same material. Read and record the clay column height of the sample requiring the shortest sedimentation period only. Once a sedimentation time has been established, subsequent tests will be run using that time. The time will be recorded along with the test results on all reports.

b. After the clay reading has been taken, place the weighted foot assembly over the cylinder and gently lower the assembly until it comes to rest on the sand. Do not allow the indicator to hit the mouth of the cylinder as the assembly is being lowered. Subtract 254 mm (10 in.) from the level indicated by the extreme top edge of the indicator and record this value as the sand reading.

c. If clay or sand readings fall between 2.5 mm (0.1 in.) graduations, record the level of the higher graduation as the reading. For example, a clay reading that appears to be 7.95 would be recorded as 8.0; a sand reading that appears to be 3.22 would be recorded as 3.3.
d. If two Sand Equivalent (SE) samples are run on the same material and the second varies by more than ±4, based on the first cylinder result, additional tests shall be run.

e. If three or more Sand Equivalent (SE) samples are run on the same material, average the results. If an individual result varies by more than ±4, based on the average result, additional tests shall be run.

Calculations

1. Calculate the SE to the nearest 0.1 using the following formula:

\[ SE = \frac{\text{Sand Reading}}{\text{Clay Reading}} \times 100 \]

For example: Sand Reading = 3.3 and Clay Reading = 8.0

\[ SE = \frac{3.3}{8.0} \times 100 = 41.25 \text{ or } 41.3 \]

*Note 9:* This example reflects the use of equipment made with English units. At this time, equipment made with metric units is not available.

2. Report the SE as the next higher whole number. In the example above, the 41.3 would be reported as 42. An SE of 41.0 would be reported as 41.

3. In determining the average of the two or more samples, raise each calculated SE value to the next higher whole number before averaging. For example, calculated values of 41.3 and 42.8 would be reported as 42 and 43, respectively.

Then average the two values:

\[ \frac{42 + 43}{2} = 42.5 \]

If the average value is not a whole number, raise it to the next higher whole number – in this case: 43.

Report

- Results on forms approved by the agency
- Sample ID
- Results to the whole number
- Sedimentation time if over 20 minutes
# PERFORMANCE EXAM CHECKLIST

**PLASTIC FINES IN GRADED AGGREGATES AND SOILS BY THE USE OF THE SAND EQUIVALENT TEST**

**FOP FOR AASHTO T 176**

Participant Name ______________________________ Exam Date ______________

Record the symbols “P” for passing or “F” for failing on each step of the checklist.

<table>
<thead>
<tr>
<th>Procedure Element</th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>Sample Preparation</td>
<td></td>
<td></td>
</tr>
<tr>
<td>1. Sample passed through 4.75 mm (No. 4) sieve?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>2. Material in clods broken up and re-screened?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>3. Split or quarter 1,000 to 1,500g of material passing the 4.75 mm (No. 4) sieve? NOTE: If necessary, the material may be dampened before splitting to avoid segregation or loss of fines.</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>4. No fines lost?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>5. Working solution dated?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>6. Temperature of working solution 22 ±3°C (72 ±5°F)?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>7. Working calcium chloride solution 915 ±25 mm (36 ±1in) above the work surface?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>8. 101.6 ±2.5 mm (4 ±0.1in) working calcium chloride solution siphoned into cylinder?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>9. Material checked for moisture condition by tightly squeezing small portion in palm of hand and forming a cast?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>10. Sample at proper water content?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>a. If too dry (cast crumbles easily) water added, re-mixed, covered, and allowed to stand for at least 15 minutes?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>b. If too wet (shows free water) sample drained, air dried and mixed frequently?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>11. Sample placed on splitting cloth and mixed by alternately lifting each corner of the cloth and pulling it over the sample toward diagonally opposite corner, causing material to be rolled?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>12. Is material thoroughly mixed?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>13. When material appears to be homogeneous, mixing finished with sample in a pile near center of cloth?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>14. Fill the 85 mL (3 oz) tin by pushing through base of pile with other hand on opposite side of pile?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>15. Material fills tin to overflowing?</td>
<td>_____</td>
<td>_____</td>
</tr>
</tbody>
</table>

OVER
<table>
<thead>
<tr>
<th>Procedure Element</th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>16. Material compacted into tin with palm of hand?</td>
<td>_______</td>
<td>_______</td>
</tr>
<tr>
<td>17. Tin struck off level full with spatula or straightedge?</td>
<td>_______</td>
<td>_______</td>
</tr>
<tr>
<td>18. Prepared sample funneled into cylinder with no loss of fines?</td>
<td>_______</td>
<td>_______</td>
</tr>
<tr>
<td>19. Bottom of cylinder tapped sharply on heel of hand several times to release air bubbles?</td>
<td>_______</td>
<td>_______</td>
</tr>
<tr>
<td>20. Wetted sample allowed to stand undisturbed for 10 min. ±1 min.?</td>
<td>_______</td>
<td>_______</td>
</tr>
<tr>
<td>21. Cylinder stoppered and material loosened from bottom by shaking?</td>
<td>_______</td>
<td>_______</td>
</tr>
<tr>
<td>22. Stoppered cylinder placed properly in mechanical shaker and cylinder shaken 45 ±1 seconds?</td>
<td>_______</td>
<td>_______</td>
</tr>
<tr>
<td>23. Following shaking, cylinder set vertical on work surface and stopper removed?</td>
<td>_______</td>
<td>_______</td>
</tr>
<tr>
<td>24. Irrigator tube inserted in cylinder and material rinsed from cylinder walls as irrigator is lowered?</td>
<td>_______</td>
<td>_______</td>
</tr>
<tr>
<td>25. Irrigator tube forced through material to bottom of cylinder by gentle stabbing and twisting action?</td>
<td>_______</td>
<td>_______</td>
</tr>
<tr>
<td>26. Stabbing and twisting motion applied until cylinder filled to 381 mm (15 in.) mark?</td>
<td>_______</td>
<td>_______</td>
</tr>
<tr>
<td>27. Liquid raised and maintained at 381 mm (15 in.) mark while irrigator is being withdrawn?</td>
<td>_______</td>
<td>_______</td>
</tr>
<tr>
<td>28. Liquid at the 381 mm (15 in.) mark?</td>
<td>_______</td>
<td>_______</td>
</tr>
<tr>
<td>29. Contents let stand 20 minutes ±15 seconds?</td>
<td>_______</td>
<td>_______</td>
</tr>
<tr>
<td>30. Timing started immediately after withdrawal of irrigator?</td>
<td>_______</td>
<td>_______</td>
</tr>
<tr>
<td>31. No vibration or disturbance of the sample?</td>
<td>_______</td>
<td>_______</td>
</tr>
<tr>
<td>32. Readings taken at 20 minutes or up to 30 minutes, when a definite line appears?</td>
<td>_______</td>
<td>_______</td>
</tr>
<tr>
<td>33. Clay level correctly read, rounded, and recorded?</td>
<td>_______</td>
<td>_______</td>
</tr>
<tr>
<td>34. Weighted foot assembly lowered into cylinder without hitting mouth of cylinder?</td>
<td>_______</td>
<td>_______</td>
</tr>
<tr>
<td>35. Sand level correctly read, rounded, and recorded?</td>
<td>_______</td>
<td>_______</td>
</tr>
<tr>
<td>36. Calculations performed correctly?</td>
<td>_______</td>
<td>_______</td>
</tr>
</tbody>
</table>

**Comments:**

First attempt: Pass Fail  Second attempt: Pass Fail

Examiner Signature ____________________________          WAQTC #:_______________
FOP for AASHTO T 176

Plastic Fines in Graded Aggregates and Soils by the Use of the Sand Equivalent Test

Materials.

Add the following:

- Labeling of SE Solution: SE solution containers will be labeled with the date the working solution was mixed.

Sample Preparation.

Add the following to Step 1:

The samples must be maintained at field moist condition until testing. Do not allow the sample to dry out. If testing will not be performed immediately, the sample must be kept in a sealed container.

Procedure.

Add the following to Step 4a:

Only the Mechanical Method will be used.

Delete Step 4b and 4c.
TOTAL EVAPORABLE MOISTURE CONTENT OF AGGREGATE BY DRYING FOP FOR AASHTO T 255 (14)

Scope

This procedure covers the determination of moisture content of aggregate in accordance with AASHTO T 255-00. It may also be used for other construction materials.

Overview

Moisture content is determined by comparing the wet mass of a sample and the mass of the sample after drying to constant mass. The term constant mass is used to define when a sample is dry.

Constant mass – the state at which a mass does not change more than a given percent, after additional drying for a defined time interval, at a required temperature.

Apparatus

- Balance or scale: Capacity sufficient for the principle sample mass, accurate to 0.1 percent of sample mass or readable to 0.1 g, meeting the requirements of AASHTO M 231.
- Containers: clean, dry and capable of being sealed
- Suitable drying containers
- Microwave safe container with ventilated lids
- Heat source, controlled
  - Forced draft oven
  - Ventilated oven
  - Convection oven
- Heat source, uncontrolled
  - Infrared heater, hot plate, fry pan, or any other device/method that will dry the sample without altering the material being dried
  - Microwave oven (900 watts minimum)
• Hot pads or gloves
• Utensils such as spoons

**Sample Preparation**

In accordance with the FOP for AASHTO T 2 obtain a representative sample in its existing condition. The representative sample size is based on Table 1 or other information that may be specified by the agency.

**TABLE 1**

Sample Sizes for Moisture Content of Aggregate

<table>
<thead>
<tr>
<th>Nominal Maximum Size* (mm in.)</th>
<th>Minimum Sample Mass g (lb)</th>
</tr>
</thead>
<tbody>
<tr>
<td>4.75 (No. 4)</td>
<td>500 (1.1)</td>
</tr>
<tr>
<td>9.5 (3/8)</td>
<td>1500 (3.3)</td>
</tr>
<tr>
<td>12.5 (1/2)</td>
<td>2000 (4)</td>
</tr>
<tr>
<td>19.0 (3/4)</td>
<td>3000 (7)</td>
</tr>
<tr>
<td>25.0 (1)</td>
<td>4000 (9)</td>
</tr>
<tr>
<td>37.5 (1 1/2)</td>
<td>6000 (13)</td>
</tr>
<tr>
<td>50 (2)</td>
<td>8000 (18)</td>
</tr>
<tr>
<td>63 (2 1/2)</td>
<td>10,000 (22)</td>
</tr>
<tr>
<td>75 (3)</td>
<td>13,000 (29)</td>
</tr>
<tr>
<td>90 (3 1/2)</td>
<td>16,000 (35)</td>
</tr>
<tr>
<td>100 (4)</td>
<td>25,000 (55)</td>
</tr>
<tr>
<td>150 (6)</td>
<td>50,000 (110)</td>
</tr>
</tbody>
</table>

* One sieve larger than the first sieve to retain more than 10 percent of the material using an agency specified set of sieves based on cumulative percent retained. Where large gaps in specification sieves exist, intermediate sieve(s) may be inserted to determine nominal maximum size.

Immediately seal or cover samples to prevent any change in moisture content or follow the steps in “Procedure.”

**Procedure**

Determine all masses to the nearest 0.1 percent of the sample mass or to the nearest 0.1 g.

When determining the mass of hot samples or containers or both, place and tare a buffer between the sample container and the balance. This will eliminate damage to or interference with the operation of the balance or scale.

1. Determine and record the mass of the container (and lid for microwave drying).
2. Place the wet sample in the container.
   a. For oven(s), hot plates, infrared heaters, etc.: Spread the sample in the container.
   b. For microwave oven: Heap sample in the container; cover with ventilated lid.

3. Determine and record the total mass of the container and wet sample.

4. Determine and record the wet mass of the sample by subtracting the container mass determined in Step 1 from the mass of the container and sample determined in Step 3.

5. Place the sample in one of the following drying apparatus:
   b. Uncontrolled heat source (Hot plate, infrared heater, etc.): Stir frequently to avoid localized overheating.

6. Dry until sample appears moisture free.

7. Determine mass of sample and container.

8. Determine and record the mass of the sample by subtracting the container mass determined in Step 1 from the mass of the container and sample determined in Step 7.

9. Return sample and container to the heat source for additional drying.
   a. Controlled (oven): 30 minutes
   b. Uncontrolled (Hot plate, infrared heater, etc.): 10 minutes
   c. Uncontrolled (Microwave oven): 2 minutes

**Caution:** Some minerals in the sample may cause the aggregate to overheat, altering the aggregate gradation.

10. Determine mass of sample and container.

11. Determine and record the mass of the sample by subtracting the container mass determined in Step 1 from the mass of the container and sample determined in Step 10.

12. Determine percent change by subtracting the new mass determination \( M_n \) from the previous mass determination \( M_p \) divide by the previous mass determination \( M_p \) multiply by 100.
13. Continue drying, performing steps 9 through 12, until there is less than a 0.10 percent change after additional drying time.

14. Constant mass has been achieved, sample is defined as dry.

15. Allow the sample to cool. Determine and record the total mass of the container and dry sample.

16. Determine and record the dry mass of the sample by subtracting the mass of the container determined in Step 1 from the mass of the container and sample determined in Step 15.

17. Determine and record percent moisture by subtracting the final dry mass determination (MD) from the initial wet mass determination (MW) divide by the final dry mass determination (MD) multiply by 100.

### Table 2

**Methods of Drying**

<table>
<thead>
<tr>
<th>Heat Source</th>
<th>Specific Instructions</th>
<th>Drying intervals to achieve constant mass (minutes)</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Controlled:</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Forced Draft Oven (preferred), Ventilated Oven, or Convection Oven</td>
<td>110 ±5°C (230 ±9°F)</td>
<td>30</td>
</tr>
<tr>
<td><strong>Uncontrolled:</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Hot plate, Infrared heater, etc.</td>
<td>Stir frequently</td>
<td>10</td>
</tr>
<tr>
<td>Microwave</td>
<td>Heap sample and cover with ventilated lid</td>
<td>2</td>
</tr>
</tbody>
</table>

### Calculation

**Constant Mass:**

Calculate constant mass using the following formula:

\[
\frac{M_p - M_n}{M_p} \times 100 = \% \text{ Change}
\]

Where:

- \( M_p = \) previous mass measurement
- \( M_n = \) new mass measurement
Example:

Mass of container: 1232.1 g

Mass of container after first drying cycle: 2637.2 g

Mass, $M_p$, of possibly dry sample: 2637.2 g - 1232.1 g = 1405.1 g

Mass of container and dry sample after second drying cycle: 2634.1 g

Mass, $M_n$, of dry sample: 2634.1 g - 1232.1 g = 1402.0 g

$$\frac{1405.1 \text{ g} - 1402.0 \text{ g}}{1405.1 \text{ g}} \times 100 = 0.22\%$$

0.22 percent is not less than 0.10 percent, so continue drying

Mass of container and dry sample after third drying cycle: 2633.0 g

Mass, $M_n$, of dry sample: 2633.0 g - 1232.1 g = 1400.9 g

$$\frac{1402.0 \text{ g} - 1400.9 \text{ g}}{1402.0 \text{ g}} \times 100 = 0.08\%$$

0.08 percent is less than 0.10 percent, so constant mass has been reached

**Moisture Content:**

Calculate the moisture content, $w$, as a percent, using the following formula:

$$\frac{M_W - M_D}{M_D} \times 100 = \% \text{ Moisture Content}$$

where:

$M_W = $ wet mass

$M_D = $ dry mass
Example:

Mass of container: 1232.1 g

Mass of container and wet sample: 2764.7 g

Mass, M_W, of wet sample: 2764.7 g - 1232.1 g = 1532.6 g

Mass of container and dry sample (COOLED): 2633.0 g

Mass, M_D, of dry sample: 2633.0 g - 1232.1 g = 1400.9 g

\[ w = \frac{1532.6g - 1400.9g}{1400.9g} \times 100 = \frac{131.7g}{1400.9g} = 9.40\% \text{ rounded to } 9.4\% \]

**Report**

- Results on forms approved by the agency
- Sample ID
- M_W, wet mass
- M_D, dry mass
- w, moisture content to nearest 0.1 percent
PERFORMANCE EXAM CHECKLIST

TOTAL MOISTURE CONTENT OF AGGREGATE BY DRYING FOP FOR AASHTO T 255

Record the symbols “P” for passing or “F” for failing on each step of the checklist.

<table>
<thead>
<tr>
<th>Procedure Element</th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>1. Representative sample of appropriate mass obtained?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>2. Mass of container determined to 0.1 percent or 0.1 g?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>3. Sample placed in container and wet mass determined to 0.1 percent or 0.1 g?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>4. Test sample mass conforms to the required mass?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>5. Wet mass of sample determined to 0.1 percent or 0.1 g?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>6. Loss of moisture avoided prior to mass determination?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>7. Sample dried by a suitable heat source?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>8. If aggregate heated by means other than a controlled oven, is sample stirred to avoid localized overheating?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>9. Is aggregate heated for the additional, specified time (forced draft, ventilated, convection – 30 minutes; microwave – 2 minutes; other – 10 minutes) and then mass determined and compared to previous mass – showing less than 0.10 percent loss?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>10. Sample cooled prior to dry mass determination to 0.1 percent or 0.1 g?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>11. Calculations performed properly and results reported to the nearest 0.1 percent?</td>
<td>_____</td>
<td>_____</td>
</tr>
</tbody>
</table>

Comments: First attempt: Pass_____ Fail_____   Second attempt: Pass_____ Fail_____
<table>
<thead>
<tr>
<th>TRIAL: #1</th>
<th>TRIAL #2</th>
</tr>
</thead>
<tbody>
<tr>
<td>Mw + pan</td>
<td></td>
</tr>
<tr>
<td>Pan</td>
<td></td>
</tr>
<tr>
<td>Mw</td>
<td></td>
</tr>
<tr>
<td>Mp1 + pan</td>
<td></td>
</tr>
<tr>
<td>Mp1</td>
<td></td>
</tr>
<tr>
<td>Mp2 + pan</td>
<td></td>
</tr>
<tr>
<td>Mp2</td>
<td></td>
</tr>
<tr>
<td>Mp3 + pan</td>
<td></td>
</tr>
<tr>
<td>Mp3</td>
<td></td>
</tr>
<tr>
<td>Md + pan</td>
<td></td>
</tr>
<tr>
<td>Md</td>
<td></td>
</tr>
</tbody>
</table>

% Moisture content Check

Examiner Signature ____________________________   WAQTC #: ______________
DETERMINING THE PERCENTAGE OF FRACTURE IN COARSE AGGREGATE FOP FOR AASHTO T 335 (16)

Scope

This procedure covers the determination of the percentage, by mass, of a coarse aggregate (CA) sample that consists of fractured particles meeting specified requirements in accordance with AASHTO T 335-09.

In this FOP, a sample of aggregate is screened on the sieve separating CA and fine aggregate (FA). This sieve will be identified in the agency’s specifications, but might be the 4.75 mm (No. 4) sieve. CA particles are visually evaluated to determine conformance to the specified fracture. The percentage of conforming particles, by mass, is calculated for comparison to the specifications.

Apparatus

- Balance or scale: Capacity sufficient for the principle sample mass, accurate to 0.1 percent of the sample mass or readable to 0.1 g, and meeting the requirements of AASHTO M 231.

- Sieves: Meeting requirements of AASHTO M 92.

- Splitter: Meeting the requirements of FOP for AASHTO R 76.

Terminology

1. Fractured Face: An angular, rough, or broken surface of an aggregate particle created by crushing or by other means. A face is considered a “fractured face” whenever one-half or more of the projected area, when viewed normal to that face, is fractured with sharp and well defined edges. This excludes small nicks.

2. Fractured particle: A particle of aggregate having at least the minimum number of fractured faces specified. (This is usually one or two.)

Sampling and Sample Preparation

1. Sample and reduce the aggregate in accordance with the FOPs for AASHTO T 2 and R 76.

2. When the specifications list only a total fracture percentage, the sample shall be prepared in accordance with Method 1. When the specifications require that the fracture be counted and reported on each sieve, the sample shall be prepared in accordance with Method 2.
3. Method 1 - Combined Fracture Determination

a. Dry the sample sufficiently to obtain a clean separation of FA and CA material in the sieving operation.

b. Sieve the sample in accordance with the FOP for AASHTO T 27/ T 11 over the 4.75 mm (No. 4) sieve, or the appropriate sieve listed in the agency’s specifications for this material.

*Note 1:* Where necessary, wash the sample over the sieve designated for the determination of fractured particles to remove any remaining fine material, and dry to a constant mass in accordance with the FOP for AASHTO T 255.

c. Reduce the sample using Method A – Mechanical Splitter, in accordance with the FOP for AASHTO R 76, to the appropriate test size. This test size should be slightly larger than shown in Table 1, to account for loss of fines through washing if necessary.

**TABLE 1**

<table>
<thead>
<tr>
<th>Sample Size</th>
<th>Method 1 (Combined Sieve Fracture)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Nominal Maximum Size*</td>
<td>Minimum Cumulative Sample Mass Retained on 4.75 mm (No. 4) Sieve g (lb)</td>
</tr>
<tr>
<td>mm (in.)</td>
<td></td>
</tr>
<tr>
<td>37.5 (1 1/2)</td>
<td>2500 (6)</td>
</tr>
<tr>
<td>25.0 (1)</td>
<td>1500 (3.5)</td>
</tr>
<tr>
<td>19.0 (3/4)</td>
<td>1000 (2.5)</td>
</tr>
<tr>
<td>12.5 (1/2)</td>
<td>700 (1.5)</td>
</tr>
<tr>
<td>9.5 (3/8)</td>
<td>400 (0.9)</td>
</tr>
<tr>
<td>4.75 (No. 4)</td>
<td>200 (0.4)</td>
</tr>
</tbody>
</table>

* One sieve larger than the first sieve to retain more than 10 percent of the material using an agency specified set of sieves based on cumulative percent retained. Where large gaps in specification sieves exist, intermediate sieve(s) may be inserted to determine nominal maximum size.

4. Method 2 – Individual Sieve Fracture Determination

a. Dry the sample sufficiently to obtain a clean separation of FA and CA material in the sieving operation. A washed sample from the gradation determination (the FOP for T 27/T 11) may be used.

b. If not, sieve the sample in accordance with the FOP for AASHTO T 27 over the sieves listed in the specifications for this material.

*Note 2:* If overload (buffer) sieves are used the material from that sieve must be added to the next specification sieve.
c. The size of test sample for each sieve shall meet the minimum size shown in Table 2. Utilize the total retained sieve mass or select a representative portion from each sieve mass by splitting or quartering in accordance with the FOP for AASHTO R 76.

**Note 3:** Where necessary, wash the sample over the sieves designated for the determination of fractured particles to remove any remaining fine material, and dry to a constant mass in accordance with the FOP for AASHTO T 255.

<table>
<thead>
<tr>
<th>TABLE 2</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Sample Size</strong></td>
</tr>
<tr>
<td><strong>Method 2 (Individual Sieve Fracture)</strong></td>
</tr>
<tr>
<td><strong>Sieve Size</strong></td>
</tr>
<tr>
<td>mm (in.)</td>
</tr>
<tr>
<td>----------------</td>
</tr>
<tr>
<td>31.5 (1 1/4)</td>
</tr>
<tr>
<td>25.0 (1)</td>
</tr>
<tr>
<td>19.0 (3/4)</td>
</tr>
<tr>
<td>16.0 (5/8)</td>
</tr>
<tr>
<td>12.5 (1/2)</td>
</tr>
<tr>
<td>9.5 (3/8)</td>
</tr>
<tr>
<td>6.3 (1/4)</td>
</tr>
<tr>
<td>4.75 (No. 4)</td>
</tr>
<tr>
<td>2.36 (No. 8)</td>
</tr>
<tr>
<td>2.00 (No. 10)</td>
</tr>
</tbody>
</table>

**Note 4:** If fracture is determined on a sample obtained for gradation, use the mass retained on the individual sieves, even if it is less than the minimum listed in Table 2. If less than 5 percent of the total mass is retained on a single specification sieve, include that material on the next smaller specification sieve. If a smaller specification sieve does not exist, this material shall not be included in the fracture determination.

**Procedure**

1. After cooling, spread the dried sample on a clean, flat surface large enough to permit careful inspection of each particle. To verify that a particle meets the fracture criteria, hold the aggregate particle so that the face is viewed directly.

2. To aid in making the fracture determination, separate the sample into three categories:
   - fractured particles meeting the criteria
   - particles not meeting the criteria
   - questionable or borderline particles

3. Determine the dry mass of particles in each category to the nearest 0.1 g.

4. Resort the questionable particles when more than 15 percent is present. Continue sorting until there is less than 15 percent in the questionable category.
Calculation

Calculate the mass percentage of questionable fractured particles to the nearest 1 percent using the following formula:

\[ \%Q = \frac{Q}{F + Q + N} \times 100 \]

where:
- \( \%Q \) = Percent of questionable fractured particles
- \( F \) = Mass of fractured particles
- \( Q \) = Mass of questionable or borderline particles
- \( N \) = Mass of unfractured particles

Example:

\( F = 632.6 \text{ g}, \quad Q = 97.6 \text{ g}, \quad N = 352.6 \text{ g} \)

\[ \%Q = \frac{97.6 \text{ g}}{632.6 \text{ g} + 97.6 \text{ g} + 352.6 \text{ g}} \times 100 = 9.0\% \]

\( \%Q = 9\% \)

Calculate the mass percentage of fractured faces to the nearest 1 percent using the following formula:

\[ P = \frac{\frac{Q}{2} + F}{F + Q + N} \times 100 \]

where:
- \( P \) = Percent of fracture
- \( F \) = Mass of fractured particles
- \( Q \) = Mass of questionable particles
- \( N \) = Mass of unfractured particles

Example:

\( F = 632.6 \text{ g}, \quad Q = 97.6 \text{ g}, \quad N = 352.6 \text{ g} \)

\[ P = \frac{\frac{97.6 \text{ g}}{2} + 632.6 \text{ g}}{632.6 \text{ g} + 97.6 \text{ g} + 352.6 \text{ g}} \times 100 \quad P = 63\% \]

Report

- Results on forms approved by the agency
- Sample ID
- Fractured particles to the nearest 1 percent.
PERFORMANCE EXAM CHECKLIST

DETERMINING THE PERCENTAGE OF FRACTURE IN COARSE AGGREGATE FOP FOR AASHTO T 335

Participant Name ______________________________ Exam Date ______________

Record the symbols “P” for passing or “F” for failing on each step of the checklist.

<table>
<thead>
<tr>
<th>Procedure Element</th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>1. Sample properly sieved through specified sieve(s)?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>2. Sample reduced to correct size?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>3. Sample dried and cooled, if necessary?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>4. Particles separated into fractured, unfractured, and questionable categories?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>5. Dry mass of each category determined to nearest 0.1 g?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>6. Questionable category resorted if more than 15 percent of total mass falls in that category?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>7. Fracture calculation performed correctly?</td>
<td>_____</td>
<td>_____</td>
</tr>
</tbody>
</table>

Comments: First attempt: Pass_____ Fail_____ Second attempt: Pass_____ Fail_____

Examiner Signature ____________________________ WAQTC #:_______________
# FIELD OPERATING PROCEDURES - SHORT FORM

<table>
<thead>
<tr>
<th>Chapter</th>
<th>Section</th>
</tr>
</thead>
</table>
| 1       | AASHTO T 168 (10)  
Sampling of Bituminous Paving Mixtures |
| 2       | AASHTO R 47 (12)  
Reducing Samples of Hot Mix Asphalt to Testing Size |
| 3       | AASHTO T 329 (16)  
Moisture Content of Hot Mix Asphalt (HMA) by Oven Method |
| 4       | AASHTO T 308 (16)  
Determining the Asphalt Binder Content of Hot Mix Asphalt (HMA) by the Ignition Method |
| 5       | AASHTO T30 (16)  
Mechanical Analysis of Extracted Aggregate |
| 6       | AASHTO T 209 (16)  
Theoretical Maximum Specific Gravity and Density of Hot Mix Asphalt Paving Mixtures |
| 7       | AASHTO T 166 (16)  
Bulk Specific Gravity of Compacted Hot Mix Asphalt using Saturated Surface-Dry Specimens |
| 8       | AASHTO R 66 (16)  
Sampling Asphalt Materials |
| 9       | AASHTO T 312 (16)  
Hot Mix Asphalt Specimens by means of the Superpave Gyratory Compactor |
| 10      | WAQTC TM 13 (13)  
Volumetric Properties of Hot Mix Asphalt |
| 11      | AASHTO R 67 (15)  
Sampling Hot Asphalt Mixtures After Compaction (Obtaining Cores) Performance Examination only |
PERFORMANCE EXAM CHECKLIST

SAMPLING ASPHALT MIXTURES AFTER COMPACTION
(OBTAINING CORES)

Participant Name ________________________________________ Exam Date ______________

Record the symbols “P” for passing or “F” for failing on each step of the checklist.

<table>
<thead>
<tr>
<th>Procedure Element</th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>1. Core location determined by agency?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>2. Asphalt mixture sufficiently cool or cooled with water, ice dry ice or liquid nitrogen?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>3. Core machine correctly positioned over location?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>4. Water or air used to remove cuttings and minimize friction?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>5. Constant pressure applied to bit while keeping it perpendicular to HMA surface?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>6. Coring stopped a desired depth?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>7. Retrieval device used to obtain object?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>8. Core labeled?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>9. Core placed for transport in a manner that prevents damage from jarring, rolling, impact with any object, or extreme temperatures?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>10. Thickness determined to 1/8 in., 0.01 ft., or 3 mm?</td>
<td>_____</td>
<td>_____</td>
</tr>
</tbody>
</table>

Comments: First attempt: Pass____ Fail____ Second attempt: Pass____ Fail____

Examiner Signature _______________________________ WAQTC #: __________________
REDUCING SAMPLES OF HOT MIX ASPHALT (HMA) TO TESTING SIZE FOP FOR AASHTO R 47 (12)

Scope

This procedure covers sample reduction of Hot Mix Asphalt (HMA) to testing size in accordance with AASHTO R 47-14. The reduced portion is to be representative of the original sample.

Apparatus

- Thermostatically controlled oven capable of maintaining a temperature of at least 110°C (230°F) or high enough to heat the material to a pliable condition for splitting.
- Non-contact temperature measuring device.
- Metal spatulas, trowels, metal straightedges, or drywall taping knives, or a combination thereof; for removing HMA samples from the quartering device, cleaning surfaces used for splitting, etc.
- Square-tipped, flat-bottom scoop, shovel or trowel for mixing HMA prior to quartering.
- Miscellaneous equipment including hot plate, non-asbestos heat-resistant gloves or mittens, pans, buckets, and cans.
- Sheeting: Non-stick heavy paper, heat-resistant plastic, or other material as approved by the agency.
- Agency-approved release agent, free of solvent or petroleum-based material that could affect asphalt binder.
- Mechanical Splitter Type A (Quartermaster): having four equal-width chutes discharging into four appropriately sized sample receptacles. Splitter is to be equipped with a receiving hopper that will hold the sample until the release lever is activated with four sample receptacles of sufficient capacity to accommodate the reduced portion of the HMA sample from the mechanical splitter. Refer to AASHTO R 47, Figures 1 through 3, for configuration and required dimensions of the mechanical splitter.
- Mechanical Splitter Type B (Riffle): having a minimum of eight equal-width chutes discharging alternately to each side with a minimum chute width of at least 50% larger than the largest particle size. A hopper or straight-edged pan with a width equal to or slightly smaller than the assembly of chutes in the riffle splitter to permit uniform discharge of the HMA through the chutes without segregation or loss of material. Sample receptacles of sufficient width and capacity to receive the reduced portions of HMA from the riffle splitter without loss of material.
• Quartering Template: formed in the shape of a cross with equal length sides at right angles to each other. Template shall be manufactured of metal that will withstand heat and use without deforming. The sides of the quartering template should be sized so that the length exceeds the diameter of the flattened cone of HMA by an amount allowing complete separation of the quartered sample. Height of the sides must exceed the thickness of the flattened cone of HMA.

• Non-stick mixing surface that is hard, heat-resistant, clean, level, and large enough to permit HMA samples to be mixed without contamination or loss of material.

**Sampling**

Obtain samples according to the FOP for AASHTO T 168.

**Sample Preparation**

The sample must be warm enough to separate. If not, warm in an oven until it is sufficiently soft to mix and separate easily. Do not exceed either the temperature or time limits specified in the test method(s) to be performed.

**Selection of Procedure (Method)**

Refer to agency requirements when determining the appropriate method(s) of sample reduction. In general, the selection of a particular method to reduce a sample depends on the initial size of the sample vs. the size of the sample needed for the specific test to be performed. It is recommended that, for large amounts of material, the initial reduction be performed using a mechanical splitter. This decreases the time needed for reduction and minimizes temperature loss. Further reduction of the remaining HMA may be performed by a combination of the following methods, as approved by the agency. The methods for reduction are:

- Mechanical Splitter Method
  - Type A (Quartermaster)
  - Type B (Riffle Splitter)
- Quartering Method
  - Full Quartering
  - By Apex
- Incremental Method
**Procedure**

**Mechanical Splitter Type A (Quartermaster)**

1. Clean the splitter and apply a light coating of approved release agent to the surfaces that will contact HMA.

2. Close and secure hopper gates.

3. Place the four sample receptacles in the splitter so that there is no loss of material.

4. Remove the sample from the agency-approved container(s) and place in the mechanical splitter hopper. Avoid segregation, loss of HMA or the accidental addition of foreign material.

5. Release the handle, allowing the HMA to drop through the divider chutes and discharge into the four receptacles.

6. Any HMA that is retained on the surface of the splitter shall be removed and placed into the appropriate receptacle.

7. Close and secure the hopper gates.

8. Reduce the remaining HMA as needed by this method or a combination of the following methods as approved by the agency.

9. Combine the material contained in the receptacles from opposite corners and repeat the splitting process until an appropriate sample size is obtained.

10. Retain and properly identify the remaining unused portion of the HMA sample for further testing if required by the agency.

**Mechanical Splitter Type B (Riffle)**

1. When heating of the testing equipment is desired, it shall be heated to a temperature not to exceed 110°C (230°F).

2. Clean the splitter and apply a light coating of approved release agent to the surfaces that will come in contact with HMA (hopper or straight-edged pan, chutes, receptacles).

3. Place two empty receptacles under the splitter.

4. Carefully empty the HMA from the agency-approved container(s) into the hopper or straight-edged pan without loss of material. Uniformly distribute from side to side of the hopper or pan.
5. Discharge the HMA at a uniform rate, allowing it to flow freely through the chutes.

6. Any HMA that is retained on the surface of the splitter shall be removed and placed into the appropriate receptacle.

7. Reduce the remaining HMA as needed by this method or a combination of the following methods as approved by the agency.

8. Using one of the two receptacles containing HMA, repeat the reduction process until the HMA contained in one of the two receptacles is the appropriate size for the required test.

9. After each split, remember to clean the splitter hopper and chute surfaces if needed.

10. Retain and properly identify the remaining unused HMA sample for further testing if required by the agency.

**Quartering Method**

1. When heating of the testing equipment is desired, it shall be heated to a temperature not to exceed the mix temperature.

2. If needed, apply a light coating of release agent to quartering template.

3. Dump the sample from the agency approved container(s) into a conical pile on a hard, “non-stick,” clean, level surface where there will be neither a loss of material nor the accidental addition of foreign material. The surface can be made non-stick by the application of an approved asphalt release agent, or sheeting.

4. Mix the material thoroughly by turning the entire sample over a minimum of four times with a flat-bottom scoop; or by alternately lifting each corner of the sheeting and pulling it over the sample diagonally toward the opposite corner, causing the material to be rolled. Create a conical pile by either depositing each scoop or shovelful of the last turning on top of the preceding one, or lifting both opposite corners.

5. Flatten the conical pile to a uniform diameter and thickness where the diameter is four to eight times the thickness. Make a visual observation to ensure that the material is homogeneous.

6. Divide the flattened cone into four equal quarters using the quartering template. Press the template down until it is in complete contact with the surface on which the sample has been placed, assuring complete separation.

   **Note 1:** Straightedges may be used in lieu of the quartering device to completely separate the material in approximately equal quarters.

7. Reduce the sample by quartering the sample completely or by removing the sample from the apex.
8. Full Quartering

8a. Remove two diagonally opposite quarters, including all of the fine material.

8b. Remove the quartering template and combine the remaining quarters, again forming a conical pile.

8c. Repeat steps 4, 5, 6, 8a, and 8b until a sample of the required size has been obtained. The final sample must consist of the two remaining diagonally opposite quarters.

8d. Retain and properly identify the remaining unused portion of the HMA sample for further testing if required by the agency.

9. By Apex

9a. Using a straightedge, slice through a quarter of the HMA from the center point to the outer edge of the quarter.

9b. Pull or drag the material from the quarter with two straight edges or hold one edge of the straightedge in contact with quartering device.

9c. Remove an equal portion from the opposite quarter and combine these increments to create the required sample size.

9d. Continue using the apex method with the unused portion of the HMA until samples have been obtained for all required tests.

9e. Retain and properly identify the remaining unused portion of the HMA sample for further testing if required by the agency.

Incremental Method

1. Cover a hard, clean, level surface with sheeting. This surface shall be large enough that there will be neither a loss of material nor the accidental addition of foreign material.

2. Place the sample from the agency approved container(s) into a conical pile on that surface.

3. Mix the material thoroughly by turning the entire sample over a minimum of four times with a flat-bottom scoop; or by alternately lifting each corner of the sheeting and pulling it over the sample diagonally toward the opposite corner, causing the material to be rolled. Create a conical pile by either depositing each scoop or shovelful of the last turning on top of the preceding one, or lifting both opposite corners.
4. Grasp the sheeting and roll the conical pile into a cylinder (loaf), then flatten the top. Make a visual observation to determine that the material is homogenous.

5. Pull the sheeting so at least ¼ of the length of the loaf is off the edge of the counter. Allow this material to drop into a container to be saved. As an alternate, using a straightedge, slice off approximately ¼ of the length of the loaf and place in a container to be saved.

6. Pull material off the edge of the counter and drop into an appropriate size sample pan or container for the test to be performed. Continue removing material from the loaf until the proper size sample has been acquired. As an alternate, using a straightedge, slice off an appropriate size sample from the length of the loaf and place in a sample pan or container.

7. Repeat step 6 until all the samples for testing have been obtained.

   **Note2:** When reducing the sample to test size it is advisable to take several small increments, determining the mass each time until the proper minimum size is achieved. Unless the sample size is grossly in excess of the minimum or exceeds the maximum test size, use the sample as reduced for the test.

8. Retain and properly identify the remaining unused portion of the HMA sample for further testing if required by the agency.
PERFORMANCE EXAM CHECKLIST

REDUCING SAMPLES OF HOT MIX ASPHALT (HMA) TO TESTING SIZE
FOP FOR AASHTO R 47

Participant Name ______________________________ Exam Date ______________

Record the symbols “P” for passing or “F” for failing on each step of the checklist.

<table>
<thead>
<tr>
<th>Procedure Element</th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>1. Sample made soft enough to separate easily without exceeding temperature limits?</td>
<td>_____</td>
<td>_____</td>
</tr>
</tbody>
</table>

**Mechanical Splitter Method Type A (Quartermaster)**

<table>
<thead>
<tr>
<th>Procedure Element</th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>2. Splitter cleaned and surfaces coated with release agent?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>3. Hopper closed and receptacles in place?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>4. Sample placed into hopper without segregation or loss of material?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>5. Hopper handle released allowing the HMA to uniformly flow into receptacles?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>6. Splitter surfaces cleaned of all retained HMA, allowing it to fall into appropriate receptacles?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>7. Further reduction with the quartermaster:</td>
<td></td>
<td></td>
</tr>
<tr>
<td>a. Material in receptacles from opposite corners combined?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>b. Splitting process repeated until appropriate sample size is obtained?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>8. Remaining HMA stored in suitable container and properly labeled?</td>
<td>_____</td>
<td>_____</td>
</tr>
</tbody>
</table>

**Mechanical Splitter Method Type B (Rifle)**

<table>
<thead>
<tr>
<th>Procedure Element</th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>9. Splitting apparatus and tools, if preheated, not exceeding 110ºC (230ºF)?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>10. Splitter cleaned and surfaces coated with release agent?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>11. Two empty receptacles placed under splitter?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>12. Sample placed in hopper or straight edged pan without loss of material and uniformly distributed from side to side?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>13. Material discharged across chute assembly at controlled rate allowing free flow of HMA through chutes?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>14. Splitter surfaces cleaned of all retained HMA allowing it to fall into appropriate receptacles?</td>
<td>_____</td>
<td>_____</td>
</tr>
</tbody>
</table>

OVER
### Procedure Element

15. Further reduction with the riffle splitter:
   a. Material from one receptacle discharged across chute assembly at controlled rate, allowing free flow of HMA through chutes?  
      [ ]  [ ]
   b. Splitting process continued until appropriate sample size obtained, with splitter surfaces cleaned of all retained HMA after every split?  
      [ ]  [ ]

16. Remaining unused HMA stored in suitable container, properly labeled?  
    [ ]  [ ]

### Quartering Method

17. Testing equipment preheated to a temperature not to exceed mix temperature?  
    [ ]  [ ]

18. Sample placed in a conical pile on a hard, non-stick, heat-resistant splitting surface such as metal or sheeting?  
    [ ]  [ ]

19. Sample mixed by turning the entire sample over a minimum of 4 times?  
    [ ]  [ ]

20. Conical pile formed and then flattened uniformly to diameter equal to about 4 to 8 times thickness?  
    [ ]  [ ]

21. Sample divided into 4 equal portions either with a metal quartering template or straightedges such as drywall taping knives?  
    [ ]  [ ]

22. Reduction by Full Quartering:
   a. Two diagonally opposite quarters removed and returned to sample container?  
      [ ]  [ ]
   b. Two other diagonally opposite quarters combined and process continued until appropriate sample size has been achieved?  
      [ ]  [ ]

23. Reduction by Apex:
   a. Using two straightedges or a splitting device and one straightedge, was one of the quarters split from apex to outer edge of material?  
      [ ]  [ ]
   b. Similar amount of material taken from opposite quarter?  
      [ ]  [ ]
   c. Increments combined to produce appropriate sample size?  
      [ ]  [ ]

24. Remaining unused HMA stored in suitable container, properly labeled?  
    [ ]  [ ]

### Incremental Method

25. Sample placed on hard, non-stick, heat-resistant splitting surface covered with sheeting?  
    [ ]  [ ]

26. Sample mixed by turning the entire sample over a minimum of 4 times?  
    [ ]  [ ]

---

**OVER**
Procedure Element | Trial 1 | Trial 2
---|---|---
27. Conical pile formed? | | |
28. HMA rolled into loaf and then flattened? | | |
29. The first quarter of the loaf removed by slicing off or dropping off edge of counter and set aside? | | |
30. Proper sample size sliced off or dropped off edge of counter into sample container? | | |
31. Process continued until all samples are obtained? | | |
32. All remaining unused HMA stored in suitable container, properly labeled? | | |

Comments: First attempt: Pass Fail Second attempt: Pass Fail

Examiner Signature ____________________________ WAQTC #:_________________
FOP for AASHTO R-47

Reducing Samples of Hot Mix Asphalt to Testing Size

Delete all references to Mechanical Splitter Type A (Quartermaster). Not an accepted method.
SAMPLING ASPHALT MATERIALS
FOP FOR AASHTO R 66

Scope

This procedure covers obtaining samples of liquid asphalt materials in accordance with AASHTO R 66-16. Sampling of solid and semi-solid asphalt materials – included in AASHTO R 66 – is not covered here.

Agencies may be more specific on exactly who samples, where to sample, and what type of sampling device to use.

Warning: Always use appropriate safety equipment and precautions for hot liquids.

Terminology

- Asphalt binder: Asphalt cement or modified asphalt cement that binds the aggregate particles into a dense mass.
- Asphalt emulsion: A mixture of asphalt binder and water.
- Cutback asphalt: Asphalt binder that has been modified by blending with a chemical solvent.

Procedure

1. Coordinate sampling with contractor or supplier.
2. Allow a minimum of 4 L (1 gal) to flow before obtaining a sample(s).
3. Obtain samples of:
   - Asphalt binder from hot mix asphalt (HMA) plant from the line between the storage tank and the mixing plant while the plant is in operation, or from the delivery truck.
   - Cutback and emulsified asphalt from distributor spray bar or application device; or from the delivery truck before it is pumped into the distributor. Sample emulsified asphalt at delivery or prior to dilution.

Containers

Sample containers must be new and the inside may not be washed or rinsed. The outside may be wiped with a clean, dry cloth.

All samples shall be put in 1 L (1 qt) containers and properly identified on the outside of the container with contract number, date sampled, data sheet number, brand and grade of material, and sample number. Include lot and sublot numbers when appropriate.
• Emulsified asphalt: Use wide-mouth plastic jars with screw caps. Protect the samples from freezing since water is a part of the emulsion. The sample container should be completely filled to minimize a skin formation on the sample.

• Asphalt binder and cutbacks: Use metal cans.

  Note: The sample container shall not be submerged in solvent, nor shall it be wiped with a solvent saturated cloth. If cleaning is necessary, use a clean dry cloth.

**Report**

• On forms approved by the agency

• Sample ID

• Date

• Time

• Location

• Quantity represented
MECHANICAL ANALYSIS OF EXTRACTED AGGREGATE FOP FOR AASHTO T 30 (16)

Scope

This procedure covers mechanical analysis of aggregate recovered from bituminous mix samples in accordance with AASHTO T 30-15. This FOP utilizes the aggregate recovered from the ignition oven used in AASHTO T 308. AASHTO T 30 was developed for analysis of extracted aggregate and thus includes references to extracted bitumen and filter element, which do not apply in this FOP.

Sieve analyses determine the gradation or distribution of aggregate particles within a given sample in order to determine compliance with design and production standards.

Apparatus

- Balance or scale: Capacity sufficient for the sample mass, accurate to 0.1 percent of the sample mass or readable to 0.1 g
- Sieves
- Mechanical sieve shaker
- Mechanical Washing Apparatus (optional)
- Suitable drying equipment (see FOP for AASHTO T 255)
- Containers and utensils: A pan or vessel of a size sufficient to contain the sample covered with water and to permit vigorous agitation without loss of any part of the sample or water

Sample Sieving

- In this procedure it is required to shake the sample over nested sieves. Sieves are selected to furnish information required by specification.
- Sieves are nested in order of decreasing size from the top to the bottom and the sample, or a portion of the sample, is placed on the top sieve.
- Sieves are shaken in a mechanical shaker for approximately 10 minutes or the minimum time determined to provide complete separation for the sieve shaker being used as established by the Time Evaluation.
Time Evaluation

The minimum time requirement should be evaluated for each shaker at least annually by the following method:

1. Shake the sample over nested sieves for approximately 10 minutes.

2. Provide a snug-fitting pan and cover for each sieve, and hold in a slightly inclined position in one hand.

3. Hand-shake each sieve by striking the side of the sieve sharply and with an upward motion against the heel of the other hand at the rate of about 150 times per minute, turning the sieve about one sixth of a revolution at intervals of about 25 strokes.

If more than 0.5 percent by mass of the total sample prior to sieving passes any sieve after one minute of continuous hand sieving adjust shaker time and re-check.

In determining sieving time for sieve sizes larger than 4.75 mm (No. 4), limit the material on the sieve to a single layer of particles.

Overload Determination

- For sieves with openings smaller than 4.75 mm (No. 4), the mass retained on any sieve shall not exceed 7 kg/m² (4 g/in²) of sieving surface.

- For sieves with openings 4.75 mm (No. 4) and larger, the mass (in kg) shall not exceed the product of 2.5 x (sieve opening in mm) x (effective sieving area). See Table 1.

Additional sieves may be necessary to keep from overloading the specified sieves. The sample may also be sieved in increments or sieves with a larger surface area.
TABLE 1
Maximum Allowable Mass of Material Retained on a Sieve, g
Nominal Sieve Size, mm (in.)
Exact size is smaller (see AASHTO T 27)

<table>
<thead>
<tr>
<th>Sieve Size mm (in.)</th>
<th>203 dia (8)</th>
<th>305 dia (12)</th>
<th>305 by 305 (12 x 12)</th>
<th>350 by 350 (14 x 14)</th>
<th>372 by 580 (16 x 24)</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>0.0285</td>
<td>0.0670</td>
<td>0.0929</td>
<td>0.1225</td>
<td>0.2158</td>
</tr>
<tr>
<td>90 (3 1/2)</td>
<td>*</td>
<td>15,100</td>
<td>20,900</td>
<td>27,600</td>
<td>48,500</td>
</tr>
<tr>
<td>75 (3)</td>
<td>*</td>
<td>12,600</td>
<td>17,400</td>
<td>23,000</td>
<td>40,500</td>
</tr>
<tr>
<td>63 (2 1/2)</td>
<td>*</td>
<td>10,600</td>
<td>14,600</td>
<td>19,300</td>
<td>34,000</td>
</tr>
<tr>
<td>50 (2)</td>
<td>3600</td>
<td>8400</td>
<td>11,600</td>
<td>15,300</td>
<td>27,000</td>
</tr>
<tr>
<td>37.5 (1 1/2)</td>
<td>2700</td>
<td>6300</td>
<td>8700</td>
<td>11,500</td>
<td>20,200</td>
</tr>
<tr>
<td>25.0 (1)</td>
<td>1800</td>
<td>4200</td>
<td>5800</td>
<td>7700</td>
<td>13,500</td>
</tr>
<tr>
<td>19.0 (3/4)</td>
<td>1400</td>
<td>3200</td>
<td>4400</td>
<td>5800</td>
<td>10,200</td>
</tr>
<tr>
<td>16.0 (5/8)</td>
<td>1100</td>
<td>2700</td>
<td>3700</td>
<td>4900</td>
<td>8600</td>
</tr>
<tr>
<td>12.5 (1/2)</td>
<td>890</td>
<td>2100</td>
<td>2900</td>
<td>3800</td>
<td>6700</td>
</tr>
<tr>
<td>9.5 (3/8)</td>
<td>670</td>
<td>1600</td>
<td>2200</td>
<td>2900</td>
<td>5100</td>
</tr>
<tr>
<td>6.3 (1/4)</td>
<td>440</td>
<td>1100</td>
<td>1500</td>
<td>1900</td>
<td>3400</td>
</tr>
<tr>
<td>4.75 (No. 4)</td>
<td>330</td>
<td>800</td>
<td>1100</td>
<td>1500</td>
<td>2600</td>
</tr>
<tr>
<td>-4.75 (-No. 4)</td>
<td>200</td>
<td>470</td>
<td>650</td>
<td>860</td>
<td>1510</td>
</tr>
</tbody>
</table>

Mass Verification

1. Using the aggregate sample obtained from the FOP for AASHTO T 308, determine and record the mass of the sample, $M_{T30}$, to 0.1 g. This mass shall agree with the mass of the aggregate remaining after ignition, $M_f$ from T 308, within 0.10 percent. If the variation exceeds 0.10 percent the results cannot be used for acceptance.

$$\frac{M_f(T308) - M(T30)}{M_f(T308)} \times 100$$

Where:

$$M_{T30} = 2422.3 \text{ g}$$
$$M_f(T308) = 2422.5 \text{ g}$$

$$\frac{2422.5 \text{ g} - 2422.3 \text{ g}}{2422.5 \text{ g}} \times 100 = 0.01\%$$
Procedure

1. Nest a sieve, such as a 2.0 mm (No. 10) or 1.18 mm (No. 16), above the 75µm (No. 200) sieve.

2. Place the test sample in a container and add sufficient water to cover it. Add a detergent, dispersing agent, or other wetting solution to the water to assure a thorough separation of the material finer than the 75µm (No. 200) sieve from the coarser particles. There should be enough wetting agent to produce a small amount of suds when the sample is agitated. Excessive suds may overflow the sieves and carry material away with them.

3. Agitate vigorously to ensure complete separation of the material finer than 75µm (No. 200) from coarser particles and bring the fine material into suspension above the coarser material. When using a mechanical washing device, exercise caution to avoid degradation of the sample. Maximum agitation is 10 min.

   Note 1: When mechanical washing equipment is used, the introduction of water, agitating, and decanting may be a continuous operation. Use care not to overflow or overload the 75µm (No. 200) sieve.

4. Immediately pour the wash water containing the suspended and dissolved solids over the nested sieves, being careful not to pour out the coarser particles.

5. Add a second change of water to the sample remaining in the container, agitate, and repeat Step 5. Repeat the operation until the wash water is reasonably clear. Continue washing until the agent is removed.

6. Rinse the material on the nested sieves until water passing through the sieve is reasonably clear.

7. Remove the upper sieve, return material retained to the washed sample.

8. Rinse the material retained on the 75 µm (No. 200) sieve until water passing through the sieve is reasonably clear.

9. Return all material retained on the 75 µm (No. 200) sieve to the washed sample by flushing into the washed sample.

10. Dry the washed aggregate to constant mass in accordance with the FOP for AASHTO T 255, and then cool prior to sieving. Record the “dry mass after washing.”

11. Select sieves to furnish information required by the specifications. Nest the sieves in order of decreasing size from top to bottom and place the sample, or a portion of the sample, on the top sieve.

12. Place sieves in mechanical shaker and shake for the minimum time determined to provide complete separation for the sieve shaker being used (approximately 10 minutes).

   Note 2: Excessive shaking (more than 10 minutes) may result in degradation of the sample.
13. Determine the mass retained on each sieve (individual/cumulative) to the nearest 0.1 g. Ensure that all material trapped in full openings of the sieves are cleaned out and included in the mass retained.

Note 3: For sieves No. 4 and larger, material trapped in less than a full opening shall be checked by sieving over a full opening. Use coarse wire brushes to clean the 600 µm (No. 30) and larger sieves, and soft bristle brushes for smaller sieves.

14. Verify the total mass of material after sieving agrees with the mass before sieving within 0.2 percent. (Check sum). When the masses before and after sieving differ by more than 0.2 percent, do not use the results for acceptance purposes.

15. Divide the masses for each sieve (individual/cumulative) by the total dry mass before washing and multiply by 100 to determine the percent retained on and passing each sieve.

16. Calculate the percent retained and passing each sieve to the nearest 0.1 percent.

17. Apply the Aggregate Correction Factor to the calculated percent passing, as required in the FOP for AASHTO T 308 “Correction Factor” Steps 10 through 12, to obtain the reported percent passing.

18. Report percentages to the nearest 1 percent except for the percent passing the 75 µm (No. 200) sieve, which shall be reported to the nearest 0.1 percent.

Calculations

\[
\text{check sum} = \frac{\text{dry mass after washing} - \text{total mass after sieving}}{\text{dry mass after washing}} \times 100
\]

PERCENT RETAINED:

\[
\text{IPR} = \frac{\text{IMR}}{M_{T30}} \times 100 \quad \text{OR} \quad \text{CPR} = \frac{\text{CMR}}{M_{T30}} \times 100
\]

Where:

IPR = Individual Percent Retained

CPR = Cumulative Percent Retained

\(M_{T30}\) = Total Dry Sample mass before washing

IMR = Individual Mass Retained

CMR = Cumulative Mass Retained
PERCENT PASSING and REPORTED PERCENT PASSING:

\[ PP = PCP - IPR \quad \text{OR} \quad PP = 100 - CPR \]

\[ RPP = PP + \text{Aggregate Correction Factor} \]

Where:

- \( PP \) = Calculated Percent Passing
- \( PCP \) = Previous Calculated Percent Passing
- \( RPP \) = Reported Percent Passing

**Example**

Dry mass of total sample, before washing (M_{T30}): 2422.3 g

Dry mass of sample, after washing out the 75 µm (No. 200) minus: 2296.2 g

Amount of 75 µm (No. 200) minus washed out: 2422.3 g – 2296.2 g = 126.1 g

Percent Retained 75 µm (No. 200):

\[ \frac{63.5 \text{ g}}{2422.3 \text{ g}} \times 100 = 2.6\% \quad \text{or} \quad \frac{2289.6 \text{ g}}{2422.3 \text{ g}} \times 100 = 94.5\% \]

Percent Passing: \( 8.1\% - 2.6\% = 5.5\% \) or \( 100\% - 94.5\% = 5.5\% \)

Reported Percent Passing: \( 5.5\% + (-0.6\%) = 4.9\% \)
## Gradation on All Screens

<table>
<thead>
<tr>
<th>Sieve Size mm (in.)</th>
<th>Mass Retained (g) (MR)</th>
<th>Percent Retained (PR)</th>
<th>Cumulative Mass Retained (g) (CMR)</th>
<th>Cumulative Percent Retained (CPR)</th>
<th>Calc'd Percent Passing (PP)</th>
<th>Agg. Corr. Factor from T 308 (ACF)</th>
<th>Reported Percent Passing (RPP)</th>
</tr>
</thead>
<tbody>
<tr>
<td>19.0 (3/4)</td>
<td>0.0</td>
<td>0</td>
<td>0.0</td>
<td>0</td>
<td>100.0</td>
<td></td>
<td>100</td>
</tr>
<tr>
<td>12.5 (1/2)</td>
<td>346.9</td>
<td>14.3</td>
<td>346.9</td>
<td>14.3</td>
<td>85.7</td>
<td></td>
<td>86</td>
</tr>
<tr>
<td>9.5 (3/8)</td>
<td>207.8</td>
<td>8.6</td>
<td>554.7</td>
<td>22.9</td>
<td>77.1</td>
<td></td>
<td>77</td>
</tr>
<tr>
<td>4.75 (No. 4)</td>
<td>625.4</td>
<td>25.8</td>
<td>1180.1</td>
<td>48.7</td>
<td>51.3</td>
<td></td>
<td>51</td>
</tr>
<tr>
<td>2.36 (No. 8)</td>
<td>416.2</td>
<td>17.2</td>
<td>1596.3</td>
<td>65.9</td>
<td>34.1</td>
<td></td>
<td>34</td>
</tr>
<tr>
<td>0.18 (No. 16)</td>
<td>274.2</td>
<td>11.3</td>
<td>1870.5</td>
<td>77.2</td>
<td>22.8</td>
<td></td>
<td>23</td>
</tr>
<tr>
<td>0.600 (No. 30)</td>
<td>152.1</td>
<td>6.3</td>
<td>2022.6</td>
<td>83.5</td>
<td>16.5</td>
<td></td>
<td>16</td>
</tr>
<tr>
<td>0.300 (No. 50)</td>
<td>107.1</td>
<td>4.4</td>
<td>2129.7</td>
<td>87.9</td>
<td>12.1</td>
<td></td>
<td>12</td>
</tr>
<tr>
<td>0.150 (No. 100)</td>
<td>96.4</td>
<td>4.0</td>
<td>2226.1</td>
<td>91.9</td>
<td>8.1</td>
<td></td>
<td>8</td>
</tr>
<tr>
<td>75 µm (No. 200)</td>
<td>63.5</td>
<td>2.6</td>
<td>2289.6</td>
<td>94.5</td>
<td>5.5</td>
<td>-0.6</td>
<td>4.9</td>
</tr>
<tr>
<td>Pan</td>
<td>5.7</td>
<td></td>
<td>2295.3</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

Check sum:

\[
\frac{2296.2 \text{ g} - 2295.3 \text{ g}}{2296.2 \text{ g}} \times 100 = 0.04\%
\]

This is less than 0.2 percent therefore the results can be used for acceptance purposes.
Report

- Results on forms approved by the agency
- Sample ID
- Depending on the agency, this may include:
  - Individual mass retained on each sieve
  - Individual percent retained on each sieve
  - Cumulative mass retained on each sieve
  - Cumulative percent retained on each sieve
  - Aggregate Correction Factor for each sieve from AASHTO T 308
  - Calculated percent passing each sieve to 0.1 percent
- Reported percent passing to the nearest 1 percent, except 75 µm (No. 200) sieve to the nearest 0.1 percent.
PERFORMANCE EXAM CHECKLIST

MECHANICAL ANALYSIS OF EXTRACTED AGGREGATE
FOP FOR AASHTO T 30

Participant Name ______________________________ Exam Date ______________

Record the symbols “P” for passing or “F” for failing on each step of the checklist.

<table>
<thead>
<tr>
<th>Procedure Element</th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>1. Total dry mass determined to 0.1 g</td>
<td>_______</td>
<td>_______</td>
</tr>
<tr>
<td>2. Dry mass agrees with sample mass after ignition (M_f) from AASHTO T 308 within 0.1 percent?</td>
<td>_______</td>
<td>_______</td>
</tr>
<tr>
<td>3. Sample placed in container and covered with water?</td>
<td>_______</td>
<td>_______</td>
</tr>
<tr>
<td>4. Wetting agent added?</td>
<td>_______</td>
<td>_______</td>
</tr>
<tr>
<td>5. Contents of container agitated vigorously?</td>
<td>_______</td>
<td>_______</td>
</tr>
<tr>
<td>6. Wash water poured through proper nest of two sieves?</td>
<td>_______</td>
<td>_______</td>
</tr>
<tr>
<td>7. Washing continued until wash water is clear and no wetting agent remaining?</td>
<td>_______</td>
<td>_______</td>
</tr>
<tr>
<td>8. Retained material returned to washed sample?</td>
<td>_______</td>
<td>_______</td>
</tr>
<tr>
<td>9. Washed material coarser than 75 µm (No. 200) dried to constant mass at 110 ±5°C (230 ±9°F)?</td>
<td>_______</td>
<td>_______</td>
</tr>
<tr>
<td>10. Sample cooled to room temperature?</td>
<td>_______</td>
<td>_______</td>
</tr>
<tr>
<td>11. Dry mass after washing determined to 0.1 g?</td>
<td>_______</td>
<td>_______</td>
</tr>
<tr>
<td>12. Material sieved on specified sieves?</td>
<td>_______</td>
<td>_______</td>
</tr>
<tr>
<td>13. Mass of each fraction of aggregate, including minus 75 µm (No. 200), determined and recorded to 0.1 g?</td>
<td>_______</td>
<td>_______</td>
</tr>
<tr>
<td>14. Percent passing on each sieve determined correctly to the nearest 0.1 percent?</td>
<td>_______</td>
<td>_______</td>
</tr>
<tr>
<td>15. Aggregate correction factor applied?</td>
<td>_______</td>
<td>_______</td>
</tr>
<tr>
<td>16. Percent passing on each sieve reported correctly to the nearest 1 percent and nearest 0.1 percent on the 75 µm (No. 200)?</td>
<td>_______</td>
<td>_______</td>
</tr>
<tr>
<td>17. Does summation of sieve masses check total washed dry mass to within 0.2 percent?</td>
<td>_______</td>
<td>_______</td>
</tr>
</tbody>
</table>

Comments: First attempt: Pass______Fail_______ Second attempt: Pass______Fail_______

Examiner Signature _______________________________ WAQTC #: _______________
BULK SPECIFIC GRAVITY ($G_{mb}$) OF COMPACTED HOT MIX ASPHALT (HMA) USING SATURATED SURFACE-DRY SPECIMENS
FOP FOR AASHTO T 166 (16)

Scope

This procedure covers the determination of bulk specific gravity ($G_{mb}$) of compacted hot mix asphalt (HMA) using three methods – A, B, and C – in accordance with AASHTO T 166-16. This FOP is for use on specimens not having open or interconnecting voids or absorbing more than 2.00 percent water by volume, or both. When specimens have open or interconnecting voids or absorbing more than 2.00 percent water by volume, or both, AASHTO T 275 or AASHTO T 331 should be performed.

Overview

- Method A: Suspension
- Method B: Volumeter
- Method C: Rapid test for A or B

Test Specimens

Test specimens may be either laboratory-molded or from HMA pavement. For specimens it is recommended that the diameter be equal to four times the maximum size of the aggregate and the thickness be at least one and one half times the maximum size.

Test specimens from HMA pavement will be sampled according to AASHTO R 67.

Terminology

*Constant Mass*: The state at which a mass does not change more than a given percent, after additional drying for a defined time interval, at a required temperature.

Apparatus - Method A (Suspension)

Balance or scale: 5 kg capacity, readable to 0.1 g, and fitted with a suitable suspension apparatus and holder to permit weighing the specimen while suspended in water, conforming to AASHTO M 231.

- Suspension apparatus: Wire of the smallest practical size and constructed to permit the container to be fully immersed.
- Water bath: For immersing the specimen in water while suspended under the balance or scale, and equipped with an overflow outlet for maintaining a constant water level.
• **Towel:** Damp cloth towel used for surface drying specimens.

• **Oven:** Capable of maintaining a temperature of 110 ±5°C (230 ±9°F) for drying the specimens to a constant mass.

• **Pan:** Pan or other suitable container of known mass, large enough to hold a sample for drying in oven.

• **Thermometer:** Having a range of 19 to 27°C (66 to 80°F), graduated in 0.1°C (0.2°F) subdivisions.

### Procedure - Method A (Suspension)

Recently molded laboratory samples that have not been exposed to moisture do not need drying.

1. Dry the specimen to constant mass, if required.
   
   a. Initially dry overnight at 52 ±3°C (125 ±5°F).

   b. Determine and record the mass of the specimen (M_p).

   c. Return the specimen to the oven for at least 2 hours.

   d. Determine and record the mass of the specimen (M_n).

   e. Determine percent change by subtracting the new mass determination (M_n) from the previous mass determination (M_p) divide by the previous mass determination (M_p) multiply by 100.

   f. Continue drying until there is less than 0.05 percent change in specimen mass after 2-hour drying intervals (constant mass).

   g. Constant mass has been achieved, sample is defined as dry.

   **Note 1:** To expedite the procedure, steps 1 and 2 may be performed last. To further expedite the process, see Method C.

2. Cool the specimen in air to 25 ±5°C (77 ±9°F), and determine and record the dry mass to the nearest 0.1 g. Designate this mass as “A.”

3. Fill the water bath to overflow level with water at 25 ±1°C (77 ±1.8°F) and allow the water to stabilize.

4. Zero or tare the balance with the immersion apparatus attached, ensuring that the device is not touching the sides or the bottom of the water bath.
5. Immerse the specimen shaking to remove the air bubbles. Place the specimen on its side in the suspension apparatus. Leave it immersed for 4 ±1 minutes.

6. Determine and record the submerged weight to the nearest 0.1 g. Designate this submerged weight as “C.”

7. Remove the sample from the water and quickly surface dry with a damp cloth towel within 5 seconds.

8. Zero or tare the balance.

9. Immediately determine and record the mass of the SSD specimen to nearest 0.1 g. Designate this mass as “B.” Any water that seeps from the specimen during the mass determination is considered part of the saturated specimen. Do not exceed 15 seconds performing Steps 7 through 9.

Calculations - Method A (Suspension)

Constant Mass:

Calculate constant mass using the following formula:

\[ \% \text{Change} = \frac{M_p - M_n}{M_p} \times 100 \]

Where:

\( M_p = \) previous mass measurement, g

\( M_n = \) new mass measurement, g

Bulk specific gravity (\( G_{mb} \)) and percent water absorbed:

\[ G_{mb} = \frac{A}{B - C} \]

\[ \text{Percent Water Absorbed (by volume)} = \frac{B - A}{B - C} \times 100 \]

where:

A = Mass of dry specimen in air, g

B = Mass of SSD specimen in air, g

C = Weight of specimen in water at 25 ±1°C (77 ±1.8°F), g
Example:

\[ G_{mb} = \frac{4833.6 \ g}{4842.4 \ g - 2881.3 \ g} = 2.465 \%
\]

% Water Absorbed \(\text{(by volume)}\) \(= \frac{4842.4 \ g - 4833.6 \ g}{4842.4 \ g - 2881.3 \ g} \times 100 = 0.45\%

**Apparatus - Method B (Volumeter)**

- Balance or scale: 5 kg capacity, readable to 0.1 g and conforming to AASHTO M 231.
- Water bath: Thermostatically controlled to 25 ±0.5°C (77 ±0.9°F).
- Thermometer: Range of 19 to 27°C (66 to 80°F), and graduated in 0.1°C (0.2°F) subdivisions.
- Volumeter: Calibrated to 1200 mL or appropriate capacity for test sample and having a tapered lid with a capillary bore.
- Oven: Capable of maintaining a temperature of 110 ±5°C (230 ±9°F) for drying the specimens to a constant mass.
- Pan: Pan or other suitable container of known mass, large enough to hold a sample for drying in oven.
- Towel: Damp cloth towel used for surface drying specimens.

**Procedure - Method B (Volumeter)**

Recently molded laboratory samples that have not been exposed to moisture do not need drying.

1. Dry the specimen to constant mass, if required.
   a. Initially dry overnight at 52 ±3°C (125 ±5°F).
   b. Determine and record the mass of the specimen \(M_p\).
   c. Return the specimen to the oven for at least 2 hours.
   d. Determine and record the mass of the specimen \(M_n\).
e. Determine percent change by subtracting the new mass determination (M_n) from the previous mass determination (M_p) divide by the previous mass determination (M_p) multiply by 100.

f. Continue drying until there is less than 0.05 percent change in specimen mass after 2-hour drying intervals (constant mass).

g. Constant mass has been achieved, sample is defined as dry.

Note 1: To expedite the procedure, steps 1 and 2 may be performed last. To further expedite the process, see Method C.

2. Cool the specimen in air to 25 ±5°C (77 ±9°F), and determine and record the dry mass to the nearest 0.1 g. Designate this mass as “A.”

3. Immerse the specimen in the temperature-controlled water bath for at least 10 minutes.

4. Fill the volumeter with distilled water at 25 ±1°C (77 ±1.8°F) making sure some water escapes through the capillary bore of the tapered lid. Wipe the volumeter dry. Determine the mass of the volumeter to the nearest 0.1 g. Designate this mass as “D.”

5. At the end of the ten minute period, remove the specimen from the water bath and quickly surface dry with a damp cloth towel within 5 seconds.

6. Immediately determine and record the mass of the SSD specimen to the nearest 0.1 g.

7. Designate this mass as “B.” Any water that seeps from the specimen during the mass determination is considered part of the saturated specimen.

8. Place the specimen in the volumeter and let stand 60 seconds.

9. Bring the temperature of the water to 25 ±1°C (77 ±1.8°F) and cover the volumeter, making sure some water escapes through the capillary bore of the tapered lid.

10. Wipe the volumeter dry.

11. Determine and record the mass of the volumeter and specimen to the nearest 0.1 g. Designate this mass as “E.”

Note 2: Method B is not acceptable for use with specimens that have more than 6 percent air voids.
Calculations - Method B (Volumeter)

Constant Mass:

Calculate constant mass using the following formula:

\[
\% \text{Change} = \frac{M_p - M_n}{M_p} \times 100
\]

Where:
- \(M_p\) = previous mass measurement, g
- \(M_n\) = new mass measurement, g

Bulk specific gravity \((G_{mb})\) and percent water absorbed:

\[
G_{mb} = \frac{A}{B + D - E}
\]

\[
\text{Percent Water Absorbed (by volume)} = \frac{B - A}{B + D - E} \times 100
\]

where:
- \(A\) = Mass of dry specimen in air, g
- \(B\) = Mass of SSD specimen in air, g
- \(D\) = Mass of volumeter filled with water at 25 ±1°C (77 ±1.8°F), g
- \(E\) = Mass of volumeter filled with specimen and water, g

Example:

\[
G_{mb} = \frac{4833.6 \text{ g}}{4842.4 \text{ g} + 2924.4 \text{ g} - 5806.0 \text{ g}} = 2.465
\]

\[
\% \text{Water Absorbed (by volume)} = \frac{4842.4 \text{ g} - 4833.6 \text{ g}}{4842.4 \text{ g} + 2924.4 \text{ g} - 5806.0 \text{ g}} \times 100 = 0.45\%
\]
**Apparatus - Method C (Rapid Test for Method A or B)**

See Methods A or B.

*Note 3:* This procedure can be used for specimens that are not required to be saved and contain substantial amounts of moisture. Cores can be tested the same day as obtained by this method.

**Procedure - Method C (Rapid Test for Method A or B)**

1. Start on Step 3 of Method A or B, and complete that procedure, then determine dry mass, “A,” as follows.

2. Determine and record mass of a large, flat-bottom container.

3. Place the specimen in the container.

4. Place in an oven at a minimum of 105°C (221°F). Do not exceed the Job Mix Formula mixing temperature.

5. Dry until the specimen can be easily separated into fine aggregate particles that are not larger than 6.3 mm (¼ in.).

6. Determine and record the mass of the specimen (Mp).

7. Return the specimen to the oven for at least 2 hours.

8. Determine and record the mass of the specimen (Mn).

9. Determine percent change by subtracting the new mass determination (Mn) from the previous mass determination (Mp) divide by the previous mass determination (Mp) multiply by 100.

10. Continue drying until there is less than 0.05 percent change in specimen mass after 2-hour drying intervals (constant mass).

11. Constant mass has been achieved, sample is defined as dry.


13. Determine and record the mass of the container and dry specimen to the nearest 0.1 g.

14. Determine and record the mass of the dry specimen to the nearest 0.1 g by subtracting the mass of the container from the mass determined in Step 13. Designate this mass as “A.”
Calculations - Method C (Rapid Test for Method A or B)

Complete the calculations as outlined in Methods A or B, as appropriate.

Report

- Results on forms approved by the agency
- Sample ID
- $G_{mb}$ to 0.001
- Absorption to 0.01 percent
- Method performed
PERFORMANCE EXAM CHECKLIST

BULK SPECIFIC GRAVITY OF COMPACTED HOT MIX ASPHALT (HMA) USING SATURATED SURFACE-DRY SPECIMENS
FOP FOR AASHTO T 166

Participant Name ______________________________ Exam Date ______________

Record the symbols “P” for passing or “F” for failing on each step of the checklist.

<table>
<thead>
<tr>
<th>Procedure Element</th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Method A:</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>1. Mass of dry sample in air determined.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>a. Dried overnight at 52 ±3°C (125 ±5°F) and at successive 2-hour intervals</td>
<td></td>
<td></td>
</tr>
<tr>
<td>to constant mass?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>b. Cooled in air to 25 ±5°C (77 ±9°F)?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>c. Dry mass determined to 0.1g?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>2. Water at the overflow?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>3. Balance zeroed?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>4. Immersed weight determined.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>a. Water at 25 ±1°C (77 ±1.8°F)?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>b. Immersed, shaken, on side, for 4 ±1 minutes?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>c. Immersed weight determined to 0.1g?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>5. Sample rapidly surface dried with damp towel and saturated surface dry (SSD)</td>
<td></td>
<td></td>
</tr>
<tr>
<td>mass determined to 0.1 g (entire operation performed within 15 seconds)?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>6. $G_{mb}$ calculated to 0.001?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>7. Absorption calculated to 0.01 percent</td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>Method B:</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>1. Specimen dried, cooled, and mass determined as in Method A?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>2. Saturated surface dry (SSD) mass determined to 0.1g.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>a. Immersed at least 10 minutes at 25 ±1°C (77 ±1.8°F)?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>b. Sample rapidly dried with damp towel?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>c. Specimen mass determined to 0.1 g?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>d. Any water that seeps from specimen included in mass?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>3. Mass of volumeter filled with distilled water at 25 ±1°C (77 ±1.8°F) determined?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>4. SSD specimen placed into volumeter and let stand for 1 minute?</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

OVER
### Procedure Element

<table>
<thead>
<tr>
<th>Procedure</th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>5. Temperature of water brought to 25 ±1°C (77 ±1.8°F) and volumeter covered, allowing some water to escape through the capillary bore of the tapered lid?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>6. Volumeter wiped dry, and mass of volumeter and contents determined?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>7. (G_{mb}) calculated to 0.001?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>8. Absorption calculated to 0.01 percent?</td>
<td>_____</td>
<td>_____</td>
</tr>
</tbody>
</table>

#### Method C/A:

1. Immersed weight determined.
   a. Water at 25 ±1°C (77 ±1.8°F)? _____ _____
   b. Immersed, shaken, on side, for 4 ±1 minutes? _____ _____
   c. Immersed weight determined to 0.1 g? _____ _____
2. Sample rapidly surface dried with damp cloth (within 5 seconds)? _____ _____
3. Saturated surface dry mass determined to 0.1 g? _____ _____
4. Dry mass determined by:
   a. Heating in oven at a minimum of 105°C (221°F)? _____ _____
   b. Breaking down to 6.3 mm (¼ in.) particles? _____ _____
   c. Drying in oven to constant mass (change less than 0.05 percent in 2 hours of additional drying)? _____ _____
   d. Cooled in air to 25 ±5°C (77 ±9°F) and mass determined to 0.1 g? _____ _____
5. \(G_{mb}\) calculated to 0.001? _____ _____
6. Absorption calculated to 0.01? _____ _____

#### Method C/B:

1. Saturated surface dry (SSD) mass determined to 0.1 g.
   a. Immersed at least 10 minutes at 25 ±1°C (77 ±1.8°F)? _____ _____
   b. Sample rapidly dried with damp towel (within 5 seconds)? _____ _____
   c. Specimen mass determined to 0.1 g? _____ _____
   d. Any water that seeps from specimen included in mass? _____ _____
2. Mass of volumeter filled with distilled water at 25 ±1°C (77 ±1.8°F) determined to 0.1 g? _____ _____
3. SSD specimen placed into volumeter and let stand for 1 minute? _____ _____
4. Temperature of water brought to 25 ±1°C (77 ±1.8°F) and volumeter covered, allowing some water to escape through the capillary pore of the tapered lid? _____ _____
5. Volumeter wiped dry, and mass of volumeter and contents determined to 0.1 g? _____ _____

**OVER**
### Procedure Element

<table>
<thead>
<tr>
<th></th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>6. Dry mass determined by:</td>
<td></td>
<td></td>
</tr>
<tr>
<td>a. Warming in oven at a minimum of 105°C (221°F)?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>b. Breaking down to 6.3 mm (¼ in.) particles?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>c. Drying in oven to constant mass (change less than 0.05 percent in 2 hours of additional drying)?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>d. Cooled in air to 25 ±5°C (77 ±9°F) and mass determined to 0.1 g?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>7. ( G_{mb} ) calculated to 0.001?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>8. Absorption calculated to 0.01 percent?</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

### Comments:

First attempt: Pass [ ] Fail [ ]
Second attempt: Pass [ ] Fail [ ]

Examiner Signature _______________________________ WAQTC #: ________________
FOP for AASHTO T 166 and AASHTO T 166

Bulk Specific Gravity of compacted Hot Mix Asphalt using Saturated Surface-Dry Specimens

Report.

Add the following:

- When specimens are produced using the FOP for AASHTO T 312 the result will be an average of two specimens.

- FOP for AASHTO T 312 developed specimens will have a surface temperature between 68° F and 80° F and must be documented on test forms. The use of a fan will aid in the process.

- When the two determinations vary by more than the 0.009 allowed, review testing procedures and check test equipment, including FOP for AASHTO T 312. Note any possible reasons for variation in the Remarks box of the ITD-777. Make adjustments to correct deficiencies as needed and perform the next random test. If these two determinations vary by less than the 0.009 allowed, no further action is required.

If the next two determinations still vary by more than the 0.009 allowed, the IA must evaluate the technician and equipment, etc. to determine the reason for the variation. The IA will document the findings of the investigation. Make adjustments to correct deficiencies as needed and perform the next random test.
SAMPLING OF BITUMINOUS PAVING MIXTURES
FOP FOR AASHTO T 168 (10)

Scope
This procedure covers the sampling of bituminous paving mixtures from HMA plants, haul units, and roadways in accordance with AASHTO T 168-03. Sampling is as important as testing, and every precaution must be taken to obtain a truly representative sample.

Apparatus
- Shovel
- Sample containers: such as cardboard boxes, metal cans, stainless steel bowls, or other agency-approved containers
- Scoops, trowels, or other equipment to obtain mix
- Sampling plate: Thick metal plate, minimum 8 gauge, sized to accommodate sample requirements, with a wire attached to one corner long enough to reach from the center of the paver to the outside of the farthest auger extension. Holes ¼ in. in diameter should be provided in each corner.
- Cookie cutter sampling device: Formed steel angle with two 100 mm by 150 mm by 9 mm (4 in. by 6 in. by 3/8 in.) handles, sized to accommodate sample requirements. Minimum 2 in. smaller than the sampling plate when used together.
  
  Example: Sampling plate 380 mm (15 in.) square and a cookie cutter sampling device 330 mm (13 in.) square.
- Mechanical sampling device

Sample Size
Sample size depends on the test methods specified by the agency for acceptance. Check agency requirement for the size required.

Sampling
General
- The material shall be tested to determine variations. The supplier/contractor shall provide equipment for safe and appropriate sampling, including sampling devices on plants when required.
• For dense graded mixture samples use cardboard boxes, stainless steel bowls or other agency-approved containers.

• For hot open graded mixture samples use stainless steel bowls. Do not put open graded mixture samples in boxes until they have cooled to the point that bituminous material will not migrate from the aggregate.

**Attached Sampling Devices**

Some agencies require mechanical sampling devices for hot mix asphalt (HMA) and cold feed aggregate on some projects. These are normally permanently attached devices that allow a sample container to pass perpendicularly through the entire stream of material or divert the entire stream of material into the container. Operation may be hydraulic, pneumatic, or manual and allows the sample container to pass through the stream twice, once in each direction, without overfilling. Special caution is necessary with manually operated systems since a consistent speed is difficult to maintain and non-representative samples may result. Check agency requirements for the specifics of required sampling systems.

1. Lightly coat the container attached to the sampling device with an agency-approved release agent or preheat it, or both, to approximately the same discharge temperature of the mix.

2. Pass the container twice through the material perpendicularly without overfilling the container.

3. Repeat until proper sample size has been obtained.

4. Transfer the HMA to an agency-approved container without loss of material.

**Sampling from Haul Units**

1. Visually divide the haul unit into approximately four equal quadrants.

2. Identify one sampling location in each quadrant.

3. Dig down and remove approximately 0.3 m (1 ft.) of material to avoid surface segregation. Obtain each increment from below this level.

4. Combine the increments to form a sample of the required size.

**Sampling from Roadway Prior to Compaction (Plate Method)**

Plate method using the “cookie cutter” sampling device.

There are two conditions that will be encountered when sampling hot mix asphalt (HMA) from the roadway prior to compaction. The two conditions are:
• Laying HMA on grade or untreated base material requires Method 1.

• Laying HMA on existing asphalt or laying a second lift of HMA requires Method 2.

**SAFETY:**

Sampling is performed behind the paving machine and in front of the breakdown roller. For safety, the roller must remain at least 3 m (10 ft.) behind the sampling operation until the sample has been taken and the hole filled with loose HMA.

Method 1 requires a plate to be placed in the roadway in front of the paving operation and therefore there is always concern with moving, operating equipment. It is safest to stop the paving train while a plate is installed in front of the paver. When this is not possible the following safety rules must be followed.

1. The plate placing operation must be at least 3 m (10 ft.) in front of the paver or pickup device. The technician placing the plate must have eye contact and communication with the paving machine operator. If eye contact cannot be maintained at all time, a third person must be present to provide communication between the operator and the technician.

2. No technician is to be between the asphalt supply trucks and the paving machine. The exception to this rule is if the supply truck is moving forward creating a windrow, in which case the technician must be at least 3 m (10 ft.) behind the truck.

If at any time the Engineer feels that the sampling technique is creating an unsafe condition, the operation is to be halted until it is made safe or the paving operation will be stopped while the plate is being placed.

**Method 1 - Obtaining a Sample on Untreated Base:**

1. Following the safety rules detailed above, the technician is to:

   a. Smooth out a location in front of the paver at least 0.5 m (2 ft.) inside the edge of the mat.

   b. Lay the plate down diagonally with the direction of travel, keeping it flat and tight to the base with the lead corner facing the paving machine.

2. Secure the plate in place by driving a nail through the hole in the lead corner of the plate.

3. Pull the wire, attached to the outside corner of the plate, taut past the edge of the HMA mat and secure with a nail.
4. Let the paving operation proceed over the plate and wire. Immediately proceed with the sampling.

5. Using the exposed end of the wire, pull the wire up through the fresh HMA to locate the corner of the plate. Place the “cookie cutter” sample device, just inside the end of the wire; align the cutter over the plate. Press “cookie cutter” device down through the HMA to the plate.

6. Using a small square tipped shovel or scoop, or both, carefully remove all the HMA from inside of the cutter and place in a sample container. Care shall be taken to prevent contamination of bituminous mixes by dust or other foreign matter, and to avoid segregation of aggregate and bituminous materials.

7. Remove the sample cutter and the plate from the roadway. The hole made from the sampling must be filled by the contractor with loose HMA.

Method 2 - Obtaining a Sample on Asphalt Surface:

1. After the paving machine has passed the sampling point, immediately place the “cookie cutter” sampling device on the location to be sampled. Push the cutter down through the HMA until it is flat against the underlying asphalt mat.

2. Using a small square tipped shovel or scoop, or both, carefully remove all the HMA from inside of the cutter and place in a sample container. The hole made from the sampling must be filled by the contractor with loose HMA.

Identification and Shipping

1. Identify sample containers as required by the agency.

2. Ship samples in containers that will prevent loss, contamination, or damage.

Report

- On forms approved by the agency
- Sample ID
- Date
- Time
- Location
- Quantity represented
**PERFORMANCE EXAM CHECKLIST**

**SAMPLING BITUMINOUS PAVING MIXTURES**
**FOP FOR AASHTO T 168**

Participant Name ______________________________ Exam Date ______________

Record the symbols “P” for passing or “F” for failing on each step of the checklist.

<table>
<thead>
<tr>
<th>Procedure Element</th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>1. Was sample taken with an attached sampling device correctly?</td>
<td>_______</td>
<td>_______</td>
</tr>
<tr>
<td>a. Container coated or preheated or both?</td>
<td>_______</td>
<td>_______</td>
</tr>
<tr>
<td>b. Sampling device passed through stream twice perpendicular to material?</td>
<td>_______</td>
<td>_______</td>
</tr>
<tr>
<td>c. Sampling device not over filled?</td>
<td>_______</td>
<td>_______</td>
</tr>
<tr>
<td>2. Samples from truck transports taken from four quadrants at required depth of 300 mm (12 in)?</td>
<td>_______</td>
<td>_______</td>
</tr>
<tr>
<td>3. Samples from roadway taken correctly with plate(s).</td>
<td>_______</td>
<td>_______</td>
</tr>
<tr>
<td>a. When on untreated base plate placed well in front of paver?</td>
<td>_______</td>
<td>_______</td>
</tr>
<tr>
<td>b. Wire pulled to locate plate corner?</td>
<td>_______</td>
<td>_______</td>
</tr>
<tr>
<td>c. Cookie cutter placed on asphalt and pushed through to plate?</td>
<td>_______</td>
<td>_______</td>
</tr>
<tr>
<td>d. All material removed from inside the cutter?</td>
<td>_______</td>
<td>_______</td>
</tr>
<tr>
<td>4. Sample placed in appropriate container.</td>
<td>_______</td>
<td>_______</td>
</tr>
<tr>
<td>5. Sample size meets agency requirements?</td>
<td>_______</td>
<td>_______</td>
</tr>
<tr>
<td>6. Sample identified as required?</td>
<td>_______</td>
<td>_______</td>
</tr>
</tbody>
</table>

Comments: First attempt: Pass____ Fail____ Second attempt: Pass____ Fail____

Examiner Signature ____________________________ WAQTC #:_______________
**PERFORMANCE EXAM CHECKLIST (ORAL)**

**SAMPLING BITUMINOUS PAVING MIXTURES**
**FOP FOR AASHTO T 168**

Participant Name ______________________________ Exam Date ______________

Record the symbols “P” for passing or “F” for failing on each step of the checklist.

<table>
<thead>
<tr>
<th>Procedure Element</th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>1. At the hot plant how must a sample be obtained using an attached sampling device?</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>a. Coat or preheat sample container.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>b. Sampling device passed through stream twice perpendicular to material.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>c. The sampling device cannot be overfilled.</td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>2. What must be done to sample from transport units?</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>a. Divide the unit into four quadrants.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>b. Obtain increments from each quadrant, 300 mm (12 in) below surface.</td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>3. Describe how to take samples from the roadway using a plate.</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>a. Place the plate well in front of the paver.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>b. Pull the wire to locate the corner of the plate.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>c. Place the cutter on the HMA above the plate and push it down to the plate.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>d. Collect all the material inside the cutter.</td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>4. What types of containers can be used?</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>a. Cardboard boxes, stainless steel bowls, or other agency approved containers.</td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>5. What dictates size of sample?</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>a. Agency requirements.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>b. Specified by test method.</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

Comments: First attempt: Pass____ Fail____ Second attempt: Pass____ Fail____

Examiner Signature ____________________________ WAQTC #:_________________
FOP for AASHTO T 168

Sampling of Bituminous Paving Mixtures

**Sampling from the Roadway Prior to Compaction (Plate Method).**

Add the following after Method 2:

**Method 3 - Obtaining Sample Without Cutter Device:** (When the sample container is large enough to accommodate the full dimensions of the sampling plate.)

1. Following the safety rules detailed above, the technician is to:
   a. Smooth out a location in front of the paver at least 2 ft. inside the edge of the mat.
   b. Lay the plate down diagonally with the direction of travel, keeping it flat and tight to the base with the lead corner facing the paving machine.
2. Secure the plate in place by driving a nail through the hole in the lead corner of the plate.
3. Pull the wire, attached to the outside corner of the plate, taut past the edge of the HMA mat and secure with a nail.
4. Let the paving operation proceed over the plate and wire. Immediately proceed with the sampling.
5. Using the exposed end of the wire, pull the wire up through the fresh HMA to locate the corner of the plate.
6. Lift the sampling plate and the HMA sample carefully placed directly into the sample container.
7. The hole made from the sampling must be filled by the Contractor with loose HMA.

**Identification and Shipping.**

Add the following:

3. After the loose mix sample is obtained, the sample must not be held in a hot oven greater than 200°F for more than 4 hours to avoid aging or oxidation. However, the sample may be held overnight as long as the oven temperature does not exceed 200 °F.
THEORETICAL MAXIMUM SPECIFIC GRAVITY ($G_{mm}$) AND DENSITY OF HOT MIX ASPHALT (HMA) PAVING MIXTURES
FOP FOR AASHTO T 209 (16)

Scope

This procedure covers the determination of the maximum specific gravity ($G_{mm}$) of uncompacted hot mix asphalt (HMA) paving mixtures in accordance with AASHTO T 209-12. Two methods using different containers—bowl and pycnometer/volumetric flask—are covered.

Specimens prepared in the laboratory shall be cured according to agency standards.

Apparatus

- Balance or scale: 10,000 g capacity, readable to 0.1 g
- Container: A glass, metal, or plastic bowl, pycnometer or volumetric flask between 2000 and 10,000 mL as required by the minimum sample size requirements in Table 1 sample and capable of withstanding a partial vacuum
- Pycnometer/volumetric flask cover: A glass plate or a metal or plastic cover with a vented opening
- Vacuum lid: A transparent lid with a suitable vacuum connection, with a vacuum opening to be covered with a fine wire mesh
- Vacuum pump or water aspirator: Capable of evacuating air from the container to a residual pressure of 4.0 kPa (30 mm Hg)
- Residual pressure manometer or vacuum gauge: Traceable to NIST and capable of measuring residual pressure down to 4.0 kPa (30 mm Hg) or less
- Manometer or vacuum gauge: Capable of measuring the vacuum being applied at the source of the vacuum
- Water bath: A constant-temperature water bath (optional)
- Thermometers: Standardized liquid-in-glass, or electronic digital total immersion type, accurate to 0.5°C (1°F)
- Bleeder valve to adjust vacuum
- Timer
Standardization of Pycnometer or Volumetric Flask

Use a pycnometer / volumetric flask that is standardized to accurately determine the mass of water, at 25 ±0.5°C (77 ±1°F), in the pycnometer / volumetric flask. The pycnometer / volumetric flask shall be standardized periodically in conformance with procedures established by the agency.

Test Sample Preparation

1. Obtain samples in accordance with the FOP for AASHTO T 168 and reduce according to the FOP for AASHTO R 47.

2. Test sample size shall conform to the requirements of Table 1. Samples larger than the capacity of the container may be tested in two or more increments. Results will be combined and averaged. If the increments have a specific gravity difference greater than 0.014 the test must be re-run.

<table>
<thead>
<tr>
<th>Nominal Maximum Aggregate Size</th>
<th>Minimum Mass</th>
</tr>
</thead>
<tbody>
<tr>
<td>mm (in.)</td>
<td>g</td>
</tr>
<tr>
<td>37.5 or greater (1 1/2)</td>
<td>4000</td>
</tr>
<tr>
<td>19 to 25 (3/4 to 1)</td>
<td>2500</td>
</tr>
<tr>
<td>12.5 or smaller (1/2)</td>
<td>1500</td>
</tr>
</tbody>
</table>

*Nominal maximum size: One sieve larger than the first sieve to retain more than 10 percent of the material using an agency specified set of sieves based on cumulative percent retained.

Procedure – General

Two procedures – bowl and pycnometer / volumetric flask – are covered. The first 11 steps are the same for both.

1. Separate the particles of the sample, taking care not to fracture the mineral particles, so that the particles of the fine aggregate portion are not larger than 6.3 mm (1/4 in.). If the mixture is not sufficiently soft to be separated manually, place it in a large flat pan and warm in an oven only until it is pliable enough for separation.

2. Cool the sample to room temperature.

3. Determine and record the mass of the dry container to the nearest 0.1 g.

4. Place the sample in the container.

5. Determine and record the mass of the dry container and sample to the nearest 0.1 g.

6. Determine and record the mass of the sample by subtracting the mass determined in Step 3 from the mass determined in Step 5. Designate this mass as “A.”
7. Add sufficient water at approximately 25° C (77° F) to cover the sample by about 25 mm (1 in.).

*Note 1:* The release of entrapped air may be facilitated by the addition of a wetting agent. Check with the agency to see if this is permitted and, if it is, for a recommended agent.

8. Place the lid on the container and attach the vacuum line. To ensure a proper seal between the container and the lid, wet the O-ring or use a petroleum gel.

9. Remove entrapped air by subjecting the contents to a partial vacuum of 3.7 ±0.3 kPa (27.5 ±2.5 mm Hg) residual pressure for 15 ±2 minutes.

10. Agitate the container and contents, either continuously by mechanical device or manually by vigorous shaking, at 2 minute intervals. This agitation facilitates the removal of air.

11. Release the vacuum, increasing the pressure to atmospheric pressure in 10 to 15 seconds, turn off the vacuum pump, and remove the lid. When performing the pycnometer / volumetric flask method, complete steps 12B through 16B within 10±1 minutes.

**Procedure – Bowl**

12A. Fill the water bath to overflow level with water at 25 ±1°C (77 ±2°F) and allow the water to stabilize.

13A. Zero or tare the balance with the immersion apparatus attached, ensuring that the device is not touching the sides or the bottom of the water bath.

14A. Suspend and immerse the bowl and contents in water at 25 ±1°C (77 ±2°F) for 10 ±1 minutes. The holder shall be immersed sufficiently to cover both it and the bowl.

15A. Determine and record the submerged weight of the bowl and contents to the nearest 0.1 g.

16A. Refill the water bath to overflow level.

17A. Empty and re-submerge the bowl following Step 12A to determine the submerged weight of the bowl to the nearest 0.1 g.

18A. Determine and record the submerged weight of the sample to the nearest 0.1 g by subtracting the submerged weight of the bowl from the submerged weight determined in Step 15A. Designate this submerged weight as “C.”
Procedure – Pycnometer or Volumetric Flask

12B. Immediately fill the pycnometer / volumetric flask with water without reintroducing air.

13B. Stabilize the temperature of the pycnometer / volumetric flask and contents so that the final temperature is within 25 ±1°C (77 ±2°F).

14B. Finish filling the pycnometer / volumetric flask with water that is 25 ±1°C (77 ±2°F), place the cover or a glass plate on the pycnometer / volumetric flask, and eliminate all air.

Note 2: When using a metal pycnometer and cover, place the cover on the pycnometer and push down slowly, forcing excess water out of the hole in the center of the cover. Use care when filling the pycnometer to avoid reintroducing air into the water.

15B. Towel dry the outside of the pycnometer / volumetric flask and cover.

16B. Determine and record the mass of the pycnometer / volumetric flask, cover, de-aired water, and sample to the nearest 0.1 g. within 10 ±1 minutes of completion of Step 11. Designate this mass as “E.”

Procedure – Mixtures Containing Uncoated Porous Aggregate

If the pores of the aggregates are not thoroughly sealed by a bituminous film, they may become saturated with water during the vacuuming procedure, resulting in an error in maximum density. To determine if this has occurred, complete the general procedure and then:

1. Carefully drain water from sample through a towel held over the top of the container to prevent loss of material.

2. Spread sample in a flat shallow pan and place before an electric fan to remove surface moisture.

3. Determine the mass of the sample when the surface moisture appears to be gone.

4. Continue drying and determine the mass of the sample at 15-minute intervals until less than a 0.5 g loss is found between determinations.

5. Record the mass as the saturated surface dry mass to the nearest 0.1 g. Designate this mass as “ASSD.”

6. Calculate, as indicated below, \( G_{mm} \) using “A” and “ASSD,” and compare the two values.
Calculation

Calculate the $G_{mm}$ to three decimal places as follows:

**Bowl Procedure**

$$G_{mm} = \frac{A}{A - C} \quad \text{or} \quad G_{mm} = \frac{A}{A_{SSD} - C}$$

(for mixes containing uncoated aggregate materials)

where:

- $A$ = mass of dry sample in air, g
- $A_{SSD}$ = Mass of saturated surface dry sample in air, g
- $C$ = submerged weight of sample in water, g

**Example:**

- $A = 1432.7$ g
- $A_{SSD} = 1434.2$ g
- $C = 848.6$ g

$$G_{mm} = \frac{1432.7 \text{ g}}{1432.7 \text{ g} - 848.6 \text{ g}} = 2.453 \quad \text{or} \quad G_{mm} = \frac{1432.7 \text{ g}}{1434.2 \text{ g} - 848.6 \text{ g}} = 2.447$$

**Pycnometer / Volumetric Flask Procedure**

$$G_{mm} = \frac{A}{A + D - E} \quad \text{or} \quad G_{mm} = \frac{A}{A_{SSD} + D - E}$$

(for mixtures containing uncoated materials)

where:

- $A$ = Mass of dry sample in air, g
- $A_{SSD}$ = Mass of saturated surface-dry sample in air, g
- $D$ = Mass of pycnometer / volumetric flask filled with water at 25°C (77°F), g, determined during the Standardization of Pycnometer / Volumetric Flask procedure
- $E$ = Mass of pycnometer / volumetric flask filled with water and the test sample at test temperature, g
Example (in which two increments of a large sample are averaged):

<table>
<thead>
<tr>
<th>Increment 1</th>
<th>Increment 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>A = 2200.3 g</td>
<td>A = 1960.2 g</td>
</tr>
<tr>
<td>D = 7502.5 g</td>
<td>D = 7525.5 g</td>
</tr>
<tr>
<td>E = 8812.0 g</td>
<td>E = 8690.8 g</td>
</tr>
<tr>
<td>Temperature = 26.2°C</td>
<td>Temperature = 25.0°C</td>
</tr>
</tbody>
</table>

\[ G_{m1} = \frac{2200.3 \ g}{2200.3 \ g + 7502.5 \ g - 8812.0 \ g} = 2.470 \]

\[ G_{m2} = \frac{1960.2 \ g}{1960.2 \ g + 7525.5 \ g - 8690.8 \ g} \times 1.00000 = 2.466 \]

Allowable variation is: 0.014

2.470 - 2.466 = 0.004, which is < 0.014, so they can be averaged.

Average

2.470 + 2.466 = 4.936 \ 4.936 \div 2 = 2.468
Theoretical Maximum Density

To calculate the theoretical maximum density at 25°C (77°F) use one of the following formulas. The density of water at 25°C (77°F) is 997.1 in Metric units or 62.245 in English units.

Theoretical maximum density kg/m³ = Gmm × 997.1 kg/m³

2.468 × 997.1 kg/m³ = 2461 kg/m³

or

Theoretical maximum density lb/ft³ = Gmm × 62.245 lb/ft³

2.468 × 62.245 lb/ft³ = 153.6 lb/ft³

Report

- Results on forms approved by the agency
- Sample ID
- Gmm to three decimal places
- Theoretical maximum density to 1 kg/m³ (0.1 lb/ft³)
PERFORMANCE EXAM CHECKLIST

THEORETICAL MAXIMUM SPECIFIC GRAVITY AND DENSITY OF HOT MIX ASPHALT (HMA) PAVING MIXTURES
FOP FOR AASHTO T 209

Participant Name ______________________________ Exam Date ______________

Record the symbols “P” for passing or “F” for failing on each step of the checklist.

<table>
<thead>
<tr>
<th>Procedure Element</th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>1. Sample reduced to correct size?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>2. Particles carefully separated insuring that aggregate is not fractured?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>3. After separation, fine aggregate particles not larger than 6.3 mm (1/4 in.)?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>4. Sample at room temperature?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>5. Mass of container determined to 0.1 g?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>6. Mass of sample and container determined to 0.1 g?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>7. Mass of sample calculated and conforms to required size?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>8. Water at approximately 25°C (77°F) added to cover sample?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>9. Entrapped air removed using partial vacuum for 15 ±2 min?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>10. Container and contents agitated continuously by mechanical device</td>
<td></td>
<td></td>
</tr>
<tr>
<td>or manually by vigorous shaking at intervals of about 2 minutes?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>11. Bowl determination:</td>
<td></td>
<td></td>
</tr>
<tr>
<td>a. Water bath filled to the overflow level?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>b. Bowl and contents suspended in water at 25 ±1°C (77 ±2°F) for 10 ±1 minutes?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>c. Submerged weight of bowl and contents determined to 0.1 g?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>d. Submerged weight of empty bowl determined to 0.1 g?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>e. Net submerged weight of contents calculated?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>12. Pycnometer / Volumetric Flask determination:</td>
<td></td>
<td></td>
</tr>
<tr>
<td>a. Pycnometer / volumetric flask filled with water without reintroducing air into</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>the sample?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>b. Contents stabilized at 25 ±1°C (77 ±2°F)</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>c. Pycnometer / volumetric flask completely filled with water that is 25 ±1°C</td>
<td></td>
<td></td>
</tr>
<tr>
<td>(77 ±2°F)?</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

OVER
### Procedure Element

<table>
<thead>
<tr>
<th>Procedure Element</th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>d. Mass of filled pycnometer / volumetric flask and cover determined to 0.1 g, 10 ±1 minutes after removal of entrapped air completed?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>e. Mass of pycnometer / volumetric flask, cover, and water obtained from the Standardization of Pycnometer or Volumetric Flask procedure?</td>
<td>_____</td>
<td>_____</td>
</tr>
</tbody>
</table>

13. G_mm calculated correctly and reported to 0.001? | _____   | _____   |

14. Density calculated correctly and reported to 1 kg/m³ (0.1 lb/ft³)? | _____   | _____   |

### Comments:

<table>
<thead>
<tr>
<th>First attempt: Pass Fail</th>
<th>Second attempt: Pass Fail</th>
</tr>
</thead>
<tbody>
<tr>
<td>________________________</td>
<td>________________________</td>
</tr>
<tr>
<td>________________________</td>
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<td>________________________</td>
<td>________________________</td>
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<tr>
<td>________________________</td>
<td>________________________</td>
</tr>
</tbody>
</table>

Examiner Signature _______________________________ WAQTC #: _______________
AASHTO T 209

Theoretical Maximum Specific Gravity and Density of Hot-Mix Asphalt Paving Mixtures

- **9. Sample Preparation.**

  Add the following:

  All laboratory developed mix samples will be conditioned per AASHTO R30 (Mixture Conditioning of Hot Mix Asphalt) for two hours plus or minus 5 minutes at the asphalt binder manufactures recommended temperature for compaction.

**FOP for AASHTO T 209 and AASHTO T 209**

The final test result will be determined from an average of two specimens.

When the two determinations vary by more than the 0.014 allowed, review testing procedures, check test equipment and note any possible reasons for variation in the Remarks box of the ITD-777. Make adjustments to correct deficiencies as needed and perform the next random test. If these two determinations vary by less than the 0.014 allowed, no further action is required.

If the next two determinations still vary by more than the 0.014 allowed, the IA must evaluate the technician and equipment, etc. to determine the reason for the variation. The IA will document the findings of the investigation. Make adjustments to correct deficiencies as needed and perform the next random test.
DETERMINING THE ASPHALT BINDER CONTENT OF HOT MIX ASPHALT (HMA) BY THE IGNITION METHOD
FOP FOR AASHTO T 308 (16)

Scope

This procedure covers the determination of asphalt binder content of hot mix asphalt (HMA) by ignition of the binder in accordance with AASHTO T 308-16.

Overview

The sample is heated in a furnace at 538°C (1000°F) or less; samples may be heated by convection or direct infrared irradiation (IR). The aggregate remaining after burning can be used for sieve analysis using the FOP for AASHTO T 30.

Some agencies allow the use of recycled HMA. When using recycled HMA, check with the agency for specific correction procedures.

Asphalt binder in the HMA is ignited in a furnace. Asphalt binder content is calculated as the percentage difference between the initial mass of the HMA and the mass of the residual aggregate, with the asphalt binder correction factor, and moisture content subtracted. The asphalt binder content is expressed as percent of moisture-free mix mass.

Two methods, A and B, are presented.

Apparatus

Note 1: The apparatus must be calibrated for the specific mix design. See “Correction Factors” at the end of this FOP.

There are two methods – A and B. The apparatus for the two methods are the same except that the furnace for Method A has an internal balance.

- Ignition Furnace: A forced-air ignition furnace that heats the specimens by either the convection or direct IR irradiation method. The convection-type furnace must be capable of maintaining the temperature at 538 ± 5°C (1000 ± 9°F).

For Method A, the furnace will be equipped with an internal scale thermally isolated from the furnace chamber and accurate to 0.1 g. The scale shall be capable of determining the mass of a 3500 g sample in addition to the sample baskets. A data collection system will be included so that mass can be automatically determined and displayed during the test. The furnace shall have a built-in computer program to calculate the change in mass of the sample baskets and provide for the input of a correction factor for aggregate loss. The furnace shall provide a printed ticket with the initial specimen mass, specimen mass loss, temperature compensation, correction factor, corrected binder content, test time, and test temperature. The furnace shall provide an
audible alarm and indicator light when the sample mass loss does not exceed 0.01 percent of the total sample mass for three consecutive minutes.

*Note 2:* The furnace shall be designed to permit the operator to change the ending mass loss percentage from 0.01 percent to 0.02 percent.

For both Method A and Method B, the furnace chamber dimensions shall be adequate to accommodate a 3500 g sample. The furnace door shall be equipped so that it cannot be opened during the ignition test. A method for reducing furnace emissions shall be provided and the furnace shall be vented so that no emissions escape into the laboratory. The furnace shall have a fan to pull air through the furnace to expedite the test and to eliminate the escape of smoke into the laboratory.

- **Sample Basket Assembly:** consisting of sample basket(s), catch pan, and basket guards. Sample basket(s) will be of appropriate size allowing samples to be thinly spread and allowing air to flow through and around the sample particles. Sets of two or more baskets shall be nested. A catch pan: of sufficient size to hold the sample basket(s) so that aggregate particles and melting binder falling through the screen mesh are caught. Basket guards will completely enclose the basket and be made of screen mesh, perforated stainless steel plate, or other suitable material.

- **Thermometer,** or other temperature measuring device, with a temperature range of 10 - 260°C (50-500°F).

- **Oven capable of maintaining** 110 ±5°C (230 ±9°F).

- **Balance or scale:** Capacity sufficient for the sample mass and conforming to the requirements of M 231, Class G2.

- **Safety equipment:** Safety glasses or face shield, high temperature gloves, long sleeved jacket, a heat resistant surface capable of withstanding 650°C (1202°F), a protective cage capable of surrounding the sample baskets during the cooling period, and a particle mask for use during removal of the sample from the basket assembly.

- **Miscellaneous equipment:** A pan larger than the sample basket(s) for transferring sample after ignition, spatulas, bowls, and wire brushes.

**Sampling**

1. Obtain samples of HMA in accordance with the FOP for AASHTO T 168.

2. Reduce HMA samples in accordance with the FOP for AASHTO R 47.

3. If the mixture is not sufficiently soft to separate with a spatula or trowel, place it in a large flat pan in an oven at 110 ±5°C (230 ±9°F) until soft enough.
4. Test sample size shall conform to the mass requirement shown in Table 1.

**Note 3:** When the mass of the test specimen exceeds the capacity of the equipment used or for large samples of fine mixes, the test specimen may be divided into suitable increments, tested, and the results appropriately combined through a weighted average for calculation of the binder content.

<table>
<thead>
<tr>
<th>Nominal Maximum Aggregate Size* (mm in.)</th>
<th>Minimum Mass Specimen (g)</th>
<th>Maximum Mass Specimen (g)</th>
</tr>
</thead>
<tbody>
<tr>
<td>37.5 (1 ½)</td>
<td>4000</td>
<td>4500</td>
</tr>
<tr>
<td>25.0 (1)</td>
<td>3000</td>
<td>3500</td>
</tr>
<tr>
<td>19.0 (3/4)</td>
<td>2000</td>
<td>2500</td>
</tr>
<tr>
<td>12.5 (1/2)</td>
<td>1500</td>
<td>2000</td>
</tr>
<tr>
<td>9.5 (3/8)</td>
<td>1200</td>
<td>1700</td>
</tr>
<tr>
<td>4.75 (No. 4)</td>
<td>1200</td>
<td>1700</td>
</tr>
</tbody>
</table>

* One sieve larger than the first sieve to retain more than 10 percent of the material using an agency specified set of sieves based on cumulative percent retained. Where large gaps in specification sieves exist, intermediate sieve(s) may be inserted to determine nominal maximum size.

**Procedure – Method A (Internal Balance)**

1. For the convection-type furnace, preheat the ignition furnace to 538 ± 5°C (1000 ± 9°F) or to the temperature determined in the “Correction Factor” section, Step 9 of this method. Manually record the furnace temperature (set point) prior to the initiation of the test if the furnace does not record automatically. For the direct IR irradiation-type furnace, use the same burn profile as used during the correction factor determination.

2. Dry the sample to constant mass, according to the FOP for AASHTO T 329; or determine the moisture content of a companion sample in accordance with the FOP for AASHTO T 329.

3. Determine and record the mass to the nearest 0.1 g of the sample basket assembly.

4. Evenly distribute the sample in the sample basket assembly, taking care to keep the material away from the edges of the basket. Use a spatula or trowel to level the sample.

5. Determine and record the total mass of the sample and sample basket assembly to the nearest 0.1 g. Calculate and record the initial mass of the sample (total mass minus the mass of the sample basket assembly) to the nearest 0.1 g. Designate this mass as \((M_i)\).

6. Record the correction factor or input into the furnace controller for the specific HMA.

7. Input the initial mass of the sample \((M_i)\) into the ignition furnace controller. Verify that the correct mass has been entered.
8. Open the chamber door and gently set the sample basket assembly in the furnace. Carefully position the sample basket assembly so it is not in contact with the furnace wall. Close the chamber door and verify that the sample mass displayed on the furnace scale equals the total mass of the sample and sample basket assembly recorded in Step 5 within ±5 g.

*Note 4:* Furnace temperature will drop below the set point when the door is opened, but will recover when the door is closed and ignition begins. Sample ignition typically increases the temperature well above the set point – relative to sample size and binder content.

9. Initiate the test by pressing the start button. This will lock the sample chamber and start the combustion blower.

*Safety note:* Do not attempt to open the furnace door until the asphalt binder has been completely burned off.

10. Allow the test to continue until the stable light and audible stable indicator indicate that the change in mass does not exceed 0.01 percent for three consecutive minutes. Press the stop button. This will unlock the sample chamber and cause the printer to print out the test results.

*Note 5:* An ending mass loss percentage of 0.02 may be used, if allowed by the agency, when aggregate that exhibits an excessive amount of loss during ignition testing is used.

11. Open the chamber door, remove the sample basket assembly, and place on the cooling plate or block. Place the protective cage over the sample basket assembly and allow it to cool to room temperature (approximately 30 minutes).

12. Determine and record the total after ignition mass to the nearest 0.1 g. Calculate and record the mass of the sample, after ignition (total after ignition mass minus the mass of the sample basket assembly) to the nearest 0.1 g. Designate this mass as $M_f$.

13. Use the asphalt binder content percentage from the printed ticket. Subtract the moisture content from the printed ticket asphalt binder content and report the difference as the corrected asphalt binder content.

14. Asphalt binder content percentage can also be calculated using the formula from “Method B” Step 16.
Calculation

Corrected asphalt binder content:

\[ P_b = BC - MC - C_f \]  
(if not input in the furnace controller)

where:

- \( P_b \) = the corrected asphalt binder content as a percent by mass of the HMA
- \( BC \) = asphalt binder content shown on printed ticket
- \( MC \) = moisture content of the companion HMA sample, percent, as determined by the FOP for AASHTO T 329 (if the specimen was oven-dried prior to initiating the procedure, MC=0)
- \( C_f \) = correction factor as a percent by mass of the HMA sample

Procedure – Method B (External Balance)

1. Preheat the ignition furnace to 538 ± 5°C (1000 ± 9°F) or to the temperature determined in the “Correction Factor” section, Step 9 of this method. Manually record the furnace temperature (set point) prior to the initiation of the test if the furnace does not record automatically.

2. Dry the sample to constant mass, according to the FOP for AASHTO T 329; or determine the moisture content of a companion sample in accordance with the FOP for AASHTO T 329.

3. Determine and record the mass of the sample basket assembly to the nearest 0.1 g.

4. Place the sample basket(s) in the catch pan. Evenly distribute the sample in the sample basket(s), taking care to keep the material away from the edges of the basket. Use a spatula or trowel to level the sample.

5. Determine and record the total mass of the sample and sample basket assembly to the nearest 0.1 g. Calculate and record the initial mass of the sample (total mass minus the mass of the sample basket assembly) to the nearest 0.1 g. Designate this mass as \( M_i \).

6. Record the correction factor for the specific HMA.

7. Open the chamber door and gently set the sample basket assembly in the furnace. Carefully position the sample basket assembly so it is not in contact with the furnace wall. Burn the HMA sample in the furnace for 45 minutes or the length of time determined in the “Correction Factors” section.
8. Open the chamber door, remove the sample basket assembly, and place on the cooling plate or block. Place the protective cage over the sample and allow it to cool to room temperature (approximately 30 min).

9. Determine and record the total after ignition mass to the nearest 0.1 g. Calculate and record the mass of the sample, after ignition (total after ignition mass minus the mass of the sample basket assembly) to the nearest 0.1 g.

10. Place the sample basket assembly back into the furnace.

11. Burn the sample for at least 15 minutes after the furnace reaches the set temperature.

12. Open the chamber door, remove the sample basket assembly, and place on the cooling plate or block. Place the protective cage over the sample basket assembly and allow it to cool to room temperature (approximately 30 min.).

13. Determine and record the total after ignition mass to the nearest 0.1 g. Calculate and record the mass of the sample, after ignition (total after ignition mass minus the mass of the sample basket assembly) to the nearest 0.1 g.

14. Repeat Steps 10 through 13 until the change in measured mass of the sample after ignition does not exceed 0.01 percent of the previous sample mass after ignition.

   **Note 6:** An ending mass loss percentage of 0.02 may be used, if allowed by the agency, when aggregate that exhibits an excessive amount of loss during ignition testing is used.

15. Determine and record the total after ignition mass to the nearest 0.1 g. Calculate and record the mass of the sample, after ignition (total after ignition mass minus the mass of the sample basket assembly) to the nearest 0.1 g. Designate this mass as Mf.

16. Calculate the asphalt binder content of the sample.
Calculations

Calculate the asphalt binder content of the sample as follows:

\[ P_b = \frac{M_i - M_f}{M_i} \times 100 - MC - C_f \]

where:
- \( P_b \) = the corrected asphalt binder content as a percent by mass of the HMA sample
- \( M_f \) = the final mass of aggregate remaining after ignition
- \( M_i \) = the initial mass of the HMA sample prior to ignition
- \( MC \) = moisture content of the companion HMA sample, percent, as determined by the FOP for AASHTO T 329 (if the specimen was oven-dried prior to initiating the procedure, \( MC = 0 \)).
- \( C_f \) = correction factor as a percent by mass of the HMA sample

Example

Correction Factor = 0.42%
Moisture Content = 0.04%
Initial Mass of Sample and Basket = 5292.7 g
Mass of Basket Assembly = 2931.5 g
\( M_i = 2361.2 \text{ g} \)
Total Mass after First ignition + basket = 5154.4 g
Sample Mass after First ignition = 2222.9 g
Sample Mass after additional 15 min ignition = 2222.7 g

\[ \frac{2222.9 \text{ g} - 2222.7 \text{ g}}{2222.9 \text{ g}} \times 100 = 0.009\% \]

Not greater than 0.01 percent, so \( M_f = 2222.7 \text{ g} \)
\[ P_b = \frac{2361.2 \, g - 2222.7 \, g}{2361.2 \, g} \times 100 - 0.42\% - 0.04\% = 5.41\% \]

1. Empty contents of the basket(s) into a flat pan, being careful to capture all material. Use a small wire brush to ensure all residual fines are removed from the baskets.

*Note 7:* Particle masks are a recommended safety precaution.

2. Perform the gradation analysis in accordance with the FOP for AASHTO T 30.

**Report**

- Results on forms approved by the agency
- Sample ID
- Method of test (A or B)
- Corrected asphalt binder content, \( P_b \), per agency standard
- Correction factor, \( C_f \), to 0.01 percent
- Temperature compensation factor (if applicable)
- Total percent loss
- Sample mass
- Moisture content to 0.01%
- Test temperature

Attach the original printed ticket with all intermediate values (continuous tape) to the report for furnaces with internal balances.
Annex – Correction Factors

(Mandatory Information)

Asphalt Binder and Aggregate

Asphalt binder content results may be affected by the type of aggregate in the mixture and by the ignition furnace. Asphalt binder and aggregate correction factors must, therefore, be established by testing a set of correction specimens for each Job Mix Formula (JMF) mix design. Each ignition furnace will have its own unique correction factor determined in the location where testing will be performed.

This procedure must be performed before any acceptance testing is completed, and repeated each time there is a change in the mix ingredients or design. Any changes greater than 5 percent in stockpiled aggregate proportions should require a new correction factor.

Historical data or scientific studies may be used to determine the correction factor(s) in lieu of using this testing procedure if the testing agency provides reference to the studies/data. All correction samples will be prepared by a central / regional laboratory unless otherwise directed.

Asphalt binder correction factor: A correction factor must be established by testing a set of correction specimens for each Job Mix Formula (JMF). Certain aggregate types may result in unusually high correction factors (> 1.00 percent). Such mixes should be corrected and tested at a lower temperature as described below.

Aggregate correction factor: Due to potential aggregate breakdown during the ignition process, a correction factor will need to be determined for the following conditions:

a. Aggregates that have a proven history of excessive breakdown
b. Aggregate from an unknown source.

This correction factor will be used to adjust the acceptance gradation test results obtained according to the FOP for AASHTO T 30.

Procedure

1. Obtain samples of aggregate in accordance with the FOP for AASHTO T 2.

2. Obtain samples of asphalt binder in accordance with the FOP for AASHTO R 66.
   
   Note 8: Include other additives that may be required by the JMF.

3. Prepare an initial, or “butter,” mix at the design asphalt binder content. Mix and discard the butter mix prior to mixing any of the correction specimens to ensure accurate asphalt content.
4. Prepare two correction specimens at the JMF design asphalt binder content. Aggregate used for correction specimens shall be sampled from material designated for use on the project. An agency approved method will be used to combine aggregate. An additional “blank” specimen shall be batched and tested for aggregate gradation in accordance with the FOP for AASHTO T 30. The gradation from the “blank” shall fall within the agency specified mix design tolerances.

5. Place the freshly mixed specimens directly into the sample basket assembly. If mixed specimens are allowed to cool prior to placement in the sample basket assembly, the specimens must be dried to constant mass according to the FOP for AASHTO T 329. Do not preheat the sample basket assembly.

6. Test the specimens in accordance with Method A or Method B of the procedure.

7. Once both of the correction specimens have been burned, determine the asphalt binder content for each specimen by calculation or from the printed oven tickets, if available.

8. If the difference between the asphalt binder contents of the two specimens exceeds 0.15 percent, repeat with two more specimens and, from the four results, discard the high and low result. Determine the correction factor from the two original or remaining results, as appropriate. Calculate the difference between the actual and measured asphalt binder contents for each specimen to 0.01 percent. The asphalt binder correction factor, $C_f$, is the average of the differences expressed as a percent by mass of HMA.

9. If the asphalt binder correction factor exceeds 1.00 percent, the test temperature must be lowered to $482 \pm 5^\circ C (900 \pm 9^\circ F)$ and new samples must be burned. The temperature for determining the asphalt binder content of HMA samples by this procedure shall be the same temperature determined for the correction samples.

10. For the direct IR irradiation-type burn furnaces, the default burn profile should be used for most materials. The operator may select burn-profile Option 1 or Option 2 to optimize the burn cycle. The burn profile for testing HMA samples shall be the same burn profile selected for correction samples.

    **Option 1** is designed for aggregate that requires a large asphalt binder correction factor (greater than 1.00 percent) – typically very soft aggregate (such as dolomite).

    **Option 2** is designed for samples that may not burn completely using the default burn profile.

11. Perform a gradation analysis on the residual aggregate in accordance with the FOP for AASHTO T 30, if required. The results will be utilized in developing an “Aggregate Correction Factor” and should be calculated and reported to 0.1 percent.
12. From the gradation results subtract the percent passing for each sieve, for each sample, from the percent passing each sieve of the “Blank” specimen gradation results from Step 4.

13. Determine the average difference of the two values. If the difference for any single sieve exceeds the allowable difference of that sieve as listed in Table 2, then aggregate gradation correction factors (equal to the resultant average differences) for all sieves shall be applied to all acceptance gradation test results determined by the FOP for AASHTO T 30. If the 75 µm (No. 200) is the only sieve outside the limits in Table 2, apply the aggregate correction factor to only the 75 µm (No. 200) sieve.

Table 2: Permitted Sieving Difference

<table>
<thead>
<tr>
<th>Sieve</th>
<th>Allowable Difference</th>
</tr>
</thead>
<tbody>
<tr>
<td>Sizes larger than or equal to 2.36 mm (No.8)</td>
<td>± 5.0%</td>
</tr>
<tr>
<td>Sizes larger than to 75 µm (No.200) and smaller than 2.36 mm (No.8)</td>
<td>± 3.0%</td>
</tr>
<tr>
<td>Sizes 75 µm (No.200) and smaller</td>
<td>± 0.5%</td>
</tr>
</tbody>
</table>

Examples:

<table>
<thead>
<tr>
<th>Sieve Size mm (in.)</th>
<th>Correction Factor Blank Sample % Passing</th>
<th>Correction Factor Sample #1 % Passing</th>
<th>Correction Factor Sample #2 % Passing</th>
<th>Difference 1/2</th>
<th>Avg. Diff.</th>
<th>Sieves to adjust</th>
</tr>
</thead>
<tbody>
<tr>
<td>19.0 (3/4)</td>
<td>100</td>
<td>100</td>
<td>100</td>
<td>0/0</td>
<td>0.0</td>
<td></td>
</tr>
<tr>
<td>12.5 (1/2)</td>
<td>86.3</td>
<td>87.4</td>
<td>86.4</td>
<td>-1.1/-0.1</td>
<td>-0.6</td>
<td></td>
</tr>
<tr>
<td>9.5 (3/8)</td>
<td>77.4</td>
<td>76.5</td>
<td>78.8</td>
<td>+0.9/-1.4</td>
<td>-0.2</td>
<td></td>
</tr>
<tr>
<td>4.75 (No. 4)</td>
<td>51.5</td>
<td>53.6</td>
<td>55.9</td>
<td>-2.1/-4.4</td>
<td>-3.2</td>
<td></td>
</tr>
<tr>
<td>2.36 (No. 8)</td>
<td>34.7</td>
<td>36.1</td>
<td>37.2</td>
<td>-1.4/-2.5</td>
<td>-2.0</td>
<td></td>
</tr>
<tr>
<td>01.18 (No. 16)</td>
<td>23.3</td>
<td>25.0</td>
<td>23.9</td>
<td>-1.7/-0.6</td>
<td>-1.2</td>
<td></td>
</tr>
<tr>
<td>0.600 (No. 30)</td>
<td>16.4</td>
<td>19.2</td>
<td>18.1</td>
<td>-2.8/-1.7</td>
<td>-2.2</td>
<td></td>
</tr>
<tr>
<td>0.300 (No. 50)</td>
<td>12.0</td>
<td>11.1</td>
<td>12.7</td>
<td>+0.9/-0.7</td>
<td>+0.1</td>
<td></td>
</tr>
<tr>
<td>0.150 (No. 100)</td>
<td>8.1</td>
<td>9.9</td>
<td>6.3</td>
<td>-1.8/+1.8</td>
<td>0.0</td>
<td></td>
</tr>
<tr>
<td>75 µm (No. 200)</td>
<td>5.5</td>
<td>5.9</td>
<td>6.2</td>
<td>-0.4/-0.7</td>
<td>-0.6</td>
<td>-0.6</td>
</tr>
</tbody>
</table>

In this example, all gradation test results performed on the residual aggregate (FOP for AASHTO T 30) would have an aggregate correction factor applied to the percent passing the 75 µm (No. 200) sieve. The correction factor must be applied because the average difference on the 75 µm (No. 200) sieve is outside the tolerance from Table 2.
In the following example, aggregate correction factors would be applied to each sieve because the average difference on the 4.75 mm (No. 4) is outside the tolerance from Table 2.

<table>
<thead>
<tr>
<th>Sieve Size</th>
<th>Correction Factor Blank Sample % Passing</th>
<th>Correction Factor Sample #1 % Passing</th>
<th>Correction Factor Sample #2 % Passing</th>
<th>Difference 1 / 2</th>
<th>Avg. Diff.</th>
<th>Sieves to adjust</th>
</tr>
</thead>
<tbody>
<tr>
<td>19.0 (3/4)</td>
<td>100</td>
<td>100</td>
<td>100</td>
<td>0/0</td>
<td>0.0</td>
<td>0.0</td>
</tr>
<tr>
<td>12.5 (1/2)</td>
<td>86.3</td>
<td>87.4</td>
<td>86.4</td>
<td>-0.1/-0.1</td>
<td>-0.6</td>
<td>-0.6</td>
</tr>
<tr>
<td>9.5  (3/8)</td>
<td>77.4</td>
<td>76.5</td>
<td>78.8</td>
<td>+0.9/-1.4</td>
<td>-0.2</td>
<td>-0.2</td>
</tr>
<tr>
<td>4.75 (No. 4)</td>
<td>51.5</td>
<td>55.6</td>
<td>57.9</td>
<td>-4.1/-6.4</td>
<td>-5.2</td>
<td>-5.2</td>
</tr>
<tr>
<td>2.36 (No. 8)</td>
<td>34.7</td>
<td>36.1</td>
<td>37.2</td>
<td>-1.4/-2.5</td>
<td>-2.0</td>
<td>-2.0</td>
</tr>
<tr>
<td>0.600 (No. 16)</td>
<td>23.3</td>
<td>25.0</td>
<td>23.9</td>
<td>-1.7/-0.6</td>
<td>-1.2</td>
<td>-1.2</td>
</tr>
<tr>
<td>0.300 (No. 50)</td>
<td>16.4</td>
<td>19.2</td>
<td>18.1</td>
<td>-2.8/-1.7</td>
<td>-2.2</td>
<td>-2.2</td>
</tr>
<tr>
<td>0.150 (No. 100)</td>
<td>12.0</td>
<td>11.1</td>
<td>12.7</td>
<td>+0.9/-0.7</td>
<td>+0.1</td>
<td>+0.1</td>
</tr>
<tr>
<td>0.150 (No. 100)</td>
<td>8.1</td>
<td>9.9</td>
<td>6.3</td>
<td>-1.8/+1.8</td>
<td>0.0</td>
<td>0.0</td>
</tr>
<tr>
<td>75 µm (No. 200)</td>
<td>5.5</td>
<td>5.9</td>
<td>6.2</td>
<td>-0.4/-0.7</td>
<td>-0.6</td>
<td>-0.6</td>
</tr>
</tbody>
</table>
PERFORMANCE EXAM CHECKLIST

DETERMINING THE ASPHALT BINDER CONTENT OF HOT MIX ASPHALT (HMA) BY THE IGNITION METHOD
FOP FOR AASHTO T 308

Participant Name ______________________________ Exam Date ______________

Record the symbols “P” for passing or “F” for failing on each step of the checklist.

<table>
<thead>
<tr>
<th>Procedure Element</th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>1. Oven at correct temperature 538 ± 5°C (1000 ± 9°F) or correction factor temperature?</td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>Or: for IR ovens, correct burn profile applied?</td>
<td></td>
</tr>
<tr>
<td>2. Sample reduced to correct size?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>3. HMA sample or companion moisture sample taken and dried per FOP for AASHTO T 329?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>4. Mass of sample basket assembly recorded to 0.1 g?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>5. With pan below basket(s) sample evenly distributed in basket(s)?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>6. Sample conforms to the required mass and mass recorded to 0.1 g?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>7. Method A</td>
<td></td>
<td></td>
</tr>
<tr>
<td>a. Initial mass entered into furnace controller?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>b. Sample correctly placed into furnace?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>c. Test continued until stable indicator signals?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>d. Uncorrected asphalt binder content obtained on printed ticket?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>e. Sample mass determined to nearest 0.1 g.?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>8. Method B</td>
<td></td>
<td></td>
</tr>
<tr>
<td>a. Sample correctly placed into furnace?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>b. Sample burned for 45 min or time determined by correction process?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>c. Sample cooled to room temperature?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>d. Sample burned to constant mass?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>e. Sample mass determined to nearest 0.1 g.?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>f. Uncorrected asphalt binder content calculated correctly and recorded?</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

OVER
<table>
<thead>
<tr>
<th>Procedure Element</th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>9. Asphalt binder content corrected for Correction Factor if needed?</td>
<td>____</td>
<td>____</td>
</tr>
<tr>
<td>10. Asphalt binder content corrected for moisture per the FOP for AASHTO T 329 if needed?</td>
<td>____</td>
<td>____</td>
</tr>
<tr>
<td>11. Corrected asphalt binder content recorded?</td>
<td>____</td>
<td>____</td>
</tr>
<tr>
<td>12. Contents of the basket(s) carefully emptied into a pan?</td>
<td>____</td>
<td>____</td>
</tr>
</tbody>
</table>

Comments: First attempt: Pass Fail____ Second attempt: Pass Fail____

Examiner Signature _______________________________ WAQTC #: ______________
FOP for AASHTO T 308

Determining the Asphalt Binder Content of Hot Mix Asphalt (HMA) by the Ignition Method

**Apparatus.**

Add the following:

- **Ignition furnace:** The testing laboratory owner must perform the Ignition Furnace Verification Procedure as outlined in the ITD Laboratory Qualification Program. The lift test will be performed and recorded weekly when the furnace is in use. The balance verification will be performed and recorded every 30 days when the furnace is in use and following furnace transport.

**Procedure – Method A (Internal Balance).**

Delete Step 14 and Substitute the following:


15. Compare the results from steps 13 & 14. If the calculated asphalt binder content is within 0.15% use the corrected asphalt binder content (percent) from the printed ticket. If the difference is greater than 0.15% use the calculated asphalt binder content (percent) and determine and correct the source of the variation prior to reliance on the printed ticket.

**Annex – Correction Factors.**

Add the following to **Procedure, Step 4:**

Combining Aggregates for Producing Calibration Factor Samples All samples shall be the same gradation and shall be combined sieve by sieve down to and including the material passing the No. 200 sieve.
ASPHALT MIXTURE SPECIMENS BY MEANS OF THE SUPERPAVE GYRATORY COMPACTOR FOP FOR AASHTO T 312 (16)

Scope
This procedure covers preparing specimens, using samples of plant produced asphalt mixtures, for determining the mechanical and volumetric properties of asphalt mixtures in accordance with AASHTO T 312-15.

Apparatus
• Superpave Gyratory Compactor (SGC) meeting the requirements of AASHTO T 312
• Molds meeting the requirements of AASHTO T 312
• Chute, mold funnel or both (Optional)
• Scale meeting the requirements of AASHTO M 231 Class G 5
• Oven, thermostatically controlled, capable of maintaining set temperature within ±3°C (±5°F)
• Thermometers accurate to ±1°C (±2°F) between 10 and 232°C (50 - 450°F)

Note 1: Non-Contact thermometers are not acceptable.
• Miscellaneous pans, spoons, spatulas, hot pads, gloves, paper discs, markers, etc.

Equipment Requirements
The calibration shall be performed on the SGC per the Manufacturer’s instructions. See agency requirements for the calibration frequency.
The mold and base plate dimensions shall be checked every twelve months or 80 hours of operation to determine that they are within the tolerances listed in AASHTO T 312.

Equipment Preparation
Prepare the equipment in accordance with manufacturer’s recommendations. At a minimum preparation includes:
• Warm-up gyratory compactor
• Verify machine settings
  - Internal Angle: 1.16 ±0.02°
  - Ram Pressure: 600 kPa ±18 kPa
  - Number of gyrations
Note 2: The number of gyrations (N_{des}) is obtained from the Job Mix Formula (JMF).

- Lubricate bearing surfaces
- Prepare recording device as required
- Pre-heat molds and plates at the compaction temperature range (minimum of 30 min.) or before reuse reheat (minimum of 5 min.)

Note 3: The use of multiple molds will speed up the compaction process.

- Pre-heat chute, mold funnel, spatulas, and other apparatus (not to exceed the maximum compaction temperature)

Sample Preparation

Laboratory Prepared Asphalt Mixtures

This is a sample produced during the Mix Design process using aggregate and binder that is combined in the laboratory. When designing asphalt mixtures using the gyratory compactor refer to AASHTO T 312.

Plant Produced Asphalt Mixtures

- Determine initial sample size, number of gyrations (N_{des}), and compaction temperature range from the Job Mix Formula (JMF).
- Obtain the sample in accordance with the FOP for AASHTO T 168.
- Reduce the sample in accordance with the FOP for AASHTO R 47.
- The sample size should be such that it results in a compacted specimen that is 115 \pm 5\text{mm} at the desired number of gyrations.

Note 4: Replicate specimens are generally prepared. Refer to agency requirements.

If the material is not in the compaction temperature range:

1. Place the appropriate sample mass into a container.
2. Spread to a depth of 1 to 2 in. for even heating of mixture.
3. Place in the oven until the material is within the compaction temperature range.

Note 5: The material properties may be altered when the times of delivery of the test sample and the placement of the material on the roadway are different.
Compaction Procedure

Follow the manufacturer’s recommended loading procedure. This may require the steps below to be performed in a different order. Steps 1 through 8 must be performed before the sample and mold cools below minimum compaction temperature.

1. Remove pre-heated mold and plate(s) from the oven (verify mold and plate(s) has been cleaned if previously used).
2. Place the base plate and paper disc in bottom of mold.
3. Place the mix into the mold in a single lift (care should be taken to avoid segregation or loss of material).
4. Level the mix in the mold.
5. Place a paper disc and the heated upper plate (if required) on top of the leveled sample.
6. Load the mold into the compactor; check settings.
7. Start the compaction process.
   a. Check the pressure (600 ±18 kPa).
   b. Check the angle (1.16 ±0.02°).
8. Upon completion of the compaction process and record the number of gyrations and specimen height.

Note 6: If the specimen is not 115 ±5mm follow agency requirements.

9. Extrude the specimen from the mold; a brief cooling period may be necessary before fully extruding some specimens to ensure the specimens are not damaged.

Note 7: Clean molds after each use.

10. Carefully remove the paper discs.
11. Cool the compacted specimen to room temperature.
12. Identify the specimen with chalk or other marker.

Report

- On forms approved by the agency
- Sample ID
- Number of gyrations
- Specimen height
PERFORMANCE EXAM CHECKLIST

GYRATORY COMPACTION OF ASPHALT MIXTURES
FOP FOR AASHTO T 312

Participant Name ____________________________________ Exam Date ______________

Record the symbols “P” for passing or “F” for failing on each step of the checklist.

<table>
<thead>
<tr>
<th>Procedure Element</th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>1. Angle, pressure and number of gyrations set?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>2. Bearing surfaces, rotating base surface, and rollers lubricated?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>3. Representative sample obtained according to the FOP for AASHTO T 168?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>4. Sample reduced according to FOP AASHTO R 47?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>5. Asphalt mixture heated to compaction temperature range?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>6. Mold, base plate, and upper plate heated to compaction temperature range?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>7. Mold, base plate, and upper plate (if required) removed from oven and paper disk placed on bottom of mold?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>8. Mix placed into mold in one lift without segregation?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>9. Paper disk placed on top of the asphalt mixture?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>10. Mold placed into compactor and upper plate clamped into place?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>11. Pressure applied at 600 kPa ±18 kPa?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>12. Specified number of gyrations applied?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>13. Proper angle confirmed from display?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>14. Compacted specimen removed from mold, paper disc(s) removed, and allowed to cool to room temperature?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>15. Asphalt mixture sample measured to a height of 115 ±5 mm at required gyrations?</td>
<td>_____</td>
<td>_____</td>
</tr>
</tbody>
</table>

Comments: First attempt: Pass____Fail____ Second attempt: Pass____Fail____

Examiner Signature _______________________________ WAQTC #: ______________
MOISTURE CONTENT OF ASPHALT MIXTURES BY OVEN METHOD
FOP FOR AASHTO T 329 (16)

Scope
This procedure covers the determination of moisture content of asphalt mixtures in accordance with AASHTO T 329-15.

Overview
Moisture content is determined by comparing the wet mass of a sample and the mass of the sample after drying to constant mass. The term constant mass is used to define when a sample is dry.

*Constant mass* – the state at which a mass does not change more than a given percent, after additional drying for a defined time interval, at a required temperature.

Apparatus
- Balance or scale: 2 kg capacity, readable to 0.1 g and conforming to AASHTO M 231.
- Forced draft, ventilated, or convection oven: Capable of maintaining the temperature surrounding the sample at 163 ±14°C (325 ±25°F).
- Sample Container: Clean, dry, not affected by heat and of sufficient size to contain a test sample without danger of spilling.
- Thermometer or other suitable device with a temperature range of 10-260°C (50-500°F).

Sample
The test sample shall be obtained in accordance with the FOP for AASHTO T 168, and reduced in accordance with the FOP for AASHTO R 47. The size of the test sample shall be a minimum of 1000 g.

Procedure
1. Preheat the oven to the Job Mix Formula (JMF) mixing temperature range. If the mixing temperature is not supplied, a temperature of 163 ±14°C (325 ±25°F) is to be used.
   *Note 1:* For repeatability between laboratories, the preferred practice is to dry the sample at no less than 9°C (15°F) below the JMF mixing temperature.
2. Determine and record the mass of the sample container, including release media, to the nearest 0.1 g.
   *Note 2:* When using paper or other absorptive material to line the sample container ensure it is dry before determining initial mass of sample container.
3. Place the test sample in the sample container.

4. Determine and record the temperature of the test sample.

5. Determine and record the total mass of the sample container and test sample to the nearest 0.1 g.

6. Calculate the initial, moist mass (M_i) of the test sample by subtracting the mass of the sample container as determined in Step 2 from the total mass of the sample container and the test sample as determined in Step 5.

7. The test sample shall be initially dried for 90 ±5 minutes, and its mass determined. Then it shall be dried at 30 ±5 min intervals until further drying does not alter the mass by more than 0.05 percent.

8. Cool the sample container and test sample to ±9°C (±15°F) of the temperature determined in Step 4.

9. Determine and record the total mass of the sample container and test sample to the nearest 0.1 g.

   Note 3: Do not attempt to remove the test sample from the sample container for the purposes of determining mass.

10. Calculate the final, dry mass (M_f) of the test sample by subtracting the mass of the sample container as determined in Step 2 from the total mass of the sample container and the test sample as determined in Step 9.

   Note 4: Moisture content and the number of samples in the oven will affect the rate of drying at any given time. Placing wet samples in the oven with nearly dry samples could affect the drying process.

Calculations

Constant Mass:

Calculate constant mass using the following formula:

\[ \%Change = \left( \frac{M_p - M_n}{M_p} \right) \times 100 \]

Where:  

- \( M_p \) = previous mass measurement 
- \( M_n \) = new mass measurement
Example:

Mass of container: 232.6 g

Mass of container and sample after first drying cycle: 1361.8 g

Mass, $M_p$, of possibly dry sample: $1361.8 \text{ g} - 232.6 \text{ g} = 1129.2 \text{ g}$

Mass of container and possibly dry sample after second drying cycle: 1360.4 g

Mass, $M_n$, of possibly dry sample: $1360.4 \text{ g} - 232.6 \text{ g} = 1127.8 \text{ g}$

$$\frac{1129.2 \text{ g} - 1127.8 \text{ g}}{1129.2 \text{ g}} \times 100 = 0.12\%$$

0.12 percent is not less than 0.05 percent, so continue drying the sample.

Mass of container and possibly dry sample after third drying cycle: 1359.9 g

Mass, $M_n$, of dry sample: $1359.9 \text{ g} - 232.6 \text{ g} = 1127.3 \text{ g}$

$$\frac{1127.8 \text{ g} - 1127.3 \text{ g}}{1127.8 \text{ g}} \times 100 = 0.04\%$$

0.04 percent is less than 0.05 percent, so constant mass has been reached.

**Moisture Content:**

Calculate the moisture content, as a percent, using the following formula.

$$Moisture\ Content = \frac{M_i - M_f}{M_f} \times 100$$

Where:

$M_i =$ initial, moist mass

$M_f =$ final, dry mass
Example:

\[ M_i = 1134.9 \, g \]
\[ M_f = 1127.3 \, g \]

\[ Moisture \, Content = \frac{1134.9 \, g - 1127.3 \, g}{1127.3 \, g} \times 100 = 0.674, \text{say 0.67\%} \]

Report

- Results on forms approved by the agency
- Sample ID
- Moisture content to 0.01 percent
PERFORMANCE EXAM CHECKLIST

MOISTURE CONTENT OF ASPHALT MIXTURES BY OVEN METHOD
FOP FOR AASHTO T 329

Participant Name ________________________________________ Exam Date ______________

Record the symbols “P” for passing or “F” for failing on each step of the checklist.

<table>
<thead>
<tr>
<th>Procedure Element</th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>1. Mass of clean dry container including release media determined to 0.1 g?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>2. Representative sample obtained; 1000 g minimum?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>3. Initial temperature taken and recorded?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>4. Mass of sample determined to 0.1 g?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>5. Sample placed in drying oven for 90 ±5 minutes?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>6. Sample dried at a temperature not to exceed the JMF mixing temp?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>7. Constant mass checked at 30 ±5 minute intervals and reached?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>8. Sample and container cooled to ±9°C (15°F) of the initial temperature before final mass determined to 0.1 g?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>9. Calculation of moisture content performed correctly to 0.01 percent?</td>
<td>_____</td>
<td>_____</td>
</tr>
</tbody>
</table>

\[
\text{Moisture Content} = \frac{M_i - M_f}{M_f} \times 100
\]

Comments: First attempt: Pass Fail Second attempt: Pass Fail

<table>
<thead>
<tr>
<th>TRIAL #1</th>
<th>TRIAL #2</th>
</tr>
</thead>
<tbody>
<tr>
<td>Mi + pan</td>
<td>Pan</td>
</tr>
<tr>
<td>Pan</td>
<td></td>
</tr>
<tr>
<td>Mi</td>
<td></td>
</tr>
<tr>
<td>Mp1 + pan</td>
<td>Mp1</td>
</tr>
<tr>
<td>Mp1</td>
<td></td>
</tr>
<tr>
<td>Mp2 + pan</td>
<td>Mp2</td>
</tr>
<tr>
<td>Mp2</td>
<td></td>
</tr>
</tbody>
</table>

% Moisture Content Check

Examiner Signature _______________________________ WAQTC #: _______________
VOLUMETRIC PROPERTIES OF HOT MIX ASPHALT (HMA)
WAQTC TM 13 (16)

Scope

This procedure covers the determination of volumetric properties of plant produced Hot Mix Asphalt, i.e., air voids ($V_a$), voids in mineral aggregate ($V_{MA}$), voids filled with asphalt binder ($V_{FA}$), effective asphalt binder content ($P_{be}$) and Dust to Binder Ratio ($P_{#200}/P_{be}$). The in-production volumetric properties are then compared to agency specifications.

Definition of Terms

- $G_{mm}$ = theoretical maximum specific gravity (Gravity mix max)
- $G_{mb}$ = measured bulk specific gravity (Gravity mix bulk)
- $G_{sb}$ = oven-dry bulk specific gravity of aggregate (Gravity stone bulk)
- $G_{sa}$ = apparent specific gravity of aggregate (Gravity stone apparent)
- $G_{se}$ = effective specific gravity of aggregate (Gravity stone effective)
- $G_{b}$ = specific gravity of the binder (Gravity binder)
- $V_a$ = air Voids (Voids air)
- $V_{MA}$ = Voids in Mineral Aggregate
- $V_{FA}$ = Voids Filled with Asphalt (binder)
- $V_{ba}$ = absorbed binder volume (Voids binder absorbed)
- $V_{be}$ = effective binder volume (Voids binder effective)
- $P_b$ = percent binder content (Percent binder)
- $P_{ba}$ = percent absorbed binder (Percent binder absorbed)
- $P_{be}$ = percent effective binder content (Percent binder effective)
- $P_s$ = percent of aggregate (Percent stone)
- $DP$ = Dust proportion to effective binder ratio ($P_{#200}/P_{be}$)
Background

Whether a mix design is developed through a Marshall, Hveem, or Superpave mix design process there are basic volumetric requirements of all. Volumetric properties are the properties of a defined material contained in a known volume. HMA Volumetric properties can include bulk specific gravity, theoretical maximum specific gravity, air voids, and voids in mineral aggregate.

Many agencies specify values of the volumetric properties to ensure optimum performance of the pavement. The HMA must be designed to meet these criteria. In production the HMA is evaluated to determine if the mix still meets the specifications and is consistent with the original mix design (JMF). The production HMA may vary from the mix design and may need to be modified to meet the specified volumetric criteria.

To compare the in-production volumetric properties to agency specifications and the JMF a sample of loose HMA mix is obtained in accordance with FOP for AASHTO T 168. The sample is then compacted in a gyratory compactor to simulate the in-place HMA pavement after it has been placed, compacted, and the volumetric properties of the compacted sample are determined.

Each of the properties in the HMA phase diagram can be measured or calculated. For example: The mass of the aggregate is measured; the voids in mineral aggregate (VMA) is calculated; total asphalt binder can be measured but the amount available to act as a binder in the mix must be calculated because it is the quantity left after the aggregate has absorbed some of the asphalt binder.
The volumetric proportions of the asphalt binder and aggregate components of an asphalt mixture and their relationship to the other components are considered. The mass of the components and their specific gravities are used to determine the volumes of each of the components in the mix. The volumetric properties of a compacted HMA paving mixture: air voids ($V_a$), voids in mineral aggregate ($V_{MA}$), voids filled with asphalt binder ($V_{FA}$), and effective asphalt binder content ($P_{bc}$) provide some indication of the mixtures probable performance.

**Volumetric Properties**

**Volumetric Relationship of HMA Constituents**

![Diagram of HMA cross section and volume diagram.](image)

**Required Values**

The specific gravities listed in Table 1 and the percent by mass of each of the components in the HMA are needed to determine the volumetric properties. Other values required are also listed. Some of these values are obtained from the JMF and some are measured from a plant produced HMA sample.
<table>
<thead>
<tr>
<th>Data</th>
<th>Test Method</th>
<th>Obtained</th>
</tr>
</thead>
<tbody>
<tr>
<td>$G_{sb}$ – combined aggregate bulk specific gravity</td>
<td>AASHTO T 84 / T 85 or agency approved test method</td>
<td>JMF or performed at the beginning of placement</td>
</tr>
<tr>
<td>$G_b$ – measured specific gravity of the asphalt binder</td>
<td>AASHTO T 228</td>
<td>JMF or from the supplier</td>
</tr>
<tr>
<td>$G_{mm}$ – measured maximum specific gravity of the loose mix</td>
<td>FOP for AASHTO T 209</td>
<td>Performed on the field test sample</td>
</tr>
<tr>
<td>$G_{mb}$ – measured bulk specific gravity of the compacted paving mix</td>
<td>FOP for AASHTO T 166</td>
<td>Performed on the field compacted specimen</td>
</tr>
<tr>
<td>$P_b$ – percent asphalt binder</td>
<td>FOP for AASHTO T 308</td>
<td>Performed on the field test sample</td>
</tr>
<tr>
<td>$P_{#200}$ – aggregate passing the #200 (75 µm) sieve</td>
<td>FOP for AASHTO T 30</td>
<td>Performed on the field test sample</td>
</tr>
</tbody>
</table>

**Air Voids ($V_a$)**

Air voids are the total volume of the small pockets of air between the coated aggregate particles throughout a compacted paving mixture. Appropriate air voids contribute to the stability of the HMA and help the pavement withstand the combined action of environment and traffic loads. The designated percent air voids allows for thermal expansion of the asphalt binder and contributes a cushion for future compaction. Air voids are expressed as a percent of the bulk volume of the compacted mixture ($G_{mb}$) when compared to the maximum specific gravity ($G_{mm}$).

\[
V_a = 100 \left[ \frac{(G_{mm} - G_{mb})}{G_{mm}} \right]
\]

Where:

$V_a$ = air voids in compacted mixture, percent of total volume (report to 0.1)
$G_{mm}$ = maximum specific gravity of paving mixture (AASHTO T 209)
$G_{mb}$ = bulk specific gravity of compacted mixture (AASHTO T 166)
Percent Aggregate (Stone) \((P_s)\)

\(P_s\) is the percent aggregate (stone) content, expressed as a percentage of the total mass of the sample.

\[
P_s = 100 - P_b
\]

Where:
- \(P_s\) = percent aggregate (stone) percent by total weight
- \(P_b\) = asphalt binder content (AASHTO T 308)

Voids in the Mineral Aggregate (VMA)

VMA is the volume of intergranular void space between the aggregate particles of the compacted paving mixture that includes the air voids and the effective binder content, expressed as a percent of the total volume of the sample.

\[
VMA = 100 - \left(\frac{G_{mb} \times P_s}{G_{sb}}\right)
\]

Where:
- \(VMA\) = voids in mineral aggregate, percent of bulk volume (report to 0.1)
- \(G_{sb}\) = bulk specific gravity of combined aggregate (AASHTO T 85 / T 84 or agency approved method from Job Mix Formula)
- \(G_{mb}\) = bulk specific gravity of compacted mixture (AASHTO T 166)
- \(P_s\) = aggregate content, percent by total weight = 100 – \(P_b\)
- \(P_b\) = asphalt binder content (AASHTO T 308) percent by total weight

Voids Filled with Asphalt (binder) (VFA)

VFA is the volume of space between the aggregate particles of the compacted paving mixture filled with asphalt binder, expressed as a percent of the total volume of the sample. The VFA increases as the asphalt binder content increases as it is the percent of voids that are filled with asphalt which doesn’t include the absorbed asphalt.

\[
VFA = 100 \left(\frac{VMA - V_a}{VMA}\right)
\]

Where:
- \(VFA\) = voids filled with asphalt, percent of VMA (report to 1)
- \(VMA\) = voids in mineral aggregate, percent of bulk volume
- \(V_a\) = air voids in compacted mixture, percent of total volume.
Effective Specific Gravity of the Aggregate (Stone) \((G_{se})\)

The \(G_{se}\) is used to quantify the asphalt binder absorbed into the aggregate particle. This is a calculated value based on the specific gravity of the mixture, \(G_{mm}\), and the specific gravity of the asphalt binder, \(G_{b}\). This measurement includes the volume of the aggregate particle plus the void volume that becomes filled with water during the test soak period minus the volume of the voids that absorb asphalt binder. Effective specific gravity lies between apparent and bulk specific gravity.

\(G_{se}\) is formally defined as the ratio of the mass in air of a unit volume of a permeable material (excluding voids permeable to asphalt binder) at a stated temperature to the mass in air (of equal density) of an equal volume of gas-free distilled water at a stated temperature.

\[
G_{se} = \frac{P_s}{\left(\frac{100}{G_{mm}} - \frac{P_b}{G_{b}}\right)}
\]

Where:
- \(G_{se}\) = effective specific gravity of combined aggregate (report to 0.001)
- \(P_s\) = aggregate content, percent by total weight = 100 – \(P_b\)
- \(G_{mm}\) = maximum specific gravity of mix (AASHTO T 209)
- \(P_b\) = asphalt binder content (AASHTO T 308) percent by total weight
- \(G_{b}\) = specific gravity of asphalt binder (JMF or asphalt binder supplier)

Percent of Absorbed (asphalt) Binder \((P_{ba})\)

\(P_{ba}\) is the total percent of the asphalt binder that is absorbed into the aggregate, expressed as a percentage of the mass of aggregate rather than as a percentage of the total mass of the mixture. This portion of the asphalt binder content does not contribute to the performance of the mix.

\[
P_{ba} = 100 \left[\frac{(G_{se} - G_{sb})}{(G_{sb} \times G_{se})}\right] G_{b}
\]

Where:
- \(P_{ba}\) = absorbed asphalt binder (report to 0.01) percent of aggregate
- \(G_{se}\) = effective specific gravity of combined aggregate
- \(G_{sb}\) = bulk specific gravity of combined aggregate (AASHTO T 85 / T 84 or agency approved method from Job Mix Formula)
- \(G_{b}\) = specific gravity of asphalt binder (JMF or asphalt binder supplier)
Percent of Effective (asphalt) Binder ($P_{be}$)

$P_{be}$ is the total asphalt binder content of a paving mixture minus the portion of asphalt binder that is lost by absorption into the aggregate particles, expressed as a percentage of the mass of aggregate. It is the portion of the asphalt binder content that remains as a coating on the outside of the aggregate particles. This is the asphalt content that controls the performance of the mix.

$$P_{be} = P_b - \left[ \frac{P_{ba}}{100} \times P_s \right]$$

Where:

- $P_{be}$ = effective asphalt binder content (report to 0.01), percent by total weight
- $P_s$ = aggregate content, percent by total weight = 100 – $P_b$
- $P_b$ = asphalt binder content (AASHTO T 308) percent by total weight
- $P_{ba}$ = absorbed asphalt binder

Dust Proportion – DP (Dust to Effective (asphalt) Binder Ratio)

The DP is the percent passing the No. 200 sieve of the gradation divided by the percent of effective asphalt binder. Excessive dust reduces asphalt binder film thickness on the aggregate which reduces the durability. Insufficient dust may allow excessive asphalt binder film thickness, which may result in a tender, unstable mix.

$$DP = \frac{P_{-#200}}{P_{be}}$$

Where:

- $DP$ = Dust Proportion, (dust-to-binder ratio) (report to 0.01)
- $P_{-#200}$ = aggregate passing the -#200 (75 µm) sieve, percent by mass of aggregate (AASHTO T 30)
- $P_{be}$ = effective asphalt binder content, percent by total weight
Mix Design and Production Values

Job Mix Formula

Table 2 includes example data required from the JMF. Some of these values are used in the example calculations.

*Note:* Some of the targets may change after the HMA is in production based on field test data.

### Table 2

<table>
<thead>
<tr>
<th>JMF Data</th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>Asphalt binder grade</td>
<td>PG 64-28</td>
</tr>
<tr>
<td><strong>N</strong> values</td>
<td></td>
</tr>
<tr>
<td>( N_{\text{ini}} ) = 7</td>
<td></td>
</tr>
<tr>
<td>( N_{\text{des}} ) = 75</td>
<td></td>
</tr>
<tr>
<td>( N_{\text{max}} ) = 115</td>
<td></td>
</tr>
<tr>
<td>( G_{\text{sb}} ) (^{\text{(combined specific gravity of the aggregate)}})</td>
<td>2.678</td>
</tr>
<tr>
<td>Target ( P_b )</td>
<td>4.75%</td>
</tr>
<tr>
<td>Initial sample mass for gyratory specimens</td>
<td>4840 grams</td>
</tr>
<tr>
<td>Mixing temperature range</td>
<td>306 – 312 °F</td>
</tr>
<tr>
<td>Laboratory compaction temperature range</td>
<td>286 – 294 °F</td>
</tr>
<tr>
<td>( G_b ) (^{\text{(specific gravity of the asphalt binder)}})</td>
<td>1.020</td>
</tr>
</tbody>
</table>

**Target gradation**

<table>
<thead>
<tr>
<th>Sieve Size mm (in.)</th>
<th>Percent Passing</th>
</tr>
</thead>
<tbody>
<tr>
<td>19.0 (3/4)</td>
<td>100</td>
</tr>
<tr>
<td>12.5 (1/2)</td>
<td>85</td>
</tr>
<tr>
<td>9.5 (3/8)</td>
<td>80</td>
</tr>
<tr>
<td>4.75 (No. 4)</td>
<td>50</td>
</tr>
<tr>
<td>2.36 (No. 8)</td>
<td>30</td>
</tr>
<tr>
<td>0.18 (No. 16)</td>
<td>25</td>
</tr>
<tr>
<td>0.600 (No. 30)</td>
<td>15</td>
</tr>
<tr>
<td>0.300 (No. 50)</td>
<td>10</td>
</tr>
<tr>
<td>0.150 (No. 100)</td>
<td>7</td>
</tr>
<tr>
<td>75 µm (No. 200)</td>
<td>5.0</td>
</tr>
</tbody>
</table>
Sample Test Result

Tables 3 and 4 include data from test results performed on a field sample of HMA used in the example calculations.

### Table 3
**Field Data**

<table>
<thead>
<tr>
<th>Test method</th>
<th>Example values</th>
</tr>
</thead>
<tbody>
<tr>
<td>( P_b )</td>
<td>FOP for AASHTO T 308</td>
</tr>
<tr>
<td>( G_{mb} )</td>
<td>FOP for AASHTO T 166</td>
</tr>
<tr>
<td>( G_{mm} )</td>
<td>FOP for AASHTO T 209</td>
</tr>
</tbody>
</table>

### Table 4
**Sieve Analysis**

<table>
<thead>
<tr>
<th>Sieve Size mm (in.)</th>
<th>Percent Passing</th>
</tr>
</thead>
<tbody>
<tr>
<td>19.0 (3/4)</td>
<td>100</td>
</tr>
<tr>
<td>12.5 (1/2)</td>
<td>86</td>
</tr>
<tr>
<td>9.5 (3/8)</td>
<td>77</td>
</tr>
<tr>
<td>4.75 (No. 4)</td>
<td>51</td>
</tr>
<tr>
<td>2.36 (No. 8)</td>
<td>34</td>
</tr>
<tr>
<td>0.118 (No. 16)</td>
<td>23</td>
</tr>
<tr>
<td>0.600 (No. 30)</td>
<td>16</td>
</tr>
<tr>
<td>0.300 (No. 50)</td>
<td>12</td>
</tr>
<tr>
<td>0.150 (No. 100)</td>
<td>8</td>
</tr>
<tr>
<td>0.075 (No. 200)</td>
<td>4.9</td>
</tr>
</tbody>
</table>

**Sample Calculations**

**Air Voids (\( V_a \))**

\[
V_a = 100 \left[ \frac{(G_{mm} - G_{mb})}{G_{mm}} \right]
\]

\[
V_a = 100 \left[ \frac{(2.516 - 2.415)}{2.516} \right] = 4.01431\% \text{ report 4.0%}
\]

Given:

\( G_{mm} = 2.516 \)

\( G_{mb} = 2.415 \)
Percent Aggregate (Stone) \((P_s)\)

\[
P_s = 100 - P_b
\]

\[
P_s = 100.0 - 4.60\% = 95.40\%
\]

Given:
\[
P_b = 4.60\%
\]

Voids in the Mineral Aggregate (VMA)

\[
VMA = 100 - \left[ \frac{(G_{mb} \times P_s)}{G_{sb}} \right]
\]

\[
VMA = 100.0 - \left[ \frac{2.415 \times 95.40\%}{2.678} \right] = 13.96\% \text{ report 14.0}\%
\]

Given:
\[
G_{sb} = 2.678
\]

Voids Filled with Asphalt (binder) (VFA)

\[
VFA = 100 \left[ \frac{(VMA - V_a)}{VMA} \right]
\]

\[
VFA = 100 \left[ \frac{(14.0\% - 4.0\%)}{14.0\%} \right] = 71.4\% \text{ report 71}\%
\]
Effective Specific Gravity of the Aggregate (Stone) \((G_{se})\)

\[
G_{se} = \frac{P_s}{\left(\frac{100}{G_{mm}} - \frac{P_b}{G_b}\right)}
\]

\[
G_{se} = \frac{(100 - 4.60\%)}{\left(\frac{100}{2.516} - \frac{4.60\%}{1.020}\right)} = 
\]

\[
G_{se} = \frac{95.40\%}{39.7456 - 4.5098} = 2.70747 \text{ report } 2.707
\]

Given:

\[
G_b = \frac{1.020}{0.0290} = 0.40804\% \text{ report } 0.41\%
\]

Percent of Absorbed (asphalt) Binder \((P_{ba})\)

\[
P_{ba} = 100 \left[\frac{(G_{se} - G_{sb})}{G_{rb} \times G_{se}}\right] G_b
\]

\[
P_{ba} = 100 \left[\frac{(2.707 - 2.678)}{(2.678 \times 2.707)}\right] 1.020 = 
\]

\[
P_{ba} = 100 \left[\frac{0.0290}{7.2493}\right] 1.020 = 0.40804\% \text{ report } 0.41\%
\]

Percent of Effective (asphalt) Binder \((P_{be})\)

\[
P_{be} = P_b - \left[\frac{P_{ba}}{100} \times P_s\right]
\]

\[
P_{be} = 4.60 - \left[\frac{0.41\%}{100} \times (100 - 4.60\%)\right] = 4.20886\% \text{ report } 4.21\%
Dust Proportion – DP (Dust to Effective (asphalt) Binder Ratio)

\[ DP = \frac{P_{-\#200}}{P_{be}} \]

\[ DP = \frac{4.9\%}{4.21\%} = 1.16390 \text{ report 1.16} \]

Given:
\[ P_{-\#200} = 4.9\% \]

Report

- Results on forms approved by the agency
- Sample ID
- Air Voids, \( V_a \) to 0.1 percent
- Voids in the Mineral Aggregate, \( VMA \) to 0.1 percent
- Voids Filled with Asphalt, \( VFA \) to nearest whole value
- Effective Specific Gravity of Aggregate (stone), \( G_{se} \) to 0.001
- Percent of Absorbed (asphalt) Binder, \( P_{ba} \) to 0.01
- Percent Effective (asphalt) Binder, \( P_{be} \) to 0.01
- Dust Proportion, \( DP \) to 0.01
Appendix - Formulas

Air Voids ($V_a$)

$$V_a = 100 \left[ \frac{(G_{mm} - G_{mb})}{G_{mm}} \right]$$

Where:

$V_a$ = air voids in compacted mixture, percent of total volume (report to 0.1)

$G_{mm}$ = maximum specific gravity of paving mixture (AASHTO T 209)

$G_{mb}$ = bulk specific gravity of compacted mixture (AASHTO T 166)

Percent Aggregate (Stone) ($P_s$)

$$P_s = 100 - P_b$$

Where:

$P_s$ = percent aggregate (stone) percent by total weight

$P_b$ = asphalt binder content (AASHTO T 308)

Voids in the Mineral Aggregate (VMA)

$$VMA = 100 - \left[ \frac{(G_{mb} \times P_s)}{G_{sb}} \right]$$

Where:

VMA = voids in mineral aggregate, percent of bulk volume (report to 0.1)

$G_{sb}$ = bulk specific gravity of combined aggregate (AASHTO T 85 / T 84 or agency approved method from Job Mix Formula)

$G_{mb}$ = bulk specific gravity of compacted mixture (AASHTO T 166)

$P_s$ = aggregate content, percent by total weight = 100 – $P_b$

$P_b$ = asphalt binder content (AASHTO T 308) percent by total weight

Voids Filled with Asphalt (binder) (VFA)

$$VFA = 100 \left[ \frac{(VMA - V_a)}{VMA} \right]$$

Where:

VFA = voids filled with asphalt, percent of VMA (report to 1)

VMA = voids in mineral aggregate, percent of bulk volume

$V_a$ = air voids in compacted mixture, percent of total volume.
Effective Specific Gravity of the Aggregate (Stone) ($G_{se}$)

$$G_{se} = \frac{P_s}{\left(\frac{100}{G_{mm}}\right) - \left(\frac{P_b}{G_b}\right)}$$

Where:

- $G_{se}$ = effective specific gravity of combined aggregate (report to 0.001)
- $P_s$ = aggregate content, percent by total weight = 100 – $P_b$
- $G_{mm}$ = maximum specific gravity of mix (AASHTO T 209)
- $P_b$ = asphalt binder content (AASHTO T 308) percent by total weight
- $G_b$ = specific gravity of asphalt binder (JMF or asphalt binder supplier)

Percent of Absorbed (asphalt) Binder ($P_{ba}$)

$$P_{ba} = 100 \left(\frac{G_{se} - G_{sb}}{G_{sb} \times G_{se}}\right) G_b$$

Where:

- $P_{ba}$ = absorbed asphalt binder (report to 0.01) percent of aggregate
- $G_{se}$ = effective specific gravity of combined aggregate
- $G_{sb}$ = bulk specific gravity of combined aggregate (AASHTO T 85 from Job Mix Formula)
- $G_b$ = specific gravity of asphalt binder (JMF or asphalt binder supplier)

Percent of Effective (asphalt) Binder ($P_{be}$)

$$P_{be} = P_b - \left[\frac{P_{ba}}{100} \times P_s\right]$$

Where:

- $P_{be}$ = effective asphalt binder content (report to 0.01), percent by total weight
- $P_s$ = aggregate content, percent by total weight = 100 – $P_b$
- $P_b$ = asphalt binder content (AASHTO T 308) percent by total weight
- $P_{ba}$ = absorbed asphalt binder

Dust Proportion – DP (Dust to Effective (asphalt) Binder Ratio)

$$DP = \frac{P_{-#200}}{P_{be}}$$

Where:

- DP = Dust Proportion, (dust-to-binder ratio) (report to 0.01)
- $P_{-#200}$ = aggregate passing the -#200 (75 µm) sieve, percent by mass of aggregate (AASHTO T 30)
- $P_{be}$ = effective asphalt binder content, percent by total weight
## CONCRETE

### FIELD OPERATING PROCEDURES - SHORT FORM

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<td>AASHTO T 309 (15) Temperature of Freshly Mixed Portland Cement Concrete</td>
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<tr>
<td>3</td>
<td>AASHTO T 119 (16) Slump of Hydraulic Cement Concrete</td>
</tr>
<tr>
<td>4</td>
<td>AASHTO T 121 (16) Density (Unit Weight), Yield, and Air Content (Gravimetric) of Concrete</td>
</tr>
<tr>
<td>5</td>
<td>AASHTO T 152 (16) Air Content of Freshly Mixed Concrete by the Pressure Method</td>
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<td>6</td>
<td>AASHTO T 23 (15) Method of Making and Curing Concrete Test Specimens in the Field</td>
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</tbody>
</table>
METHOD OF MAKING AND CURING CONCRETE TEST SPECIMENS IN THE FIELD
FOP FOR AASHTO T 23 (15)

Scope
This procedure covers the method for making, initially curing, and transporting concrete test specimens in the field in accordance with AASHTO T 23-14.

Warning—Fresh Hydraulic cementitious mixtures are caustic and may cause chemical burns to skin and tissue upon prolonged exposure.

Apparatus and Test Specimens

- Concrete cylinder molds: Conforming to AASHTO M 205 with a length equal to twice the diameter. Standard specimens shall be 150 mm (6 in.) by 300 mm (12 in.) cylinders. Mold diameter must be at least three times the maximum aggregate size unless wet sieving is conducted according to the FOP for WAQTC TM 2. Agency specifications may allow cylinder molds of 100 mm (4 in.) by 200 mm (8 in.) when the nominal maximum aggregate size does not exceed 25 mm (1 in.).

- Beam molds: Rectangular in shape with ends and sides at right angles to each other. Must be sufficiently rigid to resist warpage. Surfaces must be smooth. Molds shall produce length no more than 1.6 mm (1/16 in.) shorter than that required (greater length is allowed). Maximum variation from nominal cross section shall not exceed 3.2 mm (1/8 in.). Ratio of width to depth may not exceed 1:5; the smaller dimension must be at least 3 times the maximum aggregate size. Standard beam molds shall result in specimens having width and depth of not less than 150 mm (6 in.). Agency specifications may allow beam molds of 100 mm (4 in.) by 100 mm (4 in.) when the nominal maximum aggregate size does not exceed 38 mm (1.5 in.). Specimens shall be cast and hardened with the long axes horizontal.

- Standard tamping rod: 16 mm (5/8 in.) in diameter and approximately 600 mm (24 in.) long, having a hemispherical tip of the same diameter as the rod for preparing 150mm (6 in.) x 300 mm (12 in.) cylinders.

- Small tamping rod: 10 mm (3/8 in.) diameter and approximately 305 mm (12 in.) long, having a hemispherical tip of the same diameter as the rod for preparing 100 mm (4 in.) x 200 mm (8 in.) cylinders.

- Vibrator: At least 7000 vibrations per minute, with a diameter no more than ¼ the diameter or width of the mold and at least 75 mm (3 in.) longer than the section being vibrated for use with low slump concrete.

- Scoop: a receptacle of appropriate size so that each representative increment of the concrete sample can be placed in the container without spillage.

- Trowel or float

- Mallet: With a rubber or rawhide head having a mass of 0.57 ±0.23 kg (1.25 ±0.5 lb.).
- Rigid base plates and cover plates: may be metal, glass, or plywood.
- Initial curing facilities: Temperature-controlled curing box or enclosure capable of maintaining the required range of 16 to 27°C (60 to 80°F) during the entire initial curing period (for concrete with compressive strength of 40 Mpa (6000 psi) or more, the temperature shall be 20 to 26°C (68 to 78°F). As an alternative, sand or earth for initial cylinder protection may be used provided that the required temperature range is maintained and the specimens are not damaged.
- Thermometer: Capable of registering both maximum and minimum temperatures during the initial cure.

**Procedure – Making Specimens – General**

1. Obtain the sample according to the FOP for WAQTC TM 2.
2. Wet Sieving per the FOP for WAQTC TM 2 is required for 150 mm (6 in.) diameter specimens containing aggregate with a nominal maximum size greater than 50 mm (2 in.); screen the sample over the 50 mm (2 in.) sieve.
3. Remix the sample after transporting to testing location.
4. Begin making specimens within 15 minutes of obtaining the sample.
5. Set molds upright on a level, rigid base in a location free from vibration and relatively close to where they will be stored.
6. Fill molds in the required number of layers, attempting to slightly overfill the mold on the final layer. Add or remove concrete prior to completion of consolidation to avoid a deficiency or excess of concrete.
7. There are two methods of consolidating the concrete – rodding and internal vibration. If the slump is greater than 25 mm (1 in.), consolidation may be by rodding or vibration. When the slump is 25 mm (1 in.) or less, consolidate the sample by internal vibration. Agency specifications may dictate when rodding or vibration will be used.

**Procedure – Making Cylinders – Rodding**

1. For the standard 150 mm (6 in.) by 300 mm (12 in.) specimen, fill each mold in three approximately equal layers, moving the scoop or trowel around the perimeter of the mold to evenly distribute the concrete. For the 100 mm (4 in.) by 200 mm (8 in.) specimen, fill the mold in two layers. When filling the final layer, slightly overfill the mold.
2. Consolidate each layer with 25 strokes of the appropriate tamping rod, using the rounded end. Distribute strokes evenly over the cross section of the concrete. Rod the first layer throughout its depth without forcibly hitting the bottom. For subsequent layers, rod the layer throughout its depth penetrating approximately 25 mm (1 in.) into the underlying layer.
3. After rodding each layer, tap the sides of each mold 10 to 15 times with the mallet (reusable steel molds) or lightly with the open hand (single-use light-gauge molds).
4. Strike off the surface of the molds with tamping rod, straightedge, float, or trowel.
5. Begin initial curing.

Procedure – Making Cylinders – Internal Vibration

1. Fill the mold in two layers.
2. Insert the vibrator at the required number of different points for each layer (two points for 150 mm (6 in.) diameter cylinders; one point for 100 mm (4 in.) diameter cylinders). When vibrating the bottom layer, do not let the vibrator touch the bottom or sides of the mold. When vibrating the top layer, the vibrator shall penetrate into the underlying layer approximately 25 mm (1 in.)
3. Remove the vibrator slowly, so that no large air pockets are left in the material.
   
   Note 1: Continue vibration only long enough to achieve proper consolidation of the concrete. Over vibration may cause segregation and loss of appreciable quantities of intentionally entrained air.
4. After vibrating each layer, tap the sides of each mold 10 to 15 times with the mallet (reusable steel molds) or lightly with the open hand (single-use light-gauge molds).
5. Strike off the surface of the molds with tamping rod, straightedge, float, or trowel.
6. Begin initial curing.

Procedure – Making Flexural Beams – Rodding

1. Fill the mold in two approximately equal layers with the second layer slightly overfilling the mold.
2. Consolidate each layer with the tamping rod once for every 1300 mm² (2 in²) using the rounded end. Rod each layer throughout its depth, taking care to not forcibly strike the bottom of the mold when compacting the first layer. Rod the second layer throughout its depth, penetrating approximately 25 mm (1 in.) into the lower layer.
3. After rodding each layer, strike the mold 10 to 15 times with the mallet and spade along the sides and end using a trowel.
4. Strike off the surface of the molds with tamping rod, straightedge, float, or trowel.
5. Begin initial curing.

Procedure – Making Flexural Beams – Vibration

1. Fill the mold to overflowing in one layer.
2. Consolidate the concrete by inserting the vibrator vertically along the centerline at intervals not exceeding 150 mm (6 in.). Take care to not over-vibrate, and withdraw the vibrator slowly to avoid large voids. Do not contact the bottom or sides of the mold with the vibrator.
3. After vibrating, strike the mold 10 to 15 times with the mallet.
4. Strike off the surface of the molds with tamping rod, straightedge, float, or trowel.
5. Begin initial curing.

Procedure – Initial Curing

- When moving cylinder specimens made with single use molds support the bottom of the mold with trowel, hand, or other device.
- For initial curing of cylinders, there are two methods, use of which depends on the agency. In both methods, the curing place must be firm, within ¼ in. of a level surface, and free from vibrations or other disturbances.
- Maintain initial curing temperature of 16 to 27°C (60 to 80°F) or 20 to 26°C (68 to 78°F) for concrete with strength of 40 Mpa (6000 psi) or more.
- Prevent loss of moisture.

Method 1 – Initial cure in a temperature controlled chest-type curing box

1. Finish the cylinder using the tamping rod, straightedge, float, or trowel. The finished surface shall be flat with no projections or depressions greater than 3.2 mm (1/8 in.).
2. Place the mold in the curing box. When lifting light-gauge molds be careful to avoid distortion (support the bottom, avoid squeezing the sides).
3. Place the lid on the mold to prevent moisture loss.
4. Mark the necessary identification data on the cylinder mold and lid.

Method 2 – Initial cure by burying in earth or by using a curing box over the cylinder

Note 2: This procedure may not be the preferred method of initial curing due to problems in maintaining the required range of temperature.

1. Move the cylinder with excess concrete to the initial curing location.
2. Mark the necessary identification data on the cylinder mold and lid.
3. Place the cylinder on level sand or earth, or on a board, and pile sand or earth around the cylinder to within 50 mm (2 in.) of the top.
4. Finish the cylinder using the tamping rod, straightedge, float, or trowel. Use a sawing motion across the top of the mold. The finished surface shall be flat with no projections or depressions greater than 3.2 mm (1/8 in.).
5. If required by the agency, place a cover plate on top of the cylinder and leave it in place for the duration of the curing period, or place the lid on the mold to prevent moisture loss.
Procedure – Transporting Specimens

- Initially cure the specimens for 24 to 48 hours. Transport specimens to the laboratory for final cure after initial curing. Specimen identity will be noted along with the date and time the specimen was made and the maximum and minimum temperatures registered during the initial cure.

- Protect specimens from jarring, extreme changes in temperature, freezing, or moisture loss during transport.

- Secure cylinders so that the axis is vertical.

- Do not exceed 4 hours transportation time.

Final Curing

- Upon receiving cylinders at the laboratory, remove the cylinder from the mold and apply the appropriate identification.

- For all specimens (cylinders or beams), final curing must be started within 30 minutes of mold removal. Temperature shall be maintained at 23° ±2°C (73 ±3°F). Free moisture must be present on the surfaces of the specimens during the entire curing period. Curing may be accomplished in a moist room or water tank conforming to AASHTO M 201.

- For cylinders, during the final 3 hours prior to testing the temperature requirement may be waived, but free moisture must be maintained on specimen surfaces at all times until tested.

- Final curing of beams must include immersion in lime-saturated water for at least 20 hours prior to testing.

Report

- On forms approved by the agency

- Pertinent placement information for identification of project, element(s) represented, etc.

- Sample ID

- Date and time molded.

- Test ages.

- Slump, air content, and density.

- Temperature (concrete, initial cure max. and min., and ambient).

- Method of initial curing.

- Other information as required by agency, such as: concrete supplier, truck number, invoice number, water added, etc.
## PERFORMANCE EXAM CHECKLIST

### MAKING AND CURING CONCRETE TEST SPECIMENS IN THE FIELD
FOP FOR AASHTO T 23 (4 X 8)

**Participant Name ______________________________ Exam Date ______________**

Record the symbols “P” for passing or “F” for failing on each step of the checklist.

<table>
<thead>
<tr>
<th>Procedure Element</th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>1. Molds placed on a level, rigid, horizontal surface free of vibration?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>2. Representative sample selected?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>3. Making of specimens begun within 15 minutes of sampling?</td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>First layer</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>4. Concrete placed in the mold, moving a scoop or trowel around the perimeter of the mold to evenly distribute the concrete as discharged?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>5. Mold filled approximately half full?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>6. Layer rodded throughout its depth 25 times with hemispherical end of rod, uniformly distributing strokes?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>7. Sides of the mold tapped 10-15 times after rodding?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>a. With mallet for reusable steel molds</td>
<td></td>
<td></td>
</tr>
<tr>
<td>b. With the open hand for flexible light-gauge molds</td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>Second layer</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>8. Concrete placed in the mold, moving a scoop or trowel around the perimeter of the mold to evenly distribute the concrete as discharged?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>9. Mold filled, attempting to exactly fill the mold on the last layer?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>10. Layer rodded 25 times with hemispherical end of rod, uniformly distributing strokes and penetrating 25 mm (1 in.) into the underlying layer?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>11. Sides of the mold tapped 10-15 times after rodding each layer?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>a. With mallet for reusable steel molds</td>
<td></td>
<td></td>
</tr>
<tr>
<td>b. With the open hand for flexible light-gauge molds</td>
<td></td>
<td></td>
</tr>
<tr>
<td>12. Concrete struck off with tamping rod, float or trowel?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>13. Specimens covered with non-absorptive, non-reactive cap or plate?</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

**OVER**
Comments: First attempt: Pass____ Fail____ Second attempt: Pass____ Fail____

Examiner Signature _______________________________ WAQTC #:_________________

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## PERFORMANCE EXAM CHECKLIST

**MAKING AND CURING CONCRETE TEST SPECIMENS IN THE FIELD**  
**FOP FOR AASHTO T 23 (6 X 12)**

Participant Name ______________________________ Exam Date ______________

Record the symbols “P” for passing or “F” for failing on each step of the checklist.

<table>
<thead>
<tr>
<th>Procedure Element</th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>1. Molds placed on a level, rigid, horizontal surface free of vibration?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>2. Representative sample selected?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>3. Making of specimens begun within 15 minutes of sampling?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td><strong>First layer</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>4. Concrete placed in the mold, moving a scoop or trowel around the perimeter of the mold to evenly distribute the concrete as discharged?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>5. Mold filled approximately one third full?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>6. Layer rodded throughout its depth 25 times with hemispherical end of rod, uniformly distributing strokes?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>7. Sides of the mold tapped 10-15 times after rodding each layer?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>a. With mallet for reusable steel molds</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>b. With the open hand for flexible light-gauge molds</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td><strong>Second layer</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>8. Concrete placed in the mold, moving a scoop or trowel around the perimeter of the mold to evenly distribute the concrete as discharged?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>9. Mold filled approximately two thirds full?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>10. Layer rodded 25 times with hemispherical end of rod, uniformly distributing strokes and penetrating 25 mm (1 in.) into the underlying layer?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>11. Sides of the mold tapped 10-15 times after rodding?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>a. With mallet for reusable steel molds</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>b. With the open hand for flexible light-gauge molds</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td><strong>Third layer</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>12. Concrete placed in the mold, moving a scoop or trowel around the perimeter of the mold to evenly distribute the concrete as discharged?</td>
<td>_____</td>
<td>_____</td>
</tr>
</tbody>
</table>

OVER
**Procedure Element**

13. Mold filled, attempting to exactly fill the mold on the last layer?  
   Trial 1  Trial 2

14. Layer rodded 25 times with hemispherical end of rod, uniformly  
   distributing strokes and penetrating 25 mm (1 in.) into the underlying layer?  
   Trial 1  Trial 2

15. Sides of the mold tapped 10-15 times after rodding?  
   a. With mallet for reusable steel molds  
      Trial 1  Trial 2
   b. With the open hand for flexible light-gauge molds  
      Trial 1  Trial 2

16. Concrete struck off with tamping rod, straightedge, float, or trowel?  
   Trial 1  Trial 2

17. Specimens covered with non-absorptive, non-reactive cap or plate?  
   Trial 1  Trial 2

**Comments:**  
First attempt: Pass Fail    Second attempt: Pass Fail

Examiner Signature _______________________________ WAQTC #: __________

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SLUMP OF HYDRAULIC CEMENT CONCRETE
FOP FOR AASHTO T 119 (16)

Scope
This procedure provides instructions for determining the slump of hydraulic cement concrete in accordance with AASHTO T 119-13. It is not applicable to non-plastic and non-cohesive concrete. Concrete containing aggregate that is 37.5 mm (1 ½ in.) or larger must be wet sieved.

Warning—Fresh Hydraulic cementitious mixtures are caustic and may cause chemical burns to skin and tissue upon prolonged exposure.

Apparatus
• Mold: A metal frustum of a cone provided with foot pieces and handles. The mold must be constructed without a seam. The interior of the mold shall be relatively smooth and free from projections such as protruding rivets. The mold shall be free from dents. A mold that clamps to a rigid nonabsorbent base plate is acceptable provided the clamping arrangement is such that it can be fully released without movement of the mold.
• Mold: If other than metal, it must conform to AASHTO T 119, Sections 5.1.2.1 and 5.1.2.2.
• Tamping rod: 16 mm (5/8 in.) diameter and approximately 600 mm (24 in.) long, having a hemispherical tip the same diameter as the rod. (Hemispherical means “half a sphere”; the tip is rounded like half of a ball.)
• Scoop: a receptacle of appropriate size so that each representative increment of the concrete sample can be placed in the container without spillage.
• Tape measure or ruler with at least 5 mm or 1/8 in. graduations
• Base: Flat, rigid, non-absorbent moistened surface on which to set the slump mold

Procedure
1. Obtain the sample in accordance with the FOP for WAQTC TM 2. If any aggregate is retained on the 37.5 mm (1 ½ in.) sieve, the aggregate must be removed in accordance with the Wet Sieving portion of the FOP for WAQTC TM 2.  
   Note 1: Testing shall begin within five minutes of obtaining the sample.
2. Dampen the inside of the mold and place it on a dampened, rigid, nonabsorbent surface that is level and firm.
3. Stand on both foot pieces in order to hold the mold firmly in place.
4. Use the scoop to fill the mold 1/3 full by volume, to a depth of approximately 67 mm (2 5/8 in.) by depth.
5. Consolidate the layer with 25 strokes of the tamping rod, using the rounded end. Distribute the strokes evenly over the entire cross section of the concrete.

For this bottom layer, incline the rod slightly and make approximately half the strokes near the perimeter, and then progress with vertical strokes, spiraling toward the center.

6. Use the scoop to fill the mold 2/3 full by volume, to a depth of approximately 155 mm (6 1/8 in.) by depth.

7. Consolidate this layer with 25 strokes of the tamping rod, penetrate approximately 25 mm (1 in.) into the bottom layer. Distribute the strokes evenly.

8. Use the scoop to fill the mold to overflowing.

9. Consolidate this layer with 25 strokes of the tamping rod, penetrate approximately 25 mm (1 in.) into the second layer. Distribute the strokes evenly. If the concrete falls below the top of the mold, stop, add more concrete, and continue rodding for a total of 25 strokes. Keep an excess of concrete above the top of the mold at all times. Distribute strokes evenly as before.

10. Strike off the top surface of concrete with a screeding and rolling motion of the tamping rod.

11. Clean overflow concrete away from the base of the mold.

12. Remove the mold from the concrete by raising it carefully in a vertical direction. Raise the mold 300 mm (12 in.) in 5 ±2 seconds by a steady upward lift with no lateral or torsional (twisting) motion being imparted to the concrete.

The entire operation from the start of the filling through removal of the mold shall be carried out without interruption and shall be completed within an elapsed time of 2 1/2 minutes. Immediately measure the slump.

13. Invert the slump mold and set it next to the specimen.

14. Lay the tamping rod across the mold so that it is over the test specimen.

15. Measure the distance between the bottom of the rod and the displaced original center of the top of the specimen to the nearest 5 mm (1/4 in.).

Note 2: If a decided falling away or shearing off of concrete from one side or portion of the mass occurs, disregard the test and make a new test on another portion of the sample. If two consecutive tests on a sample of concrete show a falling away or shearing off of a portion of the concrete from the mass of the specimen, the concrete probably lacks the plasticity and cohesiveness necessary for the slump test to be applicable.

16. Discard the tested sample.

Report

- Results on forms approved by the agency
- Sample ID
- Slump to the nearest 5 mm (1/4 in.).
## PERFORMANCE EXAM CHECKLIST

### SLUMP OF HYDRAULIC CEMENT CONCRETE

**FOP FOR AASHTO T 119**

Participant Name ______________________________ Exam Date ______________

Record the symbols “P” for passing or “F” for failing on each step of the checklist.

<table>
<thead>
<tr>
<th>Procedure Element</th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>First layer</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>1. Mold and floor or base plate dampened?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>2. Mold held firmly against the base by standing on the two foot pieces? Mold not allowed to move in any way during filling?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>3. Representative sample scooped into the mold, moving a scoop around the perimeter of the mold to evenly distribute the concrete as discharged?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>4. Mold approximately one third (by volume), 67 mm (2 5/8 in.) deep?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>5. Layer rodded throughout its depth 25 times with hemispherical end of rod, uniformly distributing strokes?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td><strong>Second layer</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>6. Representative samples scooped into the mold, moving a scoop around the perimeter of the mold to evenly distribute the concrete as discharged?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>7. Mold filled approximately two thirds (by volume), 155 mm (6 1/8 in.), deep?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>8. Layer rodded throughout its depth 25 times with hemispherical end of rod, uniformly distributing strokes, penetrate approximately 25 mm (1 in.) into the bottom layer?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td><strong>Third layer</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>9. Representative sample scooped into the mold, moving a scoop around the perimeter of the mold to evenly distribute the concrete as discharged??</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>10. Mold filled to just over the top of the mold?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>11. Layer rodded throughout its depth 25 times with hemispherical end of rod, uniformly distributing strokes, penetrate approximately 25 mm (1 in.) into the second layer?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>12. Excess concrete kept above the mold at all times while rodding?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>13. Concrete struck off level with top of mold using tamping rod?</td>
<td>_____</td>
<td>_____</td>
</tr>
</tbody>
</table>

**OVER**
**Procedure Element**

<table>
<thead>
<tr>
<th></th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>14. Concrete removed from around the outside bottom of the mold?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>15. Mold lifted upward 300 mm (12 in.) in one smooth motion, without a lateral or twisting motion of the mold, in 5 ±2 seconds?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>16. Test performed from start of filling through removal of the mold within 2 1/2 minutes?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>17. Slump immediately measured to the nearest 5 mm (1/4 in.) from the top of the mold to the displaced original center of the top surface of the specimen?</td>
<td>_____</td>
<td>_____</td>
</tr>
</tbody>
</table>

**Comments:**

First attempt: Pass _____ Fail _____

Second attempt: Pass _____ Fail _____

Examiner Signature _______________________________ WAQTC #: ________________

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DENSITY (UNIT WEIGHT), YIELD, AND AIR CONTENT (GRAVIMETRIC) OF CONCRETE
FOP FOR AASHTO T 121 (16)

Scope

This procedure covers the determination of density, or unit weight, of freshly mixed concrete in accordance with AASHTO T 121-16. It also provides formulas for calculating the volume of concrete produced from a mixture of known quantities of component materials, and provides a method for calculating cement content and cementitious material content – the mass of cement or cementitious material per unit volume of concrete. A procedure for calculating water/cement ratio is also covered.

Warning—Fresh Hydraulic cementitious mixtures are caustic and may cause chemical burns to skin and tissue upon prolonged exposure.

Apparatus

- Measure: May be the bowl portion of the air meter used for determining air content under the FOP for AASHTO T 152. Otherwise, it shall be a metal cylindrical container meeting the requirements of AASHTO T 121. The capacity and dimensions of the measure shall conform to those specified in Table 1.

- Balance or scale: Accurate to within 45 g (0.1 lb) or 0.3 percent of the test load, whichever is greater, at any point within the range of use.

- Tamping rod: 16 mm (5/8 in.) diameter and approximately 600 mm (24 in.) long, having a hemispherical tip the same diameter as the rod. (Hemispherical means “half a sphere”; the tip is rounded like half of a ball.)

- Vibrator: 7000 vibrations per minute, 19 to 38 mm (3/4 to 1 1/2 in.) in diameter, and the length of the shaft shall be at least 610 mm (24 in.).

- Scoop: a receptacle of appropriate size so that each representative increment of the concrete sample can be placed in the container without spillage.

- Strike-off plate: A flat rectangular metal plate at least 6 mm (1/4 in.) thick or a glass or acrylic plate at least 12 mm (1/2 in.) thick, with a length and width at least 50 mm (2 in.) greater than the diameter of the measure with which it is to be used. The edges of the plate shall be straight and smooth within tolerance of 1.5 mm (1/16 in.).

- Mallet: With a rubber or rawhide head having a mass of 0.57 ±0.23 kg (1.25 ±0.5 lb) for use with measures of 0.014 m³ (1/2 ft³) or less, or having a mass of 1.02 ±0.23 kg (2.25 ±0.5 lb) for use with measures of 0.028 m³ (1 ft³).
### Table 1: Dimensions of Measures*

<table>
<thead>
<tr>
<th>Capacity $m^3$ (ft$^3$)</th>
<th>Inside Diameter mm (in.)</th>
<th>Inside Height mm (in.)</th>
<th>Minimum Thicknesses Bottom mm (in.)</th>
<th>Minimum Thicknesses Wall mm (in.)</th>
<th>Nominal Maximum Size of Coarse Aggregate*** mm (in.)</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td></td>
<td><em>(0.20)</em></td>
<td><em>(0.12)</em></td>
<td><em>(1)</em></td>
</tr>
<tr>
<td>0.0071</td>
<td>203 ±2.54</td>
<td>213 ±2.54</td>
<td>5.1</td>
<td>3.0</td>
<td>25</td>
</tr>
<tr>
<td>(1/4)**</td>
<td><em>(8.0 ±0.1)</em></td>
<td><em>(8.4 ±0.1)</em></td>
<td><em>(0.20)</em></td>
<td><em>(0.12)</em></td>
<td><em>(1)</em></td>
</tr>
<tr>
<td>0.0142</td>
<td>254 ±2.54</td>
<td>279 ±2.54</td>
<td>5.1</td>
<td>3.0</td>
<td>50</td>
</tr>
<tr>
<td>(1/2)</td>
<td><em>(10.0 ±0.1)</em></td>
<td><em>(11.0 ±0.1)</em></td>
<td><em>(0.20)</em></td>
<td><em>(0.12)</em></td>
<td><em>(2)</em></td>
</tr>
<tr>
<td>0.0283</td>
<td>356 ±2.54</td>
<td>284 ±2.54</td>
<td>5.1</td>
<td>3.0</td>
<td><em>(3)</em></td>
</tr>
<tr>
<td>(1)</td>
<td><em>(14.0 ±0.1)</em></td>
<td><em>(11.2 ±0.1)</em></td>
<td><em>(0.20)</em></td>
<td><em>(0.12)</em></td>
<td></td>
</tr>
</tbody>
</table>

*Note:* The indicated size of measure shall be for aggregates of nominal maximum size equal to or smaller than that listed.

** Measure may be the base of the air meter used in the FOP for AASHTO T 152.

*** Nominal maximum size: One sieve larger than the first sieve to retain more than 10 percent of the material using an agency specified set of sieves based on cumulative percent retained. Where large gaps in specification sieves exist, intermediate sieve(s) may be inserted to determine nominal maximum size.

### Standardization of Measure

Standardization is a critical step to ensure accurate test results when using this apparatus. Failure to perform the standardization procedures as described herein will produce inaccurate or unreliable test results.

1. Determine the mass of the dry measure and strike-off plate.

2. Fill the measure with water at a temperature between 16°C and 29°C (60°F and 85°F) and cover with the strike-off plate in such a way as to eliminate bubbles and excess water.

3. Wipe the outside of the measure and cover plate dry, being careful not to lose any water from the measure.

4. Determine the mass of the measure, strike-off plate, and water in the measure.

5. Determine the mass of the water in the measure by subtracting the mass in Step 1 from the mass in Step 4.

6. Measure the temperature of the water and determine its density from Table 2, interpolating as necessary.

7. Calculate the volume of the measure, $V_m$, by dividing the mass of the water in the measure by the density of the water at the measured temperature, from Table 2.
\[
V_m = \frac{\text{Mass of Water}}{\text{Density of Water}}
\]

Example: at 23°C (73.4°F)

\[
V_m = \frac{7.062 \text{ kg}}{997.54 \text{ kg/m}^3} = 0.007079 \text{ m}^3 \quad V_m = \frac{15.53 \text{ lb}}{62.274 \text{ lb/ft}^3} = 0.2494 \text{ ft}^3
\]

Table 2
Unit Mass of Water
15°C to 30°C

<table>
<thead>
<tr>
<th>°C</th>
<th>(°F)</th>
<th>kg/m³</th>
<th>(lb/ft³)</th>
<th>°C</th>
<th>(°F)</th>
<th>kg/m³</th>
<th>(lb/ft³)</th>
</tr>
</thead>
<tbody>
<tr>
<td>15</td>
<td>(59.0)</td>
<td>999.10</td>
<td>(62.372)</td>
<td>23</td>
<td>(73.4)</td>
<td>997.54</td>
<td>(62.274)</td>
</tr>
<tr>
<td>15.6</td>
<td>(60.0)</td>
<td>999.01</td>
<td>(62.366)</td>
<td>23.9</td>
<td>(75.0)</td>
<td>997.32</td>
<td>(62.261)</td>
</tr>
<tr>
<td>16</td>
<td>(60.8)</td>
<td>998.94</td>
<td>(62.361)</td>
<td>24</td>
<td>(75.2)</td>
<td>997.29</td>
<td>(62.259)</td>
</tr>
<tr>
<td>17</td>
<td>(62.6)</td>
<td>998.77</td>
<td>(62.350)</td>
<td>25</td>
<td>(77.0)</td>
<td>997.03</td>
<td>(62.243)</td>
</tr>
<tr>
<td>18</td>
<td>(64.4)</td>
<td>998.60</td>
<td>(62.340)</td>
<td>26</td>
<td>(78.8)</td>
<td>996.77</td>
<td>(62.227)</td>
</tr>
<tr>
<td>18.3</td>
<td>(65.0)</td>
<td>998.54</td>
<td>(62.336)</td>
<td>26.7</td>
<td>(80.0)</td>
<td>996.59</td>
<td>(62.216)</td>
</tr>
<tr>
<td>19</td>
<td>(66.2)</td>
<td>998.40</td>
<td>(62.328)</td>
<td>27</td>
<td>(80.6)</td>
<td>996.50</td>
<td>(62.209)</td>
</tr>
<tr>
<td>20</td>
<td>(68.0)</td>
<td>998.20</td>
<td>(62.315)</td>
<td>28</td>
<td>(82.4)</td>
<td>996.23</td>
<td>(62.192)</td>
</tr>
<tr>
<td>21</td>
<td>(69.8)</td>
<td>997.99</td>
<td>(62.302)</td>
<td>29</td>
<td>(84.2)</td>
<td>995.95</td>
<td>(62.175)</td>
</tr>
<tr>
<td>21.1</td>
<td>(70.0)</td>
<td>997.97</td>
<td>(62.301)</td>
<td>29.4</td>
<td>(85.0)</td>
<td>995.83</td>
<td>(62.166)</td>
</tr>
<tr>
<td>22</td>
<td>(71.6)</td>
<td>997.77</td>
<td>(62.288)</td>
<td>30</td>
<td>(86.0)</td>
<td>995.65</td>
<td>(62.156)</td>
</tr>
</tbody>
</table>

Procedure Selection

There are two methods of consolidating the concrete – rodding and vibration. If the slump is greater than 75 mm (3 in.), consolidation is by rodding. When the slump is 25 to 75 mm (1 to 3 in.), internal vibration or rodding can be used to consolidate the sample, but the method used must be that required by the agency in order to obtain consistent, comparable results. For slumps less than 25 mm (1 in.), consolidate the sample by internal vibration. Do not consolidate self-consolidating concrete (SCC).

When using measures greater than 0.0142 m³ (1/2 ft³) see AASHTO T 121.

Procedure – Rodding

1. Obtain the sample in accordance with the FOP for WAQTC TM 2. Testing may be performed in conjunction with the FOP for AASHTO T 152. When doing so, this FOP should be performed prior to the FOP for AASHTO T 152.

   \textbf{Note 1:} If the two tests are being performed using the same sample, this test shall begin within five minutes of obtaining the sample.

2. Determine the mass of the dry empty measure.

3. Dampen the inside of the measure.
4. Use the scoop to fill the measure approximately 1/3 full with concrete. Evenly distribute the concrete in a circular motion around the inner perimeter of the measure.

5. Consolidate the layer with 25 strokes of the tamping rod, using the rounded end. Distribute the strokes evenly over the entire cross section of the concrete. Rod throughout its depth without hitting the bottom too hard.

6. Tap around the perimeter of the measure smartly 10 to 15 times with the mallet to close voids and release trapped air.

7. Add the second layer, filling the measure about 2/3 full. Evenly distribute the concrete in a circular motion around the inner perimeter of the measure.

8. Consolidate this layer with 25 strokes of the tamping rod, penetrating about 25 mm (1 in.) into the bottom layer.

9. Tap around the perimeter of the measure smartly 10 to 15 times with the mallet.

10. Add the final layer, slightly overfilling the measure. Evenly distribute the concrete in a circular motion around the inner perimeter of the measure.

11. Consolidate this layer with 25 strokes of the tamping rod, penetrating about 25 mm (1 in.) into the second layer.

12. Tap around the perimeter of the measure smartly 10 to 15 times with the mallet.

   Note 2: The measure should be slightly over full, about 3 mm (1/8 in.) above the rim. If there is a great excess of concrete, remove a portion with the scoop. If the measure is under full, add a small quantity. This adjustment may be done only after consolidating the final layer and before striking off the surface of the concrete.

13. Strike off by pressing the strike-off plate flat against the top surface, covering approximately 2/3 of the measure. Withdraw the strike-off plate with a sawing motion to finish the 2/3 originally covered. Cover the original 2/3 again with the plate; finishing the remaining 1/3 with a sawing motion (do not lift the plate; continue the sawing motion until the plate has cleared the surface of the measure). Final finishing may be accomplished with several strokes with the inclined edge of the strike-off plate. The surface should be smooth and free of voids.

14. Clean off all excess concrete from the exterior of the measure including the rim.

15. Determine and record the mass of the measure and the concrete.

16. If the air content of the concrete is to be determined, proceed to Rodding Procedure Step 13 of the FOP for AASHTO T 152.
Procedure - Internal Vibration

1. Perform Steps 1 through 3 of the rodding procedure.

2. Use the scoop to fill the measure approximately 1/2 full with concrete. Evenly distribute the concrete in a circular motion around the inner perimeter of the measure.

3. Insert the vibrator at three different points in each layer. Do not let the vibrator touch the bottom or side of the measure.

   Note 3: Remove the vibrator slowly, so that no air pockets are left in the material.

   Note 4: Continue vibration only long enough to achieve proper consolidation of the concrete. Over vibration may cause segregation and loss of appreciable quantities of intentionally entrained air.

4. Fill the measure a bit over full. Evenly distribute the concrete in a circular motion around the inner perimeter of the measure.

5. Insert the vibrator as in Step 3. Do not let the vibrator touch the side of the measure, but do penetrate the first layer approximately 25 mm (1 in.).

6. Return to Step 13 of the rodding procedure and continue.

Procedure – Self Consolildating Concrete

1. Perform Steps 1 through 3 of the rodding procedure.

2. Use the scoop to fill the measure a bit overfull. Evenly distribute the concrete in a circular motion around the inner perimeter of the measure.

3. Complete steps 13 thru 16 of the rodding procedure.

Calculations

- **Density** – Calculate the net mass, \( M_m \), of the concrete in the measure by subtracting the mass of the measure from the gross mass of the measure plus the concrete. Calculate the density, \( W \), by dividing the net mass, \( M_m \), by the volume, \( V_m \), of the measure as shown below.

\[
W = \frac{M_m}{V_m}
\]

Example: \( W = \frac{16.920 \text{ kg}}{0.007079 \text{ m}^3} = 2390 \text{ kg/m}^3 \) \( W = \frac{36.06 \text{ lb}}{0.2494 \text{ ft}^3} = 144.6 \text{ lb/ft}^3 \)
• **Yield** – Calculate the yield, \( Y \) (m\(^3\) or yd\(^3\)), or volume of concrete produced per batch, by dividing the total mass of the batch, \( W_1 \), by the density, \( W \), of the concrete as shown below.

\[
Y_m^3 = \frac{W_1}{W} \quad \text{Example: } Y_m^3 = \frac{2436 \text{ kg}}{2390 \text{ kg/m}^3} = 1.02 \text{ m}^3
\]

\[
Y_f^3 = \frac{W_1}{W} \quad Y_{yd}^3 = \frac{Y_f t^3}{27 \text{ ft}^3/\text{yd}^3}
\]

Example: \( Y_f^3 = \frac{3978 \text{ lb}}{144.6 \text{ lb/ft}^3} = 27.51 \text{ ft}^3 \quad Y_{yd}^3 = \frac{27.51 \text{ ft}^3}{27 \text{ ft}^3/\text{yd}^3} = 1.02 \text{ yd}^3 \)

**Note 5:** The total mass, \( W_1 \), includes the masses of the cement, water, and aggregates in the concrete.

• **Cement Content** – Calculate the actual cement content, \( N \), by dividing the mass of the cement, \( N_t \), by the yield, \( Y \), as shown below.

\[
N = \frac{N_t}{Y} \quad \text{Example: } N = \frac{261 \text{ kg}}{1.02 \text{ m}^3} = 256 \text{ kg/m}^3 \quad N = \frac{602 \text{ lb}}{1.02 \text{ yd}^3} = 590 \text{ lb/yd}^3
\]

**Note 6:** Specifications may require Portland cement content and cementitious materials content

• **Water Content** – Calculate the mass of water in a batch of concrete by summing the:
  
  - water added at batch plant
  - water added in transit
  - water added at jobsite
  - free water on coarse aggregate
  - free water on fine aggregate
  - liquid admixtures (if the agency requires this)
This information is obtained from concrete batch tickets collected from the driver. Use the following conversion factors.

<table>
<thead>
<tr>
<th>To Convert From</th>
<th>To</th>
<th>Multiply By</th>
</tr>
</thead>
<tbody>
<tr>
<td>Liters, L</td>
<td>Kilograms, kg</td>
<td>1.0</td>
</tr>
<tr>
<td>Gallons, gal</td>
<td>Kilograms, kg</td>
<td>3.785</td>
</tr>
<tr>
<td>Gallons, gal</td>
<td>Pounds, lb</td>
<td>8.34</td>
</tr>
<tr>
<td>Milliliters, mL</td>
<td>Kilograms, kg</td>
<td>0.001</td>
</tr>
<tr>
<td>Ounces, oz</td>
<td>Milliliters, mL</td>
<td>28.4</td>
</tr>
<tr>
<td>Ounces, oz</td>
<td>Kilograms, kg</td>
<td>0.0284</td>
</tr>
<tr>
<td>Ounces, oz</td>
<td>Pounds, lb</td>
<td>0.0625</td>
</tr>
<tr>
<td>Pounds, lb</td>
<td>Kilograms, kg</td>
<td>0.4536</td>
</tr>
</tbody>
</table>

Calculate the mass of free water on aggregate as follows:

\[
Free \text{ Water Mass} = Total \text{ Aggregate Mass} - \frac{Total \text{ Aggregate Mass}}{1 + (\text{Free Water Percentage}/100)}
\]

**Example:**

Total Wet Aggregate Mass = 3540 kg (7804 lb)

Free Water Percentage = 1.7*

* To determine Free Water percentage:

Total moisture content of the aggregates – absorbed moisture = Free Water

\[
Free \text{ Water Mass} = 3540 \text{ kg} - \frac{3540 \text{ kg}}{1 + (1.7/100)} = \frac{7804 \text{ lb}}{1 + (1.7/100)}
\]

Example for actual water content:

Water added at batch plant = 300 L  79 gal  
Water added in transit = 0 L  
Water added at jobsite = 40 L  11 gal  
340 L = 340 kg  
90 gal = 751 lb

Coarse aggregate:  3540 kg (7804 lbs) @ 1.7% free water

Fine aggregate:  2490 kg (5489 lb) @ 5.9% free water
Concrete 4-8

Report

- Results on forms approved by the agency
- Sample ID
- Density (unit weight) to 1 kg/m³ (0.1 lb/ft³)
- Yield to 0.01 m³ (0.01 yd³)
- Cement content to 1 kg/m³ (1 lb/yd³)
- Cementitious material content to 1 kg/m³ (1 lb/yd³)
- Water/Cement ratio to 0.01

\[ \frac{CA \, Free \, Water}{1 + (1.7/100)} = 59 \, kg \quad 7804 \, lb \quad 1 + (1.7/100) = 130 \, lb \]

\[ FA \, Free \, Water = 2490 \, kg \quad 1 + (5.9/100) = 139 \, kg \, or \]

\[ FA \, Free \, Water = 5489 \, lb \quad 1 + (5.9/100) = 306 \, lb \]

Mass of water in batch = 340 kg + 59 kg + 139 kg = 538 kg
751 lb + 130 lb + 306 lb = 1187 lb

**Water/Cement Ratio** – Calculate the water/cement ratio by dividing the mass of water in a batch of concrete by the mass of cementitious material in the batch. The masses of the cementitious materials are obtained from concrete batch tickets collected from the driver.

Example:

Cement: 950 kg
Fly Ash: 180 kg
Water: 538 kg (from previous example)

\[ \frac{W/C}{950 \, kg + 180 \, kg} = 0.476 \quad \frac{W/C}{2094 \, lb + 397 \, lb} = 0.477 \]

Report 0.48
# PERFORMANCE EXAM CHECKLIST

**DENSITY (UNIT WEIGHT), YIELD, AND AIR CONTENT (GRAVIMETRIC) OF CONCRETE**  
**FOP FOR AASHTO T 121**

Participant Name ______________________________ Exam Date ______________

Record the symbols “P” for passing or “F” for failing on each step of the checklist.

<table>
<thead>
<tr>
<th>Procedure Element</th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>1. Mass and volume of empty measure determined?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td><strong>First Layer</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>2. Damptenened measure filled approximately one third full, moving a scoop around the perimeter of the measure to evenly distribute the concrete as discharged?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>3. Layer rodded throughout its depth 25 times, without forcibly striking the bottom of the measure, with hemispherical end of rod, uniformly distributing strokes?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>4. Perimeter of the measure tapped 10 to 15 times with the mallet after rodding?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td><strong>Second layer</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>5. Measure filled approximately two thirds full, moving a scoop around the perimeter of the measure to evenly distribute the concrete as discharged?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>6. Layer rodded throughout its depth, just penetrating the previous layer (approximately 25 mm (1 in.)) 25 times with hemispherical end of rod, uniformly distributing strokes?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>7. Perimeter of the measure tapped 10 to 15 times with the mallet after rodding?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td><strong>Third layer</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>8. Measure filled, moving a scoop around the perimeter of the measure to evenly distribute the concrete as discharged?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>9. Layer rodded throughout its depth, just penetrating the previous layer (approximately 25 mm (1 in.)) 25 times with hemispherical end of rod, uniformly distributing strokes?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>10. Perimeter of the measure tapped 10 to 15 times with the mallet after rodding each layer?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>11. Any excess concrete removed using a trowel or a scoop, or small quantity of concrete added to correct a deficiency, after consolidation of final layer?</td>
<td>_____</td>
<td>_____</td>
</tr>
</tbody>
</table>
Procedure Element

12. Strike-off plate placed flat on the measure covering approximately 2/3 of the surface, then sawing action used to withdraw the strike-off plate across the previously covered surface? _____ _____

13. Strike-off plate placed flat on the measure covering approximately 2/3 of the surface, then sawing action used to advance the plate across the entire measure surface? _____ _____

14. Strike off completed using the inclined edge of the plate creating a smooth surface? _____ _____

15. All excess concrete cleaned off and mass of full measure determined? _____ _____

16. Net mass calculated? _____ _____

17. Density calculated correctly? _____ _____

Comments: First attempt: Pass Fail Second attempt: Pass Fail _____ _____

Examiner Signature _______________________________ WAQTC #:_______________

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AIR CONTENT OF FRESHLY MIXED CONCRETE BY THE PRESSURE METHOD
FOP for AASHTO T 152 (16)

Scope
This procedure covers determination of the air content in freshly mixed Portland Cement
Concrete containing dense aggregates in accordance with AASHTO T 152-16, Type B meter.
It is not for use with lightweight or highly porous aggregates. This procedure includes
standardization of the Type B air meter gauge, and two methods for standardizing the gauge
are presented.

Concrete containing aggregate that is 37.5 mm (1 ½ in.) or larger must be wet sieved.

Warning—Fresh Hydraulic cementitious mixtures are caustic and may cause chemical burns
to skin and tissue upon prolonged exposure.

Apparatus
- Air meter: Type B, as described in AASHTO T 152
- Balance or scale: Accurate to 0.3 percent of the test load at any point within the range of
  use (for Method 1 standardization only)
- Tamping rod: 16 mm (5/8 in.) diameter and approximately 600 mm (24 in.) long, having
  a hemispherical tip the same diameter as the rod. (Hemispherical means “half a sphere”;
  the tip is rounded like half of a ball.)
- Vibrator: 7000 vibrations per minute, 19 to 38 mm (0.75 to 1.50 in.) in diameter, at least
  75 mm (3 in.) longer than the section being vibrated for use with low slump concrete
- Scoop: a receptacle of appropriate size so that each representative increment of the
  concrete sample can be placed in the container without spillage.
- Container for water: rubber syringe (may also be a squeeze bottle)
- Strike-off bar: Approximately 300 mm x 22 mm x 3 mm (12 in. x 3/4 in. x 1/8 in.)
- Strike-off plate: A flat rectangular metal plate at least 6 mm (1/4 in.) thick or a glass or
  acrylic plate at least 12 mm (1/2 in.) thick, with a length and width at least 50 mm (2 in.)
  greater than the diameter of the measure with which it is to be used. The edges of the
  plate shall be straight and smooth within tolerance of 1.5 mm (1/16 in.).
  Note 1: Use either the strike-off bar or strike-off plate; both are not required.
- Mallet: With a rubber or rawhide head having a mass of 0.57 ±0.23 kg (1.25 ±0.5 lb)
Standardization of Air Meter Gauge

Standardization is a critical step to ensure accurate test results when using this apparatus. Failure to perform the standardization procedures as described below will produce inaccurate or unreliable test results.

Standardization shall be performed at a minimum of once every three months. Record the date of the standardization, the standardization results, and the name of the technician performing the standardization in the log book kept with each air meter.

There are two methods for standardizing the air meter, mass or volume, both are covered below.

1. Screw the short piece of straight tubing into the threaded petcock hole on the underside of the cover. Determine the mass of the dry, empty air meter measure and cover assembly (mass method only).

2. Fill the measure nearly full with water.

3. Clamp the cover on the measure with the tube extending down into the water. Mark the petcock with the tube attached for future reference.

4. Add water through the petcock having the pipe extension below until all air is forced out the other petcock. Rock the meter slightly until all air is expelled through the petcock.

5. Wipe off the air meter measure and cover assembly, and determine the mass of the filled unit (mass method only).

6. Pump up the air pressure to a little beyond the predetermined initial pressure indicated on the gauge. Wait a few seconds for the compressed air to cool, and then stabilize the gauge hand at the proper initial pressure by pumping up or relieving pressure, as needed.

7. Close both petcocks and immediately open the main air valve exhausting air into the measure. Wait a few seconds until the meter needle stabilizes. The gauge should now read 0 percent. If two or more tests show a consistent variation from 0 percent in the result, change the initial pressure line to compensate for the variation, and use the newly established initial pressure line for subsequent tests.

8. Determine which petcock has the straight tube attached to it. Attach the curved tube to external portion of the same petcock.

9. Pump air into the air chamber. Open the petcock with the curved tube attached to it. Open the main air valve for short periods of time until 5 percent of water by mass or volume has been removed from the air meter. Remember to open both petcocks to release the pressure in the measure and drain the water in the curved tube back into the measure. To determine the mass of the water to be removed, subtract the mass found in Step 1 from the mass found in Step 5. Multiply this value by 0.05. This is the mass of the water that must be removed. To remove 5 percent by volume, remove water until the external standardization vessel is level full.

Note 2: Many air meters are supplied with a standardization vessel(s) of known volume that are used for this purpose. Standardization vessel must be protected from crushing or denting. If an external standardization vessel is used, confirm what percentage volume it represents for the air meter being used. Vessels commonly represent 5 percent volume, but they are for specific size meters. This should be confirmed by mass.
10. Remove the curved tube. Pump up the air pressure to a little beyond the predetermined initial pressure indicated on the gauge. Wait a few seconds for the compressed air to cool, and then stabilize the gauge hand at the proper initial pressure by pumping up or relieving pressure, as needed.

11. Close both petcocks and immediately open the main air valve exhausting air into the measure. Wait a few seconds until the meter needle is stabilized. The gauge should now read 5.0 ±0.1 percent. If the gauge is outside that range, the meter needs adjustment. The adjustment could involve adjusting the starting point so that the gauge reads 5.0 ±0.1 percent when this standardization is run, or could involve moving the gauge needle to read 5.0 percent. Any adjustment should comply with the manufacturer’s recommendations.

12. When the gauge hand reads correctly at 5.0 percent, additional water may be withdrawn in the same manner to check the results at other values such as 10 percent or 15 percent.

13. If an internal standardization vessel is used, follow steps 1 through 8 to set initial reading.

14. Release pressure from the measure and remove cover. Place the internal standardization vessel into the measure. This will displace 5 percent of the water in the measure. (See AASHTO T 152 for more information on internal standardization vessels.)

15. Place the cover back on the measure and add water through the petcock until all the air has been expelled.

16. Pump up the air pressure chamber to the initial pressure. Wait a few seconds for the compressed air to cool, and then stabilize the gauge hand at the proper initial pressure by pumping up or relieving pressure, as needed.

17. Close both petcocks and immediately open the main air valve exhausting air into the measure. Wait a few seconds until the meter needle stabilizes. The gauge should now read 5 percent.

18. Remove the extension tubing from threaded petcock hole in the underside of the cover before starting the test procedure.

Procedure Selection
There are two methods of consolidating the concrete – rodding and vibration. If the slump is greater than 75 mm (3 in.), consolidation is by rodding. When the slump is 25 to 75 mm (1 to 3 in.), internal vibration or rodding can be used to consolidate the sample, but the method used must be that required by the agency in order to obtain consistent, comparable results. For slumps less than 25 mm (1 in.), consolidate the sample by internal vibration. Do not consolidate self-consolidating concrete (SCC).
Procedure – Rodding

1. Obtain the sample in accordance with the FOP for WAQTC TM 2. If any aggregate 37.5 mm (1½ in.) or larger is present, aggregate must be removed in accordance with the Wet Sieving portion of the FOP for WAQTC TM 2.

Note 3: Testing shall begin within five minutes of obtaining the sample.

2. Dampen the inside of the air meter measure and place on a firm level surface.

3. Use the scoop to fill the measure approximately 1/3 full with concrete. Evenly distribute the concrete in a circular motion around the inner perimeter of the measure.

4. Consolidate the layer with 25 strokes of the tamping rod, using the rounded end. Distribute the strokes evenly over the entire cross section of the concrete. Rod throughout its depth without hitting the bottom too hard.

5. Tap around the perimeter of the measure smartly 10 to 15 times with the mallet to close voids and release trapped air.

6. Add the second layer, filling the measure about 2/3 full. Evenly distribute the concrete in a circular motion around the inner perimeter of the measure.

7. Consolidate this layer with 25 strokes of the tamping rod, penetrating about 25 mm (1 in.) into the bottom layer.

8. Tap around the perimeter of the measure smartly 10 to 15 times with the mallet.

9. Add the final layer, slightly overfilling the measure. Evenly distribute the concrete in a circular motion around the inner perimeter of the measure.

10. Consolidate this layer with 25 strokes of the tamping rod, penetrating about 25 mm (1 in.) into the second layer.

11. Tap around the perimeter of the measure smartly 10 to 15 times with the mallet.

Note 4: The measure should be slightly over full, about 3 mm (1/8 in.) above the rim. If there is a great excess of concrete, remove a portion with the trowel or scoop. If the measure is under full, add a small quantity. This adjustment may be done only after consolidating the final layer and before striking off the surface of the concrete.

12. Strike off the surface of the concrete and finish it smoothly with a sawing action of the strike-off bar or plate, using great care to leave the measure just full. The surface should be smooth and free of voids.

13. Clean the top flange of the measure to ensure a proper seal.

14. Moisten the inside of the cover and check to see that both petcocks are open and the main air valve is closed.

15. Clamp the cover on the measure.

16. Inject water through a petcock on the cover until water emerges from the petcock on the other side.

17. Incline slightly and gently rock the air meter until no air bubbles appear to be coming out of the second petcock. The petcock expelling water should be higher than the petcock
where water is being injected. Return the air meter to a level position and verify that water is present in both petcocks.

18. Close the air bleeder valve and pump air into the air chamber until the needle goes past the initial pressure determined for the gauge. Allow a few seconds for the compressed air to cool.

19. Tap the gauge gently with one hand while slowly opening the air bleeder valve until the needle rests on the initial pressure. Close the air bleeder valve.

20. Close both petcocks.

21. Open the main air valve.

22. Tap around the perimeter of the measure smartly with the mallet.

23. With the main air valve open, lightly tap the gauge to settle the needle, and then read the air content to the nearest 0.1 percent.

24. Release or close the main air valve.

25. Open both petcocks to release pressure, remove the concrete, and thoroughly clean the cover and measure with clean water.

26. Open the main air valve to relieve the pressure in the air chamber.

**Procedure - Internal Vibration**

1. Obtain the sample in accordance with the FOP for WAQTC TM 2. If any aggregate 37.5mm (1½ in.) or larger is present, aggregate must be removed in accordance with the Wet Sieving portion of the FOP for WAQTC TM 2.

2. Dampen the inside of the air meter measure and place on a firm level surface.

3. Use the scoop to fill the measure approximately 1/2 full with concrete. Evenly distribute the concrete in a circular motion around the inner perimeter of the measure.

4. Insert the vibrator at three different points. Do not let the vibrator touch the bottom or side of the measure. Remove the vibrator slowly, so that no air pockets are left in the material. Continue vibration only long enough to achieve proper consolidation of the concrete. Over vibration may cause segregation and loss of appreciable quantities of intentionally entrained air.

5. Use the scoop to fill the measure a bit over full. Evenly distribute the concrete in a circular motion around the inner perimeter of the measure.

6. Insert the vibrator as in Step 4. Do not let the vibrator touch the side of the measure, and penetrate the first layer approximately 25 mm (1 in.). Remove the vibrator slowly, so that no air pockets are left in the material. Continue vibration only long enough to achieve proper consolidation of the concrete. Over vibration may cause segregation and loss of appreciable quantities of intentionally entrained air.

7. Return to Step 12 of the rodding procedure and continue.
**Procedure – Self Consolidating Concrete**

1. Obtain the sample in accordance with the FOP for WAQTC TM 2.
2. Dampen the inside of the air meter measure and place on a firm level surface.
3. Use the scoop to fill the measure a bit overfull. Evenly distribute the concrete in a circular motion around the inner perimeter of the measure.

**Report**

- Results on forms approved by the agency
- Sample ID
- Percent of air to the nearest 0.1 percent.
- Some agencies require an aggregate correction factor in order to determine total percent of entrained air.

  Total % entrained air = Gauge reading – aggregate correction factor from mix design

(See AASHTO T 152 for more information.)
PERFORMANCE EXAM CHECKLIST

AIR CONTENT OF FRESHLY MIXED CONCRETE BY THE PRESSURE METHOD
FOP FOR AASHTO T 152

Participant Name ______________________________ Exam Date ______________

Record the symbols “P” for passing or “F” for failing on each step of the checklist.

<table>
<thead>
<tr>
<th>Procedure Element</th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>1. Representative sample selected?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>2. First Layer</td>
<td></td>
<td></td>
</tr>
<tr>
<td>3. Layer rodded throughout its depth 25 times, without forcibly striking the bottom of the measure, with hemispherical end of rod, uniformly distributing strokes?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>4. Perimeter of the measure tapped 10 to 15 times with the mallet after rodding?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>5. Second layer</td>
<td></td>
<td></td>
</tr>
<tr>
<td>6. Layer rodded throughout its depth, just penetrating the previous layer (approximately 25 mm (1 in.)) 25 times with hemispherical end of rod, uniformly distributing strokes?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>7. Perimeter of the measure tapped 10 to 15 times with the mallet after rodding?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>8. Third layer</td>
<td></td>
<td></td>
</tr>
<tr>
<td>9. Layer rodded throughout its depth, just penetrating the previous layer (approximately 25 mm (1 in.)) 25 times with hemispherical end of rod, uniformly distributing strokes?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>10. Perimeter of the measure tapped 10 to 15 times with the mallet after rodding each layer?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>11. Concrete struck off level with top of the measure using the bar or strike-off plate and rim cleaned off?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>12. Top flange of base cleaned?</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

OVER
<table>
<thead>
<tr>
<th>Procedure Element</th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>Using a Type B Meter:</td>
<td></td>
<td></td>
</tr>
<tr>
<td>13. Both petcocks open?</td>
<td>____</td>
<td>____</td>
</tr>
<tr>
<td>14. Air valve closed between air chamber and the measure?</td>
<td>____</td>
<td>____</td>
</tr>
<tr>
<td>15. Inside of cover cleaned and moistened before clamping to base?</td>
<td>____</td>
<td>____</td>
</tr>
<tr>
<td>16. Water injected through petcock until it flows out the other petcock?</td>
<td>____</td>
<td>____</td>
</tr>
<tr>
<td>17. Water injection into the petcock continued while jarring and or rocking the meter to insure all air is expelled?</td>
<td>____</td>
<td>____</td>
</tr>
<tr>
<td>18. Air pumped up to just past initial pressure line?</td>
<td>____</td>
<td>____</td>
</tr>
<tr>
<td>19. A few seconds allowed for the compressed air to stabilize?</td>
<td>____</td>
<td>____</td>
</tr>
<tr>
<td>20. Gauge adjusted to the initial pressure?</td>
<td>____</td>
<td>____</td>
</tr>
<tr>
<td>22. Air valve opened between chamber and measure?</td>
<td>____</td>
<td>____</td>
</tr>
<tr>
<td>23. The outside of measure tapped smartly with the mallet?</td>
<td>____</td>
<td>____</td>
</tr>
<tr>
<td>24. With the main air valve open, gauge lightly tapped and air percentage read to the nearest 0.1 percent?</td>
<td>____</td>
<td>____</td>
</tr>
<tr>
<td>25. Air valve released or closed and then petcocks opened to release pressure before removing the cover?</td>
<td>____</td>
<td>____</td>
</tr>
<tr>
<td>26. Aggregate correction factor applied if required?</td>
<td>____</td>
<td>____</td>
</tr>
<tr>
<td>27. Air content recorded to 0.1 percent?</td>
<td>____</td>
<td>____</td>
</tr>
</tbody>
</table>

Comments: First attempt: Pass Fail Second attempt: Pass Fail

Examiner Signature _______________________________ WAQTC #: ___________________

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TEMPERATURE OF FRESHLY MIXED PORTLAND CEMENT CONCRETE
FOP FOR AASHTO T 309 (15)

Scope
This procedure covers the determination of the temperature of freshly mixed Portland Cement Concrete in accordance with AASHTO T 309-15.

Warning—Fresh Hydraulic cementitious mixtures are caustic and may cause chemical burns to skin and tissue upon prolonged exposure.

Apparatus
• Container — The container shall be made of non-absorptive material and large enough to provide at least 75 mm (3 in.) of concrete in all directions around the sensor; concrete cover must also be a least three times the nominal maximum size of the coarse aggregate.

• Temperature measuring device — The temperature measuring device shall be calibrated and capable of measuring the temperature of the freshly mixed concrete to ±0.5°C (±1°F) throughout the temperature range likely to be encountered. Partial immersion liquid-in-glass thermometers (and possibly other types) shall have a permanent mark to which the device must be immersed without applying a correction factor.

• Reference temperature measuring device — The reference temperature measuring device shall be a thermometric device readable to 0.2°C (0.5°F) that has been verified and calibrated. The calibration certificate or report indicating conformance to the requirements of ASTM E 77 shall be available for inspection.

Calibration of Temperature Measuring Device
Each temperature measuring device shall be verified for accuracy annually and whenever there is a question of accuracy. Calibration shall be performed by comparing readings on the temperature measuring device with another calibrated instrument at two temperatures at least 15°C or 27°F apart.

Sample Locations and Times
The temperature of freshly mixed concrete may be measured in the transporting equipment, in forms, or in sample containers, provided the sensor of the temperature measuring device has at least 75 mm (3 in.) of concrete cover in all direction around it.

Complete the temperature measurement of the freshly mixed concrete within 5 minutes of obtaining the sample.

Concrete containing aggregate of a nominal maximum size greater than 75 mm (3 in.) may require up to 20 minutes for the transfer of heat from the aggregate to the mortar after batching.
**Procedure**

1. Dampen the sample container.
2. Obtain the sample in accordance with the FOP for WAQTC TM 2.
3. Place sensor of the temperature measuring device in the freshly mixed concrete so that it has at least 75 mm (3 in.) of concrete cover in all directions around it.
4. Gently press the concrete in around the sensor of the temperature measuring device at the surface of the concrete so that air cannot reach the sensor.
5. Leave the sensor of the temperature measuring device in the freshly mixed concrete for a minimum of two minutes, or until the temperature reading stabilizes.
6. Complete the temperature measurement of the freshly mixed concrete within 5 minutes of obtaining the sample.
7. Read and record the temperature to the nearest 0.5°C (1°F).

**Report**

- Results on forms approved by the agency
- Sample ID
- Measured temperature of the freshly mixed concrete to the nearest 0.5°C (1°F)
PERFORMANCE EXAM CHECKLIST

TEMPERATURE OF FRESHLY MIXED CONCRETE
FOP FOR AASHTO T 309

Participant Name ______________________________ Exam Date ______________

Record the symbols “P” for passing or “F” for failing on each step of the checklist.

<table>
<thead>
<tr>
<th>Procedure Element</th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>1. Obtain sample of concrete large enough to provide a minimum of 75 mm (3 in.) of concrete cover around sensor in all directions?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>2. Place temperature measuring device in sample with a minimum of 75 mm (3 in.) cover around sensor?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>4. Read temperature after a minimum of 2 minutes or when temperature reading stabilizes?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>5. Complete temperature measurement within 5 minutes of obtaining sample?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>6. Record temperature to nearest 0.5°C (1°F)?</td>
<td>_____</td>
<td>_____</td>
</tr>
</tbody>
</table>

Comments: First attempt: Pass____ Fail____ Second attempt: Pass____ Fail____

Examiner Signature _______________________________WAQTC #:___________________

This checklist is derived, in part, from copyrighted material printed in ACI CP-1, published by the American Concrete Institute.
SAMPLING FRESHLY MIXED CONCRETE
FOP FOR WAQTC TM 2 (14)

Scope
This method covers procedures for obtaining representative samples of fresh concrete delivered to the project site. The method includes sampling from stationary, paving and truck mixers, and from agitating and non-agitating equipment used to transport central mixed concrete.

This method also covers the removal of large aggregate particles by wet sieving.

Sampling concrete may involve hazardous materials, operations, and equipment. This standard does not purport to address all of the safety problems associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices.

Warning—Fresh Hydraulic cementitious mixtures are caustic and may cause chemical burns to skin and tissue upon prolonged exposure.

Apparatus
- Wheelbarrow
- Cover for wheelbarrow (plastic, canvas, or burlap)
- Buckets
- Shovel
- Cleaning equipment, including scrub brush, rubber gloves, water
- Apparatus for wet sieving, including: a sieve(s), conforming to AASHTO M 92, minimum of 2 ft² (0.19 m²) of sieving area, conveniently arranged and supported so that the sieve can be shaken rapidly by hand.

Procedure
1. Use every precaution in order to obtain samples representative of the true nature and condition of the concrete being placed being careful not to obtain samples from the very first or very last portions of the batch. The size of the sample will be 1.5 times the volume of concrete required for the specified testing, but not less than 0.03 m³ (1 ft³).

2. Dampen the surface of the receptacle just before sampling, empty any excess water.

Note 1: Sampling should normally be performed as the concrete is delivered from the mixer to the conveying vehicle used to transport the concrete to the forms; however, specifications may require other points of sampling, such as at the discharge of a concrete pump.

3. Use one of the following methods to obtain the sample:
• **Sampling from stationary mixers**
  Obtain the sample after a minimum of 1/2 m³ (1/2 yd³) of concrete has been discharged. Perform sampling by passing a receptacle completely through the discharge stream, or by completely diverting the discharge into a sample container. Take care not to restrict the flow of concrete from the mixer, container, or transportation unit so as to cause segregation. These requirements apply to both tilting and nontilting mixers.

• **Sampling from paving mixers**
  Obtain the sample after the contents of the paving mixer have been discharged. Obtain material from at least five different locations in the pile and combine into one test sample. Avoid contamination with subgrade material or prolonged contact with absorptive subgrade. To preclude contamination or absorption by the subgrade, the concrete may be sampled by placing a shallow container on the subgrade and discharging the concrete across the container.

• **Sampling from revolving drum truck mixers or agitators**
  Obtain the sample after a minimum of 1/2 m³ (1/2 yd³) of concrete has been discharged. Obtain samples after all of the water has been added to the mixer. Do not obtain samples from the very first or last portions of the batch discharge. Perform sampling by repeatedly passing a receptacle through the entire discharge stream or by completely diverting the discharge into a sample container. Regulate the rate of discharge of the batch by the rate of revolution of the drum and not by the size of the gate opening.

• **Sampling from open-top truck mixers, agitators, non-agitating equipment or other types of open-top containers**
  Obtain the sample by whichever of the procedures described above is most applicable under the given conditions.

• **Sampling from pump or conveyor placement systems**
  Obtain sample after a minimum of 1/2 m³ (1/2 yd³) of concrete has been discharged. Obtain samples after all of the pump slurry has been eliminated. Perform sampling by repeatedly passing a receptacle through the entire discharge system or by completely diverting the discharge into a sample container. Do not lower the pump arm from the placement position to ground level for ease of sampling, as it may modify the air content of the concrete being sampled. Do not obtain samples from the very first or last portions of the batch discharge.

4. Transport samples to the place where fresh concrete tests are to be performed and specimens are to be molded. They shall then be combined and remixed with a shovel the minimum amount necessary to ensure uniformity. Protect the sample from direct sunlight, wind, rain, and sources of contamination.

5. Complete test for temperature and start tests for slump and air content within 5 minutes of obtaining the sample. Start molding specimens for strength tests within 15 minutes of obtaining the sample. Complete the test methods as expeditiously as possible.
Wet Sieving

When required due to oversize aggregate, the concrete sample shall be wet sieved, after transporting but prior to remixing, for slump testing, air content testing or molding test specimens, by the following:

1. Place the sieve designated by the test procedure over the dampened sample container.
2. Pass the concrete over the designated sieve. Do not overload the sieve (one particle thick).
3. Shake or vibrate the sieve until no more material passes the sieve. A horizontal back and forth motion is preferred.
4. Discard oversize material including all adherent mortar.
5. Repeat until sample of sufficient size is obtained. Mortar adhering to the wet-sieving equipment shall be included with the sample.
6. Using a shovel, remix the sample the minimum amount necessary to ensure uniformity.

*Note 2:* Wet sieving is not allowed for samples being used for density determinations according to the FOP for AASHTO T121.

**Report**

- On forms approved by the agency
- Sample ID
- Date
- Time
- Location
- Quantity represented
PERFORMANCE EXAM CHECKLIST

SAMPLING FRESHLY MIXED CONCRETE
FOP FOR WAQTC TM 2

Participant Name ______________________________ Exam Date ______________

Record the symbols “P” for passing or “F” for failing on each step of the checklist.

<table>
<thead>
<tr>
<th>Procedure Element</th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>1. Receptacle dampened and excess water removed?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>2. Obtain a representative sample from drum mixer:</td>
<td></td>
<td></td>
</tr>
<tr>
<td>a) Concrete sampled after 1/2 m³ (1/2 yd³) discharged?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>b) Receptacle passed through entire discharge stream or discharge stream completely diverted into sampling container?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>3. Obtain a representative sample from a paving mixer:</td>
<td></td>
<td></td>
</tr>
<tr>
<td>a) Concrete sampled after all the concrete has been discharged?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>b) Material obtained from at least 5 different locations in the pile?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>c) Avoid contaminating the sample with sub-grade materials.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>4. Obtain a representative sample from a pump:</td>
<td></td>
<td></td>
</tr>
<tr>
<td>a) Concrete sampled after 1/2 m³ (1/2 yd³) has been discharged?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>b) All the pump slurry is out of the lines?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>c) Receptacle passed through entire discharge stream or discharge stream completely diverted into sampling container?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>d) Do not lower the pump arm from the placement position.</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>5. Samples transported to place of testing?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>6. Sample(s) combined, or remixed, or both?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>7. Sample protected?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>8. Minimum size of sample used for strength tests 0.03 m³ (1ft³)?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>9. Completed temperature test within 5 minutes of obtaining sample?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>10. Start tests for slump and air within 5 minutes of obtaining sample?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>11. Start molding cylinders within 15 minutes of obtaining sample?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>12. Protect sample against rapid evaporation and contamination?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>13. Wet Sieving:</td>
<td></td>
<td></td>
</tr>
<tr>
<td>a) Required sieve size determined for test method to be performed?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>b) Concrete placed on sieve and doesn’t overload the sieve.</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>c) Sieve shaken until no more material passes the sieve.</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>d) Sieving continued until required testing size obtained.</td>
<td>_____</td>
<td>_____</td>
</tr>
</tbody>
</table>

OVER
**Procedure Element**

e) Oversized aggregate discarded.  
f) Sample remixed.

**Trial 1  Trial 2**


**Comments:**  First attempt:  Pass_____Fail_____  Second attempt:  Pass_____Fail_____

Examiner Signature _______________________________ WAQTC #:______________

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### PERFORMANCE EXAM CHECKLIST (ORAL)

**SAMPLING FRESHLY MIXED CONCRETE**  
**FOP FOR WAQTC TM 2**

**Participant Name ______________________________ Exam Date ______________**

Record the symbols “P” for passing or “F” for failing on each step of the checklist.

<table>
<thead>
<tr>
<th>Procedure Element</th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>1. What is the minimum sample size?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>a) 0.03 m³ or 1 ft³</td>
<td></td>
<td></td>
</tr>
<tr>
<td>2. Describe how to obtain a representative sample from a drum mixer.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>a) Dampen receptacle and empty excess water.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>b) Sample the concrete after 1/2 m³ (1/2 yd³) has been discharged.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>c) Pass receptacle through entire discharge stream or completely divert discharge stream into sampling container.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>3. Describe how to obtain a representative sample from a paving mixer.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>a) Dampen receptacle and empty excess water.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>b) Sample the concrete after all the concrete has been discharged.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>c) Obtain the material from at least 5 different locations in the pile.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>d) Avoid contaminating the sample with sub-grade materials.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>4. Describe how to obtain a representative sample from a pump:</td>
<td></td>
<td></td>
</tr>
<tr>
<td>a) Dampen receptacle and empty excess water.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>b) Sample the concrete after 1/2 m³ (1/2 yd³) has been discharged.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>c) Make sure all the pump slurry is out of the lines.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>d) Pass receptacle through entire discharge stream or completely divert discharge stream into sampling container.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>e) Do not lower the pump arm from the placement position.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>5. After obtaining the sample or samples what must you do?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>a) Transport samples to place of testing.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>6. What must be done with the sample or samples once you have transported them to the place of testing?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>a) Combine and remix the sample.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>b) Protect sample against rapid evaporation and contamination.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>7. What are the two time parameters associated with this test?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>a) Complete temperature test and start tests for slump and air within 5 minutes of sample being obtained?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>b) Start molding cylinders within 15 minutes of sample being obtained?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>8. What test methods may require wet sieving?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>a) Slump, air content, and strength specimens?</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

**OVER**
<table>
<thead>
<tr>
<th>Procedure Element</th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>9. The sieve size used for wet sieving is based on?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>a) The test method to be performed.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>10. How long must you continue wet sieving?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>a) Until a sample of sufficient size for the test being performed is obtained.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>11. What is done with the oversized aggregate?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>a) Discard it.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>12. What must be done to the sieved sample before testing?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>a) Remix.</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

**Comments:**
First attempt: Pass Fail Second attempt: Pass Fail

Examiner Signature _______________________________ WAQTC #: _______________

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# Field Operating Procedures - Short Form

<table>
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<tr>
<th>Chapter</th>
<th>Section</th>
</tr>
</thead>
<tbody>
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<td>AASHTO T 255 (16)</td>
</tr>
<tr>
<td></td>
<td>Total Evaporable Moisture Content of Aggregate by Drying</td>
</tr>
<tr>
<td></td>
<td>&amp;</td>
</tr>
<tr>
<td></td>
<td>AASHTO T 265 (16)</td>
</tr>
<tr>
<td></td>
<td>Laboratory Determination of Moisture Content of Soils</td>
</tr>
<tr>
<td>2</td>
<td>AASHTO T 99 (15)</td>
</tr>
<tr>
<td></td>
<td>Moisture-Density Relations of Soils: Using a 2.5-kg (5.5-lb) Rammer and a 305-mm (12-in.) Drop</td>
</tr>
<tr>
<td></td>
<td>&amp;</td>
</tr>
<tr>
<td></td>
<td>AASHTO T180 (15)</td>
</tr>
<tr>
<td></td>
<td>Moisture-Density Relations of Soils: Using a 4.54-kg (10-lb) Rammer and 457-mm (18-in.) Drop</td>
</tr>
<tr>
<td>3</td>
<td>AASHTO R 75 (16)</td>
</tr>
<tr>
<td></td>
<td>Developing a Family of Curves</td>
</tr>
<tr>
<td>4</td>
<td>AASHTO T 85 (16)</td>
</tr>
<tr>
<td></td>
<td>Specific Gravity and Absorption of Coarse Aggregate</td>
</tr>
<tr>
<td>5</td>
<td>Use of AKDOT&amp;PF ATM 212, ITD T-74, WSDOT TM 606, or WFLHD Humphreys Curves (16)</td>
</tr>
</tbody>
</table>
DEVELOPING A FAMILY OF CURVES
FOP FOR AASHTO R 75 (16)

Scope

This procedure provides a method to develop a family of curves in accordance with AASHTO R 75-16 using multiple moisture density relationships developed using the same method, A, B, C, or D, from the FOP for AASHTO T 99/T 180.

All curves used in a family must be developed using a single Method: A, B, C, or D of a procedure for AASHTO T 99 or T 180. See the FOP for AASHTO T 99/T 180.

Terminology

**family of curves** — a group of soil moisture-density relationships (curves) determined using AASHTO T 99 or T 180, which reveal certain similarities and trends characteristic of the soil type and source.

**spine** — smooth line extending through the point of maximum density/optimum moisture content of a family of moisture-density curves.

Procedure

1. Sort the curves by Method (A, B, C, or D of the FOP for T 99/T 180). At least three curves are required per family.

2. Select the highest and lowest maximum dry densities from those selected to assist in determining the desired scale of the subsequent graph.

3. Plot the maximum density and optimum moisture points of the selected curves on the graph.

4. Draw a smooth, “best fit,” curved line through the points creating the spine of the family of curves.

5. Remove maximum density and optimum moisture points that were not used to establish the spine.

6. Add the moisture/density curves associated with the points that were used to establish the spine. It is not necessary to include the portion of the curves over optimum moisture.

**Note 1**—Intermediate template curves using slopes similar to those of the original moisture-density curves may be included when maximum density points are more than 2.0 lb/ft³ apart. Template curves are indicated by a dashed line.
7. Plot the 80 percent of optimum moisture range when desired:

8. Using the optimum moisture of an existing curve, calculate 80 percent of optimum moisture and plot this value on the curve. Repeat for each curve in the family.

9. Draw a smooth, “best fit,” curved line connecting the 80 percent of optimum moisture points plotted on the curves that parallel the spine.

**Calculations**

Calculate 80 percent of optimum moisture of each curve:

Example:

Optimum moisture of the highest density curve = 14.6%

$$80\% \text{ point} = \frac{80}{100} \times 14.6\% = 11.7\%$$
# PERFORMANCE EXAM CHECKLIST

## DEVELOPING A FAMILY OF CURVES

**FOP FOR AASHTO R 75**

Participant Name ______________________________ Exam Date ______________

Record the symbols “P” for passing or “F” for failing on each step of the checklist.

<table>
<thead>
<tr>
<th>Procedure Element</th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>1. Curves sorted by method and procedure (A, B, C, or D of the FOP for T 99/T 180)?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>a. At least three curves per family?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>2. Maximum density and optimum moisture points plotted on the graph?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>3. Spine drawn correctly?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>4. Maximum density and optimum moisture points removed that were not used for the spine?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>5. Moisture/density curves added?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>6. Optimum moisture range desired?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>a. 80 percent of optimum moisture calculated for each curve?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>b. Curved line through 80 percent of optimum moisture drawn correctly?</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

Comments: First attempt: Pass_____Fail_____ Second attempt: Pass_____Fail_____  

Examiner Signature ________________________________ WAQTC #:_________________
SPECIFIC GRAVITY AND ABSORPTION OF COARSE AGGREGATE
FOP FOR AASHTO T 85 (16)

Scope

This procedure covers the determination of specific gravity and absorption of coarse aggregate in accordance with AASHTO T 85-14. Specific gravity may be expressed as bulk specific gravity ($G_{sb}$), bulk specific gravity, saturated surface dry ($G_{sb SSD}$), or apparent specific gravity ($G_{sa}$). $G_{sb}$ and absorption are based on aggregate after soaking in water. This procedure is not intended to be used with lightweight aggregates.

Terminology

Absorption – the increase in the mass of aggregate due to water being absorbed into the pores of the material, but not including water adhering to the outside surface of the particles, expressed as a percentage of the dry mass. The aggregate is considered “dry” when it has been maintained at a temperature of $110 \pm 5^\circ C (230 \pm 9^\circ F)$ for sufficient time to remove all uncombined water.

Saturated Surface Dry (SSD) – condition of an aggregate particle when the permeable voids are filled with water, but no water is present on exposed surfaces.

Specific Gravity – the ratio of the mass, in air, of a volume of a material to the mass of the same volume of gas-free distilled water at a stated temperature.

Apparent Specific Gravity ($G_{sa}$) – the ratio of the mass, in air, of a volume of the impermeable portion of aggregate to the mass of an equal volume of gas-free distilled water at a stated temperature.

Bulk Specific Gravity ($G_{sb}$) – the ratio of the mass, in air, of a volume of aggregate (including the permeable and impermeable voids in the particles, but not including the voids between particles) to the mass of an equal volume of gas-free distilled water at a stated temperature.

Bulk Specific Gravity (SSD) ($G_{sb SSD}$) – the ratio of the mass, in air, of a volume of aggregate, including the mass of water within the voids filled to the extent achieved by submerging in water for 15 to 19 hours (but not including the voids between particles), to the mass of an equal volume of gas-free distilled water at a stated temperature.

Apparatus

- Balance or scale: with a capacity of 5 kg, sensitive to 1 g. Meeting the requirements of AASHTO M 231.

- Sample container: a wire basket of 3.35 mm (No. 6) or smaller mesh, with a capacity of 4 to 7 L (1 to 2 gal) to contain aggregate with a nominal maximum size of 37.5 mm (1 1/2 in.) or smaller; or a larger basket for larger aggregates, or both.
• Water tank: watertight and large enough to completely immerse aggregate and basket, equipped with an overflow valve to keep water level constant.

• Suspension apparatus: wire used to suspend apparatus shall be of the smallest practical diameter.

• Sieves 4.75 mm (No. 4) or other sizes as needed, conforming to AASHTO M 92.

• Large absorbent towel

**Sample Preparation**

1. Obtain the sample in accordance with the FOP for AASHTO T 2 (see Note 1).

2. Mix the sample thoroughly and reduce it to the approximate sample size required by Table 1 in accordance with the FOP for AASHTO R 76.

3. Reject all material passing the appropriate sieve by dry sieving.

4. Thoroughly wash sample to remove dust or other coatings from the surface.

5. Dry the test sample to constant mass at a temperature of 110 ±5°C (230 ±9°F) and cool in air at room temperature for 1 to 3 hours.

   **Note 1:** Where the absorption and specific gravity values are to be used in proportioning concrete mixtures in which the aggregates will be in their naturally moist condition, the requirement for initial drying to constant mass may be eliminated, and, if the surfaces of the particles in the sample have been kept continuously wet until test, the 15-to-19 hour soaking may also be eliminated.

6. Re-screen the sample over the appropriate sieve. Reject all material passing that sieve.

7. The sample shall meet or exceed the minimum mass given in Table 1.

   **Note 2:** If this procedure is used only to determine the \( G_{sb} \) of oversized material for the FOP for AASHTO T 99 / T 180, the material can be rejected over the appropriate sieve. For T 99 / T 180 Methods A and B, use the 4.75 mm (No. 4) sieve; T 99 / T 180 Methods C and D use the 19 mm (3/4 in).
Table 1

<table>
<thead>
<tr>
<th>Nominal Maximum Size*</th>
<th>Minimum Mass of Test Sample, g (lb)</th>
</tr>
</thead>
<tbody>
<tr>
<td>12.5 (1/2) or less</td>
<td>2000 (4.4)</td>
</tr>
<tr>
<td>19.0 (3/4)</td>
<td>3000 (6.6)</td>
</tr>
<tr>
<td>25.0 (1)</td>
<td>4000 (8.8)</td>
</tr>
<tr>
<td>37.5 (1 1/2)</td>
<td>5000 (11)</td>
</tr>
<tr>
<td>50 (2)</td>
<td>8000 (18)</td>
</tr>
<tr>
<td>63 (2 1/2)</td>
<td>12,000 (26)</td>
</tr>
<tr>
<td>75 (3)</td>
<td>18,000 (40)</td>
</tr>
</tbody>
</table>

* One sieve larger than the first sieve to retain more than 10 percent of the material using an agency specified set of sieves based on cumulative percent retained. Where large gaps in specification sieves exist, intermediate sieve(s) may be inserted to determine nominal maximum size.

Procedure

1. Immerse the aggregate in water at room temperature for a period of 15 to 19 hours.
   
   *Note 3:* When testing coarse aggregate of large nominal maximum size requiring large test samples, it may be more convenient to perform the test on two or more subsamples, and then combine the values obtained.

2. Place the empty basket into the water bath and attach to the balance. Inspect the immersion tank to ensure the water level is at the overflow outlet height. Tare the balance with the empty basket attached in the water bath.

3. Remove the test sample from the water and roll it in a large absorbent cloth until all visible films of water are removed. Wipe the larger particles individually. If the test sample dries past the SSD condition, immerse in water for 30 min, and then resume the process of surface-drying.
   
   *Note 4:* A moving stream of air may be used to assist in the drying operation, but take care to avoid evaporation of water from aggregate pores.

4. Determine the SSD mass of the sample, and record this and all subsequent masses to the nearest 0.1 g or 0.1 percent of the sample mass, whichever is greater. Designate this mass as “B.”

5. Immediately place the SSD test sample in the sample container and weigh it in water maintained at 23.0 ±1.7°C (73.4 ±3°F). Shake the container to release entrapped air before recording the weight. Re-inspect the immersion tank to insure the water level is at the overflow outlet height. Designate this submerged weight as “C.”
   
   *Note 5:* The container should be immersed to a depth sufficient to cover it and the test sample during mass determination. Wire suspending the container should be of the smallest practical size to minimize any possible effects of a variable immersed length.

6. Remove the sample from the basket. Ensure all material has been removed. Place in a container of known mass.
7. Dry the test sample to constant mass in accordance with the FOP for AASHTO T 255 / T 265 (Aggregate section) and cool in air at room temperature for 1 to 3 hours. Designate this mass as “A.”

Calculations

Perform calculations and determine values using the appropriate formula below.

Bulk specific gravity ($G_{sb}$)

$$G_{sb} = \frac{A}{B - C}$$

Bulk specific gravity, SSD ($G_{sb}$ SSD)

$$G_{sbSSD} = \frac{B}{B - C}$$

Apparent specific gravity ($G_{sa}$)

$$G_{sa} = \frac{A}{A - C}$$

Absorption

$$\text{Absorption} = \frac{B - A}{A} \times 100$$

Where:

- $A$ = oven dry mass, g
- $B$ = SSD mass, g
- $C$ = weight in water, g

Sample Calculations

<table>
<thead>
<tr>
<th>Sample</th>
<th>$A$</th>
<th>$B$</th>
<th>$C$</th>
<th>$B - C$</th>
<th>$A - C$</th>
<th>$B - A$</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>2030.9</td>
<td>2044.9</td>
<td>1304.3</td>
<td>740.6</td>
<td>726.6</td>
<td>14.0</td>
</tr>
<tr>
<td>2</td>
<td>1820.0</td>
<td>1832.5</td>
<td>1168.1</td>
<td>664.4</td>
<td>651.9</td>
<td>12.5</td>
</tr>
<tr>
<td>3</td>
<td>2035.2</td>
<td>2049.4</td>
<td>1303.9</td>
<td>745.5</td>
<td>731.3</td>
<td>14.2</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Sample</th>
<th>$G_{sb}$</th>
<th>$G_{sbSSD}$</th>
<th>$G_{sa}$</th>
<th>Absorption</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>2.742</td>
<td>2.761</td>
<td>2.795</td>
<td>0.7</td>
</tr>
<tr>
<td>2</td>
<td>2.739</td>
<td>2.758</td>
<td>2.792</td>
<td>0.7</td>
</tr>
<tr>
<td>3</td>
<td>2.730</td>
<td>2.749</td>
<td>2.783</td>
<td>0.7</td>
</tr>
</tbody>
</table>
These calculations demonstrate the relationship between $G_{sb}$, $G_{sb \, SSD}$, and $G_{sa}$. $G_{sb}$ is always lowest, since the volume includes voids permeable to water. $G_{sb \, SSD}$ is always intermediate. $G_{sa}$ is always highest, since the volume does not include voids permeable to water. When running this test, check to make sure the values calculated make sense in relation to one another.

**Report**

- Results on forms approved by the agency
- Sample ID
- Specific gravity values to 3 decimal places
- Absorption to 0.1 percent
PERFORMANCE EXAM CHECKLIST

SPECIFIC GRAVITY AND ABSORPTION OF COARSE AGGREGATE
FOP FOR AASHTO T 85

Participant Name ______________________________ Exam Date ______________

Record the symbols “P” for passing or “F” for failing on each step of the checklist.

Procedure Element Trial 1 Trial 2
1. Sample obtained by FOP for AASHTO T 2 and reduced by FOP for
   AASHTO R 76 or from FOP for AASHTO T 99 / T 180? _____ _____
2. Screened on the appropriate size sieve? _____ _____
3. Sample mass appropriate? _____ _____
4. Particle surfaces clean? _____ _____
5. Dried to constant mass 110 ±5°C (230 ±9°F) and cooled to room temperature? _____ _____
6. Covered with water for 15 to 19 hours? _____ _____
7. Basket placed into immersion tank and attached to balance? _____ _____
8. Immersion tank inspected for proper water height? _____ _____
9. Balance tared with basket in tank and temperature checked
   23.0 ±1.7°C (73.4 ±3°F)? _____ _____
10. Sample removed from water and rolled in cloth to remove
    visible films of water? _____ _____
11. Larger particles wiped individually? _____ _____
12. Evaporation avoided? _____ _____
13. Sample mass determined to 0.1 g? _____ _____
14. Sample immediately placed in basket, in immersion tank? _____ _____
15. Entrapped air removed before weighing by shaking basket
    while immersed? _____ _____
16. Immersion tank inspected for proper water height? _____ _____
17. Immersed sample weight determined to 0.1 g? _____ _____
18. All the sample removed from basket? _____ _____
19. Sample dried to constant mass and cooled to room temperature? _____ _____

OVER
### Procedure Element

<table>
<thead>
<tr>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>20. Sample mass determined to 0.1 g?</td>
<td>☐ ☐</td>
</tr>
<tr>
<td>21. Proper formulas used in calculations?</td>
<td>☐ ☐</td>
</tr>
</tbody>
</table>

**Comments:**

First attempt: Pass Fail  
Second attempt: Pass Fail  

---

Examiner Signature _______________________________  WAQTC #: ______________

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MOISTURE-DENSITY RELATIONS OF SOILS:
USING A 2.5 kg (5.5 lb) RAMMER AND A 305 mm (12 in.) DROP
FOP FOR AASHTO T 99 (15)
USING A 4.54 kg (10 lb) RAMMER AND A 457 mm (18 in.) DROP
FOP FOR AASHTO T 180 (15)

Scope

This procedure covers the determination of the moisture-density relations of soils and soil-aggregate mixtures in accordance with two similar test methods:

- AASHTO T 99-15: Methods A, B, C, and D
- AASHTO T 180-15: Methods A, B, C, and D

This test method applies to soil mixtures having 40 percent or less retained on the 4.75 mm (No. 4) sieve for methods A or B, or, 30 percent or less retained on the 19 mm (3/4 in.) with methods C or D. The retained material is defined as oversize (coarse) material. If no minimum percentage is specified, 5 percent will be used. Samples that contain oversize (coarse) material that meet percent retained criteria should be corrected by using Annex. Samples of soil or soil-aggregate mixture are prepared at several moisture contents and compacted into molds of specified size, using manual or mechanical rammers that deliver a specified quantity of compactive energy. The moist masses of the compacted samples are multiplied by the appropriate factor to determine moist density values. Moisture contents of the compacted samples are determined and used to obtain the dry density values of the same samples. Maximum dry density and optimum moisture content for the soil or soil-aggregate mixture is determined by plotting the relationship between dry density and moisture content.

Apparatus

- Mold – Cylindrical made of metal with the dimensions shown in Table 1 or Table 2, If permitted by the agency, the mold may be of the “split” type, consisting of two half-round sections, which can be securely locked in place to form a cylinder. Determine the mold volume according to the “Calibration of Measure” section of AASHTO T 19 for Unit Mass of Aggregate.

- Mold assembly – Mold, base plate, and a detachable collar.

- Rammer – Manually or mechanically-operated rammers as detailed in Table 1 or Table 2. A manually-operated rammer shall be equipped with a guide sleeve to control the path and height of drop. The guide sleeve shall have at least four vent holes no smaller than 9.5 mm (3/8 in.) in diameter, spaced approximately 90 degrees apart and approximately 19 mm (3/4 in.) from each end. A mechanically-operated rammer will uniformly distribute blows over the sample and will be calibrated with several soil types, and be adjusted, if necessary, to give the same moisture-density results as with the manually operated rammer. For additional information concerning calibration, see the FOP for AASHTO T 99 and T 180.
• Sample extruder – A jack, lever frame, or other device for extruding compacted specimens from the mold quickly and with little disturbance.

• Balance(s) or scale(s) of the capacity and sensitivity required for the procedure used by the agency.

  A balance or scale with a capacity of 11.5 kg (25 lb) and a sensitivity of 1 g for obtaining the sample, meeting the requirements of AASHTO M 231, Class G 5.

  A balance or scale with a capacity of 2 kg and a sensitivity of 0.1 g is used for moisture content determinations done under both procedures, meeting the requirements of AASHTO M 231, Class G 2.

• Drying apparatus – A thermostatically controlled drying oven, capable of maintaining a temperature of 110 ±5°C (230 ±9°F) for drying moisture content samples in accordance with the FOP for AASHTO T 255/T 265.

• Straightedge – A steel straightedge at least 250 mm (10 in.) long, with one beveled edge and at least one surface plane within 0.1 percent of its length, used for final trimming.

• Sieve(s) – 4.75 mm (No. 4) and/or 19.0 mm (3/4 in.), conforming to AASHTO M 92.

• Mixing tools – Miscellaneous tools such as a mixing pan, spoon, trowel, spatula, etc., or a suitable mechanical device, for mixing the sample with water.

• Containers with close-fitting lids to prevent gain or loss of moisture in the sample.
### Table 1
Comparison of Apparatus, Sample, and Procedure – Metric

<table>
<thead>
<tr>
<th></th>
<th>T 99</th>
<th>T 180</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Mold Volume, m³</strong></td>
<td>Methods A, C: 0.000943 ± 0.000001</td>
<td>Methods A, C: 0.000943 ± 0.000001</td>
</tr>
<tr>
<td></td>
<td>Methods B, D: 0.002124 ± 0.000025</td>
<td>Methods B, D: 0.002124 ± 0.000025</td>
</tr>
<tr>
<td><strong>Mold Diameter, mm</strong></td>
<td>Methods A, C: 101.60 ± 0.40</td>
<td>Methods A, C: 101.60 ± 0.40</td>
</tr>
<tr>
<td></td>
<td>Methods B, D: 152.40 ± 0.70</td>
<td>Methods B, D: 152.40 ± 0.70</td>
</tr>
<tr>
<td><strong>Mold Height, mm</strong></td>
<td>116.40 ± 0.50</td>
<td>116.40 ± 0.50</td>
</tr>
<tr>
<td><strong>Detachable Collar Height, mm</strong></td>
<td>50.80 ± 0.64</td>
<td>50.80 ± 0.64</td>
</tr>
<tr>
<td><strong>Rammer Diameter, mm</strong></td>
<td>50.80 ± 0.25</td>
<td>50.80 ± 0.25</td>
</tr>
<tr>
<td><strong>Rammer Mass, kg</strong></td>
<td>2.495 ± 0.009</td>
<td>4.536 ± 0.009</td>
</tr>
<tr>
<td><strong>Rammer Drop, mm</strong></td>
<td>305</td>
<td>457</td>
</tr>
<tr>
<td><strong>Layers</strong></td>
<td>3</td>
<td>5</td>
</tr>
<tr>
<td><strong>Blows per Layer</strong></td>
<td>Methods A, C: 25</td>
<td>Methods A, C: 25</td>
</tr>
<tr>
<td></td>
<td>Methods B, D: 56</td>
<td>Methods B, D: 56</td>
</tr>
<tr>
<td><strong>Material Size, mm</strong></td>
<td>Methods A, B: 4.75 minus</td>
<td>Methods A, B: 4.75 minus</td>
</tr>
<tr>
<td></td>
<td>Methods C, D: 19.0 minus</td>
<td>Methods C, D: 19.0 minus</td>
</tr>
<tr>
<td><strong>Test Sample Size, kg</strong></td>
<td>Method A: 3</td>
<td>Method B: 7</td>
</tr>
<tr>
<td></td>
<td>Method C: 5 (1)</td>
<td>Method D: 11(1)</td>
</tr>
<tr>
<td><strong>Energy, kN-m/m³</strong></td>
<td>592</td>
<td>2,693</td>
</tr>
</tbody>
</table>

(1) This may not be a large enough sample depending on your nominal maximum size for moisture content samples.

### Table 2
Comparison of Apparatus, Sample, and Procedure – English

<table>
<thead>
<tr>
<th></th>
<th>T 99</th>
<th>T 180</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Mold Volume, ft³</strong></td>
<td>Methods A, C: 0.0333 ± 0.0005</td>
<td>Methods A, C: 0.0333 ± 0.0005</td>
</tr>
<tr>
<td></td>
<td>Methods B, D: 0.0750 ± 0.0009</td>
<td>Methods B, D: 0.0750 ± 0.0009</td>
</tr>
<tr>
<td><strong>Mold Diameter, in.</strong></td>
<td>Methods A, C: 4.000 ± 0.016</td>
<td>Methods A, C: 4.000 ± 0.016</td>
</tr>
<tr>
<td></td>
<td>Methods B, D: 6.000 ± 0.026</td>
<td>Methods B, D: 6.000 ± 0.026</td>
</tr>
<tr>
<td><strong>Mold Height, in.</strong></td>
<td>4.584 ± 0.018</td>
<td>4.584 ± 0.018</td>
</tr>
<tr>
<td><strong>Detachable Collar Height, in.</strong></td>
<td>2.000 ± 0.025</td>
<td>2.000 ± 0.025</td>
</tr>
<tr>
<td><strong>Rammer Diameter, in.</strong></td>
<td>2.000 ± 0.025</td>
<td>2.000 ± 0.025</td>
</tr>
<tr>
<td><strong>Rammer Mass, lb</strong></td>
<td>5.5 ± 0.02</td>
<td>10 ± 0.02</td>
</tr>
<tr>
<td><strong>Rammer Drop, in.</strong></td>
<td>12</td>
<td>18</td>
</tr>
<tr>
<td><strong>Layers</strong></td>
<td>3</td>
<td>5</td>
</tr>
<tr>
<td><strong>Blows per Layer</strong></td>
<td>Methods A, C: 25</td>
<td>Methods A, C: 25</td>
</tr>
<tr>
<td></td>
<td>Methods B, D: 56</td>
<td>Methods B, D: 56</td>
</tr>
<tr>
<td><strong>Material Size, in.</strong></td>
<td>Methods A, B: No. 4 minus</td>
<td>Methods A, B: No.4 minus</td>
</tr>
<tr>
<td></td>
<td>Methods C, D: 3/4 minus</td>
<td>Methods C, D: 3/4 minus</td>
</tr>
<tr>
<td><strong>Test Sample Size, lb</strong></td>
<td>Method A: 7</td>
<td>Method B: 16</td>
</tr>
<tr>
<td></td>
<td>Method C: 12(1)</td>
<td>Method D: 25(1)</td>
</tr>
<tr>
<td><strong>Energy, lb·ft/ft³</strong></td>
<td>12,375</td>
<td>56,250</td>
</tr>
</tbody>
</table>

(1) This may not be a large enough sample depending on your nominal maximum size for moisture content samples.
Sample

If the sample is damp, dry it until it becomes friable under a trowel. Drying may be in air or by use of a drying apparatus maintained at a temperature not exceeding 60°C (140°F). Thoroughly break up aggregations in a manner that avoids reducing the natural size of individual particles.

Obtain a representative test sample of the mass required by the agency by passing the material through the sieve required by the agency. See Table 1 or Table 2 for test sample mass and material size requirements.

Note 1: Both T 99 and T 180 have four methods (A, B, C, D) that require different masses and employ different sieves.

Note 2: If the sample is plastic (clay types), it should stand for a minimum of 12 hours after the addition of water to allow the moisture to be absorbed. In this case, several samples at different moisture contents should be prepared, put in sealed containers and tested the next day. In instances where the material is prone to degradation, i.e., granular material, a compaction sample with differing moisture contents should be prepared for each point.

Procedure

During compaction, the mold shall rest firmly on a dense, uniform, rigid, and stable foundation or base. This base shall remain stationary during the compaction process.

1. Determine the mass of the clean, dry mold. Include the base plate, but exclude the extension collar. Record the mass to the nearest 1 g (0.005 lb).

2. Thoroughly mix the selected representative sample with sufficient water to dampen it to approximately 4 to 8 percentage points below optimum moisture content. See Note 2. For many materials this condition can be identified by forming a cast by hand.

3. Form a specimen by compacting the prepared soil in the mold (with collar attached) in approximately equal layers. For each layer:

   a. Spread the loose material uniformly in the mold.

   Note 3: It is recommended to cover the remaining material with a non-absorbent sheet or damp cloth to minimize loss of moisture.

   b. Lightly tamp the loose material with the manual rammer or other similar device, this establishes a firm surface.

   c. Compact each layer with uniformly distributed blows from the rammer. See Table 1 for mold size, number of layers, number of blows, and rammer specification for the various test methods. Use the method specified by the agency.

   d. Trim down material that has not been compacted and remains adjacent to the walls of the mold and extends above the compacted surface.
4. Remove the extension collar. Avoid shearing off the sample below the top of the mold. The material compacted in the mold should not be over 6 mm (¼ in.) above the top of the mold once the collar has been removed.

5. Trim the compacted soil even with the top of the mold with the beveled side of the straightedge.

6. Determine the mass of the mold and wet soil to the nearest 1 g (0.005 lb) or better.

7. Determine the wet mass of the sample by subtracting the mass in Step 1 from the mass in Step 6.

8. Calculate the wet density as indicated below under “Calculations.”

9. Extrude the material from the mold. For soils and soil-aggregate mixtures, slice vertically through the center and take a representative moisture content sample from one of the cut faces, ensuring that all layers are represented. For granular materials, a vertical face may not exist. Take a representative sample. This sample must meet the sample size requirements of the test method used to determine moisture content.

Note 4: When developing a curve for free-draining soils such as uniform sands and gravels, where seepage occurs at the bottom of the mold and base plate, taking a representative moisture content from the mixing bowl may be preferred in order to determine the amount of moisture available for compaction.

10. Determine the moisture content of the sample in accordance with the FOP for AASHTO T 255 / T 265.

11. Thoroughly break up the remaining portion of the molded specimen until it will again pass through the sieve, as judged by eye, and add to the remaining portion of the sample being tested. See Note 2.

12. Add sufficient water to increase the moisture content of the remaining soil by approximately 1 to 2 percentage points and repeat steps 3 through 11.

13. Continue determinations until there is either a decrease or no change in the wet density. There will be a minimum of three points on the dry side of the curve and two points on the wet side.

Note 5: In cases of free-draining granular material, the development of points on the wet side of optimum may not be practical.
Calculations

1. Calculate the wet density, in kg/m\(^3\) (lb/ft\(^3\)), by dividing the wet mass by the measured volume of the mold (T 19).

Example – Methods A or C mold:

Wet mass = 1.916 kg (4.22 lb)

Measured volume of the mold = 0.000946 m\(^3\) (0.0334 ft\(^3\))

\[
\text{Wet Density} = \frac{1.916 \text{ kg}}{0.000946 \text{ m}^3} = 2025 \text{ kg/m}^3
\]

\[
\text{Wet Density} = \frac{4.22 \text{ lb}}{0.0334 \text{ ft}^3} = 126.3 \text{ lb/ft}^3
\]

2. Calculate the dry density as follows.

\[
\rho_d = \left(\frac{\rho_w}{w + 100}\right) \times 100 \quad \text{or} \quad \rho_d = \frac{\rho_w}{\left(\frac{w}{100}\right) + 1}
\]

Where:

\[
\rho_d = \text{Dry density, kg/m}^3 (\text{lb/ft}^3)
\]
\[
\rho_w = \text{Wet density, kg/m}^3 (\text{lb/ft}^3)
\]
\[
w = \text{Moisture content, as a percentage}
\]

Example:

\[
\rho_w = 2030 \text{ kg/m}^3 (126.6 \text{ lb/ft}^3)
\]
\[
w = 14.7\%
\]

\[
\rho_d = \left(\frac{2030 \text{ kg/m}^3}{14.7 + 100}\right) \times 100 = 1770 \text{ kg/m}^3 \quad \rho_d = \left(\frac{126.6 \text{ lb/ft}^3}{14.7 + 100}\right) \times 100 = 110.4 \text{ lb/ft}^3
\]

or

\[
\rho_d = \frac{2030 \text{ kg/m}^3}{14.7 + 100} = 1770 \text{ kg/m}^3 \quad \rho_d = \frac{126.6 \text{ lb/ft}^3}{14.7 + 100} = 110.4 \text{ lb/ft}^3
\]
Moisture-Density Curve Development

When dry density is plotted on the vertical axis versus moisture content on the horizontal axis and the points are connected with a smooth line, a moisture-density curve is developed. The coordinates of the peak of the curve are the maximum dry density, or just “maximum density,” and the “optimum moisture content” of the soil.

Example:
Given the following dry density and corresponding moisture content values develop a moisture-density relations curve and determine maximum dry density and optimum moisture content.

<table>
<thead>
<tr>
<th>Dry Density</th>
<th>Moisture Content, %</th>
</tr>
</thead>
<tbody>
<tr>
<td>kg/m³</td>
<td>lb/ft³</td>
</tr>
<tr>
<td>1846</td>
<td>114.3</td>
</tr>
<tr>
<td>1868</td>
<td>115.7</td>
</tr>
<tr>
<td>1887</td>
<td>116.9</td>
</tr>
<tr>
<td>1884</td>
<td>116.7</td>
</tr>
<tr>
<td>1871</td>
<td>115.9</td>
</tr>
</tbody>
</table>

In this case, the curve has its peak at:

Maximum dry density = 1890 kg/m³ (117.0 lb/ft³)
Optimum moisture content = 13.2%

Note that both values are approximate, since they are based on sketching the curve to fit the points.
Report

- Results on forms approved by the agency
- Sample ID
- Maximum dry density to the closest 1 kg/m³ (0.1 lb/ft³)
- Optimum moisture content to the closest 0.1 percent
ANNEX

CORRECTION OF MAXIMUM DRY DENSITY AND OPTIMUM MOISTURE FOR OVERSIZED PARTICLES

This section corrects the maximum dry density and moisture content of the material retained on the 4.75 mm (No. 4) sieve, Methods A and B; or the material retained on the 19 mm (¾ in.) sieve, Methods C and D. The maximum dry density, corrected for oversized particles and total moisture content, are compared with the field-dry density and field moisture content.

This correction can be applied to the sample on which the maximum dry density is performed. A correction may not be practical for soils with only a small percentage of oversize material. The agency shall specify a minimum percentage below which the method is not needed. If not specified, this method applies when more than 5 percent by weight of oversize particles is present.

Bulk specific gravity ($G_{sb}$) of the oversized particles is required to determine the corrected maximum dry density. Use the bulk specific gravity as determined using the FOP for AASHTO T 85 in the calculations. For construction activities an agency established value or specific gravity of 2.600 may be used.

This correction can also be applied to the sample obtained from the field while performing in-place density.

1. Use the sample from this procedure or a sample obtained according to the FOP for AASHTO T 310.

2. Sieve the sample on the 4.75 mm (No. 4) sieve for Methods A and B or the 19 mm (¾ in.) sieve, Methods C and D.

3. Determine the dry mass of the oversized and fine fractions ($M_{DC}$ and $M_{DF}$) by one of the following:
   
   a. Dry the fractions, fine and oversized, in air or by use of a drying apparatus that is maintained at a temperature not exceeding 60°C (140°F).
   
   b. Calculate the dry masses using the moisture samples.

To determine the dry mass of the fractions using moisture samples.

1. Determine the moist mass of both fractions, fine ($M_{MF}$) and oversized ($M_{MC}$):

2. Obtain moisture samples from the fine and oversized material.
3. Determine the moisture content of the fine particles (MC_f) and oversized particles (MC_c) of the material by FOP for AASHTO T 255/T 265 or agency approved method.

4. Calculate the dry mass of the oversize and fine particles.

\[ M_D = \frac{M_m}{1 + MC} \]

Where:

- MD = mass of dry material (fine or oversize particles)
- M_m = mass of moist material (fine or oversize particles)
- MC = moisture content of respective fine or oversized, expressed as a decimal

5. Calculate the percentage of the fine (P_f) and oversized (P_c) particles by dry weight of the total sample as follows: See Note 2.

\[ P_f = \frac{100M_{DF}}{M_{DF} + M_{DC}} \quad \frac{100 \times 15.4 \text{ lb}}{15.4 \text{ lbs} + 5.7 \text{ lb}} = 73\% \quad \frac{100 \times 7.034 \text{ kg}}{7.03 \text{ kg} + 2.602 \text{ kg}} = 73\% \]

And

\[ P_c = \frac{100M_{DC}}{M_{DF} + M_{DC}} \quad \frac{100 \times 5.7 \text{ lb}}{15.4 \text{ lbs} + 5.7 \text{ lb}} = 27\% \quad \frac{100 \times 2.602 \text{ kg}}{7.03 \text{ kg} + 2.602 \text{ kg}} = 27\% \]

Or for \( P_c \):

\[ P_c = 100 - P_f \]

Where:

- \( P_f \) = percent of fine particles, of sieve used, by weight
- \( P_c \) = percent of oversize particles, of sieve used, by weight
- \( M_{DF} \) = mass of fine particles
- \( M_{DC} \) = mass of oversize particles
**Optimum Moisture Correction Equation**

1. Calculate the corrected moisture content as follows:

$$MC_T = \frac{(MC_F \times P_f) + (MC_C \times P_c)}{100}$$

\[\frac{(13.2\% \times 73.0\%) + (2.1\% \times 27.0\%)}{100} = 10.2\%\]

**MCT** = corrected moisture content of combined fines and oversized particles, expressed as a % moisture

**MC_F** = moisture content of fine particles, as a % moisture

**MC_C** = moisture content of oversized particles, as a % moisture

**Note 1:** Moisture content of oversize material can be assumed to be two (2) percent for most construction applications.

**Note 2:** In some field applications agencies will allow the percentages of oversize and fine materials to be determined with the materials in the wet state.

**Density Correction Equation**

2. Calculate the corrected dry density of the total sample (combined fine and oversized particles) as follows:

$$D_d = \frac{100\% \times D_f}{P_f \times D_f + \frac{P_c \times k}{K}}$$

Where:

- **D_d** = corrected total dry density (combined fine and oversized particles) kg/m³ (lb/ft³)
- **D_f** = dry density of the fine particles kg/m³ (lb/ft³), determined in the lab
- **P_c** = percent of oversize particles, of sieve used, by weight.
- **P_f** = percent of fine particles, of sieve used, by weight.
- **k** = Metric: 1,000 * Bulk Specific Gravity (Gsb) (oven dry basis) of coarse particles (kg/m³).
- **k** = English: 62.4 * Bulk Specific Gravity (Gsb) (oven dry basis) of coarse particles (lb/ft³)

**Note 3:** If the specific gravity is known, then this value will be used in the calculation. For most construction activities the specific gravity for aggregate may be assumed to be 2.600.
Calculation

Sample Calculations:

• Metric:
  
  Maximum laboratory dry density \( (D_d) \): \( 1890 \, \text{kg/m}^3 \)
  
  Percent coarse particles \( (P_c) \): \( 27\% \)
  
  Percent fine particles \( (P_f) \): \( 73\% \)
  
  Mass per volume coarse particles \( (k) \): \( (2.697) \times (1000) = 2697 \, \text{kg/m}^3 \)

  \[
  D_d = \frac{100\%}{\frac{P_f}{D_f} + \frac{P_c}{k}}
  \]

  \[
  D_d = \frac{100\%}{\frac{73\%}{1890 \, \text{kg/m}^3} + \frac{27\%}{2697 \, \text{kg/m}^3}}
  \]

  \[
  D_d = \frac{100\%}{0.03862 \, \text{kg/m}^3 + 0.01001 \, \text{kg/m}^3}
  \]

  \[
  D_d = 2056.3 \, \text{kg/m}^3 \text{ report } 2056 \, \text{kg/m}^3
  \]
English:

Maximum laboratory dry density ($D_d$): 117.0 lb/ft$^3$

Percent coarse particles ($P_c$): 27%

Percent fine particles ($P_f$): 73%

Mass per volume of coarse particles ($k$): $(2.697)(62.4) = 168.3$ lb/ft$^3$

\[
D_d = \frac{100\%}{\frac{P_f}{D_f} + \frac{P_c}{k}}
\]

\[
D_d = \frac{100\%}{73\% \frac{117.0 \text{ lb/ft}^3}{168.3 \text{ lb/ft}^3} + 27\%}
\]

\[
D_d = \frac{100\%}{0.6239 \text{ lb/ft}^3 + 0.1604 \text{ lb/ft}^3}
\]

\[
D_d = \frac{100\%}{0.7843 \text{ lb/ft}^3}
\]

\[
D_d = 127.50 \text{ lb/ft}^3 \quad \text{report 127.5 lb/ft}^3
\]

**Report**

- Results on forms approved by the agency
- Sample ID
- Corrected maximum dry density to the closest 1 kg/m$^3$ (0.1 lb/ft$^3$)
- Corrected optimum moisture to the 0.1 percent
# PERFORMANCE EXAM CHECKLIST

**MOISTURE-DENSITY RELATION OF SOILS**
**FOP FOR AASHTO T 99**

Participant Name ______________________________ Exam Date ______________

Record the symbols “P” for passing or “F” for failing on each step of the checklist.

<table>
<thead>
<tr>
<th>Procedure Element</th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>1. If damp, sample dried in air or drying apparatus, not exceeding 60°C (140°F)?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>2. Sample broken up and an adequate amount sieved over the appropriate sieve (4.75 mm / No. 4 or 19.0 mm / 3/4 in.) to determine oversize (coarse particle) percentage?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>3. Sample passing the sieve has appropriate mass?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>4. If soil is plastic (clay types):</td>
<td></td>
<td></td>
</tr>
<tr>
<td>a. Multiple samples mixed with water varying moisture content by 1 to 2 percent, bracketing the optimum moisture content?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>b. Samples placed in covered containers and allowed to stand for at least 12 hours?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>5. Sample determined to be 4 to 8 percent below expected optimum moisture content?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>6. Mold placed on rigid and stable foundation?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>7. Layer of soil (approximately one third compacted depth) placed in mold with collar attached, loose material lightly tamped?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>8. Soil compacted with appropriate number of blows (25 or 56)?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>9. Material adhering to the inside of the mold trimmed?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>10. Layer of soil (approximately two thirds compacted depth) placed in mold with collar attached, loose material lightly tamped?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>11. Soil compacted with appropriate number of blows (25 or 56)?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>12. Material adhering to the inside of the mold trimmed?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>13. Mold filled with soil such that compacted soil will be above the mold, loose material lightly tamped?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>14. Soil compacted with appropriate number of blows (25 or 56)?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>15. Collar removed without shearing off sample?</td>
<td>_____</td>
<td>_____</td>
</tr>
</tbody>
</table>

OVER
**Procedure Element** | **Trial 1** | **Trial 2**
--- | --- | ---
16. Approximately 6 mm (1/4 in.) of compacted material above the top of the mold (without the collar)? | | |
17. Soil trimmed to top of mold with the beveled side of the straightedge? | | |
18. Mass of mold and contents determined to appropriate precision? | | |
19. Wet density calculated from the wet mass? | | |
20. Soil removed from mold using a sample extruder if needed? | | |
21. Soil sliced vertically through center (non-granular material)? | | |
22. Moisture sample removed ensuring all layers are represented? | | |
23. Moist mass determined immediately to 0.1 g? | | |
24. Moisture sample mass of correct size? | | |
25. Sample dried and water content determined according to the FOP for T 255/T 265? | | |
26. Remainder of material from mold broken up until it will pass through the sieve, as judged by eye, and added to remainder of original test sample? | | |
27. Water added to increase moisture content of the remaining sample in 1 to 2 percent increments? | | |
28. Steps 2 through 26 repeated for each increment of water added? | | |
29. If material is degradable:
   Multiple samples mixed with water varying moisture content by 1 to 2 percent, bracketing the optimum moisture content? | | |
30. Process continued until wet density either decreases or stabilizes? | | |
31. Moisture content and dry density calculated for each sample? | | |
32. Dry density plotted on vertical axis, moisture content plotted on horizontal axis, and points connected with a smooth curve? | | |
33. Moisture content at peak of curve recorded as optimum water content and recorded to nearest 0.1 percent? | | |
34. Dry density at optimum moisture content reported as maximum density to nearest 1 kg/m³ (0.1 lb/ft³)? | | |
35. Corrected for coarse particles if applicable? | | |

**Comments:**
First attempt: Pass Fail
Second attempt: Pass Fail

Examiner Signature _______________________________ WAQTC #: ________________
EMBANKMENT AND BASE
IN-PLACE DENSITY

WAQTC

FOP AASHTO T 99/T 180 (15)

PERFORMANCE EXAM CHECKLIST

MOISTURE-DENSITY RELATION OF SOILS
FOP FOR AASHTO T 180

Participant Name ______________________________ Exam Date ______________

Record the symbols “P” for passing or “F” for failing on each step of the checklist.

<table>
<thead>
<tr>
<th>Procedure Element</th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>1. If damp, sample dried in air or drying apparatus, not exceeding 60°C (140°F)?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>2. Sample broken up and an adequate amount sieved over the appropriate sieve (4.75 mm / No. 4 or 19.0 mm / 3/4 in.) to determine oversize (coarse particle) percentage?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>3. Sample passing the sieve has appropriate mass?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>4. If soil is plastic (clay types):</td>
<td></td>
<td></td>
</tr>
<tr>
<td>a. Multiple samples mixed with water varying moisture content by 1 to 2 percent, bracketing the optimum moisture content?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>b. Samples placed in covered containers and allowed to stand for at least 12 hours?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>5. Sample determined to be 4 to 8 percent below expected optimum moisture content?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>6. Mold placed on rigid and stable foundation?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>7. Layer of soil (approximately one fifth compacted depth) placed in mold with collar attached, loose material lightly tamped?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>8. Soil compacted with appropriate number of blows (25 or 56)?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>9. Material adhering to the inside of the mold trimmed?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>10. Layer of soil (approximately two fifths compacted depth) placed in mold with collar attached, loose material lightly tamped?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>11. Soil compacted with appropriate number of blows (25 or 56)?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>12. Material adhering to the inside of the mold trimmed?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>13. Layer of soil (approximately three fifths compacted depth) placed in mold with collar attached, loose material lightly tamped?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>14. Soil compacted with appropriate number of blows (25 or 56)?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>15. Material adhering to the inside of the mold trimmed?</td>
<td>_____</td>
<td>_____</td>
</tr>
</tbody>
</table>

OVER
### Procedure Element

<table>
<thead>
<tr>
<th></th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>16. Layer of soil (approximately four fifths compacted depth) placed in mold with collar attached, loose material lightly tamped?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>17. Soil compacted with appropriate number of blows (25 or 56)?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>18. Material adhering to the inside of the mold trimmed?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>19. Mold filled with soil such that compacted soil will be above the mold, loose material lightly tamped?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>20. Soil compacted with appropriate number of blows (25 or 56)?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>21. Collar removed without shearing off sample?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>22. Approximately 6 mm (1/4 in.) of compacted material above the top of the mold (without the collar)?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>23. Soil trimmed to top of mold with the beveled side of the straightedge?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>24. Mass of mold and contents determined to appropriate precision?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>25. Wet density calculated from the wet mass?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>26. Soil removed from mold using a sample extruder if needed?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>27. Soil sliced vertically through center (non-granular material)?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>28. Moisture sample removed ensuring all layers are represented?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>29. Moist mass determined immediately to 0.1 g?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>30. Moisture sample mass of correct size?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>31. Sample dried and water content determined according to the FOP for T 255/T 265?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>32. Remainder of material from mold broken up until it will pass through the sieve, as judged by eye, and added to remainder of original test sample?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>33. Water added to increase moisture content of the remaining sample in 1 to 2 percent increments?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>34. Steps 2 through 20 repeated for each increment of water added?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>35. If soil is plastic (clay types):</td>
<td></td>
<td></td>
</tr>
<tr>
<td>a. Samples mixed with water varying moisture content by 1 to 2 percent, bracketing the optimum moisture content?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>b. Samples placed in covered containers and allowed to stand for at least 12 hours?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>36. If material is degradable:</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Multiple samples mixed with water varying moisture content by 1 to 2 percent, bracketing the optimum moisture content?</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

**OVER**
### Procedure Element

<table>
<thead>
<tr>
<th>Procedure Element</th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>37. Process continued until wet density either decreases or stabilizes?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>38. Moisture content and dry density calculated for each sample?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>39. Dry density plotted on vertical axis, moisture content plotted on horizontal axis, and points connected with a smooth curve?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>40. Moisture content at peak of curve recorded as optimum water content and recorded to nearest 0.1 percent?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>41. Dry density at optimum moisture content reported as maximum density to nearest 1 kg/m³ (0.1 lb/ft³)?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>42. Corrected for coarse particles if applicable?</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

**Comments:**

First attempt: Pass Fail
Second attempt: Pass Fail

Examiner Signature _______________________________ WAQTC #: _________________
ANNEX.

Add the following to the second paragraph:

Correct for coarse particles if more than 10% of the material is retained on the 3/4 inch sieve.
TOTAL EVAPORABLE MOISTURE CONTENT OF AGGREGATE BY DRYING
FOP FOR AASHTO T 255 (16)
LABORATORY DETERMINATION OF MOISTURE CONTENT OF SOILS
FOP FOR AASHTO T 265 (16)

Scope

This procedure covers the determination of moisture content of aggregate and soil in accordance with AASHTO T 255-00 and AASHTO T 265-15. It may also be used for other construction materials.

Overview

Moisture content is determined by comparing the wet mass of a sample and the mass of the sample after drying to constant mass. The term constant mass is used to define when a sample is dry.

*Constant mass* – the state at which a mass does not change more than a given percent, after additional drying for a defined time interval, at a required temperature.

Apparatus

- Balance or scale: capacity sufficient for the principle sample mass, accurate to 0.1 percent of sample mass or readable to 0.1 g, and meeting the requirements of AASHTO M 231
- Containers, clean, dry and capable of being sealed
- Suitable drying containers
- Microwave safe container with ventilated lid
- Heat source, controlled:
  - Forced draft oven
  - Ventilated oven
  - Convection oven
- Heat source, uncontrolled:
  - Infrared heater/heat lamp, hot plate, fry pan, or any other device/method that will dry the sample without altering the material being dried
- Microwave oven (900 watts minimum)

- Utensils such as spoons

- Hot pads or gloves

**Sample Preparation**

In accordance with the FOP for AASHTO T 2 obtain a representative sample in its existing condition.

For aggregates the representative sample size is based on Table 1 or other information that may be specified by the agency.

<table>
<thead>
<tr>
<th>Nominal Maximum Size*</th>
<th>Minimum Sample Mass (lb)</th>
</tr>
</thead>
<tbody>
<tr>
<td>mm (in.)</td>
<td></td>
</tr>
<tr>
<td>4.75 (No. 4)</td>
<td>500 (1.1)</td>
</tr>
<tr>
<td>9.5 (3/8)</td>
<td>1500 (3.3)</td>
</tr>
<tr>
<td>12.5 (1/2)</td>
<td>2000 (4)</td>
</tr>
<tr>
<td>19.0 (3/4)</td>
<td>3000 (7)</td>
</tr>
<tr>
<td>25.0 (1)</td>
<td>4000 (9)</td>
</tr>
<tr>
<td>37.5 (1 1/2)</td>
<td>6000 (13)</td>
</tr>
<tr>
<td>50 (2)</td>
<td>8000 (18)</td>
</tr>
<tr>
<td>63 (2 1/2)</td>
<td>10,000 (22)</td>
</tr>
<tr>
<td>75 (3)</td>
<td>13,000 (29)</td>
</tr>
<tr>
<td>90 (3 1/2)</td>
<td>16,000 (35)</td>
</tr>
<tr>
<td>100 (4)</td>
<td>25,000 (55)</td>
</tr>
<tr>
<td>150 (6)</td>
<td>50,000 (110)</td>
</tr>
</tbody>
</table>

* One sieve larger than the first sieve to retain more than 10 percent of the material using an agency specified set of sieves based on cumulative percent retained. Where large gaps in specification sieves exist, intermediate sieve(s) may be inserted to determine nominal maximum.
For soils the representative sample size is based on Table 2 or other information that may be specified by the agency.

TABLE 2
Sample Sizes for Moisture Content of Soil

<table>
<thead>
<tr>
<th>Maximum Particle Size (mm (in))</th>
<th>Minimum Sample Mass g</th>
</tr>
</thead>
<tbody>
<tr>
<td>0.425 (No. 40)</td>
<td>10</td>
</tr>
<tr>
<td>4.75 (No. 4)</td>
<td>100</td>
</tr>
<tr>
<td>12.5 (1/2)</td>
<td>300</td>
</tr>
<tr>
<td>25.0 (1)</td>
<td>500</td>
</tr>
<tr>
<td>50 (2)</td>
<td>1000</td>
</tr>
</tbody>
</table>

Immediately seal or cover samples to prevent any change in moisture content or follow the steps in “Procedure.”

**Procedure**

Determine and record the sample mass as follows:

- For aggregate, determine and record all masses to the nearest 0.1 percent of the sample mass or to the nearest 0.1 g.

- For soil, determine and record all masses to the nearest 0.1 g.

When determining the mass of hot samples or containers or both, place and tare a buffer between the sample container and the balance. This will eliminate damage to or interference with the operation of the balance or scale.

1. Determine and record the mass of the container (and lid for microwave drying).

2. Place the wet sample in the container.
   a. For oven(s), hot plates, infrared heaters, etc.: Spread the sample in the container.
   b. For microwave oven: Heap sample in the container; cover with ventilated lid.

3. Determine and record the total mass of the container and wet sample.

4. Determine and record the wet mass of the sample by subtracting the container mass determined in Step 1 from the mass of the container and sample determined in Step 3.
5. Place the sample in one of the following drying apparatus:
   a. For aggregate –
      i. Controlled heat source (oven): at 110 ±5°C (230 ±9°F).
      ii. Uncontrolled heat source (Hot plate, infrared heater, etc.): Stir frequently to avoid localized overheating.
   b. For soil – controlled heat source (oven): at 110 ±5°C (230 ±9°F).

   Note 1: Soils containing gypsum or significant amounts of organic material require special drying. For reliable moisture contents dry these soils at 60°C (140°F). For more information see AASHTO T 265, Note 2.

6. Dry until sample appears moisture free.

7. Determine mass of sample and container.

8. Determine and record the mass of the sample by subtracting the container mass determined in Step 1 from the mass of the container and sample determined in Step 7.

9. Return sample and container to the heat source for additional drying.
   a. For aggregate –
      i. Controlled heat source (oven): 30 minutes
      ii. Uncontrolled heat source (Hot plate, infrared heater, etc.): 10 minutes
      iii. Uncontrolled heat source (Microwave oven): 2 minutes
   
   Caution: Some minerals in the sample may cause the aggregate to overheat, altering the aggregate gradation.
   
   b. For soil – controlled heat source (oven): 1 hour

10. Determine mass of sample and container.

11. Determine and record the mass of the sample by subtracting the container mass determined in Step 1 from the mass of the container and sample determined in Step 10.
12. Determine percent change by subtracting the new mass determination \( (M_n) \) from the previous mass determination \( (M_p) \) divide by the previous mass determination \( (M_p) \) multiply by 100.

13. Continue drying, performing steps 9 through 12, until there is less than a 0.10 percent change after additional drying time.

14. Constant mass has been achieved, sample is defined as dry.

15. Allow the sample to cool. Immediately determine and record the total mass of the container and dry sample.

16. Determine and record the dry mass of the sample by subtracting the mass of the container determined in Step 1 from the mass of the container and sample determined in Step 15.

17. Determine and record percent moisture by subtracting the final dry mass determination \( (M_D) \) from the initial wet mass determination \( (M_W) \) divide by the final dry mass determination \( (M_D) \) multiply by 100.

### Table 3
Methods of Drying

<table>
<thead>
<tr>
<th>Aggregate</th>
<th>Heat Source</th>
<th>Specific Instructions</th>
<th>Drying intervals to achieve constant mass (minutes)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Controlled:</td>
<td>Forced draft (preferred), ventilated, or convection oven</td>
<td>110 ±5°C (230 ±9°F)</td>
<td>30</td>
</tr>
<tr>
<td>Uncontrolled:</td>
<td>Hot plate, infrared heater, etc.</td>
<td>Stir frequently</td>
<td>10</td>
</tr>
<tr>
<td>Microwave</td>
<td>Heap sample and cover with ventilated lid</td>
<td>2</td>
<td></td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Soil</th>
<th>Heat Source</th>
<th>Specific Instructions</th>
<th>Drying increments (minutes)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Controlled:</td>
<td>Forced draft (preferred), ventilated, or convection oven</td>
<td>110 ±5°C (230 ±9°F)</td>
<td>1 hour</td>
</tr>
</tbody>
</table>
Calculation

**Constant Mass:**

Calculate constant mass using the following formula:

\[
\frac{M_p - M_n}{M_p} \times 100 = \% \text{ Change}
\]

Where: \( M_p \) = previous mass measurement  
\( M_n \) = new mass measurement

**Example:**

Mass of container: 1232.1 g  
Mass of container and sample after first drying cycle: 2637.2 g  
Mass, \( M_p \), of possibly dry sample: 2637.2 g - 1232.1 g = 1405.1 g  
Mass of container and dry sample after second drying cycle: 2634.1 g  
Mass, \( M_n \), of dry sample: 2634.1 g - 1232.1 g = 1402.0 g

\[
\frac{1405.1 \text{ g} - 1402.0 \text{ g}}{1405.1 \text{ g}} \times 100 = 0.22\%
\]

0.22 percent is not less than 0.10 percent, so continue drying

Mass of container and dry sample after third drying cycle: 2633.0 g  
Mass, \( M_n \), of dry sample: 2633.0 g - 1232.1 g = 1400.9 g

\[
\frac{1402.0 \text{ g} - 1400.9 \text{ g}}{1402.0 \text{ g}} \times 100 = 0.08\%
\]

0.08 percent is less than 0.10 percent, so constant mass has been reached.
Moisture Content:

Calculate the moisture content, as a percent, using the following formula:

\[ w = \frac{M_W - M_D}{M_D} \times 100 \]

Where:
- \( w \) = moisture content, percent
- \( M_W \) = wet mass
- \( M_D \) = dry mass

Example:

Mass of container: 1232.1 g
Mass of container and wet sample: 2764.7 g
Mass, \( M_W \), of wet sample: 2764.7 g - 1232.1 g = 1532.6 g
Mass of container and dry sample (COOLED): 2633.5 g
Mass, \( M_D \), of dry sample: 2633.5 g - 1232.1 g = 1401.4 g

\[ w = \frac{1532.6 g - 1401.4 g}{1401.4 g} \times 100 = \frac{131.2g}{1401.4 g} \times 100 = 9.36\% \quad \text{report } 9.4\% \]

Report

- Results on forms approved by the agency
- Sample ID
- \( M_W \), wet mass
- \( M_D \), dry mass
- \( w \), moisture content to nearest 0.1 percent
# PERFORMANCE EXAM CHECKLIST

**TOTAL EVAPORABLE MOISTURE CONTENT OF AGGREGATE BY DRYING**

**FOP FOR AASHTO T 255**

**LABORATORY DETERMINATION OF MOISTURE CONTENT OF SOILS**

**FOP FOR AASHTO T 265**

Participant Name ______________________________ Exam Date ______________

Record the symbols “P” for passing or “F” for failing on each step of the checklist.

<table>
<thead>
<tr>
<th>Procedure Element</th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>1. Representative sample of appropriate mass obtained?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>2. Mass of container determined to 0.1 g?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>3. Sample placed in container and mass determined to 0.1 g?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>4. Test sample mass conforms to the required mass?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>5. Wet sample mass determined to 0.1 g?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>6. Loss of moisture avoided prior to mass determination?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>7. Sample dried by a suitable heat source?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>8. If aggregate heated by means other than a controlled oven, is sample stirred to avoid localized overheating?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>9. For aggregate: Is aggregate heated for the additional, specified time (forced draft, ventilated, convection – 30 minutes; microwave – 2 minutes; other 10 minutes) and then mass determined and compared to previous mass showing less than 0.10 percent loss?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>10. For soil: Is soil heated for at least 1 hour additional drying time and then mass determined and compared to previous mass - showing less than 0.10 percent loss?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>11. Sample cooled, dry mass determined and recorded to the nearest 0.1 percent?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>12. Moisture content calculated correctly and recorded to the nearest 0.1 percent?</td>
<td>_____</td>
<td>_____</td>
</tr>
</tbody>
</table>

Comments: First attempt: Pass Fail Second attempt: Pass Fail

Examiner Signature ______________________________ WAQTC #: ______________

USE OF AKDOT & PF ATM 212, ITD IT 74, WSDOT T 606, OR WFLHD HUMPHRES CURVES

Background

Coarse-grained granular soils are free-draining and have little or no cohesion. These soils are, therefore, not particularly well suited for the moisture-density relations procedures of AASHTO T 99 or AASHTO T 180. Transportation agencies have developed specialized test methods that are hybrids of those moisture-density procedures and methods that employ compaction under load with vibration. Those methods include:

- AKDOT & PF’s ATM 212
- ITD’s IT 74
- WSDOT’s T 606
- WFLHD’s Humphres

Description of Procedure

In these tests, material is compacted in a mold and in a manner similar to those used in a Proctor test, after which the material is further compacted through a combination of applied loads and vibration. A laboratory maximum dry density is determined, as is the percent of material passing a certain sieve such as the 4.75 mm (No. 4). A number of determinations are made for different percentages passing the specified sieve. A graph is developed in which dry density is plotted versus the percentage of material passing that sieve. These tests are conducted in the agency’s central lab, and the curve developed is a central lab function. Figure 1 is an example of such a curve.

Construction specifications will call out a percent of maximum dry density required for the granular materials used on the job. These specified values will be based on ATM 212, IT 74, T 606, or Humphres, depending on the agency.

In the field, the dry density of the granular material will be determined in accordance with the FOP for AASHTO 310. The percent of material passing the specified sieve will be determined for a sample obtained at the site of the density test. The dry density and percent passing values will then be compared with the curve developed in the lab for that particular granular material to determine conformance with the project specifications.
## Maximum Density Chart

<table>
<thead>
<tr>
<th>Density Curves</th>
<th>Density Curves</th>
<th>Density Curves</th>
</tr>
</thead>
<tbody>
<tr>
<td>Pass #4</td>
<td>Maximum</td>
<td>Pass #4</td>
</tr>
<tr>
<td>0.0</td>
<td>104.8</td>
<td>31.0</td>
</tr>
<tr>
<td>1.0</td>
<td>105.6</td>
<td>32.0</td>
</tr>
<tr>
<td>2.0</td>
<td>106.4</td>
<td>33.0</td>
</tr>
<tr>
<td>3.0</td>
<td>107.1</td>
<td>34.0</td>
</tr>
<tr>
<td>4.0</td>
<td>107.9</td>
<td>35.0</td>
</tr>
<tr>
<td>5.0</td>
<td>108.7</td>
<td>36.0</td>
</tr>
<tr>
<td>6.0</td>
<td>109.5</td>
<td>37.0</td>
</tr>
<tr>
<td>7.0</td>
<td>110.3</td>
<td>38.0</td>
</tr>
<tr>
<td>8.0</td>
<td>111.1</td>
<td>39.0</td>
</tr>
<tr>
<td>9.0</td>
<td>112.0</td>
<td>40.0</td>
</tr>
<tr>
<td>10.0</td>
<td>112.8</td>
<td>41.0</td>
</tr>
<tr>
<td>11.0</td>
<td>113.7</td>
<td>42.0</td>
</tr>
<tr>
<td>12.0</td>
<td>114.5</td>
<td>43.0</td>
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<tr>
<td>13.0</td>
<td>115.4</td>
<td>44.0</td>
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<td>14.0</td>
<td>116.4</td>
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<td>16.0</td>
<td>118.2</td>
<td>47.0</td>
</tr>
<tr>
<td>17.0</td>
<td>119.2</td>
<td>48.0</td>
</tr>
<tr>
<td>18.0</td>
<td>120.2</td>
<td>49.0</td>
</tr>
<tr>
<td>19.0</td>
<td>121.3</td>
<td>50.0</td>
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<tr>
<td>20.0</td>
<td>122.3</td>
<td>51.0</td>
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<tr>
<td>21.0</td>
<td>123.4</td>
<td>52.0</td>
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<tr>
<td>22.0</td>
<td>124.5</td>
<td>53.0</td>
</tr>
<tr>
<td>23.0</td>
<td>125.6</td>
<td>54.0</td>
</tr>
<tr>
<td>24.0</td>
<td>126.8</td>
<td>55.0</td>
</tr>
<tr>
<td>25.0</td>
<td>127.9</td>
<td>56.0</td>
</tr>
<tr>
<td>26.0</td>
<td>129.0</td>
<td>57.0</td>
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<td>27.0</td>
<td>130.0</td>
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<tr>
<td>29.0</td>
<td>132.0</td>
<td>60.0</td>
</tr>
<tr>
<td>30.0</td>
<td>132.8</td>
<td>61.0</td>
</tr>
</tbody>
</table>

### Control Points for Density Curves

<table>
<thead>
<tr>
<th>Pass #4</th>
<th>Maximum</th>
<th>Loose</th>
</tr>
</thead>
<tbody>
<tr>
<td>0.0</td>
<td>104.8</td>
<td>87.6</td>
</tr>
<tr>
<td>20.5</td>
<td>122.8</td>
<td>99.6</td>
</tr>
<tr>
<td>27.4</td>
<td>130.4</td>
<td>103.8</td>
</tr>
<tr>
<td>42.5</td>
<td>139.1</td>
<td>105.4</td>
</tr>
<tr>
<td>61.1</td>
<td>134.9</td>
<td>96.7</td>
</tr>
<tr>
<td>100.0</td>
<td>126.9</td>
<td>81.9</td>
</tr>
</tbody>
</table>
Example:

A compaction test was taken and a sample was removed from the test site per the FOP for AASHTO T 310. The sample was graded over a 4.75 mm (No. 4) sieve. The following results were reported.

Dry density from the FOP for AASHTO T 310 = 136.0 lb/ft$^3$

Percent passing 4.75 mm (No. 4) sieve = 49%

Maximum density = 138.8 lb/ft$^3$

\[
Percent
\text{ compaction} = \frac{136.0 \text{ lb/ft}^3}{138.8 \text{ lb/ft}^3} \times 100 = 98\%
\]
## IN-PLACE DENSITY

### FIELD OPERATING PROCEDURES - SHORT FORM

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Scope

This procedure covers the determination of moisture content of aggregate and soil in accordance with AASHTO T 255-00 and AASHTO T 265-15. It may also be used for other construction materials.

Overview

Moisture content is determined by comparing the wet mass of a sample and the mass of the sample after drying to constant mass. The term constant mass is used to define when a sample is dry.

*Constant mass* – the state at which a mass does not change more than a given percent, after additional drying for a defined time interval, at a required temperature.

Apparatus

- Balance or scale: capacity sufficient for the principle sample mass, accurate to 0.1 percent of sample mass or readable to 0.1 g, and meeting the requirements of AASHTO M 231

- Containers, clean, dry and capable of being sealed

- Suitable drying containers

- Microwave safe container with ventilated lid

- Heat source, controlled:
  - Forced draft oven
  - Ventilated oven
  - Convection oven

- Heat source, uncontrolled:
  - Infrared heater/heat lamp, hot plate, fry pan, or any other device/method that will dry the sample without altering the material being dried
Microwave oven (900 watts minimum)

- Utensils such as spoons
- Hot pads or gloves

**Sample Preparation**

In accordance with the FOP for AASHTO T 2 obtain a representative sample in its existing condition.

For aggregates the representative sample size is based on Table 1 or other information that may be specified by the agency.

**TABLE 1**

Sample Sizes for Moisture Content of Aggregate

<table>
<thead>
<tr>
<th>Nominal Maximum Size* mm (in.)</th>
<th>Minimum Sample Mass g (lb)</th>
</tr>
</thead>
<tbody>
<tr>
<td>4.75 (No. 4)</td>
<td>500 (1.1)</td>
</tr>
<tr>
<td>9.5 (3/8)</td>
<td>1500 (3.3)</td>
</tr>
<tr>
<td>12.5 (1/2)</td>
<td>2000 (4)</td>
</tr>
<tr>
<td>19.0 (3/4)</td>
<td>3000 (7)</td>
</tr>
<tr>
<td>25.0 (1)</td>
<td>4000 (9)</td>
</tr>
<tr>
<td>37.5 (1 1/2)</td>
<td>6000 (13)</td>
</tr>
<tr>
<td>50 (2)</td>
<td>8000 (18)</td>
</tr>
<tr>
<td>63 (2 1/2)</td>
<td>10,000 (22)</td>
</tr>
<tr>
<td>75 (3)</td>
<td>13,000 (29)</td>
</tr>
<tr>
<td>90 (3 1/2)</td>
<td>16,000 (35)</td>
</tr>
<tr>
<td>100 (4)</td>
<td>25,000 (55)</td>
</tr>
<tr>
<td>150 (6)</td>
<td>50,000 (110)</td>
</tr>
</tbody>
</table>

* One sieve larger than the first sieve to retain more than 10 percent of the material using an agency specified set of sieves based on cumulative percent retained. Where large gaps in specification sieves exist, intermediate sieve(s) may be inserted to determine nominal maximum.
For soils the representative sample size is based on Table 2 or other information that may be specified by the agency.

**Table 2**
Sample Sizes for Moisture Content of Soil

<table>
<thead>
<tr>
<th>Maximum Particle Size</th>
<th>Minimum Sample Mass</th>
</tr>
</thead>
<tbody>
<tr>
<td>mm (in)</td>
<td>g</td>
</tr>
<tr>
<td>0.425 (No. 40)</td>
<td>10</td>
</tr>
<tr>
<td>4.75 (No. 4)</td>
<td>100</td>
</tr>
<tr>
<td>12.5 (1/2)</td>
<td>300</td>
</tr>
<tr>
<td>25.0 (1)</td>
<td>500</td>
</tr>
<tr>
<td>50 (2)</td>
<td>1000</td>
</tr>
</tbody>
</table>

Immediately seal or cover samples to prevent any change in moisture content or follow the steps in “Procedure.”

**Procedure**

Determine and record the sample mass as follows:

- For aggregate, determine and record all masses to the nearest 0.1 percent of the sample mass or to the nearest 0.1 g.
- For soil, determine and record all masses to the nearest 0.1 g.

When determining the mass of hot samples or containers or both, place and tare a buffer between the sample container and the balance. This will eliminate damage to or interference with the operation of the balance or scale.

1. Determine and record the mass of the container (and lid for microwave drying).

2. Place the wet sample in the container.
   - For oven(s), hot plates, infrared heaters, etc.: Spread the sample in the container.
   - For microwave oven: Heap sample in the container; cover with ventilated lid.

3. Determine and record the total mass of the container and wet sample.

4. Determine and record the wet mass of the sample by subtracting the container mass determined in Step 1 from the mass of the container and sample determined in Step 3.
5. Place the sample in one of the following drying apparatus:
   a. For aggregate –
      i. Controlled heat source (oven): at 110 ±5°C (230 ±9°F).
      ii. Uncontrolled heat source (Hot plate, infrared heater, etc.): Stir frequently to avoid localized overheating.
   b. For soil – controlled heat source (oven): at 110 ±5°C (230 ±9°F).

   **Note 1:** Soils containing gypsum or significant amounts of organic material require special drying. For reliable moisture contents dry these soils at 60°C (140°F). For more information see AASHTO T 265, Note 2.

6. Dry until sample appears moisture free.

7. Determine mass of sample and container.

8. Determine and record the mass of the sample by subtracting the container mass determined in Step 1 from the mass of the container and sample determined in Step 7.

9. Return sample and container to the heat source for additional drying.
   a. For aggregate –
      i. Controlled heat source (oven): 30 minutes
      ii. Uncontrolled heat source (Hot plate, infrared heater, etc.): 10 minutes
      iii. Uncontrolled heat source (Microwave oven): 2 minutes

   **Caution:** Some minerals in the sample may cause the aggregate to overheat, altering the aggregate gradation.
   b. For soil – controlled heat source (oven): 1 hour

10. Determine mass of sample and container.

11. Determine and record the mass of the sample by subtracting the container mass determined in Step 1 from the mass of the container and sample determined in Step 10.
12. Determine percent change by subtracting the new mass determination \( (M_n) \) from the previous mass determination \( (M_p) \) divide by the previous mass determination \( (M_p) \) multiply by 100.

13. Continue drying, performing steps 9 through 12, until there is less than a 0.10 percent change after additional drying time.

14. Constant mass has been achieved, sample is defined as dry.

15. Allow the sample to cool. Immediately determine and record the total mass of the container and dry sample.

16. Determine and record the dry mass of the sample by subtracting the mass of the container determined in Step 1 from the mass of the container and sample determined in Step 15.

17. Determine and record percent moisture by subtracting the final dry mass determination \( (M_D) \) from the initial wet mass determination \( (M_W) \) divide by the final dry mass determination \( (M_D) \) multiply by 100.

### Table 3

**Methods of Drying**

<table>
<thead>
<tr>
<th>Aggregate</th>
<th>Heat Source</th>
<th>Specific Instructions</th>
<th>Drying intervals to achieve constant mass (minutes)</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Controlled:</strong></td>
<td>Forced draft (preferred), ventilated, or convection oven</td>
<td>110 ±5°C (230 ±9°F)</td>
<td>30</td>
</tr>
<tr>
<td><strong>Uncontrolled:</strong></td>
<td>Hot plate, infrared heater, etc.</td>
<td>Stir frequently</td>
<td>10</td>
</tr>
<tr>
<td></td>
<td>Microwave</td>
<td>Heap sample and cover with ventilated lid</td>
<td>2</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Soil</th>
<th>Heat Source</th>
<th>Specific Instructions</th>
<th>Drying increments (minutes)</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Controlled:</strong></td>
<td>Forced draft (preferred), ventilated, or convection oven</td>
<td>110 ±5°C (230 ±9°F)</td>
<td>1 hour</td>
</tr>
</tbody>
</table>
Calculation

**Constant Mass:**

Calculate constant mass using the following formula:

\[
\frac{M_p - M_n}{M_p} \times 100 = \% \text{ Change}
\]

Where:
- \( M_p \) = previous mass measurement
- \( M_n \) = new mass measurement

Example:

Mass of container: 1232.1 g
Mass of container and sample after first drying cycle: 2637.2 g
Mass, \( M_p \), of possibly dry sample: 2637.2 g - 1232.1 g = 1405.1 g
Mass of container and dry sample after second drying cycle: 2634.1 g
Mass, \( M_n \), of dry sample: 2634.1 g - 1232.1 g = 1402.0 g

\[
\frac{1405.1 \ g - 1402.0 \ g}{1405.1 \ g} \times 100 = 0.22\%
\]

*0.22 percent is not less than 0.10 percent, so continue drying*

Mass of container and dry sample after third drying cycle: 2633.0 g
Mass, \( M_n \), of dry sample: 2633.0 g - 1232.1 g = 1400.9 g

\[
\frac{1402.0 \ g - 1400.9 \ g}{1402.0 \ g} \times 100 = 0.08\%
\]

*0.08 percent is less than 0.10 percent, so constant mass has been reached.*
Moisture Content:

Calculate the moisture content, as a percent, using the following formula:

\[ w = \frac{M_W - M_D}{M_D} \times 100 \]

Where:
- \( w \) = moisture content, percent
- \( M_W \) = wet mass
- \( M_D \) = dry mass

Example:

Mass of container: 1232.1 g
Mass of container and wet sample: 2764.7 g
Mass, \( M_W \), of wet sample: 2764.7 g - 1232.1 g = 1532.6 g
Mass of container and dry sample (COOLED): 2633.5 g
Mass, \( M_D \), of dry sample: 2633.5 g - 1232.1 g = 1401.4 g

\[ w = \frac{1532.6 \text{ g} - 1401.4 \text{ g}}{1401.4 \text{ g}} \times 100 = \frac{131.2 \text{ g}}{1401.4 \text{ g}} \times 100 = 9.36\% \text{ report 9.4\%} \]

Report

- Results on forms approved by the agency
- Sample ID
- \( M_W \), wet mass
- \( M_D \), dry mass
- \( w \), moisture content to nearest 0.1 percent
**PERFORMANCE EXAM CHECKLIST**

**TOTAL EVAPORABLE MOISTURE CONTENT OF AGGREGATE BY DRYING**

**FOP FOR AASHTO T 255**

**LABORATORY DETERMINATION OF MOISTURE CONTENT OF SOILS**

**FOP FOR AASHTO T 265**

Participant Name ______________________________ Exam Date ______________

Record the symbols “P” for passing or “F” for failing on each step of the checklist.

<table>
<thead>
<tr>
<th>Procedure Element</th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>1. Representative sample of appropriate mass obtained?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>2. Mass of container determined to 0.1 g?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>3. Sample placed in container and mass determined to 0.1 g?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>4. Test sample mass conforms to the required mass?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>5. Wet sample mass determined to 0.1 g?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>6. Loss of moisture avoided prior to mass determination?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>7. Sample dried by a suitable heat source?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>8. If aggregate heated by means other than a controlled oven, is sample stirred to avoid localized overheating?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>9. For aggregate: Is aggregate heated for the additional, specified time (forced draft, ventilated, convection – 30 minutes; microwave – 2 minutes; other 10 minutes) and then mass determined and compared to previous mass showing less than 0.10 percent loss?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>10. For soil: Is soil heated for at least 1 hour additional drying time and then mass determined and compared to previous mass - showing less than 0.10 percent loss?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>11. Sample cooled, dry mass determined and recorded to the nearest 0.1 percent?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>12. Moisture content calculated correctly and recorded to the nearest 0.1 percent?</td>
<td>_____</td>
<td>_____</td>
</tr>
</tbody>
</table>

**Comments:** First attempt: Pass_____ Fail_____ Second attempt: Pass_____ Fail_____

Examiner Signature _______________________________ WAQTC #: ________________

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ONE-POINT METHOD FOR DETERMINING MAXIMUM DRY DENSITY AND OPTIMUM MOISTURE
FOP FOR AASHTO T 272 (16)

Scope

This procedure provides for a rapid determination of the maximum dry density and optimum moisture content of a soil sample, using a one-point determination in accordance with AASHTO T 272-16. This procedure is related to the FOPs for AASHTO T 99/T 180 and R 75.

One-point determinations are made by compacting the soil in a mold of a given size with a specified rammer dropped from a specified height and then compared to an individual moisture/density curve (FOP for AASHTO T 99 or T 180) or a family of curves (FOP for AASHTO R 75). Four alternate methods – A, B, C, and D – are used and correspond to the methods described in the FOP for AASHTO T 99/T 180. The method used in AASHTO T 272 must match the method used for the reference curve or to establish the family of curves. For example, when moisture-density relationships as determined by T 99 - Method C are used to form the family of curves or an individual moisture density curve, then T 99 - Method C must be used to for the one-point determination.

Apparatus

See the FOP for AASHTO T 99/T 180. Use the method matching the individual curve or Family of Curves. Refer to Table 1 of the FOP for AASHTO T 99 / T 180 for corresponding mold size, number of layers, number of blows, and rammer specification for the various test methods.

Sample

Sample size determined according to the FOP for AASHTO T 310. In cases where the existing individual curve or family cannot be used a completely new curve will need to be developed and the sample size will be determined by the FOP for AASHTO T 99/T 180.

If the sample is damp, dry it until it becomes friable under a trowel. Drying may be in air or by use of a drying apparatus maintained at a temperature not exceeding 60°C (140°F). Thoroughly break up aggregations in a manner that avoids reducing the natural size of individual particles.

Procedure

1. Determine the mass of the clean, dry mold. Include the base plate, but exclude the extension collar. Record the mass to the nearest 1 g (0.005 lb).

2. Thoroughly mix the sample with sufficient water to adjust moisture content to 80 to 100 percent of the anticipated optimum moisture.
3. Form a specimen by compacting the prepared soil in the mold (with collar attached) in approximately equal layers. For each layer:

   a. Spread the loose material uniformly in the mold.

   Note 1: It is recommended to cover the remaining material with a non-absorbent sheet or damp cloth to minimize loss of moisture.

   b. Lightly tamp the loose material with the manual rammer or other similar device, this establishes a firm surface.

   c. Compact each layer with uniformly distributed blows from the rammer.

   d. Trim down material that has not been compacted and remains adjacent to the walls of the mold and extends above the compacted surface.

4. Remove the extension collar. Avoid shearing off the sample below the top of the mold. The material compacted in the mold should not be over 6 mm (¼ in.) above the top of the mold once the collar has been removed.

5. Trim the compacted soil even with the top of the mold with the beveled side of the straightedge.

6. Determine the mass of the mold and wet soil to the nearest 1 g (0.005 lb) or better.

7. Determine the wet mass of the sample by subtracting the mass in Step 1 from the mass in Step 6.

8. Calculate the wet density as indicated below under “Calculations.”

9. Extrude the material from the mold. For soils and soil-aggregate mixtures, slice vertically through the center and take a representative moisture content sample from one of the cut faces, ensuring that all layers are represented. For granular materials, a vertical face will not exist. Take a representative sample. This sample must meet the sample size requirements of the test method used to determine moisture content.

10. Determine the moisture content of the sample in accordance with the FOP for AASHTO T 255 / T 265.
Calculations

1. Calculate the wet density, in kg/m³ (lb/ft³), by dividing the wet mass by the measured volume of the mold (T 19).

Example – Methods A or C mold:

Wet mass = 2.0055 kg (4.42 lb)

Measured volume of the mold = 0.0009469 m³ (0.03344 ft³)

\[
\text{Wet Density} = \frac{2.0055 \text{ kg}}{0.0009469 \text{ m}^3} = 2118 \text{ kg/m}^3
\]

\[
\text{Wet Density} = \frac{4.42 \text{ lb}}{0.03344 \text{ ft}^3} = 132.2 \text{ lb/ft}^3
\]

2. Calculate the dry density as follows.

\[
\rho_d = \left( \frac{\rho_w}{w + 100} \right) \times 100 \quad \text{or} \quad \rho_d = \frac{\rho_w}{\left( \frac{w}{100} \right) + 1}
\]

Where:

\( \rho_d \) = Dry density, kg/m³ (lb/ft³)
\( \rho_w \) = Wet density, kg/m³ (lb/ft³)
\( w \) = Moisture content, as a percentage

Example:

\( \rho_w = 2118 \text{ kg/m}^3 (132.2 \text{ lb/ft}^3) \)

\( w = 13.5\% \)

\[
\rho_d = \left( \frac{2118 \text{ kg/m}^3}{13.5 + 100} \right) \times 100 = 1866 \text{ kg/m}^3 \quad \rho_d = \left( \frac{132.2 \text{ lb/ft}^3}{13.5 + 100} \right) \times 100 = 116.5 \text{ lb/ft}^3
\]

or

\[
\rho_d = \left( \frac{2118 \text{ kg/m}^3}{13.5 + 100} \right) = 1866 \text{ kg/m}^3 \quad \rho_d = \left( \frac{132.2 \text{ lb/ft}^3}{13.5 + 100} \right) = 116.5 \text{ lb/ft}^3
\]
Maximum Dry Density and Optimum Moisture Content Determination Using an Individual Moisture / Density Curve

1. The moisture content must be within 80 to 100 percent of optimum moisture of the reference curve. Compact another specimen, using the same material, at an adjusted moisture content if the one-point does not fall in the 80 to 100 percent of optimum moisture range.

2. If the moisture content of the one-point determination is not within 80 to 100 percent of the optimum moisture content, compact another specimen, using the same material, at adjusted moisture content.

3. Plot the one-point, dry density on the vertical axis and moisture content on the horizontal axis, on the reference curve graph.

4. If the one-point falls on the reference curve or within ±2.0 lbs/ft³, then the maximum dry density and optimum moisture content determined by the curve can be used.

5. Perform a full moisture-density relationship if the one-point does not fall on or within ±2.0 lbs/ft³ of the reference curve at 80 to 100 percent optimum moisture.
The results of a one-point determination were 116.5 lb/ft³ at 13.5 percent moisture. The point was plotted on the reference curve graph. The one-point determination is within 2.0 lb/ft³ of the point on the curve that corresponds with the moisture content.
Maximum Dry Density and Optimum Moisture Content Determination Using a Family of Curves

1. If the moisture-density one-point falls on one of the curves in the family of curves, the maximum dry density and optimum moisture content defined by that curve is used.

2. If the moisture-density one-point falls within the family of curves but not on an existing curve, draw a new curve through the plotted single point, parallel and in character with the nearest existing curve in the family of curves. Use the maximum dry density and optimum moisture content as defined by the new curve.

3. The one-point must fall either between or on the highest or lowest curves in the family. If it does not, then a full curve must be developed.

4. If the one-point plotted within or on the family of curves does not fall in the 80 to 100 percent of optimum moisture content, compact another specimen, using the same material, at an adjusted moisture content that will place the one point within this range.

5. If the new curve through a one-point is not well defined or is in any way questionable, perform a full moisture-density relationship to correctly define the new curve and verify the applicability of the family of curves.

Note 2: New curves drawn through plotted single point determinations shall not become a permanent part of the family of curves until verified by a full moisture-density procedure following the FOP for AASHTO T 99/T 180.
EXAMPLE

The results of a one-point determination were 116.5 lb/ft³ at 13.5 percent moisture. The point was plotted on the reference curve graph. The point was plotted on the appropriate family between two previously developed curves near and intermediate curve.

The “dotted” curve through the moisture-density one-point was sketched between the existing curves. A maximum dry density of 119.3 lb/ft³ and a corresponding optimum moisture content of 15.9 percent were estimated.
Report

- Results on forms approved by the agency
- Sample ID
- Maximum dry density to the closest 1 kg/m³ (0.1 lb/ft³)
- Optimum moisture content to the closest 0.1 percent
- Reference curve or Family of Curves used
# PERFORMANCE EXAM CHECKLIST

**ONE-POINT METHOD**

**FOP FOR AASHTO T 272 (T 99)**

Participant Name ______________________________ Exam Date ______________

Record the symbols “P” for passing or “F” for failing on each step of the checklist.

<table>
<thead>
<tr>
<th>Procedure Element</th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>1. One-point determination of dry density and corresponding moisture content made in accordance with the FOP for AASHTO T 99?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>a. Correct size (4.75 mm / No. 4 or 19.0 mm / 3/4 in.) material used?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>2. If necessary, sample dried until friable in air or drying apparatus, not exceeding 60°C (140°F)?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>3. Sample broken up and an adequate amount sieved over the appropriate sieve (4.75 mm / No. 4 or 19.0 mm / 3/4 in.) to determine oversize (coarse particle) percentage?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>4. Sample passing the sieve has appropriate mass?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>5. Layer of soil (approximately one third compacted depth) placed in mold with collar attached, loose material lightly tamped?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>6. Soil compacted with appropriate number of blows (25 or 56)?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>7. Material adhering to the inside of the mold trimmed?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>8. Layer of soil (approximately two thirds compacted depth) placed in mold with collar attached, loose material lightly tamped?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>9. Soil compacted with appropriate number of blows (25 or 56)?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>10. Material adhering to the inside of the mold trimmed?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>11. Mold filled with soil such that compacted soil will be above the mold, loose material lightly tamped?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>12. Soil compacted with appropriate number of blows (25 or 56)?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>13. Collar removed without shearing off sample?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>14. Approximately 6 mm (1/4 in.) of compacted material above the top of the mold (without the collar)?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>15. Soil trimmed to top of mold with the beveled side of the straightedge?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>16. Mass of mold and contents determined to appropriate precision?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>17. Wet density calculated from the wet mass?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>18. Soil removed from mold using a sample extruder if needed?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>19. Soil sliced vertically through center (non-granular material)?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>20. Moisture sample removed ensuring all layers are represented?</td>
<td>_____</td>
<td>_____</td>
</tr>
</tbody>
</table>

OVER
**Procedure Element**

<table>
<thead>
<tr>
<th>Procedure</th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>21. Moist mass determined immediately to 0.1 g?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>22. Moisture sample mass of correct size?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>23. Sample dried and water content determined according to the FOP for T 255/T 265?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>24. One-point plotted on family of curves supplied?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>25. One-point falls within 80 to 100 percent of optimum moisture content in order to be valid?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>26. If one-point does not fall within 80 to 100 percent of optimum moisture content, another one-point determination with an adjusted water content is made?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>27. Maximum dry density and corresponding optimum moisture content correctly estimated?</td>
<td>_____</td>
<td>_____</td>
</tr>
</tbody>
</table>

**Comments:**

<table>
<thead>
<tr>
<th>First attempt:</th>
<th>Pass</th>
<th>Fail</th>
</tr>
</thead>
</table>

<table>
<thead>
<tr>
<th>Second attempt:</th>
<th>Pass</th>
<th>Fail</th>
</tr>
</thead>
</table>

Examiner Signature _______________________________ WAQTC #: __________________
PERFORMANCE EXAM CHECKLIST

ONE-POINT METHOD
FOP FOR AASHTO T 272 (T 180)

Participant Name ______________________________ Exam Date ______________

Record the symbols “P” for passing or “F” for failing on each step of the checklist.

<table>
<thead>
<tr>
<th>Procedure Element</th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>1. One-point determination of dry density and corresponding moisture content made in accordance with the FOP for AASHTO T 180?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>a. Correct size (4.75 mm / No. 4 or 19.0 mm / 3/4 in.) material used?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>2. If necessary, sample dried until friable in air or drying apparatus, not exceeding 60°C (140°F)?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>3. Sample broken up and an adequate amount sieved over the appropriate sieve (4.75 mm / No. 4 or 19.0 mm / 3/4 in.) to determine oversize (coarse particle) percentage?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>4. Sample passing the sieve has appropriate mass?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>5. Mold placed on rigid and stable foundation?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>6. Layer of soil (approximately one fifth compacted depth) placed in mold with collar attached, loose material lightly tamped?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>7. Soil compacted with appropriate number of blows (25 or 56)?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>8. Material adhering to the inside of the mold trimmed?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>9. Layer of soil (approximately two fifths compacted depth) placed in mold with collar attached, loose material lightly tamped?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>10. Soil compacted with appropriate number of blows (25 or 56)?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>12. Material adhering to the inside of the mold trimmed?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>13. Layer of soil (approximately three fifths compacted depth) placed in mold with collar attached, loose material lightly tamped?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>14. Soil compacted with appropriate number of blows (25 or 56)?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>15. Material adhering to the inside of the mold trimmed?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>16. Layer of soil (approximately four fifths compacted depth) placed in mold with collar attached, loose material lightly tamped?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>17. Soil compacted with appropriate number of blows (25 or 56)?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>18. Material adhering to the inside of the mold trimmed?</td>
<td>_____</td>
<td>_____</td>
</tr>
</tbody>
</table>

OVER
## Procedure Element

<table>
<thead>
<tr>
<th>Procedure Element</th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>19. Mold filled with soil such that compacted soil will be above the mold, loose material lightly tamped?</td>
<td>____</td>
<td>____</td>
</tr>
<tr>
<td>20. Soil compacted with appropriate number of blows (25 or 56)?</td>
<td>____</td>
<td>____</td>
</tr>
<tr>
<td>21. Collar removed without shearing off sample?</td>
<td>____</td>
<td>____</td>
</tr>
<tr>
<td>22. Approximately 6 mm (1/4 in.) of compacted material above the top of the mold (without the collar)?</td>
<td>____</td>
<td>____</td>
</tr>
<tr>
<td>23. Soil trimmed to top of mold with the beveled side of the straightedge?</td>
<td>____</td>
<td>____</td>
</tr>
<tr>
<td>24. Mass of mold and contents determined to appropriate precision?</td>
<td>____</td>
<td>____</td>
</tr>
<tr>
<td>25. Wet density calculated from the wet mass?</td>
<td>____</td>
<td>____</td>
</tr>
<tr>
<td>26. Soil removed from mold using a sample extruder if needed?</td>
<td>____</td>
<td>____</td>
</tr>
<tr>
<td>27. Soil sliced vertically through center (non-granular material)?</td>
<td>____</td>
<td>____</td>
</tr>
<tr>
<td>28. Moisture sample removed ensuring all layers are represented?</td>
<td>____</td>
<td>____</td>
</tr>
<tr>
<td>29. Moist mass determined immediately to 0.1 g?</td>
<td>____</td>
<td>____</td>
</tr>
<tr>
<td>30. Moisture sample mass of correct size?</td>
<td>____</td>
<td>____</td>
</tr>
<tr>
<td>31. Sample dried and water content determined according to the FOP for T 255/T 265?</td>
<td>____</td>
<td>____</td>
</tr>
<tr>
<td>32. One-point plotted on family of curves supplied?</td>
<td>____</td>
<td>____</td>
</tr>
<tr>
<td>33. One-point falls within 80 to 100 percent of optimum moisture content in order to be valid?</td>
<td>____</td>
<td>____</td>
</tr>
<tr>
<td>34. If one-point does not fall within 80 to 100 percent of optimum moisture content, another one-point determination with an adjusted water content is made?</td>
<td>____</td>
<td>____</td>
</tr>
<tr>
<td>35. Maximum dry density and corresponding optimum moisture content correctly estimated?</td>
<td>____</td>
<td>____</td>
</tr>
</tbody>
</table>

## Comments:

First attempt: Pass Fail Second attempt: Pass Fail

Examiner Signature _______________________________ WAQTC #: ____________
IN-PLACE DENSITY AND MOISTURE CONTENT OF SOIL AND SOIL-AGGREGATE BY NUCLEAR METHODS (SHALLOW DEPTH)
FOP FOR AASHTO T 310 (15)

Scope

This procedure covers the determination of density, moisture content, and relative compaction of soil, aggregate, and soil-aggregate mixes in accordance with AASHTO T 310-13. This field operating procedure is derived from AASHTO T 310. The nuclear moisture-density gauge is used in the direct transmission mode.

Apparatus

- Nuclear density gauge with the factory matched standard reference block.
- Drive pin, guide/scaper plate, and hammer for testing in direct transmission mode.
- Transport case for properly shipping and housing the gauge and tools.
- Instruction manual for the specific make and model of gauge.
- Radioactive materials information and calibration packet containing:
  - Daily Standard Count Log.
  - Factory and Laboratory Calibration Data Sheet.
  - Leak Test Certificate.
  - Shippers Declaration for Dangerous Goods.
  - Procedure Memo for Storing, Transporting and Handling Nuclear Testing Equipment.
  - Other radioactive materials documentation as required by local regulatory requirements.
- Sealable containers and utensils for moisture content determinations.

Radiation Safety

This method does not purport to address all of the safety problems associated with its use. This test method involves potentially hazardous materials. The gauge utilizes radioactive materials that may be hazardous to the health of the user unless proper precautions are taken. Users of this gauge must become familiar with the applicable safety procedures and governmental regulations. All operators will be trained in radiation safety prior to operating...
nuclear density gauges. Some agencies require the use of personal monitoring devices such as a thermoluminescent dosimeter or film badge. Effective instructions together with routine safety procedures such as source leak tests, recording and evaluation of personal monitoring device data, etc., are a recommended part of the operation and storage of this gauge.

**Calibration**

Calibrate the nuclear gauge as required by the agency. This calibration may be performed by the agency using manufacturer’s recommended procedures or by other facilities approved by the agency. Verify or re-establish calibration curves, tables, or equivalent coefficients every 12 months.

**Standardization**

1. Turn the gauge on and allow it to stabilize (approximately 10 to 20 minutes) prior to standardization. Leave the power on during the day’s testing.

2. Standardize the nuclear gauge at the construction site at the start of each day’s work and as often as deemed necessary by the operator or agency. Daily variations in standard count shall not exceed the daily variations established by the manufacturer of the gauge. If the daily variations are exceeded after repeating the standardization procedure, the gauge should be repaired and/or recalibrated.

3. Record the standard count for both density and moisture in the Daily Standard Count Log. The exact procedure for standard count is listed in the manufacturer’s Operator’s Manual.

*Note 1:* New standard counts may be necessary more than once a day. See agency requirements.

**Overview**

There are two methods for determining in-place density of soil / soil aggregate mixtures. See agency requirements for method selection.

- Method A Single Direction
- Method B Two Direction

**Procedure**

1. Select a test location(s) randomly and in accordance with agency requirements. Test sites should be relatively smooth and flat and meet the following conditions:
   a. At least 10 m (30 ft) away from other sources of radioactivity
   b. At least 3 m (10 ft) away from large objects
c. The test site should be at least 150 mm (6 in.) away from any vertical projection, unless the gauge is corrected for trench wall effect.

2. Remove all loose and disturbed material, and remove additional material as necessary to expose the top of the material to be tested.

3. Prepare a flat area sufficient in size to accommodate the gauge. Plane the area to a smooth condition so as to obtain maximum contact between the gauge and the material being tested. For Method B, the flat area must be sufficient to permit rotating the gauge 90 or 180 degrees about the source rod.

4. Fill in surface voids beneath the gauge with fines of the material being tested passing the 4.75 mm (No. 4) sieve or finer. Smooth the surface with the guide plate or other suitable tool. The depth of the filler should not exceed approximately 3 mm (1/8 in.).

5. Make a hole perpendicular to the prepared surface using the guide plate and drive pin. The hole shall be at least 50 mm (2 in.) deeper than the desired probe depth, and shall be aligned such that insertion of the probe will not cause the gauge to tilt from the plane of the prepared area. Remove the drive pin by pulling straight up and twisting the extraction tool.

6. Place the gauge on the prepared surface so the source rod can enter the hole without disturbing loose material.

7. Insert the probe in the hole and lower the source rod to the desired test depth using the handle and trigger mechanism.

8. Seat the gauge firmly by partially rotating it back and forth about the source rod. Ensure the gauge is seated flush against the surface by pressing down on the gauge corners, and making sure that the gauge does not rock.

9. Pull gently on the gauge to bring the side of the source rod nearest to the scaler / detector firmly against the side of the hole.

10. Perform one of the following methods, per agency requirements:

   a. Method A Single Direction: Take a test consisting of the average of two, one minute readings, and record both density and moisture data. The two wet density readings should be within 32 kg/m³ (2.0 lb/ft³) of each other. The average of the two wet densities and moisture contents will be used to compute dry density.

   b. Method B Two Direction: Take a one-minute reading and record both density and moisture data. Rotate the gauge 90 or 180 degrees, pivoting it around the source rod. Reseat the gauge by pulling gently on the gauge to bring the side of the source rod nearest to the scaler/detector firmly against the side of the hole.
hole and take a one-minute reading. (In trench locations, rotate the gauge 180 degrees for the second test.) Some agencies require multiple one-minute readings in both directions. Analyze the density and moisture data. A valid test consists of wet density readings in both gauge positions that are within 50 kg/m$^3$ (3.0 lb/ft$^3$). If the tests do not agree within this limit, move to a new location. The average of the wet density and moisture contents will be used to compute dry density.

11. If required by the agency, obtain a representative sample of the material, 4 kg (9 lb) minimum, from directly beneath the gauge full depth of material tested. This sample will be used to verify moisture content and/or identify the correct density standard. Immediately seal the material to prevent loss of moisture.

The material tested by direct transmission can be approximated by a cylinder of soil approximately 300 mm (12 in.) in diameter directly beneath the centerline of the radioactive source and detector. The height of the cylinder will be approximately the depth of measurement. When organic material or large aggregate is removed during this operation, disregard the test information and move to a new test site.

12. To verify the moisture content from the nuclear gauge, determine the moisture content with a representative portion of the material using the FOP for AASHTO T 255/T 265 or other agency approved methods. If the moisture content from the nuclear gauge is within ±1 percent, the nuclear gauge readings can be accepted. Retain the remainder of the sample at its original moisture content for a one-point compaction test under the FOP for AASHTO T 272, or for gradation, if required.

**Note 2:** Example: A gauge reading of 16.8 percent moisture and an oven dry of 17.7 percent are within the ±1 percent requirements. Moisture correlation curves will be developed according to agency guidelines. These curves should be reviewed and possibly redeveloped every 90 days.

13. Determine the dry density by one of the following.

a. From nuclear gauge readings, compute by subtracting the mass (weight) of the water (kg/m$^3$ or lb/ft$^3$) from the wet density (kg/m$^3$ or lb/ft$^3$) or compute using the percent moisture by dividing wet density from the nuclear gauge by 1 + moisture content expressed as a decimal.

b. When verification is required and the nuclear gauge readings cannot be accepted, the moisture content is determined by the FOP for AASHTO T 255/T 265 or other agency approved methods. Compute dry density by dividing wet density from the nuclear gauge by 1 + moisture content expressed as a decimal.

**Percent Compaction**

- Percent compaction is determined by comparing the in-place dry density as determined by this procedure to the appropriate agency density standard. For soil or soil-aggregate mixes, these are moisture-density curves developed using the FOP for AASHTO.
When using maximum dry densities from the FOP for AASHTO T 99/T 180 or FOP for AASHTO T 272, it may be necessary to use the Annex in the FOP for T 99/T 180 to determine corrected maximum dry density and optimum moisture content.

For coarse granular materials, the density standard may be density-gradation curves developed using a vibratory method such as AKDOT&PF’s ATM 212, ITD’s T 74, WSDOT’s TM 606, or WFLHD’s Humphres.

See appropriate agency policies for use of density standards.

**Calculation**

Wet density readings from gauge: 1963 kg/m³ (121.6 lb/ft³)  
1993 kg/m³ (123.4 lb/ft³)  
Avg: 1978 kg/m³ (122.5 lb/ft³)

Moisture readings from gauge: 14.2% and 15.4% = Avg 14.8%

Moisture content from the FOP’s for AASHTO T 255/ T 265: 15.9%

Moisture content is greater than 1 percent different so the gauge moisture cannot be used.

Calculate the dry density as follows:

\[
\rho_d = \left( \frac{\rho_w}{w + 100} \right) \times 100 \quad \text{or} \quad \rho_d = \left( \frac{\rho_w}{\frac{w}{100} + 1} \right)
\]

Where:

\(\rho_d\) = Dry density, kg/m³ (lb/ft³)  
\(\rho_w\) = Wet density, kg/m³ (lb/ft³)  
\(w\) = Moisture content from the FOP’s for AASHTO T 255 / T 265, as a percentage

\[
\rho_d = \left( \frac{1978 \text{ kg/m}^3 \text{ or } 122.5 \text{ lb/ft}^3}{15.9 + 100} \right) \times 100 \quad \rho_d = \left( \frac{1978 \text{ kg/m}^3 \text{ or } 122.5 \text{ lb/ft}^3}{\frac{15.9}{100} + 1} \right)
\]

Corrected for moisture Dry Density: 1707 kg/m³ (105.7 lb/ft³)
Calculate percent compaction as follows:

\[
\% \text{ Compaction} = \frac{\rho_d}{\text{Agency density standard}} \times 100
\]

Example:

\[
\% \text{ Compaction} = \frac{105.7 \text{ lb/ft}^3}{111.3 \text{ lb/ft}^3} \times 100 = 95\%
\]

Where:

\[\rho_d = \text{Dry density, kg/m}^3 (\text{lb/ft}^3)\]

Agency density standard = Corrected maximum dry density from the FOP from T 99/T 180 Annex

Report

- Results on forms approved by the agency
- Sample ID
- Location of test, elevation of surface, and thickness of layer tested.
- Visual description of material tested.
- Make, model and serial number of the nuclear moisture-density gauge.
- Wet density to 0.1 lb/ft³.
- Moisture content as a percent, by mass, of dry soil mass to 0.1 percent.
- Dry density to 0.1 lb/ft³.
- Density standard to 0.1 lb/ft³.
- Percent compaction.
- Name and signature of operator.
## PERFORMANCE EXAM CHECKLIST

**IN-PLACE DENSITY AND MOISTURE CONTENT OF SOIL AND SOIL-AGGREGATE BY NUCLEAR METHODS (SHALLOW DEPTH)**  
**FOP FOR AASHTO T 310**

Participant Name ______________________________ Exam Date ______________

Record the symbols “P” for passing or “F” for failing on each step of the checklist.

<table>
<thead>
<tr>
<th>Procedure Element</th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>1. Gauge turned on 10 to 20 minutes before use?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>2. Calibration verified?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>3. Standard count taken and recorded in accordance with manufacturer’s instructions?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>4. Test location selected appropriately 10 m (30 ft.) from other radioactive sources, 3 m (10 ft.) from large objects, 150 mm (6 in.) away from vertical projections?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>5. Loose, disturbed material removed?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>6. Flat, smooth area prepared?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>7. Surface voids filled with native fines (-No. 4) to 3 mm (1/8 in.) maximum thickness?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>8. Hole driven 50 mm (2 in.) deeper than probe depth?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>9. Gauge placed, probe placed, and source rod lowered without disturbing loose material?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>10. Method A:</td>
<td></td>
<td></td>
</tr>
<tr>
<td>a. Gauge firmly seated, and gently pulled back so that the source rod is against the side of the hole toward the scaler / detectors?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>b. Two, one-minute reading taken; wet density within 32 kg/m$^3$ (2.0 lb/ft$^3$)?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>c. Density and moisture data averaged?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>11. Method B:</td>
<td></td>
<td></td>
</tr>
<tr>
<td>a. Gauge firmly seated, and gently pulled back so that the source rod is against the side of the hole toward the scaler / detectors?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>b. A minimum of a one-minute reading taken; density and moisture data recorded?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>c. Gauge turned 90° or 180° (180° in trench)?</td>
<td>_____</td>
<td>_____</td>
</tr>
</tbody>
</table>

OVER
<table>
<thead>
<tr>
<th>Procedure Element</th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>d. Gauge firmly seated, and gently pulled back so that the source rod is against</td>
<td>______</td>
<td>______</td>
</tr>
<tr>
<td>the side of the hole toward the scaler / detectors?</td>
<td>______</td>
<td>______</td>
</tr>
<tr>
<td>e. A minimum of a one-minute reading taken; density and moisture</td>
<td>______</td>
<td>______</td>
</tr>
<tr>
<td>data recorded?</td>
<td>______</td>
<td>______</td>
</tr>
<tr>
<td>f. Wet densities within 50 kg/m³ (3.0 lb/ft³)?</td>
<td>______</td>
<td>______</td>
</tr>
<tr>
<td>g. Density and moisture data averaged?</td>
<td>______</td>
<td>______</td>
</tr>
<tr>
<td>12. Representative sample (4 kg or 9 lb) obtained from test location?</td>
<td>______</td>
<td>______</td>
</tr>
<tr>
<td>13. Sample sealed immediately to prevent moisture loss?</td>
<td>______</td>
<td>______</td>
</tr>
<tr>
<td>14. Moisture content correctly determined using other means than the nuclear</td>
<td>______</td>
<td>______</td>
</tr>
<tr>
<td>density gauge reading?</td>
<td>______</td>
<td>______</td>
</tr>
<tr>
<td>15. Dry Density calculated using proper moisture content?</td>
<td>______</td>
<td>______</td>
</tr>
<tr>
<td>16. Percent compaction calculated correctly?</td>
<td>______</td>
<td>______</td>
</tr>
</tbody>
</table>

Comments: First attempt: Pass Fail Second attempt: Pass Fail

Examiner Signature _______________________________ WAQTC #: ________________
FOP for AASHTO T 310

In-Place Density and Moisture Content of Soil and Soil-Aggregate by Nuclear Methods (Shallow Depth)

- **Procedure.**

  Add the following to Step 12:

  For each soil or material type, the average moisture content of at least seven (7) consecutive tests is calculated to indicate the density gauge is reading the moisture content within a tolerance of 1% moisture content of the actual AASHTO T 255/265 test results. If the average moisture content exceeds the 1% tolerance, a moisture correction is applied. If less than seven density tests are required for a specific material type, then the percent moisture is determined by performing AASHTO T 255/265.

- **Percent Compaction.**

  Delete the entire section and substitute the following:

  - Percent compaction is determined by comparing the in-place dry density as determined by this procedure to the appropriate density standard. For soil or soil-aggregate mixes, these are moisture-density curves developed using the FOP for AASHTO T 99/ FOP for AASHTO T 180. When using curves developed by the FOP for AASHTO T 99 / FOP for AASHTO T 180, it may be necessary to use the Annex of FOP for AASHTO T 99 / FOP for AASHTO T 180 and FOP for AASHTO T 272 to determine maximum density and moisture determinations.
  - For AASHTO T 99 or AASHTO T 180, a one-point determination per AASHTO T 272 is performed for every compaction test to select the proper individual moisture-density curve or family of curves, including correction for coarse aggregate when necessary.
  - When using an individual moisture density curve density of the one-point determination must match an individual moisture density curve within ±2 pounds/cubic foot for that curve to be used. Also the moisture content must match the individual moisture-density curve between 80-100% of optimum moisture of that curve.
  - A family of curves (AASHTO T 272) may be used only if the curves were developed with material from the same geologic source area with concurrence from the District Materials Engineer.
  - For coarse granular materials, the density standard may be density-gradation curves developed using a vibratory method such as AKDOT&PF’s ATM 212, ITD’s IT 74, WSDOT’s TM 606, or WFLHD’s Humphrys.

Granular Materials and Processed Aggregates above Subgrade

- For IT 74 curve, the standard density is the maximum dry density corresponding to the percent passing the No. 4 sieve. A laboratory density curve is used (produced) that represents the granular material or processed aggregate.
- Obtain a representative sample directly beneath the gauge. The sample size will be determined by the nominal maximum aggregate size from the table in AASHTO T255.
• Determine moisture content in accordance with AASHTO T255.
• Perform a field gradation test using the representative dry sample. Shake the sample over the No. 4 sieve. Hand shaking must continue until not more than 0.5 percent by mass of the total sample passes the sieve during one minute of continuous shaking. No wash is required.
  o When large aggregate is present, use a 1 inch buffer sieve.
  o Do not overload the No. 4 sieve.
• Use the IT 74 laboratory curve to find the maximum dry density at the percent passing No. 4 sieve. Divide the calculated dry density by the maximum dry density to determine the compaction percent.
• A new IT 74 curve must be provided annually for existing stockpiles or for new stockpiles of processed material.
• A field gradation test is not required for each density test if the nuclear density gauge has been calibrated for moisture correction and the gauge reading is equal to or greater than 95% (94.6 rounded) at the peak point of the IT 74 curve.
• A compaction test result over 105% is not considered valid. The material and calculations must be evaluated to resolve the cause of this type of test result.

• Procedure

Add the following:

9.7. Cement Recycled Asphalt Base Stabilization (Crabs)
  A roller pattern curve must be established with single shot (no rotation required) one-minute counts with the uncorrected gauge. The required compaction is achieved and final process rolling is defined as when the final roller pass adds no more than 0.5 lb/ft$^3$ to the previous in-place density.
IN-PLACE DENSITY OF ASPHALT MIXTURES BY NUCLEAR METHOD
FOP FOR AASHTO T 355 (16)

Scope

This test method describes a procedure for determining the density of asphalt mixtures by means of a nuclear gauge using the backscatter method in accordance with AASHTO T 355-16. Correlation with densities determined under the FOP for AASHTO T 166 is required by some agencies.

Apparatus

- Nuclear density gauge with the factory-matched standard reference block.
- Transport case for properly shipping and housing the gauge and tools.
- Instruction manual for the specific make and model of gauge.
- Radioactive materials information and calibration packet containing:
  - Daily standard count log
  - Factory and laboratory calibration data sheet
  - Leak test certificate
  - Shippers’ declaration for dangerous goods
  - Procedure memo for storing, transporting and handling nuclear testing equipment
  - Other radioactive materials documentation as required by local regulatory requirements

Material

- Filler material: Fine-graded sand from the source used to produce the asphalt pavement or other agency approved materials.

Radiation Safety

This method does not purport to address all of the safety problems associated with its use. This test method involves potentially hazardous materials. The gauge utilizes radioactive materials that may be hazardous to the health of the user unless proper precautions are taken. Users of this gauge must become familiar with the applicable safety procedures and governmental regulations. All operators will be trained in radiation safety prior to operating nuclear density gauges. Some agencies require the use of personal monitoring devices such
as a thermoluminescent dosimeter or film badge. Effective instructions, together with routine safety procedures such as source leak tests, recording and evaluation of personal monitoring device data, etc., are a recommended part of the operation and storage of this gauge.

**Calibration**

Calibrate the nuclear gauge as required by the agency. This calibration may be performed by the agency using the manufacturer’s recommended procedures or by other facilities approved by the agency. Verify or re-establish calibration curves, tables, or equivalent coefficients every 12 months.

**Standardization**

1. Turn the gauge on and allow it to stabilize (approximately 10 to 20 minutes) prior to standardization. Leave the power on during the day’s testing.

2. Standardize the nuclear gauge at the construction site at the start of each day’s work and as often as deemed necessary by the operator or agency. Daily variations in standard count shall not exceed the daily variations established by the manufacturer of the gauge. If the daily variations are exceeded after repeating the standardization procedure, the gauge should be repaired, recalibrated, or both.

3. Record the standard count for both density and moisture in the daily standard count log. The exact procedure for standard count is listed in the manufacturer’s Operator’s Manual.

*Note 1:* New standard counts may be necessary more than once a day. See agency requirements.

**Test Site Location**

1. Select a test location(s) randomly and in accordance with agency requirements. Test sites should be relatively smooth and flat and meet the following conditions:

   a. At least 10 m (30 ft.) away from other sources of radioactivity.

   b. At least 3 m (10 ft.) away from large objects.

   c. If the gauge will be closer than 600 mm (24 in.) to any vertical mass, or less than 300 mm (12 in.) from a vertical pavement edge, use the gauge manufacturer’s correction procedure.
Procedure

1. Maintain maximum contact between the base of the gauge and the surface of the material under test. Use filler material to fill surface voids. Spread a small amount of filler material over the test site surface and distribute it evenly. Strike off the surface with a straightedge (such as a lathe or flat-bar steel) to remove excess material.

2. Place the gauge on the test site, perpendicular to the roller passes. Using a crayon (not spray paint), mark the outline or footprint of the gauge. Extend the probe to the backscatter position.

3. Take a one-minute test and record the wet density reading.

4. Rotate the gauge 90 degrees centered over the original footprint. Mark the outline or footprint of the gauge.

5. Take another one-minute test and record the wet density reading.

6. If the difference between the two one-minute tests is greater than 40 kg/m³ (2.5 lb/ft³), retest in both directions. If the difference of the retests is still greater than 40 kg/m³ (2.5 lb/ft³) test at 180 and 270 degrees.

7. The density reported for each test site shall be the average of the two individual one-minute wet density readings.

Footprint of the gauge test site
Calculation of Results

Percent compaction is determined by comparing the in-place wet density as determined by this method to the appropriate agency density standard. See appropriate agency policy for use of density standards.

Example:

Reading #1: 141.5 lb/ft³
Reading #2: 140.1 lb/ft³ Are the two readings within the tolerance? (YES)
Reading average: 140.8 lb/ft³
Core correction : +2.1 lb/ft³
Corrected reading: 142.9 lb/ft³

From the FOP for AASHTO T 209:

\[ G_{mm} = 2.466 \]

**Maximum Laboratory Dry Density** = \[ 2.466 \times 62.245 lb/ft³ = 153.5 lb/ft³ \]

\[ \text{Percent compaction} = \frac{142.9 lb/ft³}{153.5 lb/ft³} \times 100 = 93.1\% \]

Report

- Results on forms approved by the agency
- Test ID
- Location of test and thickness of layer tested
- Mixture type
- Make, model and serial number of the nuclear moisture-density gauge
- Calculated wet density of each measurement and any adjustment data
- Density standard
- Compaction 0.1 percent
- Name and signature of operator
APPENDIX – CORRELATION WITH CORES

(Nonmandatory Information)

The Bulk Specific Gravity ($G_{mb}$) of the core is a physical measurement of the in-place HMA and can be compared with the nuclear density gauge readings. Comparing the core value to the corresponding gauge values, a correlation can be established.

The correlation can then be used to adjust the gauge readings to the in-place density of the cores. The core correlation is gauge specific and must be determined without traffic allowed on the pavement between nuclear density gauge readings and obtaining the core. When using multiple nuclear density gauges each gauge should be correlated to the core locations prior to removal of the core.

When density correlation with the FOP for AASHTO T 166 is required, correlation of the nuclear gauge with pavement cores shall be made on the first day’s paving (within 24 hours) or from a test strip constructed prior to the start of paving. Cores must be taken before traffic is allowed on the pavement.

Correlation with Cores

1. Determine the number of cores required for correlation from the agency’s specifications. Cores shall be located on the first day’s paving or on the test strip. Locate the test sites in accordance with the agency’s specifications. Follow the “Procedure” section above to establish test sites and obtain densities using the nuclear gauge.

2. Obtain a pavement core from each of the test sites according to AASHTO R 67. The core should be taken from the center of the nuclear gauge footprint.

Footprint of the gauge test site. Core location in the center of the footprint.
3. Determine the density of the cores by the FOP for AASHTO T 166, Bulk Specific Gravity of Compacted Asphalt Mixtures Using Saturated Surface Dry Specimens.

4. Calculate a correlation factor for the nuclear gauge reading as follows:

   a. Calculate the difference between the core density and the average nuclear gauge density at each test site to the nearest 1 kg/m³ (0.1 lb/ft³). Calculate the average difference and standard deviation of the differences for the entire data set to the nearest 1 kg/m³ (0.1 lb/ft³).

   b. If the standard deviation of the differences is equal to or less than 40 kg/m³ (2.5 lb/ft³), the correlation factor applied to the average nuclear gauge density shall be the average difference calculated above in 4.a.

   c. If the standard deviation of the differences is greater than 40 kg/m³ (2.5 lb/ft³), the test site with the greatest variation from the average difference shall be eliminated from the data set and the data set properties and correlation factor recalculated following 4.a and 4.b.

   d. If the standard deviation of the modified data set still exceeds the maximum specified in 4.b, additional test sites will be eliminated from the data set and the data set properties and correlation factor recalculated following 4.a and 4.b. If the data set consists of less than five test sites, additional test sites shall be established.

*Note A1:* The exact method used in calculating the nuclear gauge correlation factor shall be defined by agency policy.

*Note A2:* The above correlation procedure must be repeated if there is a new job mix formula. Adjustments to the job mix formula beyond tolerances established in the contract documents will constitute a new job mix formula. A correlation factor established using this procedure is only valid for the particular gauge and at the probe depth used in the correlation procedure. If another gauge is brought onto the project, it shall be correlated using the same procedure. Multiple gauges may be correlated from the same series of cores if done at the same time.

*Note A3:* For the purpose of this procedure, a job mix formula is defined as the percent and grade of paving asphalt used with a specified gradation of aggregate from a designated aggregate source. A new job mix formula may be required whenever compaction of the wearing surface exceeds the agency’s specified maximum density or minimum air voids.
### Core Correlation Example:

<table>
<thead>
<tr>
<th>Core results from T 166:</th>
<th>Average Gauge reading:</th>
<th>Difference:</th>
<th>X</th>
<th>X²</th>
</tr>
</thead>
<tbody>
<tr>
<td>1 144.9 lb/ft³</td>
<td>142.1 lb/ft³</td>
<td>2.8 lb/ft³</td>
<td>-0.7</td>
<td>0.49</td>
</tr>
<tr>
<td>2 142.8 lb/ft³</td>
<td>140.9 lb/ft³</td>
<td>1.9 lb/ft³</td>
<td>0.2</td>
<td>0.04</td>
</tr>
<tr>
<td>3 143.1 lb/ft³</td>
<td>140.7 lb/ft³</td>
<td>2.4 lb/ft³</td>
<td>-0.3</td>
<td>0.09</td>
</tr>
<tr>
<td>4 140.7 lb/ft³</td>
<td>138.9 lb/ft³</td>
<td>1.8 lb/ft³</td>
<td>0.3</td>
<td>0.09</td>
</tr>
<tr>
<td>5 145.1 lb/ft³</td>
<td>143.6 lb/ft³</td>
<td>1.5 lb/ft³</td>
<td>0.6</td>
<td>0.36</td>
</tr>
<tr>
<td>6 144.2 lb/ft³</td>
<td>142.4 lb/ft³</td>
<td>1.8 lb/ft³</td>
<td>0.3</td>
<td>0.09</td>
</tr>
<tr>
<td>7 143.8 lb/ft³</td>
<td>141.3 lb/ft³</td>
<td>2.5 lb/ft³</td>
<td>-0.4</td>
<td>0.16</td>
</tr>
<tr>
<td>8 142.8 lb/ft³</td>
<td>139.8 lb/ft³</td>
<td>3.0 lb/ft³</td>
<td>0.9</td>
<td>0.81</td>
</tr>
<tr>
<td>9 144.8 lb/ft³</td>
<td>143.3 lb/ft³</td>
<td>1.5 lb/ft³</td>
<td>-0.6</td>
<td>0.36</td>
</tr>
<tr>
<td>10 143.0 lb/ft³</td>
<td>141.0 lb/ft³</td>
<td>2.0 lb/ft³</td>
<td>-0.1</td>
<td>0.01</td>
</tr>
</tbody>
</table>

Average Difference: +2.1 lb/ft³

\[ \frac{\sum x^2}{n-1} \]

Where:
\( \sum \) = Sum
\( x \) = Difference from the average Difference
\( n-1 \) = number of data sets minus 1

Example: 10 – 1 = 9

\[ \frac{2.5}{9} = 0.53 \]

X1.1.1. The Sum of \( X^2 = 2.5 \) and the number of data sets = 9 for a computed standard deviation of 0.53. This is within the allowable 2.5 therefore no cores are eliminated, use the average difference from all ten cores.
PERFORMANCE EXAM CHECKLIST

IN-PLACE DENSITY OF ASPHALT MIXTURES BY NUCLEAR METHOD
FOP FOR AASHTO T 355

Participant Name ______________________________ Exam Date ______________

Record the symbols “P” for passing or “F” for failing on each step of the checklist.

<table>
<thead>
<tr>
<th>Procedure Element</th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>1. Gauge turned on approximately 10 to 20 minutes before use?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>2. Gauge calibrated and standard count recorded?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>3. Test location selected appropriately [600 mm (24 in.) from vertical projections or 10 m (30 ft.) from any other radioactive sources]?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>4. Procedure:</td>
<td></td>
<td></td>
</tr>
<tr>
<td>a. Filler spread evenly over test site?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>b. Excess filler material removed by striking off the surface?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>c. Gauge placed on pavement surface and footprint of gauge marked?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>d. Probe extended to backscatter position?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>e. One-minute count taken; gauge rotated 90°, reseated, and another one-minute count taken?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>f. Densities averaged?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>g. If difference of the wet densities is greater than 40 kg/m³ (2.5 lb/ft³), retest conducted in both directions?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>5. Core correlation applied if required?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>6. Percent compaction calculated correctly?</td>
<td>_____</td>
<td>_____</td>
</tr>
</tbody>
</table>

Comments: First attempt: Pass _____ Fail _____ Second attempt: Pass _____ Fail _____

Examiner Signature _______________________________ WAQTC #: ______________

FOP for AASHTO T 355

In-Place Density of Bituminous Mixes Using the Nuclear Moisture-Density Gauge

- **Scope**
  
  Add the following:
  
  Bituminous mixes when no acceptance test strip is required See [Section 270.00](#), Minimum Testing Requirements for [405 Plantmix](#).

- **Report**
  
  Add the following:

  Percent compaction to 0.1%
1. **Scope**

1.1. This method covers field sampling and fabrication and initial curing of 50-mm (2-in) cube specimens of non-shrink grout and/or mortar materials.

1.2. The values stated in either SI or inch-pound units shall be regarded separately as standard. The inch-pound units are shown in brackets. The values stated might not be exact equivalents; therefore, each system must be used independently of the other.

Note 1—Unit weight was the previous terminology used to describe the property determined by this test method, which is mass per unit volume.

1.3. The text of this test method references notes and footnotes that provide explanatory information. These notes and footnotes (excluding those in tables) shall not be considered as requirements of this test method.

1.4. This standard does not purport to address all of the safety problems, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.

**Warning**—Fresh hydraulic cementitious mixtures are caustic and may cause chemical burns to skin and tissue upon prolonged exposure.

2. **Referenced Documents**

2.1. **AASHTO / ASTM**

   - C 1107 Standard Specification for Packaged Dry, Hydraulic-Cement Grout (Non-shrink)
   - T 106 / C 109 Test method for Compressive Strength of Hydraulic Cement Mortars (Using 2-in. or 50-mm Cube Specimens.)

3. **Terminology**

3.1. **Definitions**

3.1.1. Plastic mix – material viscous enough that an indentation will be left in the surface of the grout after tamping.

3.1.2. Fluid mix – material fluid enough that little or no indentation will be left in the surface after puddling.
4. **Apparatus**

4.1. Specimen Molds including cover plate(s): The 2 in. (50 mm) cube specimen molds shall be tight fitting and made of brass or other suitable material. This material shall not be susceptible to attack by the cement mortar. The molds shall have not more than three (3) cube compartments and shall be separable into not more than two (2) parts. The parts of the molds, when assembled, shall be positively held together. The cover plate(s) working surface shall be plane and shall be positively attached to the side walls of the mold. The interior faces of the molds shall conform to the tolerances of table 1.

<table>
<thead>
<tr>
<th>Table 1</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Permissible Variations of Specimen Molds</strong></td>
</tr>
<tr>
<td><strong>Parameter</strong></td>
</tr>
<tr>
<td>Planeness of Sides</td>
</tr>
<tr>
<td>Distance Between Opposite Sides</td>
</tr>
<tr>
<td>Height of Each Compartment</td>
</tr>
<tr>
<td>Angle Between Adjacent FacesA</td>
</tr>
</tbody>
</table>

A Measured at points slightly removed from the intersection. Measured separately for each compartment between all the interior faces and between adjacent faces and between interior faces and top and bottom planes of the mold.

4.2. Tamper: A non-absorptive, non-abrasive, non-brittle material such as a hard rubber compound having a Shore A durometer hardness of 80 ± 10. The tamper shall have a cross section of about 1/2 in. x 1 in. (13 mm x 25 mm) and a length of 5 in. to 6 in. (125 mm to 150 mm). The tamping face shall be flat and at right angles to the length of the tamper.

4.3. Trowel: Steel bladed, (100 to 150 mm (4” to 6”) in length, with straight edges.

4.4. Water tight container: a 6 in. x 12 in. (150 mm x 300 mm) concrete cylinder mold with lid

4.5. Other Equipment: Rubber gloves, scoop, clamps to secure the cover plate, light release oil for oiling the molds, small brush or lint-free cloth for applying and removing excess release oil, burlap or wrapping cloth capable of retaining moisture.

5. **Sampling**

5.1. Samples shall be obtained in accordance with WAQTC TM 2 when the batch equals or exceeds 1 m³ (1 cy). When the batch is less than 1 m³ (1 cy) sample from the batch after discharge. If remixing is required sample after remixing. Begin molding the specimens within an elapsed time of not more than 2 1/2 minutes from completion of the mixing.

Note 2—This test is to be used only for grouts with 100 percent passing the 3/8- in. (9.5-mm) sieve.

5.2. Obtain a representative sample of the mix. Samples shall be a minimum size of 2000 g (4 lb) for each set of three (3) cubes to be fabricated.
6. Procedure

6.1. Assemble both portions of the mold and the bottom cover plate. All joints shall be water tight. If not water tight, seal the surfaces where the halves of the mold join by applying a coating of light cup grease (non water soluble). The amount should be sufficient to extrude slightly when the halves are tightened together. Repeat this process for attaching the mold to the bottom cover plate. Remove any excess grease. Apply a thin coating of release agent to the interior faces of the mold and the bottom cover plate. Wipe the mold faces and base plate as necessary to remove any excess release agent and to achieve a thin, even coating on the interior surfaces. Adequate coating is that which is just sufficient to allow a distinct fingerprint to remain following light finger pressure.

6.2. Place a layer of grout about 25 mm (1") (approximately one-half of the depth of the mold) in all of the cube compartments. Consolidated according to the consistency (plastic or fluid) of the mix.

6.2.1. For plastic mixes, tamp the lift in four rounds of 8 tamps for a total of 32 tamps with the rubber tamper in 10 seconds. See Figure 1 for tamping sequence of each round. Rounds 1 and 3; and 2 and 4 shall be the same.

6.2.2. For fluid mixes, puddle the lift 5 times with a gloved finger. See Figure 2 for tamping sequence.
FIGURE # 2

Puddling sequence

6.3. Place the second lift in each of the cube compartments, slightly over-filling each compartment. Consolidate the material in the same fashion as the first lift with the additional requirement that during consolidation of the second lift any grout forced out onto the top of the mold after each round will be pushed back onto the compartment by means of the tamper and/or gloved fingers before the next consolidation round. When consolidation of the grout is completed, material should extend slightly above the top of the mold. Push any grout forced out onto the top of the mold after the last round back onto the compartment with the trowel.

6.4. Smooth off the cubes by drawing the flat side of the trowel (with the leading edge slightly raised) once across the top of each cube at right angles to the length of the mold. Then, for the purpose of leveling the mortar and making the mortar that protrudes above the top of the mold of more uniform thickness, draw the flat trailing edge of the trowel (with leading edge slightly raised) once lightly along the length of the mold. Cut off the mortar to a plane surface flush with the top of the mold by drawing the straight edge of the trowel (held nearly perpendicular to the mold) with a sawing motion over the length of the mold. The material shall be flush with the top of the mold.

6.5. Immediately secure the top cover plate to the cube mold.

6.6. Place the molds in a secure location away from vibration and as close as possible to the structure for initial curing. Cover with wet burlap, towels, or rags, seal it in a plastic sack in a level location out of direct sunlight, and record the time. These samples shall remain undisturbed and protected from freezing or overheating for a period of 24 ± 4 hours.

6.7. At the end of the initial curing period as required by the agency either.
6.7.1. Place the sealed plastic sack into a water tight container. Transport the cube samples immediately to the location of final curing. During transport, the cube samples shall be protected from jarring, freezing, and moisture loss.

6.7.2. Disassemble the mold and carefully remove the cube samples. Using a permanent marker, identify the cube samples. Handling the cube samples very carefully, wrap them in wet burlap or wet towels and place them into a water tight container. Transport the cube samples immediately to the location of final curing. During transport, the cube samples shall be protected from jarring, freezing, and moisture loss.

6.8. Final curing shall consist of immersing the cube samples in a lime-saturated water storage tank. They are to remain in the storage tank until time of test. (Curing cube samples of material other than hydraulic cement shall be in conformance with the manufacturer’s recommendations.) The storage tank shall be made of non-corroding materials.
<table>
<thead>
<tr>
<th>Description</th>
<th>Quantity</th>
<th>Unit</th>
<th>Cost</th>
</tr>
</thead>
<tbody>
<tr>
<td>Quality Assurance</td>
<td></td>
<td></td>
<td>580.00</td>
</tr>
<tr>
<td>Idaho FOP’s</td>
<td></td>
<td></td>
<td>580.00</td>
</tr>
</tbody>
</table>
UNCOMPACTED VOID CONTENT OF FINE AGGREGATE
FOP FOR AASHTO T 304

Scope
This Idaho Field Operating Procedure (FOP) covers a method for determining the loose uncompactd
void content of a sample of fine aggregate.

Three procedures are included for the measurement of void content:
- Standard Graded Sample (Method A)
- Individual Size Fractions (Method B)
- As-Received Grading (Method C)

For Method A or C, the percent void content is determined directly and the average value of two test
runs is reported.

For Method B, the mean percent void content is calculated using the results from each of the three
individual size fractions.

Significance
Methods A and B provide percent void content determined under standardized conditions which depend
on the particle shape and texture of a fine aggregate. An increase in void content by these procedures
indicates greater angularity, less sphericity, rougher surface texture, or some combination of these three
factors.

Method C measures the uncompacted void content of the minus No. 4 portion of the as-received
material. This void content depends on grading as well as particle shape and texture.

The standard graded sample (Method A) is most useful as a quick test that indicates the particle shape
properties of a graded fine aggregate. Typically, the material used to make up the standard graded
sample can be obtained from the remaining size fractions after performing a single sieve analysis of the
fine aggregate.

Obtaining and testing individual size fractions (Method B) is more time-consuming and requires a
larger initial sample than using the graded sample. However, Method B provides additional information
concerning the shape and texture characteristics of individual size fractions.

Testing samples in the as-received grading (Method C) may be useful in selecting proportions of the
components used in a variety of mixtures. In general, high void content suggests that the material could
be improved by providing additional fine aggregate or more binder may be needed to fill the voids
between particles.

The bulk dry specific gravity of the fine aggregate (G_{at}) is used to calculate the void content. The
effectiveness of these methods of determining void content and its relationship to particle shape and
texture depend on the bulk specific gravity of the various size fractions being equal (or nearly so).

Void content information from Methods A, B, and C may be a useful indicator of properties such as:
- Mixing water demand of hydraulic cement concrete.
- Flowability, pumpability, or workability of grouts and mortars.
- The effect of fine aggregate on stability, strength and VMA in bituminous concrete.
- Stability and strength of base course material.
Apparatus

- **Cylindrical Measure:** A right cylinder of approximately 100 mL capacity having an inside diameter of approximately 1.5 inches and an inside height of approximately 3.4 inches made of drawn copper water tube. The bottom of the measure shall be at least 0.25 inches thick, shall be firmly sealed to the tubing, and shall be provided with the means for aligning the axis of the cylinder with that of the funnel. Determine the volume of the measure to the nearest 0.1 mL.

- **Funnel:** A funnel such that the lateral surface of the right frustum of the cone is sloped 60° from the horizontal with an opening 0.5 inches in diameter. The funnel shall be made of at least 0.02 inches thick, smooth on the inside, and at least 1.5 inches high. It shall have a volume of at least 200 mL, or shall be provided with a supplemental container to provide the required volume.

- **Funnel stand:** A three or four-legged support capable of holding the funnel firmly in position with the axis of the funnel collinear (within 4° angle and a displacement of 0.07 inches) with the axis of the cylinder measure. The funnel opening shall be 4.5 inches above the top of the cylinder.

- **Glass Plate:** A square glass plate approximately 2.3 by 2.3 inches with a minimum 0.15-inch thickness.

- **Pan:** A metal or plastic pan of sufficient size to contain the funnel stand and prevent loss of material.

- **Spatula:** A metal spatula with a blade approximately 4 inches long and at least 0.75 inches wide, with straight edges. The end shall be cut at a right angle to the edges.

- **Balance:** A balance with a capacity of 1000 g and sensitive to 0.1 g.

Sample

The samples used for this test shall be obtained using AASHTO T 2 and AASHTO T 248, or from sieve analysis samples used for AASHTO T 27, or from an extracted bituminous concrete sample.

For Methods A and B, the sample is washed over a No. 100 or No. 200 sieve in accordance with AASHTO T 11 and then dried and sieved into separate size fractions according to AASHTO T 27. Maintain the necessary size fractions obtained from one or more sieve analyses in a dry condition in separate containers for each size.

For Method C, dry a split of the as-received sample in accordance with the drying provisions of AASHTO T 27.
Sample Preparation

Method A – Standard Graded Sample
Weigh out and combine the following quantities of fine aggregate that has been dried and sieved in accordance with AASHTO T 27.

<table>
<thead>
<tr>
<th>Individual Size Fraction</th>
<th>Mass, g</th>
</tr>
</thead>
<tbody>
<tr>
<td>Passing No. 8 to Retained on No. 16</td>
<td>44 ±0.2</td>
</tr>
<tr>
<td>Passing No. 16 to Retained on No. 30</td>
<td>57 ±0.2</td>
</tr>
<tr>
<td>Passing No. 30 to Retained on No. 50</td>
<td>72 ±0.2</td>
</tr>
<tr>
<td>Passing No. 50 to Retained on No. 100</td>
<td>17 ±0.2</td>
</tr>
</tbody>
</table>

Method B – Individual Size Fractions
Prepare a separate 190 g sample of fine aggregate, dried and sieved in accordance with AASHTO T 27 for each of the following size fractions:

<table>
<thead>
<tr>
<th>Individual Size Fraction</th>
<th>Mass, g</th>
</tr>
</thead>
<tbody>
<tr>
<td>Passing No. 8 to Retained on No. 16</td>
<td>190 ±1</td>
</tr>
<tr>
<td>Passing No. 16 to Retained on No. 30</td>
<td>190 ±1</td>
</tr>
<tr>
<td>Passing No. 30 to Retained on No. 50</td>
<td>190 ±1</td>
</tr>
</tbody>
</table>

Do not mix fractions together. Each size is tested separately.

Method C – As-received Grading
Pass the sample (dried in accordance with AASHTO T 27) through a No. 4 sieve. Obtain a 190 ±1 g sample of this material for the test.

Specific Gravity of Fine Aggregate
If the bulk specific gravity (G_{sb}) of the fine aggregate sample is unknown, determine it according to Idaho IT-144.

Procedure
1. Record all masses to the nearest 0.1 g.
2. Record the mass of the empty measure.
3. Mix each test sample with the spatula until it appears to be homogeneous.
4. Position the jar and funnel section in the stand and center the cylindrical measure with the axis of the funnel. Use a finger to block the opening of the funnel.
5. Pour the test sample into the funnel. Level the material in the funnel with the spatula.
6. Remove the finger and allow the sample to freely flow into the cylindrical measure.
7. After the funnel empties, strike off excess from the top of the cylindrical measure by a single pass of the spatula with the width of the blade vertical, using the straight part of its edge in light contact.
with the top of the measure. Until this operation is complete, avoid vibration or disturbance that could cause compaction of the fine aggregate in the measure (see note).

8. Brush adhering grains from the outside of the cylindrical measure. Determine the mass of the measure and its contents to the nearest 0.1 g.

9. Recombine the sample from the retaining pan and cylindrical measure, repeat the procedure, and average the results of the two test runs.

**Calculation**

Calculate the uncompacted voids for each determination according to the following formula:

$$U = \left( \frac{F}{G} \right) \times 100$$

where:
- $U$ = uncompacted voids, percent, in the material;
- $V$ = volume of cylindrical measure, mL;
- $F$ = net mass of fine aggregate in measure, g; and,
- $G$ = bulk specific gravity ($G_{sb}$) of aggregate

For Methods A and C: **Calculate the average uncompacted voids for the two determinations.**

For Method B: First determine the uncompacted void content for each of the individual size fractions; then calculate the mean uncompacted void content as follows:

$$U_m = \frac{U_1 + U_2 + U_3}{3}$$

where:
- $U_m$ = Mean uncompacted void content, %
- $U_1$, $U_2$, $U_3$ = Uncompacted void content of individual size fractions
Calculation Examples

\[ U = \frac{99.8 - \left( \frac{146.2}{2.636} \right)}{99.98} \times 100 = 44.43, \text{ say } 44.4\% \]

where:
\( U \) = Uncompacted void content, %; 
\( V \) = 99.8 mL 
\( F \) = 146.2 g. 
\( G \) = 2.636

\[ U_m = \frac{48.7 + 49.9 + 47.0}{3} = 48.53, \text{ say } 48.5\% \]

where:
\( U_m \) = Mean uncompacted void content, % 
\( U_1 \) = 48.7% 
\( U_2 \) = 49.9% 
\( U_3 \) = 47.0%

Report
Results shall be reported on Form ITD-1046 to the nearest 0.1 percent.
<table>
<thead>
<tr>
<th>Quality Assurance</th>
<th>Idaho FOPs</th>
<th>580.00</th>
</tr>
</thead>
</table>

AASHTO T304
PERFORMANCE EXAM CHECKLIST

Uncompacted Void Content of Fine Aggregate for AASHTO T 304

Participant Name: __________________________ Exam Date: _______________________

Record the symbols “P” for passing or “F” for failing on each step of the checklist.

Procedure Element (all test methods are AASHTO unless otherwise shown)

Sampling

1. Sample obtained by one of the following:
   (a) T 2 & T 248 (sampling, splitting and quartering)? ______ ______
   or (b) From sieve analysis samples used for T 27? ______ ______
   or (c) From aggregate extracted from a bituminous concrete specimen (T 308)? ______ ______

2. Methods A
   (a) Sample washed over No. 100 or No. 200 sieve in accordance with T 11? ______ ______
   (b) Sample dried and sieved into separate size fractions in accordance with T 27? ______ ______
   (c) Necessary size fractions obtained from sieve analysis maintained in a dry condition in separate containers for each size? ______ ______

Sample Preparation

   Method A- Standard Graded Sample

1. Following quantities of aggregate that has been dried and sieved in accordance with T 27 weighed out and combined? ______ ______

<table>
<thead>
<tr>
<th>Individual Size Fractions</th>
<th>Mass, g</th>
<th>OK?</th>
</tr>
</thead>
<tbody>
<tr>
<td>No. 8 to No. 16</td>
<td>44 ± 0.2</td>
<td></td>
</tr>
<tr>
<td>No. 16 to No. 30</td>
<td>57 ± 0.2</td>
<td></td>
</tr>
<tr>
<td>No. 30 to No. 50</td>
<td>72 ± 0.2</td>
<td></td>
</tr>
<tr>
<td>No. 50 to No. 100</td>
<td>17 ± 0.2</td>
<td></td>
</tr>
<tr>
<td><strong>Total:</strong></td>
<td>190 ± 0.2</td>
<td></td>
</tr>
</tbody>
</table>

Specific Gravity of Fine Aggregate

If bulk dry specific gravity of aggregate from the source is unknown, specific gravity determined on material passing No. 4 sieve in accordance with IT 144. ______ ______

Procedure

1. Each test sample mixed with spatula until it appears to be homogeneous? ______ ______
2. Funnel stand apparatus with cylindrical measure, positioned in retaining pan? ______ ______
3. Finger used to block opening of funnel? ______ ______
4. Test sample poured into funnel? ______ ______
5. Material in funnel leveled with spatula?

6. After funnel empties, excess heaped aggregate struck off from cylindrical measure by single pass of spatula, with blade width vertical and using straight part of its edge in light contact with top of measure?

7. Care exercised to avoid vibration or any disturbance that could cause compaction of aggregate into cylindrical measure?

   Note: After strike-off, measure may be tapped lightly to compact sample to make it easier to transfer container to scale or balance without spilling any of the sample.

8. Adhering grains brushed from outside of container?

9. Mass of cylindrical measure and contents determined to nearest 0.1 g?

10. All aggregate particles retained for second test run?

11. Sample from retaining pan and cylindrical measure recombined and procedure repeated?

12. Mass of empty measure recorded?

13. Calculations performed properly?

**Formula for Calculation of Uncompacted Voids, percent**

\[
U = \frac{V - \left( \frac{F}{G} \right)}{V} \times 100
\]

where:
- \( U \) = uncompacted voids, percent;
- \( V \) = volume of cylindrical measure to nearest 0.1 mL;
- \( F \) = net mass, g, of fine aggregate in measure; and,
- \( G \) = bulk dry specific gravity of fine aggregate (\( G_{sb} \))

Comments: 

First attempt: Pass [ ] Fail [ ]

Second attempt: Pass [ ] Fail [ ]

Signature of Examiner ________________________________.
Density of In-Place Hot Mix Asphalt (HMA) Pavement by Electronic Surface Contact Devices
FOP for AASHTO T 343

Scope

This procedure covers the in-place density determination of Hot Mix Asphalt (HMA) in accordance with AASHTO T343 using an electronic surface contact device / gauge. This field operating procedure is derived from AASHTO T343. The gauge measures density and relative compaction of HMA pavements by measuring changes in the electromagnetic field resulting from the compaction process.

Apparatus

- electronic surface contact gauge shall meet the following requirements:
  - be housed in an enclosure of heavy-duty construction.
  - function in the temperature and moisture levels experienced during the placement of HMA pavements.
  - include the internal circuitry suitable for displaying individual measurements.
  - include a continuous measurement mode of operation.
  - provide power to the sensor which allows data acquisition, readout function, and calibration.

Calibration

Calibration of the gauge shall be performed as specified in the Idaho Transportation Departments Laboratory Operations Manual section 200.

Standardization

Standardize the gauge daily per the manufacturers instructions. Note: gauges are paired to the standardization (reference) blocks. Using only the standardization block paired with the gauge.

PQI 301. Establish initial reference reading with the standardization block after calibration. Calculate and record upper and lower limits. Record date. Record and compare daily readings to upper and lower limits. Remove gauge from service if values are not within limits.

PQI 380. Record date. Record results (pass/fail). Remove failing gauge from service.
Pavetracker. Record date. Remove gauge from service if it displays an error message.

**Correlation with Cores**

Correlate the gauge for each Job Mix Formula (JMF) and each pavement lift. These correlation measurements / readings should be taken at the same temperature range as the acceptance tests.

1. Determine the number of cores required for correlation. Cores shall be located on the first day’s paving or on the test strip. For projects with test strips locate the test sites in accordance with the IT125. Test sites shall be determined using random sampling practices.

2. Clear any existing correlations from the gauge.

3. Place the gauge on the HMA mat at the test sites and draw an outline around the base of the gauge. The mat shall have no noticeable moisture visible. The mat shall be flat, relatively smooth and clear of any loose particles.
4. Perform and record five (5) measurements as shown in diagram #1. Determine and record the average test site measurement / reading.

5. Obtain a 6” core from of each test site in accordance with AASHTO R 67. The core should be taken from approximately the center of the footprint.

5. Determine the density of the cores by the FOP for AASHTO T 166, Bulk Specific Gravity of Compacted Bituminous Mixtures Using Saturated Surface Dry Specimens.

6. Calculate a correlation factor for the gauge reading as follows:
   a. Calculate the difference between the core density and the average gauge density at each test site to the nearest 0.1 lb/ft³. Calculate the average difference and standard deviation of the differences for the entire data set to the nearest 0.1 lb/ft³.
   b. If the standard deviation of the differences is equal to or less than 2.5 lb/ft³, the correlation factor applied to the gauge reading shall be the average difference calculated above in 6.a.
   c. If the standard deviation of the differences is greater than 2.5 lb/ft³, the test site with the greatest variation from the average difference shall be eliminated from the data set and the data set properties and correlation factor recalculated following 6.a and 6.b.
   d. If the standard deviation of the modified data set still exceeds the maximum specified in 5.b, additional test sites will be eliminated from the data set and the data set properties and correlation factor recalculated following 6.a and 6.b. If the data set consists of less than five (5) test sites, additional test sites shall be established.

Core Correlation Example:
7. Adjust the gauge, following the manufacturer’s procedures, to account for the average difference. This will calibrate the instrument to the HMA mat by adding (or subtracting) the average difference.

**Procedure**

1. Select a test location(s) randomly and in accordance with ITD requirements. Ensure that the device is correlated in accordance with “Correlation with Cores Section”. Locate the measurement area away from any known sources of electromagnetic interference such as overhead high-tension power lines or large metal objects. For best results avoid surfaces with large temperature extremes.

2. Brush the surface clear to remove any loose particles. The mat shall have no noticeable moisture visible. It shall be flat, relatively smooth and clear of any loose particles.

3. Place the gauge firmly on the test surface and trace an outline around the probe (base) of the unit.

4. Perform and record five (5) measurements as shown in diagram #1. Determine and record the average test site measurement / reading.

**Calculation**

Density measurements / readings from gauge: 142.9 lb/ft$^3$, 141.9 lb/ft$^3$, 142.6 lb/ft$^3$, 141.6 lb/ft$^3$, & 143.1 lb/ft$^3$

Avg. density: 142.4 lb/ft$^3$
Core Correction: +2.1 lb/ft$^3$
Avg. corrected Density: 144.5 lb/ft$^3$
Percent Compaction

Percent compaction is determined by comparing the average corrected test site density as determined by this procedure to the maximum density from AASHTO T 209.

\[ G_{mm} \] and maximum density from the FOP for AASHTO T 209: \( G_{mm} = 2.466 = 153.5 \text{ lb/ft}^3 \)

\[
\frac{\text{Corrected Reading}}{\text{Maximum Density}} \times 100 = \% \text{ compaction}
\]

\[
\frac{144.5}{153.5} \times 100 = 94.1\%
\]

Report

Results shall be reported on standard forms approved by ITD. Include the following information:

- Location of test and thickness of layer tested.
- Visual description of material tested.
- Make, model and serial number of the density gauge.
- Density readings to 0.1 lb/ft\(^3\).
- Average Density readings to 0.1 lb/ft\(^3\).
- Core Correction to 0.1 lb/ft\(^3\).
- Maximum density to 0.1 lb/ft\(^3\).
- Percent compaction to 0.1%.
- Name and signature and STQP / WAQTC qualification number of the tester.
<table>
<thead>
<tr>
<th>Description</th>
<th>Details</th>
<th>Amount</th>
</tr>
</thead>
<tbody>
<tr>
<td>Quality Assurance</td>
<td>IDAHO FOP’s</td>
<td>580.00</td>
</tr>
</tbody>
</table>
PERFORMANCE EXAM CHECKLIST

Density of In-Place Hot Mix Asphalt (HMA) Pavement by Electronic Surface Contact Devices
FOP for AASHTO T 343

Participant Name ______________________________    Exam Date ______________

Record the symbols “P” for passing or “F” for failing on each step of the checklist.

<table>
<thead>
<tr>
<th>Procedure Element</th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>1. Gauge turned on?</td>
<td>______</td>
<td>______</td>
</tr>
<tr>
<td>2. Gauge calibrated using data from cores?</td>
<td>______</td>
<td>______</td>
</tr>
<tr>
<td>3. Test location selected away from any known sources of electromagnetic interference such as overhead high-tension power lines or large metal objects?</td>
<td>______</td>
<td>______</td>
</tr>
<tr>
<td>4. The HMA surface is free of moisture, relatively flat, and smooth?</td>
<td>______</td>
<td>______</td>
</tr>
<tr>
<td>5. Surface brushed clear of loose particles?</td>
<td>______</td>
<td>______</td>
</tr>
<tr>
<td>6. Gauge placed firmly on HMA surface?</td>
<td>______</td>
<td>______</td>
</tr>
<tr>
<td>7. Outline traced around base?</td>
<td>______</td>
<td>______</td>
</tr>
<tr>
<td>8. Five (5) measurements taken per diagram # 1 and recorded?</td>
<td>______</td>
<td>______</td>
</tr>
<tr>
<td>9. Average density calculated?</td>
<td>______</td>
<td>______</td>
</tr>
<tr>
<td>10. Compaction calculated to 0.1%?</td>
<td>______</td>
<td>______</td>
</tr>
</tbody>
</table>

Comments: _______________________________________________________________________

First attempt: Pass [ ] Fail [ ] Second attempt: Pass [ ] Fail [ ]

Examiner Signature _______________________________ WAQTC #:_____________________

Examiner Signature _______________________________ WAQTC #:_____________________
| Quality Assurance | IDAHO FOP’s     | 580.00      |
Pavement Thickness by Magnetic Pulse Induction
FOP FOR AASHTO T 359

1. **Scope**

1.1. This procedure covers the determination of the pavement thickness by using magnetic pulse induction in accordance with AASHTO T359. This field operating procedure is derived from AASHTO T359. This procedure is intended for use with plain jointed concrete pavements, asphalt pavements, bases with binders and unbound aggregate layers. It is not applicable for continuously reinforced, mesh reinforced or fiber reinforced pavement where the reinforcement would interfere with the magnetic field.

1.2. The values stated in SI units are to be regarded as the standard.

1.3. *This standard does not purport to address all of the safety problems, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

2. **Referenced Documents**

2.1. AASHTO
   - T 359 Pavement Thickness by Magnetic Pulse Induction

3. **Interferences**

3.1. This test method can produce misleading results when metal is nearby. Steel-toe shoes can also affect the results if the operator steps too close to the gauge head during the measurement process.

4. **Apparatus**

4.1. An electromagnetic pulse induction device that generates a variant magnetic field that creates an eddy current in a reflector capable of measuring pavement thickness.

4.2. A metal reflector that can be detected by the sensors of the pulse induction device. The type of metal and size of the reflector depends on the type and thickness of the pavement that is being measured. For deeper sections larger reflectors are needed since they create larger magnetic fields. For pavements between 6 and 14 inches thick use 12 inch diameter reflectors. For pavements less than 6 inches thick use 6 inch diameter reflector. Use the manufacturer’s reflectors or 24 gauge sheet metal meeting ASTM A653, CS Type B, G90.

   *Note 1* – The metal reflectors should conform to the manufacturer’s specifications.

5. **Procedure**

5.1. Place targets at required locations prior to paving. It is usually necessary to fasten the reflectors to the base or subbase to prevent movement during the paving operation. Place the reflector at least 3 feet from any steel or dowel bars. Record the approximate location reference for ease of locating after paving.
Note 2 – Fasten reflectors with nails. Bright common, galvanized, and coated nails as well as masonry nails up to 3-1/2 inch have worked well. Use of more than three nails per the reflector could affect the accuracy of the readings and therefore is not recommended.

5.2. Thickness measurements are normally made within 2 feet of each edge and across the driving lane. When adjacent lanes are placed simultaneously, plates across the width of the pavement will represent both lanes. When pavements include shoulders, measurements may be made in the shoulder area within 3 feet of the lane line, unless special circumstances dictate otherwise.

5.3. Place a minimum of twice the number of reflectors required for each 0.1 mile section. Reflectors are to be placed at random locations within the section. The minimum number of measurements per 0.1 mile is as follows:

<table>
<thead>
<tr>
<th>Placement Type</th>
<th>Minimum No. of Measurements</th>
</tr>
</thead>
<tbody>
<tr>
<td>1 lane no, no shoulders</td>
<td>3</td>
</tr>
<tr>
<td>1 lane, 1 shoulder</td>
<td>3</td>
</tr>
<tr>
<td>2 lanes, no shoulder</td>
<td>5</td>
</tr>
<tr>
<td>2 lanes, 2 shoulders</td>
<td>5</td>
</tr>
</tbody>
</table>

5.4. In cases where a tapered or an unusual pavement width is being placed, engineering judgment shall be used to determine where thickness measurements are made.

5.5. Once the pavement is sufficiently cured to support foot traffic, use the gauge search mode to locate the reflector center. This is done by holding the gauge head 2 to 3 inches above the pavement and moving it side to side and forward and backward. When the gauge search function is showing the strongest signal, mark directly above the reflector on the pavement.

5.6. Remove all debris from the surface where the gauge wheels will pass.

5.7. With the gauge switched to the measurement mode, place the front wheel approximately 1-1/2 feet before the mark. Press the measurement button and then slowly push the gauge over the reflector. After the gauge has traveled approximately 6 feet, the gauge processor will calculate the thickness of the pavement above the reflector.

5.8. Repeat the above step 2 more times and record the results. No single result at a single location should be more than 0.125 inch different than the other 2 readings. If an individual reading exceeds 0.125 inches, repeat the three readings. If an individual reading is more than 0.125 different with the second set of readings, record the thickness at that location could not be determined and move to another reflector.

5.9. Repeat the above to obtain the required number of measurements.

6. Calculation and Interpretation of Results

6.1. Average the 3 readings for a location and record the average to the nearest 0.05 inch.

6.2. Average the readings for a section and record the average to the nearest 0.1 inch.

7. Report

7.1. Report the metal target type used, date, test locations, all thickness measurements and averages.
FLAT AND ELONGATED PARTICLES IN COARSE AGGREGATE
FOP FOR ASTM D 4791

Scope

This FOP covers the determination of the percentage, by mass, of flat and elongated particles in coarse aggregates for comparison with specification limits.

This FOP can be performed in conjunction with AASHTO T 27/T 11.

Flat and elongated particles of aggregates, for some construction applications, may interfere with consolidation and result in harsh, difficult to place materials and a potentially unstable mixture.

Apparatus

- Balance or scale: Capacity sufficient for the principal sample mass, accurate to 0.1 percent of the sample mass or readable to 0.1 g. Meets the requirements of AASHTO M 231.
- Sieves, meeting requirements of AASHTO M 92.
- Proportional Caliper Device, meeting the requirements of ASTM D 4791. The device typically consists of a base plate with two fixed posts and a swinging arm mounted between them so that the openings between the arm and the posts maintain a constant ratio. The numbers on the arm represent the ratios for which the apparatus can be set. For example, the number 5 represents the 5:1 ratio.

Terminology

Flat and elongated particles are defined as those coarse aggregate particles that have a ratio of length to thickness equal to or greater than a specified value such as 5:1.

Sample and Sample Preparation

1. Sample the aggregate in accordance with the FOP for AASHTO T 2.
2. Mix the sample and reduce to sample size in accordance with the FOP for AASHTO T 248. See Table 1 for minimum required sample mass.

Table 1 Sample Size

<table>
<thead>
<tr>
<th>Nominal Maximum Size</th>
<th>Sample Mass, min.</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>kg</td>
</tr>
<tr>
<td>3/8”</td>
<td>1</td>
</tr>
<tr>
<td>1/2”</td>
<td>2</td>
</tr>
<tr>
<td>3/4”</td>
<td>5</td>
</tr>
<tr>
<td>1”</td>
<td>10</td>
</tr>
<tr>
<td>1½”</td>
<td>15</td>
</tr>
</tbody>
</table>
3. Dry the sample to constant mass.
4. Sieve the aggregate according to the FOP for AASHTO T 27/11.
5. If an individual sieve size fraction is not represented by at least 10% of the +No. 4 aggregate material, combine that sieve size fraction with the next smaller fraction for all sieves except the 3/8” sieve. If the 3/8” sieve is not represented by at least 10% of the +No. 4, combine the 3/8” sieve material with the next larger sieve size material.
6. Reduce each individual sieve size fraction through and including the 3/8” sieve to approximately 100 particles per T-248 (Reduction to an exact amount is not permitted).

**Procedure**

From Step 6, perform the following for each sieve size fraction:

1. Determine the total dry mass of each fraction to the nearest 0.1 g. This mass is designated as T in the calculation.
2. Set the proportional caliper device to the ratio required in the contract specifications: (2:1, 3:1, or 5:1).
3. Expedite testing through preliminary visual separation of all material which obviously is not flat and elongated.
4. Test each questionable particle by setting the larger opening of the proportional caliper device equal to the maximum dimension of the particle’s length. Determine the dimension which represents the particle thickness (the smallest dimension). Pull the particle horizontally through the smaller opening without rotating, maintaining contact of the particle with the fixed post at all times. If the entire particle thickness can be pulled through the smaller opening, the particle is flat and elongated. Develop two categories of aggregate for each size fraction, flat and elongated and not flat and elongated.
5. Determine the dry mass of the flat and elongated particles in each size fraction to the nearest 0.1 g. This mass is designated as F in the calculation.

**Calculations**

1. Calculate the percentage of flat and elongated particles in each size fraction to the nearest 0.1% according to the equation shown below.

\[ P_i = \frac{F}{T} \times 100 \]

where:

\[ P_i = \text{percent flat & elongated of individual size fraction} \]
\[ F = \text{mass of flat and elongated particles in fraction} \]
\[ T = \text{total mass of particles in fraction} \]
Example –

- **Individual Percent Flat & Elongated for 3/4” Sieve Size Fraction:**

\[
P = \frac{196.4}{1178.0} \times 100 = 16.7, \text{ report 17%}
\]

**Sample Report**

<table>
<thead>
<tr>
<th>Sieve Size</th>
<th>Total Mass in Size Fraction (Mass)</th>
<th>Mass of Flat &amp; Elongated Particles (Mass)</th>
<th>Flat &amp; Elongated (Percent) *</th>
</tr>
</thead>
<tbody>
<tr>
<td>1”</td>
<td>1640.9</td>
<td>589.2</td>
<td>36</td>
</tr>
<tr>
<td>3/4”</td>
<td>1178.0</td>
<td>196.4</td>
<td>17</td>
</tr>
<tr>
<td>1/2”</td>
<td>825.7</td>
<td>70.1</td>
<td>8</td>
</tr>
<tr>
<td>3/8”</td>
<td>277.0</td>
<td>23.3</td>
<td>8</td>
</tr>
</tbody>
</table>

* Report to the nearest 1 percent.
Quality Assurance  Idaho FOPs  580.00
PERFORMANCE EXAM CHECKLIST

Flat Particles, Elongated Particles, or Flat and Elongated Particles in Coarse Aggregate Fop for ASTM D 4791

Participant Name: ___________________________ Exam Date: ______________________

Record the symbols “P” for passing or “F” for failing on each step of the checklist.

<table>
<thead>
<tr>
<th>Procedure Element</th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Sample Preparation</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>1. Sample obtained, mixed and reduced in accordance with AASHTO T 2 and AASHTO T 248 to approximately the amount required for testing?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>2. Minimum dry sample mass meets requirements?</td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>Procedure</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>1. If determination by mass, sample oven-dried to constant mass at 230 ±9° F? <strong>Note:</strong> If determination is by particle count drying is not necessary.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>2. Sample sieved according to AASHTO T 27?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>3. Each size fraction larger than No. 4 sieve present in amount of 10% or more of original sample reduced according to T 248 until approximately 100 particles obtained?</td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>Flat and Elongated Particle Test:</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>4. Each particle in each size fraction tested and placed into one of two groups: (1) flat and elongated or (2) not flat and elongated?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>5. Proportional caliper device positioned at proper ratio?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>6. Larger opening set equal to particle length?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>7. Particle is flat and elongated if the thickness can be placed in the smaller opening?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>8. Proportion of sample in each group determined by count or by mass, as required?</td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>Calculation</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>1. Percentage of flat and elongated particles calculated to nearest 1% for each sieve size greater than No. 4?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>2. When weighted average for sample is required, sieve sizes not tested (those representing less than 10% of sample) assumed to have same percentage of flat particles, elongated particles, or flat and elongated particles as the next smaller or the next larger size? Or if both are present, is average for next smaller and larger sizes used?</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

Comments and Score:  First Attempt: Pass ☐ Fail ☐ Second Attempt: Pass ☐ Fail ☐

Signature of Examiner: ____________________________________________
| Quality Assurance | Idaho FOPs   | 580.00 |
PERFORMANCE EXAM CHECK LIST
SAMPLING & FABRICATION OF 2” (50 – MM) CUBE SPECIMENS USING GROUT (NON-SHRINK) MORTAR
AASHTO R 64

Participant Name: ___________________________ Exam Date: ________________

Record the symbols “P” for passing or “F” for failing on each step of the checklist:

<table>
<thead>
<tr>
<th>Procedure</th>
<th>Elements</th>
<th>Trial#1</th>
<th>Trial#2</th>
</tr>
</thead>
<tbody>
<tr>
<td>1.</td>
<td>Obtain Sample. Use AASHTO R 60 for 1 yd³ or more or for less than 1 yd³ sample from discharge after remixing takes place.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>2.</td>
<td>Inspect and adjust test apparatus. Apparatus includes mold assembly, tamper, trowel, watertight container.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>3.</td>
<td>Mold portion attached to bottom plate and joints are water tight. Use of a light coating of non water-soluble grease is allowed.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>4.</td>
<td>Place a 1”(approximately 1/2 the depth of the mold) layer of Grout or non-shrink mortar into the mold. Grout or mortar shall be placed in all compartments.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>5.</td>
<td>Consolidate the mix. The mix shall be consolidated depending on the consistency, either plastic or fluid.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>6.</td>
<td>Plastic mixes: tamp lift in 4 rounds, 8 tamps per round, for a total of 32 tamps in 10 seconds with rubber tamper. Rounds 1 and 3 and 2 and 4 shall be the same.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>7.</td>
<td>Fluid Mixes: puddle the lift 5 times with gloved finger.</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

Rounds 1 and 3

Rounds 2 and 4

OVER
8. **Place the second lift into all of the mold compartments and consolidate:** Slightly overfill. Consolidate in same fashion as first lift. After consolidation material should extend slightly above the top of the mold. Push any grout forced out onto the top of the mold back onto the compartment with a trowel.

8. **Strike off the surface.** Using the trowel draw the flat side with the leading edge slightly raised once across the top of each cube at right angles to the length of the mold. Then draw the flat trailing edge of the trowel, with leading edge slightly raised,) once lightly along the length of the mold. Cut off the mortar to a plane surface flush with the top of the mold by drawing the straight edge of the trowel (held nearly perpendicular to the mold) with a sawing motion over the length of the mold. The material shall be flush with the top of the mold.

9. **Immediately secure the top plate to the molds.**

10. **Molds properly stored:** Cover with wet burlap, towels, or rags, seal it in a plastic sack in a level location out of direct sunlight, and record the time. These samples shall remain undisturbed and protected from freezing or overheating for a period of 24 ± 4 hours.

**COMMENTS:** First Attempt : Pass [ ] Fail [ ] Second Attempt: Pass [ ] Fail [ ]

Examiner Signature: ___________________________ Sampler / Tester Qualification #

Examiner Signature: ___________________________ Sampler / Tester Qualification #
PERFORMANCE EXAM CHECKLIST

SAMPLING ASPHALT MIXTURES AFTER COMPACTION
(OBTAINING CORES)  FOP for AASHTO R 67

Participant Name ________________________________________ Exam Date ______________

Record the symbols “P” for passing or “F” for failing on each step of the checklist.

<table>
<thead>
<tr>
<th>Procedure Element</th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>1. Core location determined by agency?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>2. Asphalt mixture sufficiently cool or cooled with water, ice dry ice or liquid nitrogen?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>3. Core machine correctly positioned over location?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>4. Water or air used to remove cuttings and minimize friction?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>5. Constant pressure applied to bit while keeping it perpendicular to HMA surface?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>6. Coring stopped a desired depth?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>7. Retrieval device used to obtain object?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>8. Core labeled?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>9. Core placed for transport in a manner that prevents damage from jarring, rolling, impact with any object, or extreme temperatures?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>10. Thickness determined to 1/8 in., 0.01 ft., or 3 mm?</td>
<td>_____</td>
<td>_____</td>
</tr>
</tbody>
</table>

Comments: First attempt: Pass_____ Fail_____ Second attempt: Pass_____ Fail_____

Examiner Signature _______________________________ WAQTC #: ______________
PERFORMANCE EXAM CHECK LIST

BULK DENSITY (UNIT WEIGHT) AND VOIDS IN AGGREGATE
AASHTO T 19

Participant Name: __________________________ Exam Date: ____________

Record the symbols “P” for passing or “F” for failing on each step of the checklist:

<table>
<thead>
<tr>
<th>Procedure</th>
<th>Elements</th>
<th>Trial#1</th>
<th>Trial#2</th>
</tr>
</thead>
<tbody>
<tr>
<td>1.</td>
<td>Obtain Sample. Use the FOP for AASHTO T 2.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>2.</td>
<td>Aggregate dried to constant mass per the FOP for AASHTO T 255.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>3.</td>
<td>Reduce Sample to required size. Use the FOP for AASHTO T 248. Sample shall be 125% to 200% of the quantity needed to fill the measure.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>4.</td>
<td>Inspect measure and other apparatus. Measure must be calibrated within the last 12 months, balance conforms to M 231, scoop/ shovel, &amp; tamping rod in good working order.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>5.</td>
<td>Rodding aggregate NMS 1 1/2” (37.5 mm) or less</td>
<td></td>
<td></td>
</tr>
<tr>
<td>a.</td>
<td>Measure filled 1/3 full, leveled by hand, and rodded 25 times evenly distributed. The rod shall not strike the bottom of the measure forcibly.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>b.</td>
<td>Measure filled 2/3 full, leveled by hand, and rodded 25 times evenly distributed. The rod shall not penetrate into the first layer.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>c.</td>
<td>Measure filled to overflowing, and rodded 25 times evenly distributed. The rod shall only penetrate the top lift. The surface shall be leveled in such a way either by hand or straightedge that the number of slight projections equals the voids.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>6.</td>
<td>Jigging: aggregates NMS greater than 1 ½” (37.5 mm) but not exceeding 5” (125mm)</td>
<td></td>
<td></td>
</tr>
<tr>
<td>a.</td>
<td>Measure filled 1/3 full.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>b.</td>
<td>Measure placed on concrete floor with opposite side lifted 2” (50mm) and allowed to drop freely, continue this process for 25 times then drip it 25 more times from the opposite side for a total of 50 drops and leveled by hand.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>c.</td>
<td>Measure filled 2/3 full and placed on concrete floor with opposite side lifted 2” (50mm) and allowed to drop freely, continue this process for 25 times then drip it 25 more times from the opposite side for a total of 50 drops and leveled by hand</td>
<td></td>
<td></td>
</tr>
<tr>
<td>d.</td>
<td>Measure filled to overflowing, and placed on concrete floor with opposite side lifted 2” (50mm) and allowed to drop freely, continue this process for 25 times then drip it 25 more times from the opposite side for a total of 50 drops and leveled. The surface shall be leveled in such a way either by hand or straightedge that the number of slight projections equals the voids.</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

OVER
7. **Shoveling: only when specified**

   a. **Measure filled to overflowing with shovel or scoop.** Material placed into measure from a height not to exceed 2” (50mm) above the top of the measure minimizing segregation while filling.

   b. **Measure leveled by hand or straightedge.** The surface shall be leveled in such a way either by hand or straightedge that the number of slight projections equals the voids.

8. **Determine mass of the measure and aggregate and mass of the measure alone to 0.1lb (0.05 kg).**

9. **Determined & record the mass of Aggregate 0.1lb (0.05 kg).**

10. **Calculate the bulk density to 1 lb/ft³ (10 kg/ m³).**

**COMMENTS:** First Attempt : Pass ☐ Fail ☐ Second Attempt: Pass ☐ Fail ☐

Examiner Signature: ________________________________ Sampler / Tester Qualification # _____________

Examiner Signature: ________________________________ Sampler / Tester Qualification # _____________
PERFORMANCE EXAM CHECKLIST

Specific Gravity and Absorption of Fine Aggregate
FOP for AASHTO T 84

Participant Name _________________________________ Exam Date ___ __________

Record the symbols “P” for passing or “F” for failing on each step of the checklist.

### Sample Preparation

<table>
<thead>
<tr>
<th>Step</th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>1. Sampled according to AASHTO T 2?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>2. Sample reduced according to AASHTO T 248 to approximately 2000 g?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>3. Dried to a constant mass at 230 ±9º F, cooled to a comfortable handling temp.?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>4. Addition of 6% moisture to sample?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>5. Allowed to stand 15 – 19 hours?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>6. Uniformly dried by a current of warm air, with frequent stirring?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>7. Mold placed on flat, non-absorbent surface and filled to over-flowing?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>8. Sample compacted with 25 light drops of tamper from 0.2” above top of sample?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>9. Tamper allowed to fall freely under gravitational attraction?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>10. Loose sand removed from around bases and mold lifted vertically?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>11. Sample fails to slump on the first test?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>12. If it does slump, is water added, sample covered and allowed to stand 30 minutes?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>13. Drying continued, and test repeated at frequent intervals until sample slumps slightly? Slight slump is when there is some evidence of slumping around the circumference of the cone?</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

### Testing Procedure

<table>
<thead>
<tr>
<th>Step</th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>1. Split out two 500 gram samples that weigh within 0.2 grams of each other.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>2. 1000 ml Pycnometer partially filled with water and first sample added?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>3. Second sample dried back to constant mass?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>4. Pycnometer filled to 90 % of calibrated capacity and agitated to eliminate air bubbles?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>5. Temperature adjusted to 73.4 ±3º F.?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>6. Water level brought to calibrated capacity and agitated to eliminate air bubbles?</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>
7. Second sample cooled in air at room temperature for 1.0 ±0.5 hr. and weighed?

8. Pycnometer calibrated mass determined?

9. All masses determined to nearest 0.1 g?

10. Calculations performed and values rounded correctly?

Formulas for Specific Gravities and Absorption

Bulk Specific Gravity
\[
\frac{A}{B+S-C}
\]

Bulk Specific Gravity (SSD)
\[
\frac{S}{B+S-C}
\]

Apparent Specific Gravity
\[
\frac{A}{B+A-C}
\]

Absorption, percent
\[
\frac{(S-A)}{A} \times 100
\]

where:
- \(A\) = mass of oven-dry specimen (second sample) in air, g;
- \(B\) = mass of pycnometer filled with water, g;
- \(C\) = mass of pycnometer with specimen and water to calibration mark, g; and
- \(S\) = mass of saturated surface-dry specimen (weight of first sample), g.

Comments: First attempt: Pass [ ] Fail [ ] Second attempt: Pass [ ] Fail [ ]

Examiner Signature: ________________________________ Sampler / Tester Qualification # __________
PERFORMANCE EXAM CHECK LIST

DETERMINING THE LIQUID LIMIT OF SOILS
AASHTO T-89 (METHOD “B” ONE POINT)

Participant Name: _______________________________ Exam Date: ________________

Record the symbols “P” for passing or “F” for failing on each step of the checklist:

Procedure Elements: Trial#1 Trial#2

1. **Prepare sample.** Using AASHTO T-87 or AASHTO T-146. This test requires a minimum of 50g of minus # 40 (0.425 mm) material. _____ _____

2. **Inspect and adjust test apparatus.** Apparatus includes liquid limit device, porcelain mixing dish, spatula, grooving tool, gauge for cup height drop, containers with lids, balance readable to the hundredth and a drying oven. All apparatus shall be clean, dry and within specifications. Moisture containers and lids will be weighed and recorded before each test. Check the drop height on the liquid limit device using the gauge and a piece of tape and adjust as necessary. _____ _____

3. **Adjust sample moisture and mix.** Use distilled or demineralized water only Add 8 to 10 ml of water to material and mix thoroughly, approximately 5 to 10 minutes. Moisture may then be adjusted by adding increments of 1 to 3 ml of water and mixing thoroughly, approximately 1 minute, or by air drying while mixing and kneading. Moisture may not be adjusted by adding dry soil to the moistened sample. Cover the sample and allow to season for 30 minutes. _____ _____

4. **Spread sample into cup of device.** Remix sample and spread above the spot where cup rests on the base. The top surface should be as level as possible and 10 mm in thickness at it’s maximum depth. Use as few strokes as possible, do not entrap air into the sample. Return excess material to the mixing dish. _____ _____

5. **Cut groove into the sample.** Cut groove through the center of the sample, perpendicular to the hinge pin of the cup. Use as few strokes as possible. Up to 6 strokes may be used, only the last stroke should touch the bottom of the cup. _____ _____

6. **Turn the device on and count the taps.** Count the number of taps required to close the groove for a length of approx. ½” (13 mm). If sample slides instead of flowing, add water, remix and repeat test. If problem re-occurs discontinue test and note. _____ _____

7. **Repeat steps 3 through 6 until the groove closes with a range of 22 and 28 taps.** Return remaining soil in the brass cup to the mixing dish with something other than the spatula. Apparatus shall be cleaned and dried between tests. Adjustment of moisture shall follow the guidelines in step 3. _____ _____

8. **Take sample for moisture content determination.** Using the spatula, take a slice of the sample the width of the spatula at the point of closure. The slice shall extend from edge to edge of the soil and perpendicular to the groove for the full depth of the sample. Place the moisture sample in a suitable container, **cover immediately, determine the mass** to the nearest 0.01g and record immediately. _____ _____

9. **Remove cover, place in oven at 110±5° C (230±9° F) and dry to a constant mass.** When removing the sample from the oven to determine constant mass **cover immediately.** _____ _____

OVER
Procedure Elements continued:  

10. **Complete moisture content determination on samples.** After drying to a constant mass, cool to room temperature and determine the mass to a 0.01g and record. Calculate moisture content to the nearest 0.1%

   [Trial#1 Trial#2]

11. **Calculate the Liquid Limit.** Using the formula $\text{LL} = (w_N) \left( \frac{N}{25} \right)^{0.121}$ calculate the corrected Liquid Limit for 25 taps to the nearest 0.1%

   [Trial#1 Trial#2]

12. **Report the Liquid Limit.** The Liquid Limit is the nearest whole number.

   [Trial#1 Trial#2]

COMMENTS:  First Attempt : Pass ☐ Fail ☐  Second Attempt: Pass ☐ Fail ☐

Examiner Signature: ___________________________ Sampler / Tester Qualification # ____________

Examiner Signature: ___________________________ Sampler / Tester Qualification # ____________
PERFORMANCE EXAM CHECK LIST
DETERMINING THE PLASTIC LIMIT AND PLASTICITY INDEX OF SOILS
AASHTO T-90

Participant Name: ___________________________ Exam Date: ______________________

Record the symbols “P” for passing or “F” for failing on each step of the checklist:

Procedure Elements: Trial#1 Trial#2

1. Inspect and clean apparatus. Apparatus include mixing dish, spatula, rolling surface, moisture containers with lids, balance readable to 0.01g and a drying oven. All apparatus should be clean dry and within specifications. Moisture containers and their lids will be weighed and recorded before each test. _____ _____

2. Prepare sample . As per AASHTO T-87 or AASHTO T-146. This test requires approximately 20g of material. Material for this test can be obtained from material used for AASHTO T-89. _____ _____

3. Adjustment of moisture content. Moisture content shall be such that the material can be shaped into a ball and is not sticky. Use distilled or demineralized water only. _____ _____

4. Roll sample to 3.0 mm (approx. 1/8”). Take approximately 8g of the 20g sample and separate into1.5– 2.0 gram increments. Roll on a ground surface with just enough pressure to make a thread of uniform diameter for it’s entire length. A rolling rate of 80 to 90 strokes/minute shall be used. When the diameter of the thread becomes 3.0 mm (approx. 1/8”) break thread into 6 to 8 pieces then make a ball and repeat process. There is a 2 minute time to get from a ball down to 3.0 mm (approx. 1/8”). _____ _____

5. Re-roll until thread breaks or crumbles. Repeat step # 4 until thread breaks into a series of segments 6.4 mm (1/4”) to 9.5 mm (3/8”) in length. The sample must be rolled to 3.0 mm (1/8”) at least once before it breaks or crumbles, if failure occurs on the first try add moisture and repeat steps. Do not attempt to produce failure at 3.0 mm (1/8”) in diameter. _____ _____

6. Collect crumbled particles. Using the spatula, gather all portions of the crumbled particles into a suitable container, cover immediately and determine the mass to the nearest 0.01g. _____ _____

7. Remove cover and place in oven at 110±5° C (230±9° F) and dry to constant mass. When removing sample from the drying oven cover immediately. _____ _____

8. Determine moisture content. After drying to a constant mass, cool and determine the mass to the nearest 0.01g and calculate moisture content to the nearest 0.1%. _____ _____

9. Report Plastic Limit. Plastic Limit is recorded as the nearest whole number . _____ _____

10. Determine Plasticity Index (PI). Calculate the Plasticity Index of the soil as the difference between its Liquid Limit and its Plastic Limit. Example: LL – PL = PI, the result is reported to the nearest whole number. _____ _____

COMMENTS: First Attempt : Pass ☐ Fail ☐ Second Attempt: Pass ☐ Fail ☐

Examiner Signature: ___________________________ Sampler / Tester Qualification #___________

Examiner Signature: ___________________________ Sampler / Tester Qualification #___________

1/13
PERFORMANCE EXAM CHECK LIST

DETERMINING THE SPECIFIC GRAVITY OF SOILS

AASHTO T-100

Participant Name: ________________________________ Exam Date: ________________

Record the symbols “P” for passing or “F” for failing on each step of the checklist:

Procedure Elements: Trial#1 Trial#2

1. Sample obtained? ______ ______
2. Flask filled three quarters with distilled water? ______ ______
3. Entrapped air removed? ______ ______
4. Vacuum 100mm or less? ______ ______
5. Flask agitated gently for the allowed amount of time? ______ ______
   a. Oven dried sample 2 – 4 hours ______ ______
   b. Low plasticity 4 – 6 hours ______ ______
   c. High plasticity containing moisture 6 -8 hours ______ ______
6. Pycnometer filled to calibration mark? ______ ______
7. Pycnometer mass determined? ______ ______
8. Temperature determined? ______ ______

Specific Gravity, \( T_x / T_x = W_o / [W_o + (W_a - W_b)] \)
Specific Gravity, \( T_x / 20^\circ C = (\text{Specific Gravity, } T_x/T_x) \times K \)

Where:

- \( T_x \) = temperature of the contents of the Pycnometer when mass \( W_b \) was determined, in degrees Celsius;
- \( W_o \) = mass of sample of oven-dried soil in grams
- \( W_a \) = mass of pycnometer filled with water at temperature \( T_x \) in grams
- \( W_b \) = mass of pycnomter filled with water and soil at temperature \( T_x \), in grams
- \( K \) = Correction Factor = (Rel. Density of Water at \( T_x \) / Rel. Density of Water at \( 20^\circ C \))

COMMENTS: First Attempt : Pass ☐ Fail ☐ Second Attempt: Pass ☐ Fail ☐

Examiner Signature:_________________________________________ Sampler / Tester Qualification #________

Examiner Signature:_________________________________________ Sampler / Tester Qualification #________
# PERFORMANCE EXAM CHECKLIST

**Effect of Water on Compressive Strength of Compacted Bituminous Mixtures**  
**FOP FOR AASHTO T 165**

Participant Name: ______________________________   Exam Date: ______________

Record the symbols “P” for passing or “F” for failing on each step of the checklist.

<table>
<thead>
<tr>
<th>Procedure Element</th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>1. Six specimens made according to T-167?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>2. Specimens cooled and Bulk Specific Gravity determined?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>3. Six specimens sorted into 2 groups of three?</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>a. Group 1 and 2 with essentially the same gravity</td>
<td>_____</td>
<td>_____</td>
</tr>
<tr>
<td>4. Group 1 placed in incubator at 77° ± 1.8°F (25° ± 1°C) for no less than 4 hours?</td>
<td>_____</td>
<td>_____</td>
</tr>
</tbody>
</table>
| 5. Group 2 immersed in water at 140° ± 1.8°F (60° ± 1°C) for 24 hours,  
Then transferred to 2nd water bath 77° ± 1.8°F (25° ± 1°C) for 2 hours? | _____ | _____ |
| 6. Determine Compressive strength at 0.05 in/min? | _____ | _____ |
| 7. Group 1 Compressive Strength averaged? | _____ | _____ |
| 8. Group 2 Compressive Strength averaged? | _____ | _____ |
| 9. Determine Index of retained strength, rounded to the nearest whole number? | _____ | _____ |

Index of retained strength, % = \( \frac{S_2}{S_1} \times 100 \)

Where:

\( S_1 \) = compressive strength of dry specimens (group 1), and  
\( S_2 \) = compressive strength of immersed specimens (group 2)

Comments: First attempt: Pass_____Fail_____   Second attempt: Pass_____Fail_____  

________________________________________________________________________

Examiner Signature _______________________________ WAQTC #: ______________
PERFORMANCE EXAM CHECKLIST

Uncompacted Void Content of Fine Aggregate for AASHTO T 304

Participant Name: _______________________  Exam Date: ______________________

Record the symbols “P” for passing or “F” for failing on each step of the checklist.

Procedure Element (all test methods are AASHTO unless otherwise shown)

Sampling

<table>
<thead>
<tr>
<th>Procedure Element</th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>1. Sample obtained by one of the following:</td>
<td></td>
<td></td>
</tr>
<tr>
<td>(a) T 2 &amp; T 248 (sampling, splitting and quartering)?</td>
<td>______</td>
<td>______</td>
</tr>
<tr>
<td>or (b) From sieve analysis samples used for T 27?</td>
<td>______</td>
<td>______</td>
</tr>
<tr>
<td>or (c) From aggregate extracted from a bituminous concrete specimen (T 308)?</td>
<td>______</td>
<td>______</td>
</tr>
<tr>
<td>2. Methods A</td>
<td></td>
<td></td>
</tr>
<tr>
<td>(a) Sample washed over No. 100 or No. 200 sieve in accordance with T 11?</td>
<td>______</td>
<td>______</td>
</tr>
<tr>
<td>(b) Sample dried and sieved into separate size fractions in accordance with T 27?</td>
<td>______</td>
<td>______</td>
</tr>
<tr>
<td>(c) Necessary size fractions obtained from sieve analysis maintained in a dry condition in separate containers for each size?</td>
<td>______</td>
<td>______</td>
</tr>
</tbody>
</table>

Sample Preparation

Method A- Standard Graded Sample

1. Following quantities of aggregate that has been dried and sieved in accordance with T 27 weighed out and combined? | ______   | ______  |

<table>
<thead>
<tr>
<th>Individual Size Fractions</th>
<th>Mass, g</th>
<th>OK?</th>
</tr>
</thead>
<tbody>
<tr>
<td>No. 8 to No. 16</td>
<td>44 ± 0.2</td>
<td></td>
</tr>
<tr>
<td>No. 16 to No. 30</td>
<td>57 ± 0.2</td>
<td></td>
</tr>
<tr>
<td>No. 30 to No. 50</td>
<td>72 ± 0.2</td>
<td></td>
</tr>
<tr>
<td>No. 50 to No. 100</td>
<td>17 ± 0.2</td>
<td></td>
</tr>
<tr>
<td><strong>Total:</strong></td>
<td>190 ± 0.2</td>
<td></td>
</tr>
</tbody>
</table>

Specific Gravity of Fine Aggregate

If bulk dry specific gravity of aggregate from the source is unknown, specific gravity determined on material passing No. 4 sieve in accordance with IT 144. | ______   | ______  |

Procedure

1. Each test sample mixed with spatula until it appears to be homogeneous? | ______   | ______  |
2. Funnel stand apparatus with cylindrical measure, positioned in retaining pan? | ______   | ______  |
3. Finger used to block opening of funnel? | ______   | ______  |
4. Test sample poured into funnel? | ______   | ______  |
5. Material in funnel leveled with spatula? | ______   | ______  |
6. After funnel empties, excess heaped aggregate struck off from cylindrical measure by single pass of spatula, with blade width vertical and using straight part of its edge in light contact with top of measure?

7. Care exercised to avoid vibration or any disturbance that could cause compaction of aggregate into cylindrical measure?

Note: After strike-off, measure may be tapped lightly to compact sample to make it easier to transfer container to scale or balance without spilling any of the sample.

8. Adhering grains brushed from outside of container?

9. Mass of cylindrical measure and contents determined to nearest 0.1 g?

10. All aggregate particles retained for second test run?

11. Sample from retaining pan and cylindrical measure recombined and procedure repeated?

12. Mass of empty measure recorded?

13. Calculations performed properly?

**Formula for Calculation of Uncompacted Voids, percent**

\[
U = \left( 1 - \frac{F}{G} \right) \times 100
\]

where:
- \( U \) = uncompacted voids, percent;
- \( V \) = volume of cylindrical measure to nearest 0.1 mL;
- \( F \) = net mass, g, of fine aggregate in measure; and,
- \( G \) = bulk dry specific gravity of fine aggregate (\( G_{sb} \))

Comments:  
First attempt: Pass [ ] Fail [ ]  
Second attempt: Pass [ ] Fail [ ]

Signature of Examiner ________________________________.
PERFORMANCE EXAM CHECKLIST

BULK SPECIFIC GRAVITY AND DENSITY OF COMPACTED HOT MIX ASPHALT (HMA) USING AUTOMATIC VACUUM SEALING METHOD FOP FOR AASHTO T 331

Participant Name ______________________________ Exam Date ______________

Record the symbols “P” for passing or “F” for failing on each step of the checklist.

**Procedure Element** | **Trial 1** | **Trial 2**
--- | --- | ---
1. Mass of dry sample in air determined? | ______ | ______ |
   a. Dried overnight at 125°F and at successive 2-hour intervals to constant mass? | ______ | ______ |
   b. Cooled in air to 77°± 9°F? | ______ | ______ |
   c. Dry mass determined to 0.1g? | ______ | ______ |
   d. Record initial dry mass as (A)? | ______ | ______ |
2. Bag mass recorded? | ______ | ______ |
   a. Bag inspected for holes or irregularities? | ______ | ______ |
   b. Bag mass recorded? | ______ | ______ |
3. Bag placed in vacuum chamber? | ______ | ______ |
4. Specimen placed in bag 1 inch from end of bag? | ______ | ______ |
5. Check that there are no wrinkles in the bag along the seal bar. | ______ | ______ |
6. Lid closed and lid retaining latch engaged? | ______ | ______ |
7. Once sealed remove the specimen carefully from chamber? | ______ | ______ |
8. Specimen mass in bag in air? | ______ | ______ |
   a. Determine mass to 0.1g? | ______ | ______ |
   b. Record mass as (B). | ______ | ______ |
9. Sealed puck quickly placed in water bath at 77°± 1.8°F? | ______ | ______ |
   a. From time vacuum lid opens to being submerged in water, not to exceed 1 min? | ______ | ______ |
   b. Specimen fully submerged? | ______ | ______ |
   c. Specimen not touching edges of water bath? | ______ | ______ |
   d. Once scale stabilizes, record mass as (E). | ______ | ______ |
10. Bag removed from water bath? | ______ | ______ |
11. Sample removed from bag? | ______ | ______ |
12. Sample Mass determined and designated as (C)?
   a. Verify mass (A) is no more than 5g from mass specimen (C)?
   b. If more than 5g different, oven dry to constant mass and retest?

\[
G_{mb} = \frac{A}{C + (B - A) - E - \left[\frac{B - A}{F}\right]}
\]

\(G_{mb}\) = specimen bulk specific gravity;
A = initial mass of the dried specimen in air, g;
B = calculated mass of the dry, sealed specimen, g;
C = final mass of the specimen after removal from the sealed bag, g;
E = mass of the sealed specimen underwater, g; and
F = apparent specific gravity of the plastic sealing material at 77°F, provided by the Manufacture.

Comments: First attempt: Pass Fail Second attempt: Pass Fail

Examiner Signature ___________________________ WAQTC #: __________________
**PERFORMANCE EXAM CHECKLIST**

**Density of In-Place Hot Mix Asphalt (HMA) Pavement by Electronic Surface Contact Devices**

**FOP for AASHTO T 343**

Participant Name _______________________________    Exam Date ______________

**Record the symbols “P” for passing or “F” for failing on each step of the checklist.**

<table>
<thead>
<tr>
<th>Procedure Element</th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>1. Gauge turned on?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>2. Gauge calibrated using data from cores?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>3. Test location selected away from any known sources of electromagnetic interference such as overhead high-tension power lines or large metal objects?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>4. The HMA surface is free of moisture, relatively flat, and smooth?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>5. Surface brushed clear of loose particles?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>6. Gauge placed firmly on HMA surface?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>7. Outline traced around base?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>8. Five (5) measurements taken per diagram # 1 and recorded?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>9. Average density calculated?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>10. Compaction calculated to 0.1%?</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

Comments: First Attempt: Pass [ ] Fail [ ] Second Attempt: Pass [ ] Fail [ ]

Examiner Signature ____________________________  WAQTC #: ______________

Examiner Signature ____________________________  WAQTC #: ______________
PERFORMANCE EXAM CHECKLIST

Flat Particles, Elongated Particles, or Flat and Elongated Particles in Coarse Aggregate Fop for ASTM D 4791

Participant Name: ___________________________ Exam Date: _______________________

Record the symbols “P” for passing or “F” for failing on each step of the checklist.

<table>
<thead>
<tr>
<th>Procedure Element</th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Sample Preparation</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>1. Sample obtained, mixed and reduced in accordance with AASHTO T 2 and AASHTO T 248 to approximately the amount required for testing?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>2. Minimum dry sample mass meets requirements?</td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>Procedure</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>1. If determination by mass, sample oven-dried to constant mass at 230 ±9° F? <strong>Note:</strong> If determination is by particle count drying is not necessary.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>2. Sample sieved according to AASHTO T 27?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>3. Each size fraction larger than No. 4 sieve present in amount of 10% or more of original sample reduced according to T 248 until approximately 100 particles obtained?</td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>Flat and Elongated Particle Test:</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>4. Each particle in each size fraction tested and placed into one of two groups: (1) flat and elongated or (2) not flat and elongated?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>5. Proportional caliper device positioned at proper ratio?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>6. Larger opening set equal to particle length?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>7. Particle is <strong>flat and elongated</strong> if the <strong>thickess</strong> can be placed in the smaller opening?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>8. Proportion of sample in each group determined by count or by mass, as required?</td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>Calculation</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>1. Percentage of flat and elongated particles calculated to nearest 1% for each sieve size greater than No. 4?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>2. When weighted average for sample is required, sieve sizes not tested (those representing less than 10% of sample) assumed to have same percentage of flat particles, elongated particles, or flat and elongated particles as the next smaller or the next larger size? Or if both are present, is average for next smaller and larger sizes used?</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

Comments and Score: First Attempt: Pass [ ] Fail [ ] Second Attempt: Pass [ ] Fail [ ]

Signature of Examiner: __________________________________________

1/14

ASTM D 4791
QUALIFICATION CHECKLIST
FIELD VISCOSITY – IDAHO IT 61

Record the symbols “P” for passing or “F” for failing on each step of the checklist.

<table>
<thead>
<tr>
<th>Procedure Element</th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Sampling</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>1. Sample taken using a valve:</td>
<td></td>
<td></td>
</tr>
<tr>
<td>a. Minimum of 4 L (1gal) allowed to flow before sample taken?</td>
<td>1a</td>
<td></td>
</tr>
<tr>
<td>b. Sample taken in clean 1 L (1 quart) wide mouth jar?</td>
<td>1b</td>
<td></td>
</tr>
<tr>
<td>2. Sample taken with Thief device.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>a. Sample can immersed approximately to middle of tanker?</td>
<td>2a</td>
<td></td>
</tr>
<tr>
<td>b. Rubber stopper removed from can and sample taken from the middle of the tanker / tank?</td>
<td>2b</td>
<td></td>
</tr>
<tr>
<td>3. A portion of the sample transferred to a one (1) half pint plastic bottle and sealed with a stopper having a thermometer in the center?</td>
<td>3</td>
<td></td>
</tr>
<tr>
<td><strong>Equipment</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>4. Temperature of the viscometer bath at 50°C (122°F)?</td>
<td>4</td>
<td></td>
</tr>
<tr>
<td>5. Viscosity tube clean and dry and cork installed?</td>
<td>5</td>
<td></td>
</tr>
<tr>
<td><strong>Testing</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>6. Sample cooled to 51.7 ±0.3°C (125 ±0.5°F)?</td>
<td>6</td>
<td></td>
</tr>
<tr>
<td>7. Sample poured through a #20 sieve prior to entering the brass viscosity tube?</td>
<td>7</td>
<td></td>
</tr>
<tr>
<td>8. Enough sample poured into the tube to allow overflow into gallery?</td>
<td>8</td>
<td></td>
</tr>
<tr>
<td>9. Thermometer placed into tube and sample stirred slowly until testing temperature reached?</td>
<td>9</td>
<td></td>
</tr>
<tr>
<td>10. Thermometer withdrawn and excess in the overflow gallery siphoned out using a pipette without touching overflow rim?</td>
<td>10</td>
<td></td>
</tr>
<tr>
<td>11. Emulsified asphalt sample in viscometer immediately covered?</td>
<td>11</td>
<td></td>
</tr>
<tr>
<td>12. Cork pulled allowing the sample roll down the inside lip of the receiving flask?</td>
<td>12</td>
<td></td>
</tr>
<tr>
<td>13. Timer immediately started when cork is pulled?</td>
<td>13</td>
<td></td>
</tr>
<tr>
<td>14. Timer stopped when bottom of sample meniscus reaches graduation mark?</td>
<td>14</td>
<td></td>
</tr>
<tr>
<td>15. Test results reported to nearest 1 second on ITD-1045 form?</td>
<td>15</td>
<td></td>
</tr>
</tbody>
</table>

First Attempt: Pass ☐ Fail ☐  Second Attempt: Pass ☐ Fail ☐

Comments: ____________________________________________________________

Participant Name ___________________________ Exam Date __________ WAQTC# __________

Examiner’s Name: ___________________________ Signature ___________________________

WAQTC #: ___________________________

1/08 Idaho IT-61
# PERFORMANCE EXAM CHECKLIST

## CLEANNESS VALUE – IDAHO IT 72

Record the symbols “P” for passing or “F” for failing on each step of the checklist.

<table>
<thead>
<tr>
<th>Procedure Element</th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>General</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>1. The sample was maintained moist in sealed container.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>2. The sample is equal to 1000 ± 50 grams.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>3. There is 7 ml of SE solution in SE tube.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>4. The graduate assembly including sieves, funnel and 500 ml graduate cylinder is properly put together.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>5. CCM sample was placed in washing vessel or jar and water was added just covering the aggregate.</td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>Mechanical Method</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>6. The vessel was secure in the shaker.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>7. Agitation was started after one (1) minute.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>8. The vessel was agitated for two minutes.</td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>Hand Method</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>9. Agitation was started after one (1) minute.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>10. The vessel was properly rotated with 150mm radius.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>11. Vessel was agitated 3 complete rotations per second.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>12. Vessel was agitated for one (1) full minute.</td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>Measure for Cleanness</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>13. All contents of vessel or jar were washed over sieves into the 500 ml graduate cylinder.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>14. Cylinder was rapidly turned upside down at 180º, ten (10) times.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>15. Mixture was poured into SE cylinder to 15 inch mark.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>16. SE Cylinder was rotated at least ten (10) complete cycles. Bubble traveled full length of tube.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>17. Cylinder was allowed to stand 20 minutes on work table free from vibrations.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>18. The sediment reading was to the nearest 0.1 inch.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>19. Calculations were accurate to the nearest whole number.</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

Comments: First Attempt: Pass □ Fail □ Second Attempt: Pass □ Fail □

Testing Technician’s Name: ___________________________ WAQTC #: ______ Date: _______

Examiner’s Name: ___________________________ Signature ___________________________________
## QUALIFICATION CHECKLIST

**DETECTION OF ANTI-STRIP ADDITIVE IN ASPHALT – IDAHO T 99**

Record the symbols “P” for passing or “F” for failing on each step of the checklist.

<table>
<thead>
<tr>
<th>Procedure Element</th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>General</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>1. All containers and or stir sticks were clean and chemical solutions were fresh</td>
<td>1</td>
<td></td>
</tr>
<tr>
<td><strong>Detection test by Color Method only</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>2. A control blank was performed.</td>
<td>2</td>
<td></td>
</tr>
<tr>
<td>3. 40 ml of Reagent Isopropyl Alcohol or equivalent was used.</td>
<td>3</td>
<td></td>
</tr>
<tr>
<td>4. The asphalt mixture was heated on a hot plate.</td>
<td>4</td>
<td></td>
</tr>
<tr>
<td>5. Heating of sample was stopped before mixture became too dark.</td>
<td>5</td>
<td></td>
</tr>
<tr>
<td>6. The same amount of Bromophenol Blue Indicator was added to both mixtures.</td>
<td>6</td>
<td></td>
</tr>
<tr>
<td>7. Test results were accurately interpreted and recorded on the proper ITD form.</td>
<td>7</td>
<td></td>
</tr>
</tbody>
</table>

**Comments:**

First Attempt: Pass [ ] Fail [ ]  Second Attempt: Pass [ ] Fail [ ]

Testing Technician’s Name: ___________________________  WAQTC #: _______  Date: ________

Examiner’s Name: ___________________________  Signature ___________________________
**PERFORMANCE EXAM CHECKLIST**

**SPECIFIC GRAVITY AND ABSORPTION OF FINE AGGREGATE USING AUTOMATIC VACUUM SEALING (CORELOK) METHOD**

IDAHO IT-144-08

Participant Name_________________________________________  Exam Date ____________

Record ‘P’ For Passing “F” for failing each step of the checklist.

### Verification Element

<table>
<thead>
<tr>
<th>Procedure</th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>1. Pycnometer and lid placed inside a bucket of water at 25 ± 1°C (77 ± 2°F)?</td>
<td>_______</td>
<td>_______</td>
</tr>
<tr>
<td>2. Pycnometer and lid removed from water dried well and placed on clamping device until it makes contact with stops?</td>
<td>_______</td>
<td>_______</td>
</tr>
<tr>
<td>3. Pycnometer filled with 25 ± 1°C (77 ± 2°F) water to 10mm (3/8&quot;) of top, sprayed with Isopropyl alcohol to remove air?</td>
<td>_______</td>
<td>_______</td>
</tr>
<tr>
<td>4. Lid gently placed on Pycnometer and clamped?</td>
<td>_______</td>
<td>_______</td>
</tr>
<tr>
<td>5. A syringe filled with 25 ± 1°C (77 ± 2°F) inserted in top of lid and gently added until water is expelled through the 3mm (1/8&quot;) hole?</td>
<td>_______</td>
<td>_______</td>
</tr>
<tr>
<td>6. Water wiped from lid, device water and pycnometer weighed and recorded to 0.1 g?</td>
<td>_______</td>
<td>_______</td>
</tr>
<tr>
<td>7. Procedure repeated two additional times (no greater than 0.5 g difference) recorded to work sheet and averaged?</td>
<td>_______</td>
<td>_______</td>
</tr>
</tbody>
</table>

### Procedure Element

<table>
<thead>
<tr>
<th>Procedure</th>
<th>Trial 1</th>
<th>Trial 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>8. Representative samples obtained per FOP for AASHTO T 2?</td>
<td>_______</td>
<td>_______</td>
</tr>
<tr>
<td>9. Reduced per FOP for AASHTO T 248?</td>
<td>_______</td>
<td>_______</td>
</tr>
<tr>
<td>10. Dried per FOP for AASHTO T 255?</td>
<td>_______</td>
<td>_______</td>
</tr>
<tr>
<td>11. Samples cooled to 25 ±1°C (77 ± 2°F)?</td>
<td>_______</td>
<td>_______</td>
</tr>
<tr>
<td>12. Three samples obtained @ 500g ±1g and one @ 1000g ± 1g?</td>
<td>_______</td>
<td>_______</td>
</tr>
<tr>
<td>13. Pycnometer and lid removed from water, dried and pycnometer placed on clamping device until it makes contact with stops?</td>
<td>_______</td>
<td>_______</td>
</tr>
<tr>
<td>14. Water added to pycnometer (at 25 ± 1°C, 77 ± 2°F) to approximately half full?</td>
<td>_______</td>
<td>_______</td>
</tr>
<tr>
<td>Procedure Element</td>
<td>Trial 1</td>
<td>Trial 2</td>
</tr>
<tr>
<td>----------------------------------------------------------------------------------</td>
<td>---------</td>
<td>---------</td>
</tr>
<tr>
<td>15. Sample at 500 g ± 1g slowly added to pycnometer?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>16. Metal spatula inserted against side of pycnometer and slowly pushed to center removed, repeated in eight equal increments?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>17. Water added at 25 ± 1C (77 ± 2F) to within 10mm (3/8&quot;) of rim?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>18. Sprayed with isopropyl alcohol to remove air?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>19. Lid gently placed on pycnometer with 3mm (1/8&quot;) hole to the front and clamped?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>20. Syringe filled with 25 ± 1C (77 ± 2F) water inserted in top of lid and water slowly added until it is expelled through 3mm (1/8&quot;) hole?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>21. Excess water wiped from lid?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>22. Clamping device, pycnometer and sample mass recorded to 0.1 g?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>23. Clamping device, pycnometer and sample mass determined no more than 2 minutes from time sample was submerged?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>24. Second 500g ±1 g sample tested and mass recorded?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>25. If recorded mass of first and second sample greater than 1 g, was a third 500 g ± 1 g sample tested?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>26. Vacuum device set at manufacture’s recommended setting?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>27. Small plastic bag inspected and mass determined to 0.1 g and recorded?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>28. 1000 g ±1 g sample mass determined and recorded?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>29. 1000 g ±1 g sample placed in the bag, supported by a smooth surface to prevent punctures?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>30. Sample placed in vacuum device and spread flat by grasping both sides of bag and gently shaking?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>31. Open end of bag placed over seal bar and closed?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>32. Sample removed from vacuum chamber when door opens and submerged in 25 ± 1C (77 ± 2F) water bath within 5 seconds?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>33. Bag maintained at a minimum depth of two inches?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>34. A small cut made at corner of bag approximately 25 to 50mm (1&quot; to 2&quot;)?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>35. Submerged bag held open until water flows freely into bag (approximately 45 seconds)</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Procedure Element</td>
<td>Trial 1</td>
<td>Trial 2</td>
</tr>
<tr>
<td>-------------------</td>
<td>---------</td>
<td>---------</td>
</tr>
<tr>
<td>36. A second cut approximately 25 to 50mm (1” to 2”) made to opposite side of bag?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>37. Residual air removed from bag by running fingers across top of submerged bag?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>38. Bag placed in weighing basket and water allowed to flow freely into bag?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>39. Sample mass determined and recorded after 15 minutes but not more than 20 minutes and recorded to 0.1g?</td>
<td></td>
<td></td>
</tr>
<tr>
<td>40. Test data entered into manufacture’s software to obtain test results?</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

COMMENTS:  First Attempt : Pass ☐ Fail ☐ Second Attempt: Pass ☐ Fail ☐

Examiner Signature: ___________________________ Sampler / Tester Qualification #       

Examiner Signature: ___________________________ Sampler / Tester Qualification #       
Summary of Edition Changes – January 2018

- **Section 100.00 Quality Assurance Program Introduction**
  - No changes
- **Section 200.00, 201.00, 215.00, 220.00, 225.00, 230.00, 240.00, 250.00**
  - No changes
- **Section 255.00 Performance Graded Binder Quality Assurance Plan.**
  - Add the requirements of AASHTO R 26 Certifying Suppliers of Performance Graded Asphalt Binders
- **Section 256.00**
  - Change 2017 to 2018.
- **Section 260.01.02 Definitions**
  - Correct the equation for $G_{sb}$ of RAP
- **Section 265.00 Qualified Aggregate Material Suppliers**
  - No changes
- **Section 270.10 MTR 205-2, Granular Borrow, Subgrade Embankment Fill**
  - Add FOP for AASHTO T 27 and T 11 to Test Method
  - Add footnote (2) to Acceptance, Sand Equivalent: “Sand Equivalent is not required if the material has less than 5% passing the No. 200 sieve in accordance with AASHTO T 27/ T 11. Document on Form ITD-901.”
- **Section 270.20,**
  - No changes.
- **Section 270.30,**
  - Delete reference to AASHTO T 343 from 405-3, 405-4, and 405-5.
- **Section 270.40 & 50**
  - No changes.
- **Section 270.60 MTR 621, Seeding**
  - Add “and Viability” to “Purity and Germination & Tetrazolium (TZ)”
- **Section 275.01, Table 275.01.1**
  - Delete Idaho Standard Practice (IR)
  - Delete duplicate Idaho IT-74
  - Delete Idaho IT-130
  - Delete AASHTO T 275
  - Move AASHTO T 343 to Idaho FOP section
  - Delete duplicate AASHTO T 304 from AASHTO FOP section.
  - Add AASHTO T 359 to Idaho FOP section.
- **Section 300.00**
  - Add “Additional information is provided in AASHTO R 44.” at the end of the first paragraph.
- **Section 470.02**
  - Change metric values to English in the example letter.
### SECTION 500.00 – STANDARD

**METHODS & PRACTICES IDAHO**

**STANDARD PRACTICE (IR),**

**IDAHO STANDARD METHOD OF TEST (IT)**

<table>
<thead>
<tr>
<th>Action</th>
</tr>
</thead>
</table>

#### SECTION 510.00 - AGGREGATES

<table>
<thead>
<tr>
<th>Action</th>
</tr>
</thead>
</table>

<table>
<thead>
<tr>
<th>IT-13-17</th>
<th>Measuring Mortar-Making Properties of Fine Aggregate</th>
<th>No Changes</th>
</tr>
</thead>
<tbody>
<tr>
<td>IT-15-04</td>
<td>Idaho Degradation</td>
<td>No Changes</td>
</tr>
<tr>
<td>IT-72-17</td>
<td>Evaluating Cleanness of Cover Coat Material</td>
<td>No Changes</td>
</tr>
<tr>
<td>IT-74-98</td>
<td>Vibratory Spring-Load Compaction for Coarse Granular Material</td>
<td>No Changes</td>
</tr>
<tr>
<td>IT-116-13</td>
<td>Disintegration of Quarry Aggregates (Ethylene Glycol)</td>
<td>No Changes</td>
</tr>
<tr>
<td>IR-142-06</td>
<td>Investigation of Aggregate and Borrow Deposits</td>
<td>No Changes</td>
</tr>
<tr>
<td>IT-144-08</td>
<td>Specific Gravity and Absorption of Fine Aggregate Using Automatic Vacuum Sealing (CoreLok) Method</td>
<td>No Changes</td>
</tr>
</tbody>
</table>

#### SECTION 520.00 - BITUMINOUS MATERIALS

<table>
<thead>
<tr>
<th>Action</th>
</tr>
</thead>
</table>

<p>| IT-61-08 | Sampling and Viscosity Testing Emulsified Asphalt Binders in the Field | No Changes |
| IR-63-13 | Design of Seal Coats and Single Surface Treatments by the McLeod Method | Change Section 560 to 520 in Header |
| IT-99-17 | Detection of Anti-Stripping Additive in Asphalt | No Changes |
| IR-125-16 | Acceptance Test Strip for Hot Mix Asphalt (HMA) | No Changes |
| IT-137-17 | Effectiveness of Anti-Strip Agents After Hot Storage in Asphalt Binder Using Bottle and Sand | No Changes |
| IT-146-16 | Determination Of Reclaimed Asphalt Pavement (Rap) Aggregate Bulk (Dry) Specific Gravity (Gsb) | Correct Equation in Section 8.5 |</p>
<table>
<thead>
<tr>
<th>SECTION 530.00 – CONCRETE</th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>IR-128-17</td>
<td>Sampling Concrete for Chloride Analysis</td>
</tr>
<tr>
<td>IT-131-17</td>
<td>Total Chloride Content of Hardened Concrete by Gran Plot Method</td>
</tr>
<tr>
<td>IT-133-17</td>
<td>Determination of the Rate of Evaporation of Surface Moisture from Concrete</td>
</tr>
<tr>
<td>IR-143-17</td>
<td>Field Sampling of Hydraulic Cement and Fly Ash</td>
</tr>
<tr>
<td>IT-147-17</td>
<td>Measuring Texture Depth of Portland Cement Concrete Using a Tire Tread Depth gauge</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>SECTION 540.00 - PAINT</th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>IR-7-04</td>
<td>Inspecting/Sampling Paint and Curing Compound</td>
</tr>
<tr>
<td>IT-121-98</td>
<td>Determining Total Solids-Latex Percent</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>SECTION 550.00 - SOILS</th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>IT-8-17</td>
<td>Resistance R-Value and Expansion Pressure of Compacted Soils and Aggregates</td>
</tr>
<tr>
<td>IR-62-17</td>
<td>Taking Undisturbed Soil Samples for Laboratory Consolidation, Shear and Permeability Tests</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>SECTION 560.00 - MISCELLANEOUS</th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>IR-12-17</td>
<td>Calibrating Torque-Wrenches, Tightening and Testing Bolt Tensions</td>
</tr>
<tr>
<td>IR-17-98</td>
<td>Calibrating the Skidmore-Wilhelm Torque-Wrench Calibration Unit</td>
</tr>
<tr>
<td>IR-87-17</td>
<td>Pavement Straightedge Procedures</td>
</tr>
<tr>
<td>IT-120-17</td>
<td>Determining Volume of Liquids in Horizontal or Vertical Storage Tanks</td>
</tr>
</tbody>
</table>
### SECTION 570.00 – WAQTC / IDAHO FIELD OPERATING PROCEDURES

**Check Highlighted TEST Methods for Modifications at the end of the Method**

<table>
<thead>
<tr>
<th>SECTION 570.01 - AGGREGATE</th>
<th>ACTION</th>
</tr>
</thead>
<tbody>
<tr>
<td>1. AASHTO T 2 (16) Sampling of Aggregates</td>
<td>Change Table 1.</td>
</tr>
<tr>
<td>2. AASHTO R 76 (16) Reducing Samples of Aggregates to Testing Size</td>
<td>No Changes</td>
</tr>
<tr>
<td>3. AASHTO T 255 (16) Total Evaporable Moisture Content of Aggregate by Drying</td>
<td>Change Table 1</td>
</tr>
<tr>
<td>Sieve Analysis of Fine and Coarse Aggregates &amp; Materials Finer Than 75 µm (No. 200) Sieve in Mineral Aggregates by Washing</td>
<td></td>
</tr>
<tr>
<td>5. AASHTO T 335 (16) Determining the Percentage of Fracture in Coarse Aggregate</td>
<td>Change M 92 to T 27/T 11 Changes in “Procedure”</td>
</tr>
<tr>
<td>6. AASHTO T 176 (16) Plastic Fines in Graded Aggregates and Soils by Use of the Sand Equivalent Test</td>
<td>Add “Label working solution with date mixed.” Change to FOP for AASHTO T 176: Step “4a,b,c to 6a,b,c.”</td>
</tr>
</tbody>
</table>

| SECTION 570.02 – ASPHALT I |
|-----------------------------|--------|
| 1. AASHTO T 168 (10) Sampling Bituminous Paving Mixtures | Change to FOP for AASHTO T 168 |
| 2. AASHTO R 47 (12) Reducing Samples of Hot Mix Asphalt (HMA) to Testing Size | No Changes |
| 3. AASHTO T 329 (16) Moisture Content of Hot Mix Asphalt (HMA) by Oven Method | No Changes |
| 4. AASHTO T 308 (16) Determining the Asphalt Binder Content of Hot Mix Asphalt (HMA) by the Ignition Method | Add “Asphalt” to “Binder”, Add Perform “Lift Test…”Apparatus, Change to FOP for AASHOT T 308 |
| 5. AASHTO T 30 (16) Mechanical Analysis of Extracted Aggregate | Add Language to Appendix and Sample Sieving. Time Evaluation and Overhead moved to Annex |
| 6. AASHTO T 209 (16) Theoretical Maximum Specific Gravity and Density of Hot Mix Asphalt Paving Mixtures | Change to FOP for AASHTO T 209 |
| 7. AASHTO T 166 (16) Bulk Specific Gravity of Compacted Hot Mix Asphalt using Saturated Surface-Dry Specimens | Change HMA to Asphalt Mixtures Change to FOP for AASHTO T 166 |
| 8. AASHTO R 66 (16) Sampling Asphalt Materials | No changes |
| 9. AASHTO T 312 (16) Asphalt Mixture Specimens by Means of the Superpave Gyratory Compactor | Added an FOP for AASHTO T 312 |
| 10. WAQTC TM 13 (13) Volumetric Properties of Hot Mix Asphalt | No Changes |
| 11. AASHTO R 67 (15) Sampling Hot Mix Asphalt (HMA) After Compaction (Obtaining Cores) | No changes |
### SECTION 570.03 – CONCRETE

<table>
<thead>
<tr>
<th>Standard</th>
<th>Description</th>
<th>Change/Note</th>
</tr>
</thead>
<tbody>
<tr>
<td>WAQTC TM 2 (14)</td>
<td>Sampling Freshly Mixed Concrete</td>
<td>Change M 92 to T 27/T 11</td>
</tr>
<tr>
<td>AASHTO T 309 (15)</td>
<td>Temperature of Freshly Mixed Portland Cement Concrete</td>
<td>No Changes</td>
</tr>
<tr>
<td>AASHTO T 119 (16)</td>
<td>Slump of Hydraulic Cement Concrete</td>
<td>No Changes</td>
</tr>
<tr>
<td>AASHTO T 121 (16)</td>
<td>Density (Unit Weight), Yield, and Air Content (Gravimetric) of Concrete</td>
<td>Change to “slightly overfill” from “fill”. Change calculations. Add Annex.</td>
</tr>
<tr>
<td>AASHTO T 152 (16)</td>
<td>Air Content of Freshly Mixed Concrete by the Pressure Method</td>
<td>Move “Standardization” to Annex.</td>
</tr>
<tr>
<td>AASHTO T 23 (15)</td>
<td>Method of Making and Curing Concrete Test Specimens in the Field</td>
<td>Change 7000 vibrations to 9000 vibrations. Add SCC. Add “immediate” to “begin”.</td>
</tr>
</tbody>
</table>

### SECTION 570.04 – EMBANKMENT AND BASE

<table>
<thead>
<tr>
<th>Standard</th>
<th>Description</th>
<th>Change/Note</th>
</tr>
</thead>
<tbody>
<tr>
<td>AASHTO T 255 (16)</td>
<td>Total Evaporable Moisture Content of Aggregate by Drying &amp; Laboratory Determination of Moisture Content of Soils</td>
<td>No changes</td>
</tr>
<tr>
<td>AASHTO T 99 (15)</td>
<td>Moisture-Density Relations of Soils Using a 2.5-kg (5.5-lb) Rammer and 305-mm (12-in.) Drop</td>
<td>Correction for oversize moved to Annex. Added FOP for T 99/T 180 to add back language that was removed from the note on Table 205.03-1 of the spec book.</td>
</tr>
<tr>
<td>AASHTO T 180 (15)</td>
<td>Moisture-Density Relations of Soils Using a 4.54-kg (10-lb) Rammer and 457-mm (18-in.) Drop</td>
<td></td>
</tr>
<tr>
<td>AASHTO R 75 (16)</td>
<td>Developing a Family of Curves</td>
<td>No Changes</td>
</tr>
<tr>
<td>AASHTO T 85 (16)</td>
<td>Specific Gravity and Absorption of Coarse Aggregate</td>
<td>No Changes</td>
</tr>
</tbody>
</table>

### SECTION 570.05 – IN-PLACE DENSITY

<table>
<thead>
<tr>
<th>Standard</th>
<th>Description</th>
<th>Change/Note</th>
</tr>
</thead>
<tbody>
<tr>
<td>AASHTO T 355 (16)</td>
<td>In-Place Density of Hot Mix Asphalt using the Nuclear Moisture-Density Gauge</td>
<td>No Changes</td>
</tr>
<tr>
<td>AASHTO T 310 (13)</td>
<td>In-Place Density and Moisture Content of Soil and Soil-Aggregate by Nuclear Methods (Shallow Depth)</td>
<td>Change to FOP for AASHTO T 310. Added to #12 Procedure.</td>
</tr>
<tr>
<td>AASHTO T 255 (16)</td>
<td>Total Evaporable Moisture Content of Aggregate by Drying &amp; Laboratory Determination of Moisture Content of Soils</td>
<td>No changes</td>
</tr>
<tr>
<td>AASHTO T 272 (16)</td>
<td>One-Point Method for Determining Maximum Dry Density and Optimum Moisture</td>
<td>No changes</td>
</tr>
<tr>
<td>FOP CURVES(16)</td>
<td>Use of AKDOT &amp; PF ATM-212, ITD T-74, WSDOT TM 606, or WFLHD Humphreys Curves</td>
<td>Description of Procedure changed. Changed Proctor Test to moisture/density relationship</td>
</tr>
</tbody>
</table>
### SECTION 580.00 – IDAHO FIELD OPERATING PROCEDURES, (FOPs)

<table>
<thead>
<tr>
<th></th>
<th>Method</th>
<th>Description</th>
<th>Changes</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>ASTM D4791</td>
<td>Flat and Elongated Particles in Coarse Aggregate</td>
<td>Reformat procedure to be consistent with Idaho and AASHTO. Change AASHTO M 92 to ASTM E11. Change AASHTO T 248 to AASHTO R 76. Add Reference Documents section.</td>
</tr>
<tr>
<td>2</td>
<td>AASHTO T 304</td>
<td>Uncompacted Void Content of Fine Aggregate</td>
<td>Reformat procedure to be consistent with Idaho and AASHTO. Change AASHTO T 248 to AASHTO R 76. Fix text in “Funnel” paragraph. Changed “bituminous concrete” to “asphalt mixture”</td>
</tr>
<tr>
<td>3</td>
<td>AASHTO T 343</td>
<td>Density of In-Place Hot Mix Asphalt Pavement by Electronic Surface Contact Devices</td>
<td>Delete method because it is not approved by FHWA</td>
</tr>
<tr>
<td>5</td>
<td>AASHTO T 359</td>
<td>Pavement Thickness by Magnetic Pulse Induction</td>
<td>Reformat procedure to be consistent with Idaho and AASHTO.</td>
</tr>
</tbody>
</table>

### SECTION 590.00 – ITD STQP

- Changed “five WAQTC and three ITD STQP” to “six WAQTC and two ITD STQP” in the third paragraph.
- Reformatted all Performance Exam Checklists for a more consistent look and standardized the Pass/Fail, Comments, and Signatures area to be uniform throughout the checklists.
- Delete Performance Exam Checklist for AASHTO T 343 method because it is not approved by FHWA.