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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 Contractor's responsibility 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.
- 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.

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 or an appearance of a conflict of interest, the following applies to any non-Department laboratory for each project:

1. Any non-Department laboratory is allowed to perform only one of the following types of testing on the same project:
  - Acceptance
  - Quality Control
  - Independent Assurance
  - Dispute Resolution
2. If the non-Department laboratory, participated in any process of the mix design development for a project (i.e., from sampling the aggregate to the sealing and stamping of the mix design), the non-Department laboratory is only allowed to work for the Contractor on this project; thereby limiting the non-Department laboratory to quality control testing only on this project.
3. If a mix design(s) used on a project has been previously used and approved by the Department for another project(s), the restriction above in 2 does not apply and the non-Department laboratory may participate in any one, but only one, of the following types of testing on the project:
  - Acceptance
  - Quality Control
  - Independent Assurance
  - Dispute Resolution

All levels of testing by the Contractor or their designated laboratories to control the quality of a product are considered QC testing.

The non-Department laboratory 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 Highways Construction and Operations 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.

Most recently, this team has only worked on the Quality Assurance Special Provision. (FHWA has placed a high priority on the Department to renew its priority on quality assurance including a statewide QA team and ideally filling in the quality assurance engineer position.)



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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 Department's Quality Assurance Special Provision (QASP) has this information for bid items under the QASP.

**200.00.01 Test Result Challenge Resolution.** The Contractor and the Department may enter into a challenge resolution when the quality of a lot is believed to be misrepresented. The Department has established a Test Result Challenge Resolution process in Section 106.07 of the Standard Specifications.

The Central Materials Laboratory will perform all challenge resolutions.

**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 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 calendar 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**

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

**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-Department 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-Department 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 Department specifications are exempt from the Department's 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 the Department's 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 Department's 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 Specifications. 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 an Idaho licensed professional engineer. 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 Materials 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 & Tester 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.

**210.03 Source Documents.** A source document is defined as the original document on which any measurements, original observations, calculations, or derived data of actual work performed are first recorded.

A source document is an essential project record because it is the beginning of a verifiable audit trail. Individually and collectively, source documents permit the evaluation of project data and the quality of the data produced. Source documents enable independent observers the ability to confirm data and verify the information reported as accurate and true. It is crucial to accurately and timely complete, make available, and retain source documents.

Source documents include:

- Electronic printouts (e.g., weight tickets, certifications)
- Electronic forms completed throughout the project (e.g., ITD-0025). Paper forms completed throughout the project (See 210.03.03)
- Field notes used to capture project information (e.g., field books, field notes, project scratch sheets)

**210.03.01 Source Document Requirements.** Data must be collected and immediately recorded on an ITD approved source document. Data transferred from other sources will not be accepted (e.g., computer, whiteboard, contractor proprietary form).

The source document must be consistent with and match electronically submitted data, forms, and final reports. If the information captured on the source document does not match the electronically submitted data, remarks must be documented to establish clear justification for the difference in data, or be subject to rejection.

Create and correct hand written source documents using permanent blue or black ink to ensure the quality of reproduction. Corrections and amendments to source documents must follow criteria described in 203.03.02. All entries in the source document must be legible to individuals other than the author.

The Contractor and its subcontractors must save, maintain, and make source documents available (upon Department request) for a minimum of 5 years from the date of the final voucher. All source documents, regardless of form or format, must be maintained in their entirety, and no document or entry may be deleted from the record during the retention period.

Source documents are to be made available immediately, at Department request, for auditing and verification at any time during working hours (e.g., project work, office hours). It is the Contractor's responsibility to maintain appropriate records and backups of any project document that has been submitted to the Department.

Source documents not used for material acceptance will be electronically submitted at the end of each workday. Original paper versions of source documents must be submitted before project closeout.

1. Source document submittals can be photo copies or images of the source document submitted in .pdf or .jpeg, but will not be considered the official source document.
2. Electronically submitted source documents do not replace the original source document or the original source document retention requirement.

Source documents used for material acceptance:

1. Data must only be initially recorded on ITD-provided source documents (See 210.03.03).
2. Source documents must be electronically submitted before submitting test results. Original paper versions of source documents must be preserved and available for Department audit for a minimum of 5 years after project closeout.
3. Sample information and chain of custody must be complete or the source document and associated sample will be subject to rejection.
4. All required information on the source document must be complete and legible or the source document and associated tests will be subject to rejection.

## 5. Re-testing

- a) Re-test data is required if any re-testing is performed.
  - b) Re-testing completed without remarks will be subject to rejection. The re-testing remarks must clearly illustrate the reason for re-testing or be subject to rejection. If a re-test is rejected, values recorded from the original test will be the official values used.
  - c) If additional space is required for remarks:
    - i) Attach additional documentation with remarks to the source document.
    - ii) Note additional documentation attached in the remarks field.
    - iii) Note test method, remarks made by, time and date on the attached document.
    - iv) Include attached document with daily source document submittals.
6. A source document may be noted as invalidated or subject to invalidation by project and department personnel (e.g., tester, checker, project manager, Engineer) with knowledge of the testing being conducted. The reason for invalidating or recommending invalidation will be documented. Reasons for invalidating a test may be due to incomplete, illegible, inaccurate, or missing data, improper following of test procedures, or human error (e.g., dropped the pan of material on the floor). The final determination of whether or not the test is used in acceptance will be at the Engineer's discretion based on the reason(s) for invalidating the test. The Engineer will document the final determination.
7. All source documents used in material acceptance that are invalidated will be submitted to the Departments Independent Assurance inspector. Invalidated tests may be submitted by the IA to the STQC.
8. If Department-completed source documents (e.g., Department test results) used for non-statistical based pay items are invalidated as determined by the Engineer, due to incomplete, illegible, inaccurate, or missing required information, basis of payment will default to the contracted amount at no greater than a 1.0 pay factor, and will be submitted, by Department Independent Assurance, to the STQC for review.
9. If the Department-completed source documents used for statistical based pay are invalidated as determined by the Engineer, testing will be performed on the dispute resolution samples and those results will be the official results used for payment on that lot. An invalidated Contractor QC test does exclude the Contractor from dispute resolution.

**210.03.02 Corrections and Amendments to Source Documents.** When an error is made in a test record entry, the original entry must not be obliterated. The inaccurate (superseded) information must still be legible.

The correction must indicate the reason for the correction, and the correction entry must be dated and initialed by the person making the revision. Examples of reasons for incorrect entries may include “transposed numbers”, etc. The contents of the test record must not otherwise be edited, altered, or removed.

1. Documents created in paper format:
  - a) Do not cover the original entries when correcting information on a source document.
  - b) If information in a paper record is corrected or revised, draw a single line through the incorrect entry and annotate the record, including the date and the reason for the revision, and initials of the person making the revision.
2. Documents created in electronic format:
  - a) Add an addendum to the electronic document indicating the corrected information, the identity of the individual making the addendum.
  - b) Preliminary versions of transcribed documents may be edited by the author before signing. A transcriber may also make changes when a non-testing error is discovered before signing (e.g., wrong work type, wrong WAQTC number).
  - c) Once a transcribed document is final, it can only be corrected in the form of an addendum affixed to the final copy as indicated above. Examples of documentation errors that are corrected by addendum include: wrong weights or sample locations, duplicate documents, or incomplete documents. The amended version must be reviewed and signed by the Engineer.
3. When a pertinent entry was missed or not entered in a timely manner, the author must meet the following requirements:
  - a) Identify the new entry as a “late entry”
  - b) Enter the current date and time – do not attempt to give the appearance that the entry was made on a previous date or an earlier time. The entry must be signed by the person making the entry.
  - c) Identify or refer to the date and circumstance for which the late entry or addendum is written.
  - d) For documents created in electronic format attach an addendum as described in paragraph 2.

**210.03.03 Forms.** The Contractor and the Department will utilize the following paper forms as original source documentation.

- ITD 0888 (Production Test For Plant Produced Mix (Loose))
- ITD 0855 (Compaction Report for Plant Mix Pavement Production)
- ITD 0916 (Aggregate Data Sheet)



**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.

**All test results and source documents must be submitted to the Department regardless of whether the results are passing or failing.** 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 *do not* apply for any material that is subject to statistically based acceptance. 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 and maintain all source documentation, 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 feet 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 Department's 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.** A Department 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 Materials 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 Department's Sampler Tester Qualification Committee (STQC) for action.

**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 Materials Laboratory Radiation Safety Officer (RSO).

**Table 220.01.1 Materials, Sample Size and Container for Shipping**

MATERIAL	MINIMUM SAMPLE SIZE	SAMPLING METHOD	TYPE OF CONTAINER <sup>1</sup>
AGGREGATES:			
Preliminary Base and Surfacing	400 lb.	All aggregates will be sampled according to FOP for AASHTO R 90 / FOP for AASHTO R 76. Minimum mass of field samples will be based on the maximum nominal size of the aggregates. Samples for quality testing should be at least 60 lb. Single aggregate sacks must not contain more than 40 lb	Canvas Sacks or 5 gallon Plastic Buckets
F.A. for Concrete	30 lb.		
C.A. for Concrete	55 lb.		
P.C.C. Pavement Design (Pit Run)	1,500 lb.		
P.C.C. Pavement Design (Crushed)	500 lb. Coarse		
	300 lb. Fine		
Base Course <sup>2</sup>	80 lb.		
Surface Course	80 lb.		
Cover Coat Material	60 lb.		
Mineral Filler	25 lb.		
Special Backfill	60 lb.		
Borrow & Granular Borrow	60 lb.		
Blotter	30 lb.		
SUPERPAVE HMA JOB MIX FORMULA (Submitted by Contractor for Confirmation)	See 405.03	FOP for AASHTO R 66	<sup>1</sup> Screw Top Can
SUPERPAVE HMA	100 lb	FOP for AASHTO R 97	Cardboard Box of approximate equal dimensions
ASPHALTS:			
PG Binder	Three 1 qt containers	FOP for AASHTO R 66	<sup>1</sup> Screw Top Can
Emulsified Asphalts	1 qt	FOP for AASHTO R 66	<sup>1</sup> Screw Top Plastic Jar Glass or Plastic Bottle
Anti-Strip Additive	4 oz		
CONCRETE:			
Cement/Fly Ash/Silica Fume	1 gal	Idaho IR 143	<sup>1</sup> Cylinder Can
Cylinders	Set of 3	FOP for AASHTO T 23	<sup>1</sup> Cylinder Cans
Curing Compound	1 qt	Idaho IR 7	Metal Screw Top Can
Water	1 gal		Plastic Bottle
Concrete for Chlorides	15 grams pulverized	Idaho IR 128	New 20-Gram Plastic Vial

Quality Assurance		Sampling Procedures		220.00
GLASS BEADS	1- 50 lb Sack			Sack
JOINT MATERIAL	24 in. x full width			
LIME	1 gal	AASHTO T 218		Plastic bucket
METALS:				
Reinforcing Steel (All Grades, All Sizes)	Two - 36 in.	<div> <div></div> Field sample from shipments delivered to project. </div>		
Dowel Bars for Transverse Joints in Concrete Pavement	Two – Special cut by the supplier- Approximately 36 in.			
Tie Bars for Longitudinal Joints in Concrete Pavement	Two - At least 30 in.			
Prestressing Reinforcement	60 in. Length each heat number	<div> <div></div> See Section 230.03.02 </div>		Ship Straight (do not kink or bend)
Welded Wire Fabric	24 in. Square			Ship Flat
PAINT				
Waterborne	1 qt	Idaho IR 7		Plastic Screw Top Can or Lined Metal Friction Top Can
Solvent	1 qt	Idaho IR 7		Lined Metal Friction Top Can
PIPE:				
Galvanized Coating (Steel Sheet)	2 in. Square	AASHTO M 36		Cardboard Box
SALT	10 lb	ASTM D632		<sup>1</sup> Plastic Wide Mouth or Cylinder Can
SEALANTS (SILICONE)	1 qt			
SOIL & SOIL AGGREGATE MIX				
pH & Resistivity (T 288, T 289)	5 lb	AASHTO R 13		Sealed Non-Metallic Container
Soil Classification (M 145)	5 lb	AASHTO R 13		Sealed Non-Metallic Container
pH & Resistivity & Soil Classification (T 288, T 289, M 145*)	5 lb	AASHTO R 13		Sealed Non-Metallic Container
‘R’ Value, Soil Classification, pH & Resistivity (IT 8, M 145*, T 90, T 176, T 288, T 289)	26 lb	AASHTO R 13		Sack/ Canvas Bag
Complete Soils Tests (IT 8, M 145*, T 99, T 180. T 100, T 176, T 288, T 289)	50 lb	AASHTO R 13		Sack/ Canvas Bag

Quality Assurance		Sampling Procedures		220.00
Complete Soils Tests Plus Permeability (IT 8, M 145*, FOP for T 99/T180,T 100, T 176, T 288, T 289, T 215)		100 lb	AASHTO R 13	2 Sacks/ Canvas Bags
Complete Soils Tests Plus Resilient Modulus (IT 8, M 145*, FOP for T 99, FOP for T 180, T 100, FOP for T 176, T 288, T 289, T 307)		100 lb	AASHTO R 13	2 Sacks/ Canvas Bags
*Note M 145 requires T 88, T 89, T 90 for Classification				
GEOSYNTHETICS				
Geotextiles	At least 6 LF across the entire roll width		See Section 230.09	
Biaxial Geogrids	At least 6 LF across the entire roll width		See Section 230.09	
Uniaxial Geogrids	At least 15 LF across the entire roll width		See Section 230.09	

<sup>1</sup>Standard ITD Supply Inventory item; do not re-use a sample container; all sample containers must be new.

<sup>2</sup>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 must be done strictly in accordance with the specified procedures. Any deviations from specified procedures must be documented and clearly communicated to the Department. Standard testing procedures have been developed by organizations such as AASHTO, ASTM, AWS (American Welding Society), WAQTC, and the Department.

Section 590.00 is the Department's 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 District Materials Engineer, with the assistance of Construction/Materials, and the Central Materials 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. Certifications are source documents.

**230.01 General Provisions.** Standard Department 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 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 Department's Qualified Products List (QPL) Program can supply cement and/or fly ash to Department projects by certification. The Central Materials 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 Materials 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 Materials Laboratory 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 Materials 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 Materials 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 Department's Laboratory Operations Manual.

**230.02.01.02 Cement Testing Appeal Process.** The Central Materials 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 Department's 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 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 Materials 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 Materials Laboratory 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 Material 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 Department's Laboratory Operations Manual.

**230.02.02.02 Fly Ash Testing Appeal Process.** The Central Materials 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 Materials 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 Materials Laboratory should be consulted for the correct sampling technique.

Samples must be promptly shipped or delivered to the Central Materials Laboratory within 2 business 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.

Q# 13. Does Buy America apply to recycled steel?

A# 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.
6. Reinforcing samples – Rebar, Strand, Misc. connections/parts with ITD-914, ITD-1044, and all Manufactures Mill Analysis/Certifications.

The Department requires 5 business 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 Materials 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 Materials 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-2 – Asphalt Storage, states "make provisions for measuring and sampling contents of the 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 Materials Laboratory for testing no later than 30 calendar 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 Materials 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 Materials 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 Materials 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.** All seed bags (Department or Contractor-supplied) must have the analysis (certification) tag attached and secured to each bag or container. Seed should be retested if seed tests are older than 9 months of the target seeding date.

**230.12.01 Contractor Furnished Seed.** Provide official certification tags with tests results for each seed species and verify it meets the contract specifications. 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.

**230.12.02 Department Furnished Seed.** 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.

**230.12.03 Seed Sampling and Testing.** 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**

<b>Material</b>	<b>Standard Specification Section</b>
Bearing Pads and Plates	507
Brick and Blocks, Masonry	Miscellaneous
Bridge Rail, Metal	504
Concrete, Rapid Set	Special Contract Provision
Delineators and Mileposts	617
Dowel Bars and Tie Bars for Concrete Pavement	409, 503, 510, 609, 611
Dust Oil	Miscellaneous
Electrical	Miscellaneous
Epoxies	Miscellaneous
Epoxy Patch	Miscellaneous
Guard Rail and Posts	612
H-Beam Piles	505
Illumination Poles and Bases	619
Joint Sealants and Sealers	409, 502, 625
Paint (only small quantities less than 25 gallons (100L))	504, 505, 627
Sewers (Storm and Sanitary)	605
Signs and Posts	616
Steel Shell Piling	505
Structural Bolts	504
Timber (Structural)	609, 612, 616
Traffic Signal Poles and Mast Arms	656

## **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 Materials Laboratory Intranet page or on a list obtained from the Central Materials 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 Materials 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 Materials Laboratory for testing. Allow 30 calendar 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, manufacturers, 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 Materials 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 2020. The supplier will submit, on an annual basis, a Quality Assurance Plan to the Central Materials 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 Engineer. The Engineer in conjunction with the District Materials Engineer, the Construction and Materials section, and the Central Materials Laboratory will evaluate the mix design in accordance with Idaho IR 151. 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 B Mix Design 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 Idaho IT-150

The Engineer will provide the Contractor written approval or rejection of the Mix Design within 5 business days after receiving the full submittal package. .

The Contractor, or a designated representative, must perform a Superpave HMA mix design in accordance with Idaho IR-150. The Asphalt Institute publication "Asphalt Mix Design Methods," (MS-2), is available at [www.asphaltinstitute.org](http://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  $N_{design}$ .

The Superpave Mix Design Technician (SPMDT) must maintain current qualifications for all test procedures performed during the mix design as shown in Idaho IR-150. 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.

**260.01.02 Volumetric Properties of Asphalt Mixtures.** All mix designs prepared for the Department must follow AASHTO R 35, Standard Practice for Superpave Volumetric Design for Asphalt Mixtures and this section covers the procedures of determining volumetric properties. WAQTC TM 13 Volumetric Properties of Hot Mix Asphalt (HMA) defines the procedure used to determine air voids ( $P_a$  or  $V_a$ ), voids in mineral aggregate (VMA), voids filled with asphalt binder (VFA), effective asphalt binder content ( $P_{be}$ ), and Dust to Binder Ratio ( $P_{\#200}/P_{be}$ ) or DP.

**260.01.03 Information in Addition to TM 13.** The following is in addition to the information contained in TM 13 and is from sources common to the HMA industry. These items require further definition because TM 13 does not cover it or does not provide the desired detail. Asphalt Institute MS-2, 7<sup>th</sup> 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 of each stockpile.

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).

Note: This uses the Weighted Harmonic Mean and NOT the Weighted Arithmetic Mean. (See AI MS-2)

**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.



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

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)

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

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 is assumed as 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.

$$P_{ba} = water\ absorption \times 0.667$$

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

$$G_{sb(RAP)} = \frac{G_{se(RAP)}}{\left( \frac{P_{ba(RAP)} \times G_{se(RAP)}}{100 \times G_b(RAP)} \right) + 1}$$

**Air Voids,  $P_a$ :** MS-2, 7<sup>th</sup> 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.

**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.** The Central Materials 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 Department's Standard Specifications.

**260.02.01.01 Items Provided to the Central Materials Laboratory.** The Central Materials Laboratory must receive the following items before the concrete mix design confirmation process will be initiated. All samples submitted to Central Materials Laboratory must be accompanied by a completed ITD-1044 form. These items must be submitted 60 calendar 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 85, 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 Materials 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 (e.g., cement content, air, slump, compressive strength). 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.

The Central Materials 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 Materials Laboratory unless otherwise agreed to in writing:

1. Add coarse aggregate,  $\frac{3}{4}$  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  $\frac{1}{4}$  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 Materials Laboratory may conduct AASHTO T 303 (modified) testing using the proposed mitigation admixtures to confirm the Contractor's testing.

**260.02.01.03 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 Materials 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 Materials Laboratory.

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

ITD-907 4-90



## CONCRETE MIX DESIGN REVIEW FOR STRUCTURAL OR PAVEMENT DESIGN SHEET 1 OF 1

Example

PROJECT NO. IR-84-2(0.35)95 COUNTY ELMORE  
 CONCRETE SUPPLIER ACME SOURCE NO. EL-116  
 CONTRACT ITEM NO. 409 CONCRETE, CLASS 45 (5600/28 day)  
 CONCRETE MIX DESIGN NO. 3 DATE 7/14/97

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

% SAND =  $\frac{M_c - M}{M_c - M_s}$  = R = 34.5 % or W/C = 0.40

## ABSOLUTE VOLUME METHOD for DESIGN of CONCRETE

YIELD = 27 CU. FT./CU. YD. = 27,000 C.F. = Y  
 WATER = GAL./CU. YD. ÷ 7.48 = 3,743 C.F. = W  
 CEMENT =  $\frac{LB./C.Y.}{3.15 \times 62.4}$  = 467 C.F. = C  
 FLY ASH =  $\frac{LB./C.Y.}{196.56}$  = 116 C.F. = FLY ASH  
 Y =  $\frac{SP.GR. \times 2.240 \times 62.4}{1}$  = 27,000 C.F. =  
 AIR = Y X % AIR at max. 7% = 1,897 C.F. = A  
 W + C + FLY ASH + A = 8,837 C.F.  
 Y - (W + C + FLY ASH + A) = 18,161 C.F. = C.A. + F.A.  
 (C.A. + F.A.) X R = 6,266 C.F. = F.A.  
 (C.A. + F.A.) - F.A. = 11,895 C.F. = C.A.

COARSE = C.A. X SP. GR. X 62.4 = 1908 LB. (BATCH/SSD) \*  
 FINE = F.A. X SP. GR. X 62.4 = 1020 LB. (BATCH/SSD) \*  
 BLEND SAND X SP. GR. X 62.4 = — LB. (DRY/SSD) \*

## CORRECTION FOR ABSORPTION

% ABSORP. X LB. C.A. = 22.7 LB. WATER  
 % ABSORP. X LB. F.A. = 18.4 LB. WATER  
 BLEND SAND = — LB. WATER  
 INCREASE THE MIXING WATER BY THE  
 SUM OF THESE THREE = 41.3 LB. WATER

\* CROSS OUT EITHER DRY OR SSD AS APPROPRIATE.  
 FINAL ACCEPTANCE IS CONTINGENT UPON ACCEPTANCE OF AIR CONTENT, SLUMP AND STRENGTH.

COMPUTED BY D.T. CHECKED BY M.L. DATE 7/14/97

AGGREGATE BULK SPECIFIC GRAVITY ( <del>BATCH</del> ) OR (SSD) *	% ABSORP.	LABORATORY NUMBERS	% BLEND EACH SIZE
COARSE..... = <u>2.57</u>	<u>1.2</u>	CRSE. _____	_____
FINE..... = <u>2.61</u>	<u>1.8</u>	CRSE. _____	_____
		FINE _____	_____
BLEND SAND= _____		FINE _____	_____

BASIC BATCH WEIGHTS FOR A CUBIC YARD BATCH	BATCH WEIGHTS CORRECTED FOR		BATCH WEIGHT
	ABSORPTION	MOISTURE	
CEMENT .. <u>467</u> LB.	<u>467</u> LB.	<u>—</u> LB.	<u>467</u> LB.
FLY ASH .. <u>116</u> LB.	<u>116</u> LB.	<u>—</u> LB.	<u>116</u> LB.
WATER .... <u>234</u> LB.	<u>275</u> LB.	<u>—</u> LB.	<u>275</u> LB.
COARSE .. <u>1908</u> LB. (BATCH/SSD) *	<u>1885</u> LB.	(X) <u>—</u> LB.	<u>1885</u> LB. (DRY) (SSD) *
FINE ..... <u>1020</u> LB. (BATCH/SSD) *	<u>1002</u> LB.	(Z) <u>—</u> LB.	<u>1002</u> LB. (DRY) (SSD) *
BLEND SAND <u>—</u> LB. (DRY) (SSD) *	<u>—</u> LB.	<u>—</u> LB.	<u>—</u> LB. (DRY) (SSD) *

## DETERMINATION OF THE YIELD

TOTAL BATCH WEIGHT (DESIGN) = 3,745 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)  
 WT./CU. FT. FRESH CONC. = 0.999 RELATIVE YIELD.  
 VOLUME OF CONCRETE PRODUCED = 0.999 RELATIVE YIELD.  
 NUMBER OF YARDS X 27

## CORRECTION FOR MOISTURE CONTENT

% MOISTURE IN C.A. X LB. COARSE AGGR. = — LB. WATER (X)  
 % MOISTURE IN F.A. X LB. FINE AGGR. = — LB. WATER (Z)  
 DECREASE THE MIXING WATER BY THE  
 SUM OF THESE TWO = — LB. WATER  
 INCREASE THE WEIGHT OF THE C.A. BY (X).  
 INCREASE THE WEIGHT OF THE F.A. BY (Z).

**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.

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

Refer to Subsection 106.09, Material Sources, in the Department's 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.

**265.04 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.** The following tables outline the minimum testing and acceptance (MTR) requirements for materials incorporated into Department construction projects and are a part of the Department's 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 Materials 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 Materials 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.

Sampled By and Tested By columns of the table specify who would normally perform these functions. The term "ITD Project Personnel" is utilized throughout this manual. Historically, all construction inspection and testing has been performed by ITD technicians; however, due to increasing work load and a decreasing number of construction technicians, the Department is utilizing private engineering firms to perform a portion of the construction inspection and testing. Therefore, when reference is made to "ITD Project Personnel", this refers to either an individual working for the Department or an appointed representative paid by the Department. In addition, some Tested By functions specified as the Central Materials Laboratory and or District Lab may be performed by either one or by a qualified, approved non-ITD entity.

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 radiuses, cores are required as specified in the Standard Specifications 405.03.O 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**

Item	Quantity
Asphalt (Emulsified)	2000 gallons; (8 tons)
Asphalt (PG Binder)	22 Tons
Cement, Lime, Fly ash	40 cubic yards of concrete placed
Geotextiles	1,000 square yards

**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
- Asphaltic ditches and slopes
- Material behind guardrail and for guardrail terminals
- Asphaltic 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 (including portable barriers installed permanently and cable barriers), all other terminals (including flared terminals, terminals installed on a flare, buried-in-backslope terminals, double-sided or median terminals, and cable barrier terminals), sign supports, and all other breakaway hardware

For projects utilizing December 2018 Standard Drawings release or earlier, replace the 612 series sheets with the 612 series from the latest Standard Drawings release.

Temporary work zone devices (including portable barriers, truck- and trailer-mounted attenuators, portable changeable message signs (PCMS), temporary traffic signals, and camera trailers) manufactured after December 31, 2019, must have been successfully tested to the 2016 edition of MASH. Such devices manufactured on or before this date, and successfully tested to NCHRP Report 350 or the 2009 edition of MASH, may continue to be used throughout their normal service lives.

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

**Table 270.09: MTR Table Sections**

MTR Table Section	Standard Specification Section
270.10	200 Earthwork
270.20	300 Bases
270.30	400 Surface Courses and Bituminous Pavement
270.40	409 Portland Cement
270.50	500 Structures
270.60	600 Incidental Construction

See Section 270.01 for content of the tables.



BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS
TYPE OF CONSTRUCTION		SAMPLED BY	TESTED BY			
STANDARD SPECIFICATION SECTION: 205 EXCAVATION AND EMBANKMENT						
Excavation, Class C Compaction  Excavated to top of subgrade or below Natural ground under embankments	ACCEPTANCE In-Place Density (1)	205.03-F	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	ITD-850	Each 5,000 SY.	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
	INDEPENDENT ASSURANCE In-Place Density	ITD Project Personnel	ITD Project Personnel			
	INDEPENDENT ASSURANCE In-Place Density	IA Inspector	IA Inspector	ITD-857	1 observation per project	
Excavation  Subgrade Embankment Fill	ACCEPTANCE In-Place Density (1)	205.03-F	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	ITD-850	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.	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
	INDEPENDENT ASSURANCE In-Place Density	ITD Project Personnel	ITD Project Personnel			
	INDEPENDENT ASSURANCE In-Place Density	IA Inspector	IA Inspector	ITD-857	1 observation per project	
(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.						

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	BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS	
	TYPE OF CONSTRUCTION		SAMPLED BY	TESTED BY				
205-2	Borrow	ACCEPTANCE In-Place Density (1)	205.03 -F	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	ITD-850	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.	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	
	Subgrade Embankment Fill		ITD Project Personnel	ITD Project Personnel				
		INDEPENDENT ASSURANCE In-Place Density	IA Inspector	IA Inspector	ITD-857	1 observation per project		
	Granular Borrow	ACCEPTANCE In-Place Density (1)	205.03 -F	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	ITD-850	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.	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	
	Subgrade Embankment Fill		ITD Project Personnel	ITD Project Personnel				
		INDEPENDENT ASSURANCE In-Place Density	IA Inspector	IA Inspector	ITD-857	1 observation per project		
		ACCEPTANCE Sand Equivalent (2)	205.02	FOP for AASHTO T 27 FOP for AASHTO T 11 FOP for AASHTO T 176 Alt. Method 2, Mechanical	ITD-901	Each 10,000 CY	Sand equivalent requirements do not apply to Recycled Asphalt Pavement (RAP) used as granular borrow.	
			ITD Project Personnel	ITD Project Personnel				
		INDEPENDENT ASSURANCE Sand Equivalent	IA Inspector	IA Inspector	ITD-857	Each 200,000 CY		
	Soft Spot Repair	ACCEPTANCE In-Place Density (1)	205.03 -E	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	ITD-850	Each repair area or combination of areas but not less than each 300 SF		
			ITD Project Personnel	ITD Project Personnel				
	(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.							

BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS
TYPE OF CONSTRUCTION		SAMPLED BY	TESTED BY			
STANDARD SPECIFICATION SECTION: <b>209 – SMALL DITCHES</b>						
Small Ditches	ACCEPTANCE In-Place Density (1)	205.03 -F 209.03	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	ITD-850	1 per project	Testing required only when constructed upon dikes per Standard Specification Subsection 209.03.
When constructed upon dikes		ITD Project Personnel	ITD Project Personnel			
	INDEPENDENT ASSURANCE In-Place Density	IA Inspector	IA Inspector	ITD-857	1 observation per project	
(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.						

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BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS	
		SAMPLED BY	TESTED BY				
TYPE OF CONSTRUCTION							
210	STANDARD SPECIFICATION SECTION: <b>210 – COMPACTING BACKFILL</b>						
	Compacting Backfill  (Structure Backfill)	ACCEPTANCE  In-Place Density (1)	210.03	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	ITD-850	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.	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
			ITD Project Personnel	ITD Project Personnel			
		INDEPENDENT ASSURANCE  In-Place Density	IA Inspector	IA Inspector	ITD-857	1 observation per project	
	Compacting Backfill  (Pipe Backfill)	ACCEPTANCE  In-Place Density (1)	210.03	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	ITD-850	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.
			ITD Project Personnel	ITD Project Personnel			
		INDEPENDENT ASSURANCE  In-Place Density	IA Inspector	IA Inspector	ITD-857	1 observation per project	
	Compacting Backfill  (Retaining Wall Backfill)	ACCEPTANCE  In-Place Density (1)	210.03	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	ITD-850	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
			ITD Project Personnel	ITD Project Personnel			
		INDEPENDENT ASSURANCE  In-Place Density	IA Inspector	IA Inspector	ITD-857	1 observation per project	
	(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.						

BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS
TYPE OF CONSTRUCTION		SAMPLED BY	TESTED BY			
STANDARD SPECIFICATION SECTION: <b>212 – EROSION AND SEDIMENT CONTROL</b>						
Slope Drain	ACCEPTANCE Certification	212.03-B 706		ITD-914 with mill test report attached for steel/iron ITD-851 (All other material)	Total Quantity Paid	See QA Manual Section 230.01 and Section 230.03 If Specification requires removal then ITD-914 is not required
		Manufacturer	Manufacturer			
Fiber Wattles	ACCEPTANCE Certification	711.20		ITD-851	Total Quantity Paid	Certified noxious weed-free grain straw
		Manufacturer	Manufacturer			
Sediment Trap	ACCEPTANCE (Erosion Control Geotextile) Certification	212.03-B		ITD-849	Total Quantity Paid	See QA Manual Section 230.09
		Manufacturer	Manufacturer			
Silt Fence	ACCEPTANCE Certification	212.03-B 718.09		ITD-849	Total Quantity Paid	See QA Manual Section 230.09
		Manufacturer	Manufacturer			
Diversion Channels and Ditches	ACCEPTANCE Inspection	212.03-B		ITD-854	Total Quantity Paid	RE Letter-See QA Manual Section 250.00
		No sample required	No testing required			
	ACCEPTANCE Certification	212.03-B		ITD-849 (When Erosion Control Geotextile used)	Total Quantity Paid	See QA Manual Section 230.09
		Manufacturer	Manufacturer			
Dikes and Berms	ACCEPTANCE Inspection	212.03 -B		ITD-854	Total Quantity Paid	RE Letter-See QA Manual Section 250.00
		No sample required	No testing required			
Open-top Culvert	ACCEPTANCE Inspection	212.03-B		ITD-854	Total Quantity Paid	RE Letter-See QA Manual Section 250.00
		No sample required	No testing required			
Water Bar	ACCEPTANCE Inspection	212.03-B		ITD-854	Total Quantity Paid	RE Letter-See QA Manual Section 250.00
		No sample Required	No testing Required			

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	BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS
	TYPE OF CONSTRUCTION		SAMPLED BY	TESTED BY			
212-2	Siltation Berm	ACCEPTANCE Inspection	212.03-B No sample Required	No testing Required	ITD-854	Total Quantity Paid	RE Letter-See QA Manual Section 250.00
	Stabilized Construction Entrance	ACCEPTANCE Inspection	212.03-B No sample Required	No testing Required	ITD-854	Total Quantity Paid	RE Letter-See QA Manual Section 250.00
		ACCEPTANCE (Erosion Control Geotextile) Certification	212.03-B Manufacturer	Manufacturer	ITD-849	Total Quantity Paid	See QA Manual Section 230.09
	Soil Binder	ACCEPTANCE Certification	212.03-B Manufacturer	Manufacturer	ITD-851	Total Quantity Paid	Certification of non-toxic properties
	Gabion	FOLLOW MTR TABLE STANDARD SPECIFICATION SECTION 512					
	Revet Mattress	FOLLOW MTR TABLE STANDARD SPECIFICATION SECTION 512					
	Stone Filter Berms/Dams	ACCEPTANCE	212.03-C Permanent Measures		ITD-854	Total Quantity Paid	RE Letter-See QA Manual Section 250.00
		Inspection	No sample required	No testing required			
	Sediment Basin	ACCEPTANCE	212.03-C Permanent Measures		ITD-854	Total Quantity Paid	RE Letter-See QA Manual Section 250.00
		Inspection	No sample required	No testing required			



BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS
		SAMPLED BY	TESTED BY			
STANDARD SPECIFICATION SECTION: 301- GRANULAR SUBBASE						
Aggregate	ACCEPTANCE	301.02 703.11	FOP for AASHTO R 90 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.
	Gradation(1) Sand Equivalent		ITD Project Personnel			ITD Project Personnel
	INDEPENDENT ASSURANCE	IA Inspector	IA Inspector	ITD-857	Each 100,000 Tons	Moisture percent required for payment only
	Gradation Sand Equivalent					
(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	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.
	In-Place Density	ITD Project Personnel	ITD Project Personnel			
	INDEPENDENT ASSURANCE	IA Inspector	IA Inspector	ITD-857	1 observation per project	
	In-Place Density					
Recycled Asphalt Pavement	ACCEPTANCE	301.02	Visual Inspection	ITD-854	Each 5,000 Tons	
	Gradation	ITD Project Personnel	ITD Project Personnel			
	ACCEPTANCE	301.03	FOP for AASHTO T 310 Method B modified	ITD-854	Each 7,200 SY but not less than 1 test each lift	
	In-Place Density	ITD Project Personnel	ITD Project Personnel			

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BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS	
		SAMPLED BY	TESTED BY				
302	STANDARD SPECIFICATION SECTION: 302 – EMULSION TREATED BASE						
	Emulsified Asphalt	ACCEPTANCE Certification	702.03 702.05		Loading Certificate	Each shipment to the project	See QA Manual Section 230.11
			Manufacturer	Manufacturer			
		ACCEPTANCE Saybolt Viscosity Field Test	702.03	Idaho IT 61	ITD-1045	Test each load for Saybolt viscosity. <b>Reject failing loads.</b>	Do not sample emulsions from storage tank discharge lines.
			ITD Project Personnel	ITD Project Personnel			
		VERIFICATION Laboratory Tests <sup>(1)</sup>	702.03	FOP for AASHTO R 66 AASHTO T 59	ITD-1045	1 undiluted sample per project	<sup>(1)</sup> No samples for laboratory testing required when total project quantity is less than 2,000 Gal (8 tons).
			ITD Project Personnel	ITD Central Materials Laboratory			
	Aggregate (prior to mixing)	ACCEPTANCE Gradation Sand Equivalent Fracture Count	302.02 703.04	FOP for AASHTO R 90 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	ITD-901	Each 700 CY or 1,000 Tons	Acceptance at point of delivery prior to mixing. Moisture percent required for payment only
				ITD Project Personnel			
		INDEPENDENT ASSURANCE Gradation Sand Equivalent Fracture Count	IA Inspector	IA Inspector	ITD-857	Each 14,000 CY or 20,000 tons	
	Compacted Roadway	ACCEPTANCE In-Place Density	302.03	FOP for AASHTO T 310 Method B	ITD-850	Each 700 CY or 1,000 Tons	
			ITD Project Personnel	ITD Project Personnel			
		INDEPENDENT ASSURANCE In-Place Density	IA Inspector	IA Inspector	ITD-857	1 observation per project	

BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS
		SAMPLED BY	TESTED BY			
STANDARD SPECIFICATION SECTION: 303 – AGGREGATE BASE						
Aggregate	ACCEPTANCE  Gradation Sand Equivalent Fracture Count	303.02 703.04	FOP for AASHTO R 90 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	ITD-901	Each 700 CY or 1,000 Tons	Acceptance from windrow or roadway.  Moisture percent required for payment only
		ITD Project Personnel	ITD Project Personnel			
		INDEPENDENT ASSURANCE  Gradation Sand Equivalent Fracture Count	IA Inspector	IA Inspector	ITD-857	Each 14,000 CY or 20,000 tons
Compacted Roadway	ACCEPTANCE  In-Place Density	303.02	FOP for AASHTO T 310 Method B	ITD-850	Each 700 CY or 1,000 tons	Contractor is responsible for providing an Idaho T 74 density curve.
		ITD Project Personnel	ITD Project Personnel			
		INDEPENDENT ASSURANCE  In-Place Density	IA Inspector	IA Inspector	ITD-857	1 observation per project

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	BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS
			SAMPLED BY	TESTED BY			
304	STANDARD SPECIFICATION SECTION: 304 – RECONDITIONING						
	Pulverizing Roadbed	ACCEPTANCE Gradation	304.03	Visual Inspection	ITD-854	Prior to compaction each lane mile	
			ITD Project Personnel	ITD Project Personnel			
		ACCEPTANCE In-Place Density	304.03	FOP for AASHTO T 310 Method A modified (CRABS)	ITD-1866 or ITD-854	Establish roller pattern every lane mile.	Acceptance at roadway.
			ITD Project Personnel	ITD Project Personnel			
	Soft Spot Repair	ACCEPTANCE In-Place Density	205.03 D 304.03	FOP for AASHTO T 310 Method B	ITD-850	Each repair area or combination of areas but not less than each 1,500 SF	
			ITD Project Personnel	ITD Project Personnel			
307	STANDARD SPECIFICATION SECTION: 307 – OPEN-GRADED BASE						
	Aggregate	ACCEPTANCE Gradation <sup>(1)</sup>	703.08	FOP for AASHTO R 90 FOP for AASHTO R 76 FOP for AASHTO T 27	ITD-901	Each 1,800 CY or 2,500 Tons	Acceptance at Crusher Conveyor Belt  Reducing & wash method not required for Class I & II  Drying to constant mass is not required for Class I & II
			ITD Project Personnel	ITD Project Personnel			
		INDEPENDENT ASSURANCE Gradation	IA Inspector	IA Inspector	ITD-857	Each 14,000 CY or 20,000 Tons	Field Test samples will be used for IA evaluation. No split samples required.
		ACCEPTANCE In-place Density	307.03	Method Specification	ITD-850	Each 3,000 LF but not less than once per day	
			ITD Project Personnel	ITD Project Personnel			
	<sup>(1)</sup> The minimum test sample mass for FOP for AASHTO T27 Sieve Analysis will be 65 lb. for Class 1, 50 lb. for Class II and 25 lb. for Class III.						

BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS
		SAMPLED BY	TESTED BY			
STANDARD SPECIFICATION SECTION: 308 - CEMENT RECYCLED ASPHALT BASE STABILIZATION (CRABS)						
Cement	ACCEPTANCE Certification	701.01	AASHTO M 85	Bill of Lading with chemical analysis attached	Weekly	See QA Manual Sections 230.02 and 230.02.01
		Manufacturer	Manufacturer			
Pulverizing Roadbed	ACCEPTANCE Gradation	308.03	Visual Inspection	ITD-854	Prior to compaction each lane mile	
		ITD Project Personnel	ITD Project Personnel			
Compacted Roadway	ACCEPTANCE In-Place Density	308.03	FOP for AASHTO T 310 Method A modified (CRABS)	ITD-850 ITD-1866	Verify the contractor met the density specification every lane mile or when mixture properties changes	Acceptance at roadway.
		ITD Project Personnel	ITD Project Personnel			

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BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS	
		SAMPLED BY	TESTED BY				
STANDARD SPECIFICATION SECTION: 401 - TACK COAT							
Emulsified Asphalt	ACCEPTANCE Certification	702.03 702.05		Loading Certificate	Each individual truck, trailer, car or shipment to the project.	See QA Manual Section 230.11	401
		Manufacturer	Manufacturer				
	VERIFICATION Laboratory Tests	702.03	FOP for AASHTO R 66 AASHTO T 59	ITD-1045	1 undiluted sample (as received from the asphalt supplier) per project	No samples required when total project quantity is less than 2,000 Gal 8 Tons.	
		ITD Project Personnel	ITD Central Materials Laboratory				
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: 402 - PRIME COAT							
Emulsified Asphalt	ACCEPTANCE Certification	702.03 702.05		Loading Certificate	Each individual truck, trailer, car or shipment to the project.	See QA Manual Section 230.11	402
		Manufacturer	Manufacturer				
	VERIFICATION Laboratory Tests	702.03	FOP for AASHTO R 66 AASHTO T 59	ITD-1045	1 undiluted sample (as received from the asphalt supplier) per project	No samples required when total project quantity is less than 2,000 Gal 8 Tons.	
		ITD Project Personnel	ITD Central Materials Laboratory				
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.							
Blotter	ACCEPTANCE Gradation	703.07 402.02	FOP for AASHTO R 90 FOP for AASHTO R 76 FOP for AASHTO T 27 FOP for AASHTO T 11	ITD-901	1 field gradation per source.	Sample at point of loading to the project.	
		ITD Project Personnel	ITD Project Personnel				
		STANDARD SPECIFICATION SECTION: 403 CHIP SEAL WARRANTY					
Warranty Seal Coat (Cover Coat Material)	ACCEPTANCE Certification	403	FOP for AASHTO T 27 FOP for AASHTO T 335 Method 1		1 test per 400 tons	Provide Quality control testing results for the Engineer's records.	403
		Contractor	Contractor				
Warranty Seal Coat (Blotter)	ACCEPTANCE Certification	403	FOP for AASHTO T 27 FOP for AASHTO T 335 Method 1		1 test per 400 tons	Provide Quality control testing results for the Engineer's records.	
		Contractor	Contractor				
Warranty Seal Coat	Design of Seal Coats	403	McLeod Method	The Contractor furnishes the Seal Coat Mix Design			
		Contractor	Contractor				
	FINAL ACCEPTANCE	403	McLeod Method	ITD 854	The Engineer will conduct a field review of the project the following April. Final acceptance and payment will be made based on the field review. RE Letter See QA Manual Section 250.00		
		ITD Project Personnel	ITD Project Personnel				

BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS
		SAMPLED BY	TESTED BY			
STANDARD SPECIFICATION SECTION: 404 SURFACE TREATMENT						
Asphalt & Cover Coat Material	Design of Seal Coats	404 703	Idaho IR 63		The Contractor furnishes the seal coat design.	Asphalt & Cover Coat Material
		ITD Project Personnel	ITD District Lab			
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.						
Emulsified Asphalt	ACCEPTANCE Saybolt Viscosity Field Test	702.03	FOP for AASHTO R 66 Idaho IT 61	ITD-1045	Test each load for Saybolt viscosity. If the district Saybolt viscosity result is outside specified limits, reject the load.	Do not sample emulsions from storage tank discharge lines.
		ITD Project Personnel	ITD Project Personnel			
	ACCEPTANCE Certification	702.03 702.05		Loading Certificate	Each individual truck, trailer, car or shipment to the project.	See QA Manual Section 230.11
		Manufacturer	Manufacturer			
	VERIFICATION Laboratory Tests	702.03	FOP for AASHTO R 66 AASHTO T 59	ITD-1045	Each 25,000 Gal or 100 Tons	No samples required when total project quantity is less than 2,000 Gal 8 Tons.
		ITD Project Personnel	ITD Central Materials Laboratory			
	INDEPENDENT ASSURANCE Viscosity Field Test	IA Inspector	IA Inspector	ITD-857	1 observation of Saybolt viscosity per project.	See QA Manual Sections 330.00 & 380.00
PG. Binder	ACCEPTANCE Certification	702.01 702.05		ITD-966 OR manufacturer certification	Initial lot & each new lot to project	See QA Manual Sections 230.10 & 255.00
		Manufacturer	Manufacturer	Loading Certificate	Each shipment to project	
	VERIFICATION Laboratory Tests	702.01	FOP for AASHTO R 66 AASHTO M 320	ITD-859 ITD-859AW (ITD-859AW is the Central Materials Laboratory Report)	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	No samples required when total project quantity is less than 22 tons
		ITD Project Personnel	ITD Central Materials Laboratory			



BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS
		SAMPLED BY	TESTED BY			
Anti-Strip Additive	ACCEPTANCE Presence of Anti-Stripping Additive	702.04	Idaho IT 99 (color method only)	ITD-859	Test the initial truck & trailer prior to unloading into the contractor's storage tank. Thereafter, test at same frequency as sampling of asphalt. Purge one gallon from the injection line valve before taking sample.	If anti-strip cannot be detected, the supplier must add the anti- strip on-site.
		ITD Project Personnel	ITD Project Personnel			
Cover Coat Material	ACCEPTANCE Gradation Cleanness Value Fracture Count	703.06	FOP for AASHTO R 90 FOP for AASHTO R 76 FOP for AASHTO T 27 FOP for AASHTO T 11 Idaho IT 72 FOP for AASHTO T335 Method 1	ITD-901	Each 280 CY or 400 Tons 26,000 yd <sup>2</sup>	Sample at point of loading to the roadway
		ITD Project Personnel	ITD Project Personnel			
	INDEPENDENT ASSURANCE Gradation Cleanness Value Fracture Count	IA Inspector	IA Inspector	ITD-857	Each 5,600 CY or 8,000 Tons .	
Blotter	ACCEPTANCE Gradation	703.07 404.02	FOP for AASHTO R 90 FOP for AASHTO R 76 FOP for AASHTO T 27 FOP for AASHTO T 11	ITD-901	1 field gradation per source.	Sample at point of loading to the project.
		ITD Project Personnel	ITD Project Personnel			
Choke Sand	ACCEPTANCE Gradation	703.07 404.02	FOP for AASHTO R 90 FOP for AASHTO R 76 FOP for AASHTO T 27 FOP for AASHTO T 11	ITD-901	1 per day	Sample at point of loading to the project.
		ITD Project Personnel	ITD Project Personnel			

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BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS
		SAMPLED BY	TESTED BY			
STANDARD SPECIFICATION SECTION: 405 - SUPERPAVE HOT MIX ASPHALT						
Performance Graded Binder	ACCEPTANCE Certification	702.01 702.05		ITD-966 OR manufacturer certification	Initial lot & each new lot to project	See QA Manual Sections 230.10
		Manufacturer	Manufacturer	Loading Certificate	Each shipment to project	
	VERIFICATION Laboratory Tests	FOP for AASHTO R 66 AASHTO M 320	FOP for AASHTO R 66	ITD-859 ITD-859AW (ITD-859AW is the Central Materials Laboratory Report)	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	No samples required when total quantity is less than 22 Tons See QA Manual Section 230.10
		ITD Project Personnel	TD Central Materials Lab			
Anti-Strip Additive	ACCEPTANCE Presence of Anti-Stripping Additive	702.04	Idaho IT 99	ITD-859	Test at same frequency as sampling of asphalt binder	If anti-strip cannot be detected, add additional anti- strip. The binder will be sampled and tested until a positive result is determined. (green or blue color)
		ITD Project Personnel	ITD Project Personnel			
Superpave HMA for Acceptance Test Strip	CONSTRUCTION of Test Strip by Contractor	405.03	Idaho IR 125	ITD-891 (Completed by Contractor)	2 locations per Test Section	Contractor establishes roller pattern.
	ACCEPTANCE (1) (Aggregate Cold Feed Samples) Sand Equivalent Fracture Flat and/or Elongated Particles Fine Aggregate Angularity	405.02 405.03H 405.03F 703.05	Idaho IR 125 FOP for AASHTO R 90 FOP for ASHTO 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	ITD-1046 ITD-772	**3 cold feed increments per test strip.	Random Samples per Idaho IR 125  (1)Combine cold feed increments into a composite sample to determine <u>test strip acceptance</u> .
		Contractor	ITD District Project Personnel			
		INDEPENDENT ASSURANCE	IA Inspector	IA Inspector	ITD-857	Each 15,000 Tons
**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.						

405-1

405-1

	BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS
			SAMPLED BY	TESTED BY			
405-2	Superpave HMA for Acceptance Test Strip (Cont.)	ACCEPTANCE (2) (Loose Mix Samples)	405.02 405.03-H 405.03-I	Idaho IR 125 FOP for AASHTO R 97 * 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)	ITD-773 ITD-772	3 per <u>test section</u> . Each sample must be at least 100 lb.	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 <u>test section</u> acceptance. (3) For calculating VMA use the combined aggregate bulk specific gravity, G <sub>sb</sub> , determined by the Engineer (4) For SP 3 and SP5 mixes only
		Air Voids					
		Asphalt Content					
		Gradation					
405-2	Superpave HMA for Acceptance Test Strip (Cont.)	Voids in Mineral Aggregate (VMA) (3)	Contractor	HQ Central Lab/District Lab	ITD-773 ITD-772	3 per <u>test section</u> . Each sample must be at least 100 lb.	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 <u>test section</u> acceptance. (3) For calculating VMA use the combined aggregate bulk specific gravity, G <sub>sb</sub> , determined by the Engineer (4) For SP 3 and SP5 mixes only
		Voids Filled With Asphalt (VFA)					
		Dust to Binder Ratio (DP)					
		Moisture Content					
405-2	Superpave HMA for Acceptance Test Strip (Cont.)	Rut Depth (4)					
		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 Materials Laboratory Manager for details: Phone: (208) 334-8453					
		INDEPENDENT ASSURANCE	IA Inspector	IA Inspector	ITD-857	Observation of loose mix testing performed by District Lab every 90 days.	

BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS	
		SAMPLED BY	TESTED BY				
STANDARD SPECIFICATION SECTION: 405 - SUPERPAVE HOT MIX ASPHALT							
Superpave HMA for Acceptance Test Strip (Cont.)	Density (5) GAUGE CORRELATION	405.03-L	Idaho IR 125 FOP for AASHTO T 355 Alt. Method No. 1 (Backscatter mode)	ITD-820	5 per <u>test section</u>	Use same cores that were taken for density acceptance.  (5) Each gauge to be used on the project for QC or acceptance testing must be correlated on the test strip.  Gauge readings for each core must be obtained at each test site prior to coring using each gauge.  Each gauge will have a unique correlation factor.  Form ITD-820 is completed for each gauge.	
		Contractor	Contractor and ITD District Project Personnel				
	ACCEPTANCE(6) Cores Density (Percent Compaction)	405.03-L	Idaho IR 125 FOP for AASHTO R 67 FOP for AASHTO T 166 Method A FOP for AASHTO T 331 ASTM D7227	ITD-892 ITD-772	5 per <u>test section</u> .	Random sample locations per Idaho IR 125  (6) Test section densities are calculated as the average percent compaction of all cores from the test section using the average G <sub>mm</sub> of the test section.	
		Contractor	ITD Project Personnel				
	INDEPENDENT ASSURANCE		IA Inspector	IA Inspector	ITD-857	Observation of core testing performed by Project Personnel every 90 days	

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	BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS
			SAMPLED BY	TESTED BY			
405-4	Production Paving SP2	ACCEPTANCE Loose Mix from Roadway	405.03	FOP for AASHTO R 97* FOP for AASHTO R 47 FOP for AASHTO T 329 FOP for AASHTO T 308 FOP for AASHTO T 30 FOP for AASHTO T 209 Bowl Method	ITD-833	Each 750 Tons Each sample must be at least 50 lb	Random sample locations  * See page 405-6  G <sub>mm</sub> results will be used in density determination below
		Asphalt Content Gradation Moisture G <sub>mm</sub>		ITD Project Personnel			
		INDEPENDENT ASSURANCE Sampling Asphalt Content Gradation Moisture	IA Inspector	IA Inspector	ITD-857	1 observation each project.	
		ACCEPTANCE Density (Percent Compaction)  (Density using correlated density gauge)	405.03	FOP for AASHTO T 355 Alt. Method No. 1 (Backscatter Mode)	ITD-855	Each 750 Tons	Test at random locations  . The G <sub>mm</sub> for determining the percent compaction will be determined using a rolling, consecutive 2-lot average (i.e., the most recent 2 completed lots) of the Department's G <sub>mm</sub> test results. For the first lot of production paving, the test strip G <sub>mm</sub> corresponding to the C-JMF is used for determining percent compaction.
			ITD Project Personnel	ITD Project Personnel			
		INDEPENDENT ASSURANCE Density (Percent Compaction)	IA Inspector	IA Inspector	ITD-857	1 observation each project	

BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS
		SAMPLED BY	TESTED BY			
Production Paving SP3, SP5	ACCEPTANCE Loose Mix from Roadway  Air Voids VMA Moisture	405.03	FOP for AASHTO R 97* FOP for AASHTO R 47 FOP for AASHTO T 329 FOP for AASHTO T 308 FOP for AASHTO T 166 Method A FOP for AASHTO T 331 FOP for AASHTO T 209 Bowl Method AASHTO T 269 FOP for AASHTO T 312	ITD-833 ITD-777	Each 750 Tons  Each sample must be at least 50 lb	Random Sample Locations  * See page 405-6
		ITD Project Personnel	ITD Project Personnel			
	INDEPENDENT ASSURANCE Sampling Air Voids VMA Moisture	IA Inspector	IA Inspector	ITD-857	1 observation each project.	Observation of the tests that are performed to calculate air voids, VMA, and Moisture
	ACCEPTANCE Density (Percent Compaction) (Density using correlated density gauge)	405.03	FOP for AASHTO T 355 Alt. Method No. 1 (Backscatter Mode)	ITD-855	Each 750 Tons	Test at random locations  The G <sub>mm</sub> for determining the percent compaction will be determined using a rolling, consecutive 2-lot average (i.e., the most recent 2 completed lots) of the Department's acceptance test results. For the first lot of production paving, the test strip G <sub>mm</sub> corresponding to the C-JMF is used for determining percent compaction.
		ITD Project Personnel	ITD Project Personnel			
	INDEPENDENT ASSURANCE Density (Percent Compaction)	IA Inspector	IA Inspector	ITD-857	1 observation each project	
Production Paving Non-structural and Temporary, except on NHS.***	ACCEPTANCE Certification	405.03		ITD-851	Total Quantity Paid	ITD Project Inspector documents visual inspection.
		Manufacturer	Manufacturer			
*** 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 <sub>mm</sub> ). Sampling will be by the Contractor; testing by the State.						

	BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS
			SAMPLED BY	TESTED BY			
405-6	Production Paving when an acceptance test strip is not required, <i>regardless of the class of SuperPave mix</i> and the total quantity is <u>greater than</u> one frequency.  Contractor will sample (Department will witness sampling) and ITD will test for acceptance	ACCEPTANCE Loose Mix from Roadway	405.03	FOP for AASHTO R 97 * FOP for AASHTO R 47 FOP for AASHTO T 329 FOP for AASHTO T 308 FOP for AASHTO T 30	ITD-833	Each 750 Tons	* See page 405-6 SP2 Specification Limits apply.
		Asphalt Content	ITD Project Personnel	ITD Project Personnel			
		Gradation					
		Moisture					
	INDEPENDENT ASSURANCE Sampling Asphalt Content Gradation Moisture	IA Inspector	IA Inspector	ITD-857	1 observation each project of more than 2,250 tons.		
	ACCEPTANCE Density (Percent Compaction)	405.03 405.03-L	FOP for AASHTO R 67 FOP for AASHTO R 97 * FOP for AASHTO T 166 Method A FOP for AASHTO T 331 FOP for AASHTO T 209 (Bowl Method) ASTM D7227	ITD-773 ITD-892	5 Stratified Random Cores per phase of project	* 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).	
Contractor		ITD Project Personnel					
Production Paving When an acceptance test strip is not required, <i>regardless of the class of SuperPave mix</i> and the total quantity is less than one frequency.	FOLLOW SECTION 270.04 ACCEPTANCE BY SMALL QUANTITIES Density acceptance will be determined from the average of cores.						
* The plate method is the primary method for obtaining samples from the roadway. For the lifts, less than 0.2', the samples may be obtained from the plant using an attached sampling device or sample from haul units.							



BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS	
		SAMPLED BY	TESTED BY				
Surface Smoothness	ACCEPTANCE Profiler	405.03-P	AASHTO R 57	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			
		Contractor	Contractor				
	VERIFICATION Profiler	405.03-P		ITD-854 ITD-769	Fully witnessed with report		
		ITD Project Personnel	ITD Project Personnel				
Pavement Reinforcement Fabric	ACCEPTANCE Certification	718.02 718.08		ITD-849 with QC test results attached	Total Quantity Paid	See QA Manual Section 230.09	405-7
		Manufacturer	Manufacturer				
	VERIFICATION Laboratory Tests	718.03 718.08	ASTM D4632 ASTM D4533 ASTM D6140	ITD-1044 (Sample Data) ITD-1047 (Lab Report)	1 sample from each manufacturer- identified lot for each type		
		ITD Project Personnel	HQ Central Lab				



BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS
		SAMPLED BY	TESTED BY			
STANDARD SPECIFICATION SECTION: 406 - ROAD MIX & 407 SCRUB COAT						
Aggregate	ACCEPTANCE Gradation Sand Equivalent Fracture Count	703 406.02 407.02	FOP for AASHTO R 90 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	ITD-901	Each 700 CY or 1,000 Tons	Sample at point of loading to the roadway
		ITD Project Personnel	ITD Project Personnel			
		INDEPENDENT ASSURANCE Gradation Sand Equivalent Fracture Count	IA Inspector	IA Inspector	ITD-857	Each 14,000 CY or 20,000 Tons .
Emulsified Asphalt	ACCEPTANCE Certification	702.03 702.05		Loading Certificate	Each individual truck, trailer, car or shipment	See QA Manual Section 230.11
		Manufacturer	Manufacturer			
	VERIFICATION Laboratory Tests	702.03	FOP for AASHTO R 66 AASHTO T 59	ITD-1045	Each 100 tons	No samples required when total project quantity is less than 2,000 Gal 8 Tons
		ITD Project Personnel	ITD Central Materials Laboratory			
PG. Binder	ACCEPTANCE Certification	702.01 702.05		ITD-966 OR manufacturer certification	Initial lot & each new lot to project	See QA Manual Sections 230.10 & 255.00
		Manufacturer	Manufacturer	Loading Certificate	Each shipment to project	
	VERIFICATION Laboratory Tests	702.01	AASHTO M 320 FOP for AASHTO R 66	ITD-859 ITD-859AW (ITD-859AW is the Central Materials Laboratory Report)	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	No samples required when total project quantity is less than 22 tons See QA Manual Section 255.00
		ITD Project Personnel	ITD Central Materials Laboratory			
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.						

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	BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS
			SAMPLED BY	TESTED BY			
406/407-2	Anti-Strip Additive	ACCEPTANCE  Presence of Anti-Striping Additive	702.04	Idaho IT 99	ITD-859	Test the initial truck & 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)
			ITD Project Personnel	ITD Project Personnel			
408	STANDARD SPECIFICATION SECTION: <b>408 - FOG COAT</b>						
	Emulsified Asphalt	ACCEPTANCE  Certification	702.03 702.05		Loading Certificate	Each individual truck, trailer, car or shipment	See QA Manual Section 230.11
			Manufacturer	Manufacturer			
		VERIFICATION  Laboratory Tests	702.02 702.03	FOP for AASHTO R 66 AASHTO T 59	ITD-1045	One (1) undiluted sample (as received from the asphalt supplier) per project.	No samples required when total project quantity is less than 2,000 Gal 8 Tons.
			ITD Project Personnel	ITD Central Materials Laboratory			
	Blotter	ACCEPTANCE  Gradation	703.07 408.02	FOP for AASHTO R 90 FOP for AASHTO R76 FOP for AASHTO T 27 FOP for AASHTO T 11	ITD-901	1 field gradation per source.	Sample at point of loading to the project.
			ITD Project Personnel	ITD Project Personnel			
	<b>Distributors</b> 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.						
415	STANDARD SPECIFICATION SECTION <b>415 - MICROSURFACING</b>						
	Aggregate	ACCEPTANCE  Gradation Sand Equivalent	703 415	FOP for AASHTO R 90 FOP for AASHTO R 76 FOP for AASHTO T 27 FOP for AASHTO T 11 FOP for AASHTO T 176 Alt. Method 2, Mechanical	ITD-901	Each 750 Tons or fraction thereof.	Acceptance at stockpile
			ITD Project Personnel	ITD Project Personnel			
	Polymer- modified Emulsified Asphalt	ACCEPTANCE  Certification	702.03 702.05		Loading Certificate	Each individual truck, trailer, car or shipment	See QA Manual Section 230.11
			Manufacturer	Manufacturer			
		VERIFICATION  Laboratory Tests	702.03	FOP for AASHTO R 66 AASHTO T 59	ITD-1045	1 random undiluted sample (as received from the asphalt supplier) twice per day	
ITD Project Personnel			ITD Central Materials Laboratory				

BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS
		SAMPLED BY	TESTED BY			
STANDARD SPECIFICATION SECTION: 430 – COLD IN-PLACE RECYCLING (CIR) PAVEMENT						
Cold-in-Place Mix Design	Design of C.I.R.	430			As needed	The Contractor furnishes the Design
		Contractor	Contractor			
	FINAL ACCEPTANCE	430		ITD-854		
		ITD Project Personnel	ITD Project Personnel			
Rolling for Recompaction	ACCEPTANCE In-Place Density	301.03	FOP for AASHTO T 310 Method A Modified	ITD-25 Standard Diary	Each 7,200 SY each lift	After curing time of approximatly 5-7 days and a moisture content of less than 1.5% is reached the cold recycled pavement shall be recompacted by the same methodology as the initial compaction.
		ITD Project Personnel	ITD Project Personnel			
Cold-in-Place Recycled Pavement (C.I.R.)	ACCEPTANCE Gradation	403.02	Visual Inspection	ITD-25 Standard Diary	1 per lane mile	See 430.02
		ITD Project Personnel	ITD Project Personnel			
	ACCEPTANCE In-Place Density	301.02	Visual Inspection	ITD-25 Standard Diary	Each 7,200 SY each lift	A roller pattern curve must be established with single shot (no rotation required). The required compaction is achieved when the final roller pass adds no more than 0.5 lb/ft3 to the previous in- place density.
		ITD Project Personnel	ITD Project Personnel			

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	BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS
			SAMPLED BY	TESTED BY			
430-2	Emulsified Asphalt Recycling Agent (EARA)	ACCEPTANCE Certification	702.02 702.05	AASHTO T 59 AASHTO T 53 AASHTO T 49	Loading Certificate	Each individual truck, trailer, car or shipment to the project	See QA Manual Section 230.11
			Manufacturer	Manufacturer			
		VERIFICATION Laboratory Testing	702.03	FOP for AASHTO R 66	ITD-1045	Twice per day from random truck or trailer onsite	No Samples required when total project quantity is less than 2000 Gal (8 Tons).
			ITD Project Personnel	ITD Central Materials Laboratory			
	Lime for Treated Recycled Pavement	ACCEPTANCE Certification	706.06 A		Bill of Lading with chemical analysis attached	Weekly	See 430.02
			Manufacturer	Manufacturer			
		VERIFICATION Laboratory Testing	ASTM C977	ASTM C50 ASTM C25 ASTM C110	ITD-1044 (Sample Data) ITD-1825 (Lab Report)	1 Sample per Project	See 430.02
			ITD Project Personnel	ITD Central Materials Laboratory			
	Cement	ACCEPTANCE Certification	701	AASHTO M 85	Bill of Lading with chemical analysis attached	Weekly	See QA Manual Section 230.02 and 230.02.01
			Manufacturer	Manufacturer			
		VERIFICATION Laboratory Testing	701		ITD-1044 (Sample Data) ITD-1825 (Lab Report)	1 Sample per Project	See 430.02
			ITD Project Personnel	ITD Central Materials Laboratory			
	Water for C.I.R.	ACCEPTANCE Inspection	430.03		ITD-25 Standard Diary	Daily Visual Inspection by ITD Personnel	See 430.02
			ITD Project Personnel	ITD Project Personnel			

BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS
		SAMPLED BY	TESTED BY			
STANDARD SPECIFICATION SECTION: 409 - PORTLAND CEMENT CONCRETE PAVEMENT						
Concrete Ready-Mix Plant Inspection				ITD-893	1 per project	Inspection of plant is valid for 1 year.
		ITD Project Personnel	ITD Project Personnel			
Mix Design	CONFIRMATION (Mix samples not required for projects less than 2,500 CY)	409.01 409.03-A		Central Lab will notify the Engineer of the confirmation	Submittal required 60 days prior to use	See QA Manual Section 260.02
		Contractor	ITD Central Lab			
	ACCEPTANCE (Water from other than a municipal drinking supply) Certification	720.01	ASTM C1602	Submit independent test results with mix design information	1 per project	Water from any municipal drinking supply does not require testing.
		Contractor	Independent Lab			
	ACCEPTANCE (Admixtures) Approved List	709.02 709.03 709.04 709.05	ASTM C494 AASHTO M 154	Qualified Products List		
		Manufacturer	Manufacturer			
Fine Aggregate	ACCEPTANCE Gradation Sand Equivalent	409.02 703.02	FOP for AASHTO R 90 FOP for AASHTO R 76 FOP for AASHTO T 27 FOP for AASHTO T 11 FOP for AASHTO T 176 Alt Method 2 Mechanical	ITD-901 OR ITD-1043	Each 1,000 CY of concrete placed	Frequency applies to multiple concrete items from same concrete plant per project.
		ITD Project Personnel	ITD Project Personnel			
		INDEPENDENT ASSURANCE Gradation Sand Equivalent	IA Inspector	IA Inspector	ITD-857	Each 20,000 CY of concrete placed
Coarse Aggregate	ACCEPTANCE Gradation	409.02 703.03	FOP for AASHTO R 90 FOP for AASHTO R 76 FOP for AASHTO T 27	ITD-901 OR ITD-1043	Each 1,000 CY of concrete placed	Frequency applies to multiple concrete items from same concrete plant per project. Wash method not required.
		ITD Project Personnel	ITD Project Personnel			
		INDEPENDENT ASSURANCE Gradation	IA Inspector	IA Inspector	ITD-857	Each 20,000 CY of concrete placed

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BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS	
		SAMPLED BY	TESTED BY				
409-2	Cement	ACCEPTANCE Certification	701.01	AASHTO M 85 or AASHTO M 240 Total Alkali	ITD-968 with bills of lading attached	Each week concrete is placed representing the amount of cement used	See QA Manual Section 230.02
			Manufacturer	Manufacturer			
		VERIFICATION Laboratory Tests(1)	701.01	AASHTO M 85 or AASHTO M 240	ITD-1044 (1A) (Sample Data)	Each 2,500 CY of concrete placed and for each mill analysis number. (2)	The frequency applies to multiple concrete items from the same concrete plant per project. Price adjustment for failing cement.
			ITD Project Personnel	ITD Central Lab	ITD-1825 (Lab Report)		
	Secondary Cementitious Material (SCM)	ACCEPTANCE Certification	714	AASHTO M 295	ITD-968 with bills of lading attached	Each week concrete is placed representing the amount of SCM used	See QA Manual Section 230.02
			Manufacturer	Manufacturer			
		VERIFICATION Laboratory Tests(1)	714		ITD-1044 (1A) (Sample Data)	Each 15,000 CY of concrete placed and for each sample ident number. (2)	The frequency applies to multiple concrete items from the same concrete plant per project.
			ITD Project Personnel	ITD Central Lab	ITD-1826 (Lab Report)		
(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.							



BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS
		SAMPLED BY	TESTED BY			
Dowel Bars	FOLLOW MTR TABLE STANDARD SPECIFICATION SECTION 503					
Tie Bars	FOLLOW MTR TABLE STANDARD SPECIFICATION SECTION 503					
Concrete Production (1A)	FIELD ACCEPTANCE Slump Air Content Temperature Unit Weight Cement Factor W/C Ratio	409.02	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	ITD-70	Each 300 CY	See QA Manual Section 215.00 Materials or Work Failing Specifications Computerized batch ticket accompanies each load to project.
		ITD Project Personnel	ITD Project Personnel			
	INDEPENDENT ASSURANCE Field Tests	IA Inspector	IA Inspector	ITD-857	Each 6,000 CY	
	ACCEPTANCE Compressive Strength	409.02	AASHTO T 22 FOP for AASHTO T 23 AASHTO T 358	ITD-1044 (Sample Data) ITD-845 (Lab Report)	3 sets for each day's production; 1 set randomly during each third of the day's placement.	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.
		ITD Project Personnel	ITD District or Central Lab			
	INDEPENDENT ASSURANCE Making Cylinders	IA Inspector	IA Inspector	ITD-857	1 observation per project	
(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.						

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BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS	
		SAMPLED BY	TESTED BY				
409-4	Concrete Production (1A) (Multiple small placements of less than 200 CY per day, i.e. slab replacements, intersections)	FOLLOW MTR TABLE STANDARD SPECIFICATION SECTION 502					
	Curing Compound	ACCEPTANCE Laboratory Test	709.01	ASTM C309	ITD-1044 (Sample Data)	Submit sample at least 30 days prior to use for each batch/lot	Pre-approved by batch or lot number.
			Manufacturer	ITD Central Lab	ITD-1823 (Lab Report)		
	Finished Pavement	ACCEPTANCE (Depth Measurements)	409.03-J	FOP for AASHTO T 359	ITD-827	Randomly once every 0.1 mile	Thickness price adjustment.
				ITD Project Personnel			
		ACCEPTANCE Profiler (Smoothness)	409.03-K	AASHTO R 57	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.		
			Contractor	Contractor			
		VERIFICATION Profiler	409.03-K		ITD-854 ITD-769	Fully witnessed with report	
			ITD Project Personnel	ITD Project Personnel			
		ACCEPTANCE (Final Finish)	409.03-J	Idaho IT 147	ITD-797	Initially, then each lane mile	
				ITD Project Personnel			
	Joints	FOLLOW MTR TABLE STANDARD SPECIFICATION SECTION 625					
	STANDARD SPECIFICATION SECTION: <b>411 - URBAN CONCRETE PAVEMENT</b>						
	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.						

BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS
		SAMPLED BY	TESTED BY			
STANDARD SPECIFICATION SECTION: 420 – CONCRETE PAVEMENT REHABILITATION						
A. Slab Replacement	FOLLOW MTR TABLE STANDARD SPECIFICATION SECTION 409					
	ACCEPTANCE Concrete	409				See QA Manual Section 230.01
		Contractor	Manufacturer			
	ACCEPTANCE Epoxy for Grouting Certification	420.02 A.	AASHTO M 235 Type III Grade 1 or 2 or ASTM C881 Type III Grade 1 or 2		Total Quantity Paid	See QA Manual Section 230.01
		Manufacturer	Manufacturer			
B. Repairing Spalls	ACCEPTANCE Certification	420.02 B.	ASTM C928 (modified) or AASHTO M 235 Type III Grade 1 or 2 or ASTM C881 Type III Grade 1 or 2	ITD-901 OR ITD-1043	Total Quantity Paid	See QA Manual Section 230.01
		Manufacturer	Manufacturer			
C. Subsealing	ACCEPTANCE Grout Certification	705		ITD-901 OR ITD-1043	Total Quantity Paid	See QA Manual Section 230.01
		Manufacturer	Manufacturer			
	ACCEPTANCE Fly Ash Certification	714	ASTM C618 Class C or F	ITD-857	Total Quantity Paid	See QA Manual Section 230.01
		Manufacturer	Manufacturer			

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420-2	BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS
			SAMPLED BY	TESTED BY			
	E. Repairing Cracks	ACCEPTANCE Certification	704		ITD-851	Total Quantity Paid	See QA Manual Section 230.01
			Manufacturer	Manufacturer			
	F. Reconstruction of Plant Mix Shoulders Asphalt	FOLLOW MTR TABLE STANDARD SPECIFICATION SECTION 405					
		ACCEPTANCE Superpave HMA	405		ITD-833 ITD-777	See 405	See QA Manual Section 230.01
			ITD Project Personnel	ITD Project Personnel			
		INDEPENDENT ASSURANCE Sampling Air Voids VMA Moisture	IA Inspector	IA Inspector	ITD-857	1 observation each project.	Observation of the tests that are performed to calculate air voids, VMA, and Moisture
	G. Sealing Edge Joints	ACCEPTANCE Certification	704		ITD-851	Total Quantity Paid	See QA Manual Section 230.01
			Manufacturer	Manufacturer			
H. Resealing Joints	ACCEPTANCE Certification	704		ITD-851	Total Quantity Paid	See QA Manual Section 230.01	
		Manufacturer	Manufacturer				

BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS
		SAMPLED BY	TESTED BY			
STANDARD SPECIFICATION SECTION: 502 - CONCRETE						
Concrete Ready-Mix Plant Inspection		ITD Project Personnel	ITD Project Personnel	ITD-893	1 per project	Inspection of plant is valid for 1 year.
Mix Design	REVIEW BY HQ Central Lab	502.01 502.03-A		See Section 260.03.		
		Contractor	Contractor			
	ACCEPTANCE (Admixtures) Approved List	709.02 709.03 709.04 709.05	ASTM C494 AASHTO M 154	Qualified Products List		
		Manufacturer	Manufacturer			
	ACCEPTANCE (Water from other than a municipal drinking supply) Certification	720.01	ASTM C1602	Submit independent test results with mix design information	1 per project	Water from any municipal drinking supply does not require testing.
		Contractor	Independent Lab			
Fine Aggregate	ACCEPTANCE Gradation Sand Equivalent	409.02 703.02	FOP for AASHTO r 90 FOP for AASHTO R 76 FOP for AASHTO T 27 FOP for AASHTO T 11 FOP for AASHTO T 176 Alt. Method 2 Mechanical	ITD-901 OR ITD-1043	Each 500 CY of concrete placed	Frequency applies to multiple concrete items from same concrete plant per project.
		ITD Project Personnel	ITD Project Personnel			
		INDEPENDENT ASSURANCE Gradation Sand Equivalent	IA Inspector	IA Inspector	ITD-857	Each 10,000 CY of concrete placed
Coarse Aggregate	ACCEPTANCE Gradation	409.02 703.03	FOP for AASHTO R 90 FOP for AASHTO R 76 FOP for AASHTO T 27	ITD-901 OR ITD-1043	Each 500 CY of concrete placed	Frequency applies to multiple concrete items from same concrete plant per project. Wash method not required.
		ITD Project Personnel	ITD Project Personnel			
		INDEPENDENT ASSURANCE Gradation	IA Inspector	ITD District Lab	ITD-857	Each 10,000 CY of concrete placed

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BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS
		SAMPLED BY	TESTED BY			
Cement	ACCEPTANCE Certification	701.01	AASHTO M 85 or AASHTO M 240 Total Alkali	ITD-968 with bill of lading attached	Each week concrete is placed representing the amount of cement used	See QA Manual Section 230.02
		Manufacturer	Manufacturer			
	VERIFICATION Laboratory Tests(1)	701.01	AASHTO M 85 or AASHTO M 240	ITD- 1044(1B) (Sample Data)  ITD-1825 (Lab Report)	Each 1,000 CY of concrete placed and for each mill analysis number (2)	The frequency applies to multiple concrete items from the same concrete plant per project.  Price adjustment for failing cement.
		ITD Project Personnel	ITD Central Lab			
Secondary Cementitious Material (SCM)	ACCEPTANCE Certification	714		ITD-968 with bill of lading attached	Each week concrete is placed representing the amount of SCM used	See QA Manual Section 230.02
		Manufacturer	Manufacturer			
	VERIFICATION Laboratory Tests(1)	714		ITD- 1044(1B) (Sample Data)  ITD-1826 (Lab Report)	Each 4,000 CY of concrete placed and for each sample ident number (2)	The frequency applies to multiple concrete items from the same concrete plant per project.
		ITD Project Personnel	ITD Central Lab			
Metal Reinforcement	FOLLOW MTR TABLE STANDARD SPECIFICATION SECTION 503					
Pre-Stressing Strand	FOLLOW MTR TABLE STANDARD SPECIFICATION SECTION 506					
Curing Compound(1A)	ACCEPTANCE Laboratory Test	709.01	ASTM C309	ITD-1044 (Sample Data)  ITD-1823 (Lab Report)	Submit sample at least 30 days before use for each batch/lot	Pre-approved by batch or lot number.
		Manufacturer	ITD Central Lab			
	ACCEPTANCE Certification			ITD-851	Total Quantity Paid	See QA Manual Section 230.01
		Manufacturer	Manufacturer			
Joint Fillers and Sealers	FOLLOW STANDARD SPECIFICATION SECTION 625 OF THE MTR 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)						

BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS
		SAMPLED BY	TESTED BY			
Concrete Production (1B) Specified Strength of 3,500 psi or greater	FIELD ACCEPTANCE Slump Air Content Temperature Unit Weight Cement Factor W/C Ratio	502.02	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	ITD-70	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)	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.
		ITD Project Personnel	ITD Project Personnel			
	INDEPENDENT ASSURANCE Field Tests	IA Inspector	IA Inspector	ITD-857	Each 2,000 CY	
	ACCEPTANCE Compressive Strength/Surface Resistivity	502.02	AASHTO T 22 FOP for AASHTO T 23 AASHTO T 358	ITD-1044 (Sample Data)	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).	A single sample of concrete must be of sufficient size for the cylinders and air, slump, unit weight tests.
		ITD Project Personnel	ITD Project Personnel	ITD-845 (Lab Report)		
	INDEPENDENT ASSURANCE Making Cylinders	IA Inspector	IA Inspector	ITD-857	1 observation per project	
<p>(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.</p> <p>(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 <b>not</b> apply are sign or pole bases larger than 4 CY bridge footings, columns, pier caps or bridge parapet.</p>						
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			
<p>(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).</p> <p>(3) When total is less than 50CY, QC tests can be from previous batches in the 30 days prior to the first placement.</p>						

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BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS
		SAMPLED BY	TESTED BY			
502-4	FIELD ACCEPTANCE  Flow, VSI, Temperature Unit Weight Air Content	502.02	FOP for AASHTO T 347 FOP for AASHTO T 351 FOP for AASHTO T 121 FOP for AASHTO T 152	ITD 70	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)	When there is a failing test, obtain check test immediately and continue checking each load until 2 consecutive tests are passing. Computerized batch tickets accompanies each load to project.
		ITD Project Personnel	ITD Project Personnel			
	INDEPENDENT ASSURANCE Field Tests	IA Inspector	IA Inspector	ITD-857	Each 2,000 CY	
	ACCEPTANCE Compressive Strength	502.02	ASHTO T 22 FOP for AASHTO T 23	ITD-1044 (Sample Data) ITD-845 (Lab Report)	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).	A single sample of concrete must be of sufficient size for the cylinders and air, slump, unit weight tests.
		ITD Project Personnel	ITD Project Personnel			
	INDEPENDENT ASSURANCE Field Tests	IA Inspector	IA Inspector	ITD-857	1 Observation per project	



BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS
		SAMPLED BY	TESTED BY			
Pre-cast Stringers, Prestressed Members	ACCEPTANCE Field Tests (Air, slump, unit weight, temperature)	502.02	FOP for AASHTO T 119 FOP for AASHTO T 152 FOP for AASHTO T 309 FOP for AASHTO T 121	ITD-70	1 per member	The ITD On- site Inspector will provide a memo of acceptance to the Engineer with all required test reports and certifications attached.
		ITD On-site Inspector	ITD On-site Inspector			
	ACCEPTANCE Compressive Strength	502.02	AASHTO T 22 FOP for AASHTO T 23	ITD-845	1 set of 3 28-day cylinders per member	
		ITD On-site Inspector	ITD District or Central Lab			
Concrete Parapet	FOLLOW MTR FOR STRENGTH SPECIFIED					
Voided Slabs, Approach Slabs	ACCEPTANCE Field Tests (Air, slump, unit weight, temperature)	502.02	FOP for AASHTO T 119 FOP for AASHTO T 152 FOP for AASHTO T 309 FOP for AASHTO T 121	ITD-70	1 per member and when multiple members are poured in one continuous line- one test per line up to 50 cy and additional tests per 50cy.	The ITD On- site Inspector will provide a memo of acceptance to the Engineer with all required test reports and certifications attached.
		ITD On-site Inspector	ITD On-site Inspector			
	ACCEPTANCE Compressive Strength	502.02	AASHTO T 22 FOP for AASHTO T 23	ITD-845	1 set of 3 28-day cylinders per member	
		ITD On-site Inspector	ITD District or Central Lab			
Permanent Metal Concrete Forms	ACCEPTANCE Certification	708.31	ASTM A653 SS (SS=structural steel)	ITD-914 with mill test reports attached for steel/iron	Total Quantity Paid	See QA Manual Section 230.01 and Section 230.03
		Manufacturer	Manufacturer			
Finished Concrete	ACCEPTANCE (Smoothness)	502.03-I-e	Idaho IR 87	ITD-854 ITD-769	As required	
			ITD Project Personnel			
	ACCEPTANCE (Final Finish)	502.03-I-d	Idaho IT 147	ITD-797	Once per project	
			ITD Project Personnel			

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BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS
		SAMPLED BY	TESTED BY			
STANDARD SPECIFICATION SECTION: 503 - METAL REINFORCEMENT						
Reinforcing Steel	ACCEPTANCE Certification	503.02 708.02	AASHTO M 31	ITD-914 with mill test reports attached for steel/iron	Total Quantity Paid	See QA Manual Section 230.01 and Section 230.03
		Manufacturer	Manufacturer			
	VERIFICATION Laboratory Tests (3)	503.02		ITD- 1044(3A) (Sample Data)  ITD-1810 (ITD 812 Lab Report)	Field sample every size and heat number from deliveries to project	FedEx or overnight samples.  Reject failing heat numbers. See QA Manual Section 230.03.02
		ITD Project Personnel	ITD Central Lab			
Epoxy Coated Metal Reinforcement	ACCEPTANCE Certification	503.02 708.02	ASTM A775	ITD-914 with mill test reports attached for steel/iron and with Holiday and coating thickness test reports attached	Total Quantity Paid	See QA Manual Section 230.01 and Section 230.03
		Manufacturer	Manufacturer			
	VERIFICATION Laboratory Tests (3)	503.02		ITD- 1044(3A) (Sample Data)  ITD-1810 (ITD-812 Lab Report)	Field sample every size and heat number from deliveries to project	FedEx or overnight samples.  Reject failing heat numbers. See QA Manual Section 230.03.02
		ITD Project Personnel	ITD Central Lab			
Dowel Bars	ACCEPTANCE Certification	708.03	AASHTO M 254	ITD-914 with mill test reports attached for steel/iron	Total Quantity Paid	See QA Manual Section 230.01 and Section 230.03
		Manufacturer	Manufacturer			
(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).						

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	BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS	
			SAMPLED BY	TESTED BY				
503-2	Tie Bars	ACCEPTANCE Certification	708.04	AASHTO M 31	ITD-914 with mill test reports attached for steel/iron	Total Quantity Paid	See QA Manual Section 230.01 and Section 230.03	
			Manufacturer	Manufacturer				
		VERIFICATION Laboratory Tests(3)(4)	503.02		ITD- 1044(3A) (Sample Data)  ITD-1810 (ITD-812 Lab Report)	1 sample of 2 bars per day of concrete paving	Slab replacement or rehab project where less than 1,000 bars, then 1 sample of 2 bars per project.	
			ITD Project Personnel	ITD Central Lab				
		(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.								

BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS
		SAMPLED BY	TESTED BY			
STANDARD SPECIFICATION SECTION: 504 - STRUCTURAL METALS						
Steel Bridge	ACCEPTANCE Certification	504.01 504.03 708.06	AASHTO M 270	ITD-914 with mill test reports attached for steel/iron	Total Quantity Paid	See QA Manual Section 230.01 and Section 230.03
		Manufacturer	Manufacturer			
	ACCEPTANCE Fabrication Inspection(5)	504.01 504.02 504.03		HQ will provide memo of inspection		District notifies HQ as soon as fabricator is known. HQ arranges fabrication inspection.
		ITD Project Personnel	ITD Central Lab			
Structural Steel	ACCEPTANCE Certification	504.01 504.03 708.06	AASHTO M 270	ITD-914 with mill test reports attached for steel/iron	Total Quantity Paid	See QA Manual Section 230.01 and Section 230.03
		Manufacturer	Manufacturer			
	ACCEPTANCE Fabrication Inspection(5)	504.01 504.02 504.03		HQ will provide memo of inspection		District notifies HQ as soon as fabricator is known. HQ arranges fabrication inspection.
		ITD Project Personnel	ITD Central Lab			
Steel Forgings	ACCEPTANCE Certification	708.06	AASHTO M 270	ITD-914 with mill test reports attached for steel/iron	Total Quantity Paid	See QA Manual Section 230.01 and Section 230.03
		Manufacturer	Manufacturer			
	ACCEPTANCE Fabrication Inspection(5)	504.03		HQ will provide memo of inspection		District notifies HQ as soon as fabricator is known. HQ arranges fabrication inspection.
		ITD Project Personnel	ITD Central Lab			
Paint	FOLLOW MTR TABLE STANDARD SPECIFICATION SECTION 627					
(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).						

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	BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS
			SAMPLED BY	TESTED BY			
504-2	Bolts, Nuts, Hardened Washers, Direct Tension Indicators	ACCEPTANCE Certification	504.03-L 708.06-2	ASTM A307 ASTM A325 ASTM A490 ASTM E18	ITD-914 no mill test reports for steel/iron	Total Quantity Paid	See QA Manual Section 230.01 and Section 230.03
			Manufacturer	Manufacturer			
		VERIFICATION Laboratory Tests	504.03-L 708.06-2	ASTM A307 ASTM A325 ASTM A490 ASTM E18	ITD-1044 (Sample Data) ITD-1811 (Lab Report)	3 random samples of each assembly from each lot and size	Sample from material delivered to the project.
			ITD Project Personnel	ITD Central Lab			
	Structural Steel Handrail	ACCEPTANCE Certification	504.02 708.06-1	AASHTO M 270	ITD-914 with mill test reports attached for steel/iron	Total Quantity Paid	See QA Manual Section 230.01 and Section 230.03
			Manufacturer	Manufacturer			
	Two Tube Curb- Mount Railing	ACCEPTANCE Certification	504.02 708.06-1	AASHTO M 270	ITD-914 with mill test reports attached for steel/iron	Total Quantity Paid	See QA Manual Section 230.01 and Section 230.03
			Manufacturer	Manufacturer			
	Pedestrian Bicycle Railing	ACCEPTANCE Certification	504.02 708.06-1	AASHTO M 270	ITD-914 with mill test reports attached for steel/iron	Total Quantity Paid	See QA Manual Section 230.01 and Section 230.03
			Manufacturer	Manufacturer			
	Combination Pedestrian, Bicycle, and Traffic Railing	ACCEPTANCE Certification	504.02 708.06-1	AASHTO M 270	ITD-914 with mill test reports attached for steel/iron	Total Quantity Paid	See QA Manual Section 230.01 and Section 230.03
			Manufacturer	Manufacturer			

BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS
		SAMPLED BY	TESTED BY			
STANDARD SPECIFICATION SECTION: 505 - PILING						
H-Beam Piles	ACCEPTANCE Certification	505.02 708.08	ASTM A36	ITD-914 with mill test reports attached for steel/iron	Total Quantity Paid	See QA Manual Section 230.01 and Section 230.03
		Manufacturer	Manufacturer			
Steel Shell Piles	ACCEPTANCE Certification	505.02 708.30		ITD-914 with mill test reports attached for steel/iron	Total Quantity Paid	See QA Manual Section 230.01 and Section 230.03
		Manufacturer	Manufacturer			
Timber Piles	ACCEPTANCE Certification	505.02 710.05	ASTM D25	ITD-851	Total Quantity Paid	See QA Manual Section 230.01 and Section 230.03
		Manufacturer	Manufacturer			
Pile Point	ACCEPTANCE Approved List and Certification	505.03-C		Qualified Product List ITD-914 with mill test reports attached for steel/iron		See QA Manual Section 230.01 and Section 230.03
		Manufacturer	Manufacturer			
Concrete with specified strength of 3,000 psi or less	ACCEPTANCE Certification	502.02-B		ITD-875 with QC test results attached	Total Quantity Paid	See QA Manual Section 230.06 Concrete Suppliers Certification Note locations on ITD-875
		Concrete Supplier	Concrete Supplier			
STANDARD SPECIFICATION SECTION: 506 - PRE-STRESSING CONCRETE						
Reinforcement	FOLLOW MTR TABLE STANDARD SPECIFICATION SECTION 503					
Welded Wire	ACCEPTANCE Certification			ITD-914 with mill test reports attached for steel/iron	Total Quantity Paid	See QA Manual Section 230.01 and Section 230.03
		Manufacturer	Manufacturer			
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
		Manufacturer	Manufacturer			
	VERIFICATION Laboratory Tests	506.03		ITD-1044 (Sample Data) ITD-1813 (ITD-838 Lab Report)	1 per reel	See QA Manual Section 230.05.01
		ITD Project Personnel	ITD Central Lab			
Grout Type A Type B Class I Type B Class II Type C (used in post tensioning)	ACCEPTANCE Compressive Strength	506.03-I 705	ID FOP for AASHTO R 64 AASHTO T 106	ITD-1044 (Sample Data) ITD-845 (Lab Report)	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
		ITD Project Personnel	ITD District or Central Lab			
		INDEPENDENT ASSURANCE Observation	IA Inspector	IA Inspector	ITD-857	1 observation per project

	BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS
			SAMPLED BY	TESTED BY			
506-2	Grout Type A Type B Class I Type B Class II Type C (used in other than post tensioning)	ACCEPTANCE Compressive Strength	506.03-I 705	AASHTO R 64 AASHTO T 106	ITD-1044 ITD-845 (Lab Report)	1 per project	The average of three 28-day cubes for Type A or Type B.  The average of three 24-hour cubes for Type C
			ITD Project Personnel	ITD District or Central Lab			
	Grout Type D	ACCEPTANCE Certification	701 703 705	AASHTO M85 FOP for AASHTO T 11 FOP for AASHTO T 27 FOP for AASHTO T 176 Alt. Method 2, Mechanical	ITD-851	Total Quantity Paid	See QA Manual Section 230.01
			Manufacturer	Manufacturer			
507	STANDARD SPECIFICATION SECTION: 507 - BEARING PADS AND PLATES						
	Self-Lubricating Bronze Bearing Plates	ACCEPTANCE Certification	507.02 708.29		ITD-851	Total Quantity Paid	See QA Manual Section 230.01
			Manufacturer	Manufacturer			
	Neoprene Bearing Pads	ACCEPTANCE Certification	507.02 720.02	AASHTO M 251	ITD-851	Total Quantity Paid	See QA Manual Section 230.01
			Manufacturer	Manufacturer			
	TFE/PTFE Bridge Bearing Pads	ACCEPTANCE Certification	507.02 720.03		ITD-851	Total Quantity Paid	See QA Manual Section 230.01
			Manufacturer	Manufacturer			
	STANDARD SPECIFICATION SECTION: 508 - CORRUGATED PLATE PIPE						
508	Corrugated Plate Pipe Culvert	ACCEPTANCE Certification	508.02 708.20	AASHTO M 167 or AASHTO M 219	ITD-914 with mill test reports attached for steel/iron	Total Quantity Paid	See QA Manual Section 230.01 Section 230.03 and Section 230.07
			Manufacturer	Manufacturer			
	Corrugated Plate Pipe Arch	ACCEPTANCE Certification	508.02 708.20	AASHTO M 167 or AASHTO M 219	ITD-914 with mill test reports attached for steel/iron	Total Quantity Paid	See QA Manual Section 230.01 Section 230.03 and Section 230.07
			Manufacturer	Manufacturer			
	Corrugated Plate Arch	ACCEPTANCE Certification	508.02 708.20	AASHTO M 167 or AASHTO M 219	ITD-914 with mill test reports attached for steel/iron	Total Quantity Paid	See QA Manual Section 230.01 Section 230.03 and Section 230.07
			Manufacturer	Manufacturer			



BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS
		SAMPLED BY	TESTED BY			
STANDARD SPECIFICATION SECTION: 509 - NON-STRUCTURAL CONCRETE						
Mix Design	REVIEW BY District	509.01		See Section 260.03.		
		Contractor	Contractor			
Concrete(1)	ACCEPTANCE Certification	509.02		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.	Total Quantity Paid	(2) 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. See QA Manual Section 230.06 Concrete supplier's certification Note locations on ITD-875
		Contractor	Contractor			
(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).						

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BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS		
		SAMPLED BY	TESTED BY					
STANDARD SPECIFICATION SECTION: 510 - CONCRETE OVERLAY								
510	Mix Design	FOLLOW MTR TABLE STANDARD SPECIFICATION SECTION 502						
	Aggregate							
	Portland Cement							
	Curing Compound							
	Latex Modified Concrete	ACCEPTANCE (Latex Modifier) Certification	510.02	FOP for Idaho IR 121	ITD-851 with test results attached	Total Quantity Paid	See QA Manual Section 230.01	
			Manufacturer	Manufacturer				
		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 121	ITD-70	First load, then randomly each 50 CY until quantity reaches 100 CY, thereafter randomly each 100 CY.		
			ITD Project Personnel	ITD Project Personnel				
		INDEPENDENT ASSURANCE Field Tests	IA Inspector	IA Inspector	ITD-857	Each 2,000 CY		
		ACCEPTANCE (Concrete) Compressive Strength	510.03	AASHTO T 22 FOP for AASHTO T 23	ITD-1044 (Sample Data) ITD-845 (Lab Report)	1 set of 3 28-day cylinders per day		
			ITD Project Personnel	ITD District or Central Lab				
		INDEPENDENT ASSURANCE Making Cylinders	IA Inspector	IA Inspector	ITD-857	1 observation per project		
		Silica Fume Concrete	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) ITD-1827 (Lab Report)	1 per project	1 Cylinder Can
				ITD Project Personnel	ITD Central Lab			
	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 121	ITD-70	First load, then randomly each 50 CY until quantity reaches 100 CY, thereafter randomly each 100 CY.		
			ITD Project Personnel	ITD Project Personnel				
	INDEPENDENT ASSURANCE Field Tests		IA Inspector	IA Inspector	ITD-857	Each 2,000 CY		

BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS			
		SAMPLED BY	TESTED BY						
Silica Fume Concrete (Continued)	ACCEPTANCE (Concrete) Compressive Strength	510.03	AASHTO T 22 FOP for AASHTO T 23	ITD-1044 (Sample Data) ITD-845 (Lab Report)	1 set of 3 28-day cylinders per day		510-2		
		ITD Project Personnel	ITD District or Central Lab						
	INDEPENDENT ASSURANCE Making Cylinders	IA Inspector	IA Inspector	ITD-857	1 observation per project				
Finished Overlay	ACCEPTANCE (Smoothness and Integrity)	409.03-K 510.03-F	Idaho IR 87	ITD-854 ITD-769	As required	Identify any delaminations for removal.			
			ITD Project Personnel						
	ACCEPTANCE (Final Finish)	510.03-E	Idaho IT 147	ITD-797	Once per structure				
			ITD Project Personnel						
STANDARD SPECIFICATION SECTION: 511 - CONCRETE WATERPROOFING SYSTEMS								511	
Liquid Asphalt Sealant Type A System	ACCEPTANCE Certification	511.02	ASTM D3406	ITD-851	Total Quantity Paid	See QA Manual Section 230.01			
		Manufacturer	Manufacturer						
Asphalt Roll Roofing Type A System	ACCEPTANCE Certification	511.02	ASTM D224 TYPE II	ITD-851	Total Quantity Paid	See QA Manual Section 230.01			
		Manufacturer	Manufacturer						
Primer Type A System	ACCEPTANCE Certification	702.03		ITD-851	Total Quantity Paid	See QA Manual Section 230.01			
		Manufacturer	Manufacturer						
Asphalt Cement Type B System	ACCEPTANCE Certification	702.01		ITD-851	Total Quantity Paid	See QA Manual Section 230.01			
		Manufacturer	Manufacturer						
Fabric Type B System	ACCEPTANCE Certification	718.02		ITD-851	Total Quantity Paid	See QA Manual Section 230.01			
		Manufacturer	Manufacturer						
Sand Membrane Protection Blanket	ACCEPTANCE Gradation Sand Equivalent	703.02	FOP for AASHTO R 90 FOP for AASHTO R 76 FOP for AASHTO T 27 FOP for AASHTO T 11 FOP for AASHTO T 176 Alt. Method 2, Mechanical	ITD-901	1 per project (At first Placement)	If test fails immediately, perform check test. If check test fails, reject material.			
		ITD Project Personnel	ITD Project Personnel						
Membrane Sheet Type D System	ACCEPTANCE Certification	511.02 511.03		ITD-851	Total Quantity Paid	See QA Manual Section 230.01			
		Manufacturer	Manufacturer						
Water Repellant Type C System	ACCEPTANCE Certification	511.02 511.03		ITD-851	Total Quantity Paid	See QA Manual Section 230.01			
		Manufacturer	Manufacturer						

BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS	
		SAMPLED BY	TESTED BY				
512	STANDARD SPECIFICATION SECTION: 512 – GABION STRUCTURE						
	Wire Mesh	ACCEPTANCE Certification	715.01	ASTM A370 ASTM A641 ASTM A90 ASTM A185	ITD-914 with mill test reports attached for steel/iron	Total Quantity Paid	See QA Manual Section 230.01 and Section 230.03
			Manufacturer	Manufacturer			
	Joints	ACCEPTANCE Certification	715.05	ASTM A641 ASTM A370 ASTM A641 ASTM A90 ASTM A764	ITD-851 ITD-914 with mill test reports attached for steel/iron	Total Quantity Paid	See QA Manual Section 230.01 and Section 230.03
			Manufacturer	Manufacturer			
	Gabion Fill Material	ACCEPTANCE Inspection	715.06		ITD-854		
			No sample required	No testing required			
	Compacting Backfill	ACCEPTANCE In-Place Density	512.03-C	FOP for AASHTO T 99 Method C or A FOP for AASHTO T 310 Method B	ITD-850	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
			ITD Project Personnel	ITD Project Personnel			
			INDEPENDENT ASSURANCE In-Place Density	IA Inspector	IA Inspector	ITD-857	1 observation per project exceeding 2,500CY
Geotextile	FOLLOW MTR TABLE STANDARD SPECIFICATION SECTION 640						
520	STANDARD SPECIFICATION SECTION: 520 – PREDRILLING FOR PILING						
	Coarse Aggregate for Concrete Size No. 1	ACCEPTANCE Visual	703.02		ITD-854	1 per project	
			ITD Project Personnel	ITD Project Personnel			
		ACCEPTANCE Certification	703.02		ITD-851 ITD-901	Each 700 CY or 1000 Tons	
Contractor	Contractor						

BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS
		SAMPLED BY	TESTED BY			
STANDARD SPECIFICATION SECTION: 522 – CONTROLLED DENSITY FILL (CDF)						
Controlled Density Fill (CDF)	ACCEPTANCE Visual	522.02		ITD 854	1 per project	See QA Manual Section 230.01
		ITD Project Personnel	ITD Project Personnel			
	ACCEPTANCE Certification	522.02		ITD 851	1 per project	
		Contractor	Contractor			
STANDARD SPECIFICATION SECTION: 551 – POLYESTER POLYMER CONCRETE (PPC) OVERLAY						
Primer	ACCEPTANCE Certification	551.02		ITD-851	Total Quantity Paid	See QA Manual Section 230.01
		Manufacturer	Manufacturer			
Polyester Resin Binder	ACCEPTANCE Certification	551.02		ITD-851	Total Quantity Paid	See QA Manual Section 230.01
		Manufacturer	Manufacturer			
Aggregate	ACCEPTANCE Certification	551.02		ITD-851	Total Quantity Paid	See QA Manual Section 230.01
		Manufacturer	Manufacturer			
PPC Composite	ACCEPTANCE Certification	551.02		ITD-851	Total Quantity Paid	See QA Manual Section 230.01
		Manufacturer	Manufacturer			
Sand for Abrasive Finish	ACCEPTANCE Certification	551.02		ITD-851	Total Quantity Paid	See QA Manual Section 230.01
		Manufacturer	Manufacturer			

	BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS
			SAMPLED BY	TESTED BY			
553	STANDARD SPECIFICATION SECTION: <b>553 – EPOXY OVERLAY</b>						
	Epoxy	ACCEPTANCE Certification	553.02		ITD-851	Total Quantity Paid	See QA Manual Section 230.01
			Manufacturer	Manufacturer			
	Aggregates	ACCEPTANCE Certification	553.02	FOP for AASHTO R 90 FOP for AASHTO R 76 FOP for AASHTO T 27 FOP for AASHTO T 11 AASHTO T 278 or ASTM A641 AASHTO T 96 AASHTO T 255 ASTM C25	ITD-851	Total Quantity Paid	See QA Manual Section 230.01
			Manufacturer	Manufacturer			
565	STANDARD SPECIFICATION SECTION: <b>565 – ASPHALTIC PLUG EXPANSION JOINT SYSTEM</b>						
	Binder Material	ACCEPTANCE Certification	565.02		ITD-851	Total Quantity Paid	See QA Manual Section 230.01
			Manufacturer	Manufacturer			
	Aggregates	ACCEPTANCE Certification	565.02		ITD-851	Total Quantity Paid	See QA Manual Section 230.01
			Manufacturer	Manufacturer			
	Backer Rod	ACCEPTANCE Certification	565.02		ITD-851	Total Quantity Paid	See QA Manual Section 230.01
			Manufacturer	Manufacturer			
	Bridge Plate	ACCEPTANCE Certification	565.02		ITD-851 ITD-914 with mill test reports attached for steel/iron	Total Quantity Paid	See QA Manual Section 230.01
			Manufacturer	Manufacturer			
	Location Spikes	ACCEPTANCE Certification	565.02		ITD-851 ITD-914 with mill test reports attached for steel/iron	Total Quantity Paid	See QA Manual Section 230.01
			Manufacturer	Manufacturer			
	Mixing and Compaction	ACCEPTANCE Visual	565.03		ITD 854	1 per project	See QA Manual Section 230.01
			ITD Project Personnel	ITD Project Personnel			

BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS	
		SAMPLED BY	TESTED BY				
STANDARD SPECIFICATION SECTION: 566 – COMPRESSION SEAL EXPANSION JOINT							566
Neoprene Seals	ACCEPTANCE Certification	704.04		ITD-851	Total Quantity Paid	See QA Manual Section 230.01	
		Manufacturer	Manufacturer				
STANDARD SPECIFICATION SECTION: 567 – STRIP SEAL EXPANSION JOINT							567
Metal	ACCEPTANCE Certification	567.02-A		ITD-851 ITD-914 with mill test reports attached for steel/iron	Total Quantity Paid	See QA Manual Section 230.01	
		Manufacturer	Manufacturer				
Neoprene Seals	ACCEPTANCE Certification	567.02-B 704.04		ITD-851	Total Quantity Paid	See QA Manual Section 230.01	
		Manufacturer	Manufacturer				
Adhesive	ACCEPTANCE Certification	567.02-C		ITD-851	ITD-851	Total Quantity Paid	
		Manufacturer	Manufacturer				
STANDARD SPECIFICATION SECTION: 568 –ELASTOMERIC CONCRETE HEADER							568
Elsatomeric Concrete	ACCEPTANCE Certification	568.02		ITD-851	Total Quantity Paid	See QA Manual Section 230.01	
		Manufacturer	Manufacturer				
Bonding Agent	ACCEPTANCE Certification	568.02		ITD-851	Total Quantity Paid	See QA Manual Section 230.01	
		Manufacturer	Manufacturer				
STANDARD SPECIFICATION SECTION: 576 –GLASS FIBER REINFORCED POLYMER (GFPR) REINFORCEMENT							576
GFPR Reinforcement	ACCEPTANCE Certification	576.02		ITD-851	Total Quantity Paid	See QA Manual Section 230.01	
		Manufacturer	Manufacturer				
STANDARD SPECIFICATION SECTION: 577 –PILE SLEEVES							577
Coarse Aggregate for Concrete Size No. 1	ACCEPTANCE Visual	703.02 409.02 703.03		ITD-854	1 per Project		
		ITD Project Personnel	ITD Project Personnel				
	ACCEPTANCE Certification	703.02 409.02 703.03		ITD-851 ITD-901	Each 700 CY or 1000 Tons		
		Manufacturer	Manufacturer				
Corrugated Metal Pipe and Galvanized Metal Spacers	ACCEPTANCE Certification	706.06	AASHTO M 36 or AASHTO M 196	ITD-851 ITD-914 with mill test reports attached for steel/iron	Total Quantity Paid	See QA Manual Section 230.01 Section 230.03, and Section 230.07	
		Manufacturer	Manufacturer				

BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS	
		SAMPLED BY	TESTED BY				
578	STANDARD SPECIFICATION SECTION: <b>578 – PRECAST CONCRETE CULVERT</b>						
	Precast Concrete Culvert	ACCEPTANCE Certification	706.01 706.04	AASHTO M 170	ITD-851 ITD-914 with mill test reports attached for steel/iron	Total Quantity Paid	See QA Manual Section 230.01 Section 230.03 and Section 230.04
			Manufacturer	Manufacturer			
	Gaskets for Concrete Pipe	ACCEPTANCE Certification	706.11	ASTM C990	ITD-851	Total Quantity Paid	See QA Manual Section 230.01
			Manufacturer	Manufacturer			
	Compacting Backfill (Pipe Backfill)	ACCEPTANCE In-Place Density	210.03	FOP for AASHTO T 180 Idaho IT-74 AASHTO T 310 Method B	ITD 850	Each 200 LF of pipe installed, but no less than one (1) test per pipe installed.	A pipe is considered the total continuous length as shown on the project pipe summary sheet. If this contract has a pay item for pipe backfill in the 210 section post test results in the 210 item.
			ITD Project Personnel	ITD Project Personnel			
			INDEPENDENT ASSURANCE In-Place Density	IA Inspector	IA Inspector	ITD-857	1 observation of density per project



BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS		
		SAMPLED BY	TESTED BY					
STANDARD SPECIFICATION SECTION: 579 – BOND REINFORCING STEEL								579
Adhesive	ACCEPTANCE Certification	720.04	AASHTO M 31	ITD-851	Total Quantity Paid	See QA Manual Section 230.01		
		Manufacturer	Manufacturer					
STANDARD SPECIFICATION SECTION: 581 – CONCRETE CRACK REPAIR								581
Epoxy Resin for Surface Sealing	ACCEPTANCE Certification	581.02	ASTM C881 Type 1, Grade 3, Class B and C	ITD-851	Total Quantity Paid	See QA Manual Section 230.01		
		Manufacturer	Manufacturer					
Epoxy Resin for Injection	ACCEPTANCE Certification	581.02	ASTM C881 Type 1 and IV, Grade 1, Class B and C	ITD-851	Total Quantity Paid	See QA Manual Section 230.01		
		Manufacturer	Manufacturer					
STANDARD SPECIFICATION SECTION: 582 – PATCH AND REPAIR OF CONCRETE								
Concrete Surface Patching Material	ACCEPTANCE Certification	582.02	ASTM C109 ASTM C882 ASTM C531 ASTM C157	ITD-851	Total Quantity Paid	See QA Manual Section 230.01		
		Manufacturer	Manufacturer					
Concrete Deck Patching Material	ACCEPTANCE Certification	582.02	ASTM C928, Type R3	ITD-851	Total Quantity Paid	See QA Manual Section 230.01		
		Manufacturer	Manufacturer					
STANDARD SPECIFICATION SECTION: 584 –TEMPORARY SHORING								584
Temporary shoring	ACCEPTANCE Inspection	584.02		ITD-854	Total Quantity Paid	See QA Manual Section 230.01		
		ITD Project Personnel	No Testing Required					
STANDARD SPECIFICATION SECTION: 586 –UTILITY CONDUIT								586-1
Utility Conduit	ACCEPTANCE Certification	586.02		ITD-851 ITD-914 with mill test reports attached for steel/iron	Total Quantity Paid	See QA Manual Section 230.08		
		Manufacturer	Manufacturer					
Deck Inserts	ACCEPTANCE Certification	586.02		ITD-851 ITD-914 with mill test reports attached for steel/iron	Total Quantity Paid	See QA Manual Section 230.08		
		Manufacturer	Manufacturer					
Standard Weighth Steel Pipe	ACCEPTANCE Certification	586.02	ASTM A53, Grade B or A501	ITD-851 ITD-914 with mill test reports attached for steel/iron	Total Quantity Paid	See QA Manual Section 230.03		
		Manufacturer	Manufacturer					

	BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS
			SAMPLED BY	TESTED BY			
586-2	Compacting Backfill (Pipe Backfill)	ACCEPTANCE In-Place Density	210.03	FOP for AASHTO T 180 Idaho IT-74 AASHTO T 310 Method B	ITD-850	Each 200 LF of pipe installed, but no less than one (1) test per pipe installed.	A pipe is considered the total continuous length as shown on the project pipe summary sheet. If this contract has a pay item for pipe backfill in the 210 section post test results in the 210 item.
			ITD Project Personnel	ITD Project Personnel			
		INDEPENDENT ASSURANCE In-Place Density	IA Inspector	IA Inspector	ITD-857	1 observation of density per project	
587	STANDARD SPECIFICATION SECTION: <b>587 – PAINTING STRUCTURAL STEEL</b>						
	Coating System	ACCEPTANCE Pre-Tests	707.02		ITD-1832	All lots (1-quart can sample size)	Record lot numbers and lab numbers of approved pre- tested paint from ITD Central Lab letter and/ or ITD-1832.
			Coordinate with ITD Central Lab	ITD Central Lab			
		ACCEPTANCE Certification	707.03		ITD-851	Total Quantity Paid	See QA Manual Section 230.01
			Manufacturer	Manufacturer			

BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS
		SAMPLED BY	TESTED BY			
STANDARD SPECIFICATION SECTION: 602 - CULVERTS, 603 - PIPE SIPHONS, 604 - IRRIGATION PIPE LINES, 605 - SEWERS, 606 - PIPE UNDERDRAINS, 607 - EMBANKMENT PROTECTORS, 608 - APRONS FOR PIPE						
Corrugated Metal Pipe and Pipe Arches	ACCEPTANCE Certification	706.06	AASHTO M 36 or AASHTO M 196	ITD-914 with mill test reports attached for steel/iron & ITD-851 for aluminum	Total Quantity Paid	See QA Manual Section 230.01 Section 230.03, and Section 230.07
		Manufacturer	Manufacturer			
	ACCEPTANCE Certification	706.06	AASHTO M 36 Galvanized Coating	ITD-914 with QC results attached	Total Quantity Paid .	See QA Manual Section 230.07
		Manufacturer	Manufacturer			
Structural Plate Pipe, Pipe Arches and Arches	ACCEPTANCE Certification	708.20	AASHTO M 167 or AASHTO M 219	ITD-914 with mill test reports attached for steel/iron	Total Quantity Paid	See QA Manual Section 230.01 and Section 230.03
		Manufacturer	Manufacturer			
Concrete Pipe for Sewer, Irrigation or Drainage (Non-Reinforced)	ACCEPTANCE Certification	706.01 706.02 706.03	AASHTO M 86 ASTM C118	ITD-851 or ITD-914 with mill test reports attached for steel/iron	Total Quantity Paid	See QA Manual Sections 230.01, Section 230.03 and Section 230.04 ITD-914 is not required if metal reinforcement is not used
		Manufacturer	Manufacturer			
Reinforced Concrete Culvert, Storm Drain and Sewer Pipe	ACCEPTANCE Certification	706.01 706.04	AASHTO M 170	ITD-851 or ITD-914 with mill test reports attached for steel/iron	Total Quantity Paid	See QA Manual Section 230.01, Section 230.03 and Section 230.04
		Manufacturer	Manufacturer			
Pipe Underdrains (metallic coated corrugated steel, corrugated aluminum pipe, corrugated PE drainage tubing PVC pipe)	ACCEPTANCE Certification	706.07 706.08 706.10 706.14	AASHTO M 36 AASHTO M 196 AASHTO M 252 AASHTO M 278	ITD-851 or ITD-914 with mill test reports attached for steel/iron	Total Quantity Paid	See QA Manual Section 230.01 and Section 230.03
		Manufacturer	Manufacturer			

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602, 603, 604, 605, 606, 607, 608-1

	BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS
			SAMPLED BY	TESTED BY			
602, 603, 604, 605, 606, 607, 608-2	ABS or PVC or PE Pipe	ACCEPTANCE Certification	706.13 706.14 706.15 706.16 706.17	ASTM D2680 AASHTO M 278 ASTM F794 AASHTO M 294 ASTM F894	ITD-851	Total Quantity Paid	See QA Manual Section 230.06
			Manufacturer	Manufacturer			
	Metal Aprons	ACCEPTANCE Certification	608 708.21	AASHTO M 36 or AASHTO M 196	ITD-914 with mill test reports attached for steel/iron	Total Quantity Paid	See QA Manual Section 230.01 and Section 230.03
			Manufacturer	Manufacturer			
	Concrete Aprons	ACCEPTANCE Certification	608 509.01-B		ITD-875 with QC test reports attached ITD 914 with mill test results attached for steel/iron	Total Quantity Paid	See QA Manual Section 230.01 Section 230.03, and Section 230.06 Manufacturer certification Note locations on ITD-875
			Manufacturer	Manufacturer			
	Gaskets for Concrete Pipe	ACCEPTANCE Certification	706.11	ASTM C990	ITD-851	Total Quantity Paid	See QA Manual Section 230.01
			Manufacturer	Manufacturer			
	Rubber Gaskets for CMP	ACCEPTANCE Certification	706.12	ASTM D1056	ITD-851	Total Quantity Paid	See QA Manual Section 230.01
			Manufacturer	Manufacturer			
	Manhole Covers and Rings, Grates	ACCEPTANCE Certification	708.22	AASHTO M 105	ITD-851 ITD-914 with mill test reports attached for steel/iron	Total Quantity Paid	See QA Manual Section 230.01 and Section 230.03
			Manufacturer	Manufacturer			
	Catch Basins, Inlets & Manholes (Pre-cast)	ACCEPTANCE Certification	609 Standard Drawings 605		ITD-875 ITD-914 with mill test reports attached for steel/iron	Total Quantity Paid	See QA Manual Section 230.01, Section 230.03 and Section 230.06
			Manufacturer	Manufacturer			
	Catch Basins, Inlets & Manholes (Cast in-Place)	ACCEPTANCE Certification	609 Standard Drawings 605		ITD-875 with QC test reports attached ITD-914 With mill test results attached for steel/iron	Total Quantity Paid	See QA Manual Section 230.01, Section 230.03 and Section 230.06 Concrete Supplier's certification Note locations on ITD-875
			Manufacturer	Manufacturer			

BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS
		SAMPLED BY	TESTED BY			
Corrugated Metal Embankment Protectors	ACCEPTANCE Certification	607.02 706.06	AASHTO M 36 AASHTO M 196	ITD-914 with test reports attached for steel/iron	Total Quantity Paid	See QA Manual Section 230.01 and Section 230.03
		Manufacturer	Manufacturer			
Compacting Backfill	FOLLOW MTR TABLE STANDARD SPECIFICATION SECTION 210					
Drain Rock	ACCEPTANCE Certification	606.02	FOP for AASHTO R 90 FOP for AASHTO R 76 FOP for AASHTO T 27	ITD-851 with QC gradation tests attached	Total Quantity Paid	See QA Manual Section 230.01
		Contractor	Contractor			
Geotextile	FOLLOW MTR TABLE STANDARD SPECIFICATION SECTION 640					
STANDARD SPECIFICATION SECTION: 609 - MINOR STRUCTURES						
Concrete  Specified strength of 3,000 psi or less	ACCEPTANCE Certification	509		ITD-851 (Precast) ITD-875 (Cast in Place) with QC test results attached	Total Quantity Paid	See QA Manual Section 230.06  Concrete Supplier's certification  Note locations on ITD-875.
		Concrete Supplier	Concrete Supplier			
Concrete  Specified strength of 3,500 psi or greater	FOLLOW MTR TABLE STANDARD SPECIFICATION SECTION 502					
Metal Reinforcement [with concrete of specified strength of 3,000 psi or less]	ACCEPTANCE Certification	708.02		ITD-914 with mill test reports attached	Total Quantity Paid	See QA Manual Section 230.03  No samples required.
		Manufacturer	Manufacturer			
Metal Reinforcement [with concrete of specified strength of 3,500 psi or greater]	FOLLOW MTR TABLE STANDARD SPECIFICATION SECTION 503					
Timber	ACCEPTANCE Certification	710		ITD-851	Total Quantity Paid	
		Manufacturer	Manufacturer			
Compacting Backfill	FOLLOW MTR TABLE STANDARD SPECIFICATION SECTION 210					

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	BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS
			SAMPLED BY	TESTED BY			
610	STANDARD SPECIFICATION SECTION: <b>610 - FENCE</b>						
	Barbed Wire	ACCEPTANCE Certification	708.09		ITD-914 with mill test reports attached for steel/iron	Total Quantity Paid	See QA Manual Section 230.01 and Section 230.03
				No Testing Required			
	Woven Wire	ACCEPTANCE Certification	708.10		ITD-914 with mill test reports attached for steel/iron	Total Quantity Paid	See QA Manual Section 230.01 and Section 230.03
				No Testing Required			
	Chain Link	ACCEPTANCE Certification	708.13		ITD-914 with mill test reports attached for steel/iron	Total Quantity Paid	See QA Manual Section 230.01 and Section 230.03
				No Testing Required			
	Metal Posts for all fence types	ACCEPTANCE Certification	708.12		ITD-914 with mill test reports attached for steel/iron	Total Quantity Paid	See QA Manual Section 230.01 and Section 230.03
			ITD Project Personnel	No Testing Required			
	Wood Posts	ACCEPTANCE Inspection	710.08	Visual Inspection	ITD-854	Total Quantity Paid	RE Letter-See QA Manual Section 250.00
				No Testing Required			
	Gates	ACCEPTANCE Inspection or Certification for steel/iron	610.03	Visual Inspection	ITD-854 or ITD-914 with mill test reports attached for steel/iron	Total Quantity Paid	See QA Manual Section 230.01 & Section 230.03  RE Letter-See QA Manual Section 250.00
				No Testing Required			
	Braces	ACCEPTANCE Inspection or Certification for steel/iron	610.03	Visual Inspection	ITD-854 or ITD-914 with mill test reports attached for steel/iron	Total Quantity Paid	See QA Manual Section 230.01 & Section 230.03  RE Letter-See QA Manual Section 250.00
				No Testing Required			
	Hardware for Barbed or Woven Wire Fence	ACCEPTANCE Inspection or Certification for steel/iron	708.11	Visual Inspection	ITD-854 or ITD-914 with <b>no</b> mill test reports attached for steel/iron	Total Quantity Paid	See QA Manual Section 230.01 & Section 230.03  RE Letter-See QA Manual Section 250.00
Concrete	ACCEPTANCE Certification	509		ITD-875	Total Quantity Paid	See QA Manual Section 230.06  Concrete Supplier's certification	
			No Testing Required				

BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS
		SAMPLED BY	TESTED BY			
STANDARD SPECIFICATION SECTION: 611 - CATTLE GUARDS						
Concrete	ACCEPTANCE Certification	509		ITD-875 with QC test results attached	Total Quantity Paid	See QA Manual Section 230.06  Concrete Supplier's certification
		Concrete Supplier	Concrete Supplier			
Metal Reinforcement	ACCEPTANCE Certification	708.02		ITD-914 with mill test reports attached	Total Quantity Paid	See QA Manual Section 230.01 and Section 230.03
		Manufacturer	Manufacturer			
Structural Metals	ACCEPTANCE Certification	504.02	(1)	ITD-914 with mill test reports attached for steel/iron	Total Quantity Paid	See QA Manual Section 230.01 and Section 230.03
		Manufacturer	Manufacturer			
Culverts	FOLLOW MTR TABLE STANDARD SPECIFICATION SECTION 602					
Fence	FOLLOW MTR TABLE STANDARD SPECIFICATION SECTION 610					
(1) Fabrication Inspection by ITD Central Lab required when quantities over 16 Tons.						

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BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS	
		SAMPLED BY	TESTED BY				
612-1	STANDARD SPECIFICATION SECTION: 612 – GUARDRAIL						
	Wood Post and Blocks	ACCEPTANCE Certification	710.03 710.09		ITD-851	Total Quantity Paid	See QA Manual Section 230.01
			Manufacturer	Manufacturer			
	Steel Post	ACCEPTANCE Certification	708.07		ITD-914 with mill test reports attached for steel/iron	Total Quantity Paid	See QA Manual Section 230.01 and Section 230.03
			Manufacturer	Manufacturer			
	Blocks (Other than wood)	ACCEPTANCE Certification	QPL		ITD-851	Total Quantity Paid	See QA Manual Section 230.01 and Section 230.03
			Manufacturer	Manufacturer			
	Steel Rail	ACCEPTANCE Certification	708.14		ITD-914 with mill test reports attached for steel/iron	Total Quantity Paid	See QA Manual Section 230.01 and Section 230.03
			Manufacturer	Manufacturer			
	Bolts, Nuts, Washers, and Fittings	ACCEPTANCE Certification	708.14		ITD-914 <b>No</b> mill test reports for steel/iron	Total Quantity Paid	See QA Manual Section 230.01 and Section 230.03
			Manufacturer	Manufacturer			
	Aluminum Rail and Fittings	ACCEPTANCE Certification	708.25		ITD-851	Total Quantity Paid	See QA Manual Section 230.01
			Manufacturer	Manufacturer			
	Metal Terminal Section	ACCEPTANCE Certification (2)	Standard Drawings Section G		ITD-851 ITD-914 with mill test reports attached for steel/iron	Total Quantity Paid	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
			Manufacturer	Manufacturer			
	Impact Attenuator (Temporary or Permanent)	ACCEPTANCE Certification (2)	[Special Provision]		ITD-851 ITD-914 with mill test reports attached for steel/iron	Total Quantity Paid	See QA Manual Section 230.01 and Section 230.03
Manufacturer			Manufacturer				
(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.							



BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS
		SAMPLED BY	TESTED BY			
STANDARD SPECIFICATION SECTION: 612 - CONCRETE BARRIER						
Pre-Cast	ACCEPTANCE Certification (3)	502.01-B		ITD-875 with QC test results attached*	Total Quantity Paid	See QA Manual Section 230.01 and Section 230.05
		Manufacturer	Manufacturer			
Cast-In-Place Specified strength of 3,000 psi or less	ACCEPTANCE Certification (3)	502.01-B		ITD-875 with QC test results attached	Total Quantity Paid	See QA Manual Section 230.06  Concrete Supplier's certification Note locations on ITD-875.
		Concrete Supplier	Concrete Supplier			
Cast-In-Place Specified strength of 3,500 psi or greater	FOLLOW MTR TABLE STANDARD SPECIFICATION SECTION 502					
Metal Reinforcement	ACCEPTANCE Certification (3)	503.02 708.02		ITD-914 with mill test results attached for steel/iron	Total Quantity Paid	See QA Manual Section 230.01 and Section 230.03
		Manufacturer	Manufacturer			
Concrete Terminal Section	ACCEPTANCE Certification (3)	Standard Drawings Section G		ITD-875 with QC test results attached*	Total Quantity Paid	See QA Manual Section 230.01
		Manufacturer	Manufacturer			
STANDARD SPECIFICATION SECTION: 613 - CRASH CUSHIONS						
Concrete	ACCEPTANCE Certification	509		ITD-875 with QC test results attached*	Total Quantity Paid	See QA Manual Section 230.06  Concrete Supplier's certification Note locations on ITD-875.
		Concrete Supplier	Concrete Supplier			
Metal Reinforcement	FOLLOW MTR TABLE STANDARD SPECIFICATIONS SECTION 503					
Device	ACCEPTANCE Certification (3)	613		ITD 851	Total Quantity Paid	See QPL for list of acceptable devices.
		Manufacturer	Manufacturer			
(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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613.

	BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS
			SAMPLED BY	TESTED BY			
614	STANDARD SPECIFICATION SECTION: 614 - SIDEWALKS, DRIVEWAYS, CURB RAMPS						
	Concrete	ACCEPTANCE Certification	509		ITD-875 with QC test results attached*	Total Quantity Paid	See QA Manual Section 230.06 Concrete Supplier's certification  Note locations on ITD-875.
			Concrete Supplier	Concrete Supplier			
	Agg. Base Compaction	ACCEPTANCE Inspection	614.03			Total Quantity Paid	Minimum 2 passes of lightweight mech. Tamper, roller, or vibratory system.
			ITD Project Personnel	No Testing Required			
	Subgrade Compaction	ACCEPTANCE In-Place Density	614.02	FOP for AASHTO T 99 FOP for AASHTO T 310 Method B	ITD-850	1 per project	
			ITD Project Personnel	ITD Project Personnel			
615	STANDARD SPECIFICATION SECTION: 615 - CURB AND GUTTER						
	Class 30 Concrete (cast-in-place, precast, extruded)	ACCEPTANCE Certification	509		ITD-875 with test results attached*	Total Quantity Paid	See QA Manual Section 230.06 Concrete Supplier's certification  Note locations on ITD-875.
			Concrete Supplier	Concrete Supplier			
	Superpave HMA ½" SP 2 or 3, Non-structural	ACCEPTANCE Inspection	405		ITD-854	Total Quantity Paid	RE Letter-See QA Manual Section 250.00
				No Testing Required			
	Metal Reinforcement	ACCEPTANCE Certification	708.02		ITD-914 with mill test reports attached for steel/iron	Total Quantity Paid	See QA Manual Section 230.01 and Section 230.03  No samples required.
			Manufacturer	Manufacturer			
* When total is less than 50CY, QC tests can be from previous batches in the 30 days prior to the first placement.							

BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS
		SAMPLED BY	TESTED BY			
STANDARD SPECIFICATION SECTION: 616 - SIGNS AND SIGN SUPPORTS						
Sign Material <i>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.</i>	ACCEPTANCE Certification	Extruded Aluminum 708.26		ITD-851	Total Quantity Paid	See QA Manual Section 230.01
		Manufacturer	Manufacturer			
	ACCEPTANCE Certification	Sheet Aluminum 708.27		ITD-851	Total Quantity Paid	See QA Manual Section 230.01
		Manufacturer	Manufacturer			
	ACCEPTANCE Certification	Steel and Aluminum sign supports 708.17-A		ITD-851 or ITD-914 with mill test reports attached for steel/iron	Total Quantity Paid	See QA Manual Section 230.01 and Section 230.03
		Manufacturer	Manufacturer			
	ACCEPTANCE Certification	Hardware for signs 708.18		ITD-851 or ITD-914 With <b>no</b> mill test reports for steel/iron	Total Quantity Paid	See QA Manual Section 230.01 and Section 230.03
		Manufacturer	Manufacturer			
	ACCEPTANCE Certification	Plywood for Type E signs 712.01		ITD-851	Total Quantity Paid	See QA Manual Section 230.01
		Manufacturer	Manufacturer			
	ACCEPTANCE Certification	Reflective Sheeting 712.02		ITD-851	Total Quantity Paid	See QA Manual Section 230.01
		Manufacturer	Manufacturer			

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616-1

	BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS
			SAMPLED BY	TESTED BY			
616-2	Overhead Sign Structures	ACCEPTANCE Certification	708.17-B Manufacturer	Manufacturer	ITD-851 or ITD-914 with mill test reports attached for steel/iron	Total Quantity Paid	ITD Central Lab Inspection required See QA Manual Section 230.01 and Section 230.03
	Breakaway Wood Posts	ACCEPTANCE Certification	710.02 710.09 Manufacturer	Manufacturer	ITD-851	Total Quantity Paid	See QA Manual Section 230.01 The manufacturer must provide a copy of the wood treatment certification to ITD Central Materials Laboratory.
	Steel Brackets and Brace angles	ACCEPTANCE Certification	708.17-A 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
	Breakaway Steel Sign Posts	ACCEPTANCE Certification	708.17-A 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
	Breakaway Steel Sign Post Installation	ACCEPTANCE Inspection	708.17-A		ITD-854	Total Quantity Paid	See QA Manual Section 230.01
	Concrete Specified strength of 3,000 psi or less	ACCEPTANCE Certification	509.01-B Concrete Supplier	Concrete Supplier	ITD-875 with QC test results attached	Total Quantity Paid	See QA Manual Section 230.06 Concrete Supplier's certification Note locations on ITD- 875
	Concrete Specified strength of 3,500 psi or greater	FOLLOW MTR TABLE STANDARD SPECIFICATION SECTION 502					
	Metal Reinforcement [with concrete of specified strength of 3,000 psi or less]	ACCEPTANCE Certification	708.02 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 No samples required.
	Metal Reinforcement [with concrete of specified strength of 3,500 psi or greater]]	FOLLOW MTR TABLE STANDARD SPECIFICATION SECTION 503					

BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS
		SAMPLED BY	TESTED BY			
STANDARD SPECIFICATION SECTION: 617 - DELINEATORS AND MILEPOSTS						
Steel Posts	ACCEPTANCE Certification	708.16		ITD-914 with mill test reports attached for steel/iron	Total Quantity Paid	See QA Manual Section 230.01 and Section 230.03
		Manufacturer	Manufacturer			
Aluminum Posts	ACCEPTANCE Certification	708.16		ITD-851	Total Quantity Paid	See QA Manual Section 230.01
		Manufacturer	Manufacturer			
Delineator and Milepost Plates	ACCEPTANCE Certification	708.15		ITD-851	Total Quantity Paid	See QA Manual Section 230.01
		Manufacturer	Manufacturer			
Reflector Units	ACCEPTANCE Certification	712.04		ITD-851	Total Quantity Paid	See QA Manual Section 230.01
		Manufacturer	Manufacturer			
Reflective Sheeting	ACCEPTANCE Certification	712.02		ITD-851	Total Quantity Paid	See QA Manual Section 230.01
		Manufacturer	Manufacturer			
Silk Screen Paste	ACCEPTANCE Certification	712.08		ITD-851	Total Quantity Paid	See QA Manual Section 230.01
		Manufacturer	Manufacturer			

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BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS	
		SAMPLED BY	TESTED BY				
618	STANDARD SPECIFICATION SECTION: 618 - MARKER POSTS, WITNESS POSTS AND STREET MONUMENTS						
	Right-of-Way Markers	ACCEPTANCE Inspection or Certification for steel/iron	618.02		ITD-854 or ITD-914 with mill test reports attached for steel/iron	Total Quantity Paid	RE Letter-See QA Manual Section 250.00 See QA Manual Section 230.01 and Section 230.03
				No Testing Required			
	Brass Caps	ACCEPTANCE Inspection	708.28		ITD-854	Total Quantity Paid	RE Letter-See QA Manual Section 250.00
				No Testing Required			
	Reference Markers	ACCEPTANCE Inspection or Certification for steel/iron	618.02		ITD-854 or ITD-914 with mill test reports attached for steel/iron	Total Quantity Paid	RE Letter-See QA Manual Section 250.00 See QA Manual Section 230.01 and Section 230.03
				No Testing Required			
	Project Markers	ACCEPTANCE Inspection or Certification for steel/iron	618.02		ITD-854 ITD-914 with mill test reports attached for steel/iron	Total Quantity Paid	RE Letter-See QA Manual Section 250.00 See QA Manual Section 230.01 and Section 230.03
				No Testing Required			
	Witness Posts	ACCEPTANCE Inspection or Certification for steel/iron	Steel 708.16		ITD-854 or ITD-914 with mill test reports attached for steel/iron	Total Quantity Paid	RE Letter-See QA Manual Section 250.00 See QA Manual Section 230.01 and Section 230.03
				No Testing Required			
		ACCEPTANCE Inspection	Wood 710.09		ITD-854	Total Quantity Paid	RE Letter-See QA Manual Section 250.00
				No Testing Required			
		ACCEPTANCE Inspection	Fiberglass 618.02		ITD-854	Total Quantity Paid	RE Letter-See QA Manual Section 250.00
				No Testing Required			
	Street Monuments	ACCEPTANCE Inspection or Certification for steel/iron	618.02		ITD-854 or ITD-914 with test reports attached for steel/iron	Total Quantity Paid	RE Letter-See QA Manual Section 250.00 See QA Manual Section 230.01 and Section 230.03
				No Testing Required			

BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS
		SAMPLED BY	TESTED BY			
STANDARD SPECIFICATION SECTION: 619 - ILLUMINATION						
Illumination Poles and Bases	ACCEPTANCE Certification	708.19 710.06		ITD-851 or ITD-914 with mill test reports attached for steel/iron	Total Quantity Paid	See QA Manual Section 230.01 and Section 230.03
		Manufacturer	Manufacturer			
Illumination Components	ACCEPTANCE Inspection or Certification for steel/iron	710.07 713.01 713.02 713.03 713.04 713.05 713.06		ITD-854 or ITD-914 with mill test reports attached for steel/iron	Total Quantity Paid	RE Letter-See QA Manual Section 250.00 See QA Manual Section 230.01 and Section 230.03
			No Testing Required			
Concrete Specified strength of 3,000 psi or less	ACCEPTANCE Certification	509.01(B)		ITD-875 with QC test results attached	Total Quantity Paid	See QA Manual Section 230.06  Concrete Supplier's certification  Note locations on ITD-875
		Concrete Supplier	Concrete Supplier			
Concrete Specified strength of 3,500 psi or greater	FOLLOW MTR TABLE STANDARD SPECIFICATION SECTION 502					
Metal Reinforcement [with concrete of specified strength of 3,500 psi or greater]	FOLLOW MTR TABLE STANDARD SPECIFICATION SECTION 503					
Metal Reinforcement [with concrete of specified strength of 3,000 psi or less]	ACCEPTANCE Certification	503.02 708.02		ITD-914 with mill test reports attached for steel/iron	Total Quantity Paid	See QA Manual Section 230.01 and Section 230.03  No samples required.
		Manufacturer	Manufacturer			

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	BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS
			SAMPLED BY	TESTED BY			
620	STANDARD SPECIFICATION SECTION: 620 - PLANTING						
	Plants, Commercial Fertilizer, Soil Conditioner, Topsoil, Mulch	ACCEPTANCE Inspection	711.06 711.07 711.08 711.09 711.10 711.12	Visual Inspection	ITD-854	Total Quantity Paid	RE Letter-See QA Manual Section 250.00
				No Testing Required			
621	STANDARD SPECIFICATION SECTION: 621 - SEEDING						
	Seed, Mulch, Commercial Fertilizer, Rolled Erosion Control Products (RECP), Turf Reinforcement Mats, Irrigation Water, Mulch Tackifier	ACCEPTANCE Certification ACCEPTANCE Certification	711.05 711.07 711.10 711.11 711.12 711.16	AOSA	ITD-851* with Laboratory Analysis Report attached	Total Quantity Paid	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.
			Licensed Supplier / Manufacturer	Licensed Supplier / Manufacturer			
			704.02				
		VERIFICATION Laboratory Test <u>Seed Only</u>	Manufacturer	Manufacturer	ISDA Test Results	1 for each individually packaged seed containers from each species	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.
			711.05 ITD Project Inspector	Purity and Viability, (Germination & Tetrazolium (TZ)) (Boise) ISDA Seed Laboratory			
			ITD Project Inspector	(Boise) ISDA Seed Laboratory			
	622	STANDARD SPECIFICATION SECTION: 622 – PRECAST CONCRETE HEADGATES					
Pre-Cast Concrete Head gates		ACCEPTANCE Certification	502.01-B		ITD-851 & ITD-914 with mill test reports attached for steel/iron	Total Quantity Paid	See QA Manual Section 230.05 See QA Manual Section 230.01 & Section 230.03
			Manufacturer	Manufacturer			



BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS		
		SAMPLED BY	TESTED BY					
STANDARD SPECIFICATION SECTION: 623 - CONCRETE SLOPE PAVING								623
Concrete	ACCEPTANCE Certification	502.01-B		ITD-875 with QC test results attached  ITD-914 with mill test reports attached for steel/iron	Total Quantity Paid	See QA Manual Section 230.06 Concrete Supplier certification Note locations on ITD-875 See QA Manual Section 230.01 & Section 230.03		
		Concrete Supplier	Concrete Supplier					
Pre-formed- expansion Joint Fillers	ACCEPTANCE Certification	623.02	AASHTO M 213	ITD-851	Total Quantity Paid	See QA Manual Section 230.01		
		Manufacturer	Manufacturer					
Compaction	FOLLOW MTR TABLE STANDARD SPECIFICATION SECTION 205 or 303							
STANDARD SPECIFICATION SECTION: 624 - RIPRAP								624
Loose Placed	ACCEPTANCE Inspection	711.04	Visual Inspection	ITD-854	Total Quantity Paid	RE Letter-See QA Manual Section 250.00  Initial testing required for Apparent Specific Gravity, Absorption, (AASHTO T 85) and Coarse durability Index, (AASHTO T 210). Only visual inspection during placement.		
			ITD Project Personnel					
STANDARD SPECIFICATION SECTION: 625 - JOINTS								625
Pre-Formed Expansion Joint Filler	ACCEPTANCE Certification	704.01		ITD-851	Total Quantity Paid	See QA Manual Section 230.01		
		Manufacturer	Manufacturer					
Hot Poured Elastic Type Concrete Joint Sealer	ACCEPTANCE Certification	704.02		ITD-851	Total Quantity Paid	See QA Manual Section 230.01		
		Manufacturer	Manufacturer					
Hot Poured Elastomeric Type Concrete Joint Sealer	ACCEPTANCE Certification	704.03		ITD-851	Total Quantity Paid	See QA Manual Section 230.01		
		Manufacturer	Manufacturer					
Neoprene Compression Seal	ACCEPTANCE Certification	704.04		ITD-851	Total Quantity Paid	See QA Manual Section 230.01		
		Manufacturer	Manufacturer					
Silicone Sealant	ACCEPTANCE Certification	704.05		ITD-851 with test results attached	Total Quantity Paid	See QA Manual Section 230.01		
		Independent Laboratory	Independent Laboratory					

BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS	
		SAMPLED BY	TESTED BY				
626	STANDARD SPECIFICATION SECTION: 626 – TEMPORARY TRAFFIC CONTROL						
	Rent Construction Signs, Barricades, Drums, Portable Tubular Markers, Incidental Traffic Control Items	ACCEPTANCE Inspection	Reflectivity 712.02		ITD-854	Total Quantity Paid	RE Letter-See QA Manual Section 250.00
				No Testing Required			
	Rent Vertical Panels, Advance Warning Arrow Panel, Traffic Control Signal, Hazard Identification Beacon	ACCEPTANCE Inspection	Reflectivity 712.02		ITD-854	Total Quantity Paid	RE Letter-See QA Manual Section 250.00
				No Testing Required			
	Temporary Pavement Striping Tape	ACCEPTANCE Inspection	Reflectivity 712.02		ITD-854	Total Quantity Paid	RE Letter-See QA Manual Section 250.00
				No Testing Required			
	Temporary Flexible Raised Pavement Marker	ACCEPTANCE Inspection	Reflectivity 712.02		ITD-854	Total Quantity Paid	RE Letter-See QA Manual Section 250.00
				No Testing Required			
	Temporary Rigid Raised Pavement Marker	ACCEPTANCE Inspection	Reflectivity 712.02		ITD-854	Total Quantity Paid	RE Letter-See QA Manual Section 250.00
			No Testing Required				

BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS
		SAMPLED BY	TESTED BY			
STANDARD SPECIFICATION SECTION: 627 - PAINTING						
Painting Steel(4)	ACCEPTANCE Pre-Tests(4)	707.02		ITD-1832	All lots (1-quart can sample size)	Record lot numbers and lab numbers of approved pre- tested paint from ITD Central Lab letter and/ or ITD-1832.
		Coordinate with ITD Central Lab	ITD Central Lab			
	ACCEPTANCE Certification	707.03		ITD-851	Total Quantity Paid	See QA Manual Section 230.01
		Manufacturer	Manufacturer			
Painting Wood(4)	ACCEPTANCE Pre-Tests(4)	707.02			All lots (1-quart can sample size)	Record lot numbers and lab numbers of approved pre- tested paint from ITD Central Lab letter.
		Coordinate with ITD Central Lab	ITD Central Lab			
	ACCEPTANCE Certification	707.03		ITD-851	Total Quantity Paid	See QA Manual Section 230.01
		Manufacturer	Manufacturer			
Painting Concrete(4)	ACCEPTANCE Pre-Tests(4)	702.02		ITD-1832	All lots (1-quart can sample size)	Record lot numbers and lab numbers of approved pre- tested paint from ITD Central Lab letter.
		Coordinate with ITD Central Lab	ITD Central Lab			
	ACCEPTANCE Certification	707.03		ITD-851	Total Quantity Paid	See QA Manual Section 230.01
		Manufacturer	Manufacturer			
(4)Acceptance by Manufacturer's Certification when total project quantity is less than 25 gallons.						

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	BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS
			SAMPLED BY	TESTED BY			
628	STANDARD SPECIFICATION SECTION: <b>628 - SNOW POLES</b>						
	Rigid Posts for Delineators, Snow Poles, and Mileposts	ACCEPTANCE Inspection Inspection or Certification for steel/iron	708.16		ITD-854 or ITD-914 with mill test reports attached for steel/iron	Total Quantity Paid	RE Letter-See QA Manual Section 250.00 See QA Manual Section 230.01 and Section 230.03
				No Testing Required			
	Reflector Units for Delineators	ACCEPTANCE Inspection	712.04		ITD-854	Total Quantity Paid	RE Letter-See QA Manual Section 250.00
				No Testing Required			
Flexible Snow Poles	ACCEPTANCE Approved List	712.11		Qualified Products List			
		Manufacturer	Manufacturer				
630	STANDARD SPECIFICATION SECTION: <b>630 – PAVEMENT MARKINGS</b>						
	Waterborne Paint(6)	ACCEPTANCE Laboratory Tests	707		ITD-1830	Each lot used on Project	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. <b>(Not project specific.)</b>  Reject if totes do not match lot numbers.
			ITD Project Personnel	ITD CentralLab			
	Glass Beads (7)	ACCEPTANCE Laboratory Tests			ITD-1828	50 pound sample of glass beads Each lot used on project (Sample must be left in manufacturer's bag.)	Record lot numbers and lab numbers of approved pre-tested beads from ITD Central Lab letter and/ or ITD-1828. <b>(Not project specific.)</b>
			ITD Project Personnel	ITD Central Laboratory			
Preformed Thermalplastic	ACCEPTANCE Certification			ITD-851	Total Quantity Paid	See QA Manual Section 230.01	
		Manufacturer	Manufacturer				
	(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 gallons.						

BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS
		SAMPLED BY	TESTED BY			
STANDARD SPECIFICATION SECTION: 631 – RUMBLE STRIPS						
Emulsified Asphalt	ACCEPTANCE Certification	702.02 702.05		Loading Certificate	Each individual truck, trailer, car or shipment to the project	See QA Manual section 230.11
		Manufacturer	Manufacturer			
	VERIFICATION Laboratory Testing	702.03		ITD-1045	1 undiluted sample (as received from the asphalt supplier) per project	No Samples required when total project quantity is less than 2000 Gal (8 Tons) (7600 L).
		ITD Project Personnel	ITD Central Materials Laboratory			
STANDARD SPECIFICATION SECTION: 634- MAILBOX						
Support	ACCEPTANCE Certification	708.16 710.02		ITD-851 or ITD-914 with mill test reports attached for steel/iron	Total Quantity Paid	See QA Manual Section 230.01 and Section 230.03
		Manufacture	Manufacturer			
Mailbox	ACCEPTANCE Inspection or Certification for steel/iron	634.02		ITD-854 or ITD-914 with mill test reports attached for steel/iron	Total Quantity Paid	RE Letter-See QA Manual Section 250.00  See QA Manual Section 230.01 and Section 230.03
			No Testing Required			
STANDARD SPECIFICATION SECTION: 635 - ANTI-SKID MATERIAL						
Aggregate (Production)	ACCEPTANC E Gradation	703.10	FOP for AASHTO R 90 FOP for AASHTO R 76 FOP for AASHTO T 11 FOP for AASHTO T 27	ITD-901	Each 1,000 Tons	
		ITD Project Personnel	ITD Project Personnel			
	INDEPENDENT ASSURANCE  Gradation Sand Equivalent	IA Inspector	IA Inspector	ITD-857	Each 20,000 Tons	

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BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS	
		SAMPLED BY	TESTED BY				
640	STANDARD SPECIFICATION SECTION: 640 - GEOSYNTHETICS						
	Drainage Geotextile	ACCEPTANCE Certification	718.05	ASTM D4632 ASTM D6241 ASTM D4751 ASTM D4491 ASTM D4533	ITD-849 with QC test results attached	Total Quantity Paid	See QA Manual Section 230.09
			Manufacturer	Manufacturer			
		VERIFICATION Laboratory Tests(5)	718.05	ASTM D4632 ASTM D6241 ASTM D4533	ITD- 1044(5A) (Sample Data)  ITD-1047 (Lab Reports)	1 sample per lot (5B)	See QA Manual Section 230.09 Samples will not be tested unless requested.
			ITD Project Personnel	ITD Central Lab			
	Riprap/Erosion Control Geotextile	ACCEPTANCE Certification	718.06	ASTM D4632 ASTM D6241 ASTM D4533 ASTM D4751 ASTM D4491 ASTM D4355	ITD-849 with QC test results attached	Total Quantity Paid	See QA Manual Section 230.09
			Manufacturer	Manufacturer			
		VERIFICATION Laboratory Tests(5)	718.06	ASTM D4632 ASTM D6241 ASTM D4533	ITD- 1044(5A) (Sample Data)  ITD-1047 (Lab reports)	1 sample per lot (5B)	See QA Manual Section 230.09 Samples will not be tested for ASTM D4632 unless requested.
			ITD Project Personnel	ITD Central Lab			
	Subgrade Separation Geotextile	ACCEPTANCE Certification	718.07	ASTM D4632 ASTM D6241 ASTM D4533 ASTM D4751 ASTM D4491	ITD-849 with QC test results attached	Total Quantity Paid	See QA Manual Section 230.09
			Manufacturer	Manufacturer			
		VERIFICATION Laboratory Tests(5)	718.07	ASTM D4632 ASTM D6241 ASTM D4533	ITD- 1044(5A) (Sample Data)  ITD-1047 (Lab reports)	1 sample per lot (5B)	See QA Manual Section 230.09 Samples will not be tested for ASTM D4632 and D4533unless requested.
ITD Project Personnel			ITD Central Lab				

BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS	
		SAMPLED BY	TESTED BY				
Pavement Overlay Geotextile	ACCEPTANCE Certification	718.08	ASTM D4632 ASTM D4533 ASTM D6140	ITD-849 with QC test results attached	Total Quantity Paid	See QA Manual Section 230.09	640
		Manufacturer	Manufacturer				
	VERIFICATION Laboratory Tests(5)	718.08	ASTM D4632 ASTM D4533 ASTM D6140	ITD- 1044(5A) (Sample Data)	1 sample per lot (5B)	See QA Manual Section 230.09 Samples will not be tested unless requested.	
		ITD Project Personnel	ITD Central Lab	ITD-1047 (Lab Reports)			
STANDARD SPECIFICATION SECTION: <b>641 – BIAXIAL GEOGRID</b>							
Geogrid	ACCEPTANCE Certification	641.02	ASTM D6637 ASTM D7748 GRI-GG2 (2000) COE CW-02215	ITD-849 with QC test results attached	Total Quantity Paid	See QA Manual Section 230.09	641
		Manufacturer	Manufacturer				
	VERIFICATION Laboratory Tests(5)	641.02	ASTM D6637	ITD- 1044(5A) (Sample Data)	1 sample per lot (5B)	See QA Manual Section 230.09	
		ITD Project Personnel	ITD Central Lab	ITD-1048 (Lab Reports)			
<p>(5) No Samples required for quantities less than 1000 square yards.</p> <p>(5A) Include acceptance certification documents with ITD-1044 and sample.</p> <p>(5B) A lot is defined as geotextile or geogrid rolls within the same consignment or shipment that a manufacturer produced under the same lot number with the same product name or designation (Section 718.03 Samples of ITD Standard Specifications)</p> <p>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:</p> <ul style="list-style-type: none"><li>• Prefabricated Vertical Drain (Wick Drain), Prefabricated Drainage Mat (Geocomposite Drainage System), Edge Drain, Geonet.</li><li>• Geocell (Cellular Confinement System).</li><li>• Geomembrane, Geosynthetic Clay Liner.</li></ul>							

	BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS
			SAMPLED BY	TESTED BY			
645	STANDARD SPECIFICATION SECTION: 645 – FIELD LABORATORIES						
	Field Laboratory Class I, II, III, & IV	ACCEPTANCE Certification	645		ITD-922 Provide proof of Laboratory Certification	1 per project	See Laboratory Operations Manual Section 230
			Contractor	Contractor			
		VERIFICATION Inspection	645		ITD-921	Prior to taking posession	See Laboratory Operations Manual Section 230
			ITD Project Personnel	ITD Project Personnel			
647	STANDARD SPECIFICATION SECTION: 647 – TEMPORARY TURBIDITY CURTAIN						
	Turbidity Curtain	ACCEPTANCE Certification	647	ASTM D4632 ASTM D6241 ASTM D4533 ASTM D4751 ASTM D4491	ITD-849 with QC test results attached	Total Quantity Paid	See QA Manual Section 230.09
			Manufacturer	Manufacturer			
		VERIFICATION Laboratory Tests(5)	647 718.07	ASTM D4632 ASTM D6241 ASTM D4533	See 640-Geotextiles, Subgrade Separation Geotextile		
			ITD Project Personnel	ITD Central Lab			
650	STANDARD SPECIFICATION SECTION: 650 – TIME-LAPSE CAMERA						
	Time Lapse Camera	ACCEPTANCE Certification	650		ITD-851	Total Quantity Paid	
			Manufacturer	Manufacturer			
651	STANDARD SPECIFICATION SECTION: 651 – LAWN CONSTRUCTION						
	Turf seed	ACCEPTANCE Certification	651		ITD-851	Total Quantity Paid	
			Manufacturer	Manufacturer			
	Sod	ACCEPTANCE Certification	651.02-A		ITD-851	Total Quantity Paid	
			Manufacturer	Manufacturer			
	Fertilizer and Soil Conditioners	ACCEPTANCE Certification	711.07 711.08		ITD-851	Total Quantity Paid	
Manufacturer			Manufacturer				



BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS										
		SAMPLED BY	TESTED BY													
Spil Amendment	ACCEPTANCE Certification	711.18		ITD-851	Total Quantity Paid		651									
		Manufacturer	Manufacturer													
Mulch	ACCEPTANCE Certification	711.10		ITD-851	Total Quantity Paid			652								
		Manufacturer	Manufacturer													
STANDARD SPECIFICATION SECTION: 652 – UNDERGROUND SPRINKLER SYSTEM							652									
Water Pipe and Fittings	ACCEPTANCE Certification	652.02-A		ITD-851	Total Quantity Paid				652							
		Manufacturer	Manufacturer													
Sprinkler Heads	ACCEPTANCE Certification	652.02-B		ITD-851	Total Quantity Paid			652								
		Manufacturer	Manufacturer													
Vacuum Breakers	ACCEPTANCE Certification	652.02-C		ITD-851	Total Quantity Paid					652						
		Manufacturer	Manufacturer													
Gate Valves	ACCEPTANCE Certification	652.02-D		ITD-851	Total Quantity Paid						652					
		Manufacturer	Manufacturer													
Quick Coupling Valves, Valve Cuoplers, and hose Swivels	ACCEPTANCE Certification	652.02-E		ITD-851	Total Quantity Paid							652				
		Manufacturer	Manufacturer													
Electric Automatic Controls	ACCEPTANCE Certification	652.02-F		ITD-851	Total Quantity Paid								652			
		Manufacturer	Manufacturer													
Section (Zone) Control Valves and master Valves	ACCEPTANCE Certification	652.02-G		ITD-851	Total Quantity Paid									652		
		Manufacturer	Manufacturer													
Electrical Conductors	ACCEPTANCE Certification	652.02-H		ITD-851	Total Quantity Paid										652	
		Manufacturer	Manufacturer													
Water and Power Source	ACCEPTANCE Certification	652.02-I		ITD-851												652
		Manufacturer	Manufacturer													
STANDARD SPECIFICATION SECTION: 653 – COMPOST							653									
Compost	ACCEPTANCE Certification	654.02		ITD-851					653							
		Manufacturer	Manufacturer													

BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS	
		SAMPLED BY	TESTED BY				
656	STANDARD SPECIFICATION SECTION: 656 - TRAFFIC SIGNAL INSTALLATION						
	Signal Poles and Mast Arms	ACCEPTANCE Certification	656.02		ITD-914 with mill test reports attached	Total Quantity Paid	See QA Manual Section 230.03
			Manufacturer	Manufacturer			
	Signal Components	ACCEPTANCE Inspection or Certification for steel/iron			ITD-854 or ITD-914 no mill test reports for steel/iron	Total Quantity Paid	RE Letter-See QA Manual Section 250.00 See QA Manual Section 230.01 and Section 230.03
				No Testing Required			
	Signal Cabinet Electrical Components	ACCEPTANCE PRE-TEST			ITD-500 memo		Post acceptance memo on MSR
				HQ or District Traffic			
	State-Furnished Material						
				No Testing Required			
	Concrete Specified strength of 3,000 psi or less	ACCEPTANCE Certification	509.01(B)		ITD-875 with QC test results attached	Total Quantity Paid	See QA Manual Section 230.06 Note locations on ITD-875
			Concrete Supplier	Concrete Supplier			
	Concrete Specified strength of 3,500 psi or greater	FOLLOW MTR TABLE STANDARD SPECIFICATION SECTION 502					
	Metal Reinforcement [with concrete of specified strength of 3,500 psi or greater]	FOLLOW MTR TABLE STANDARD SPECIFICATION SECTION 503					
	Metal Reinforcement [with concrete of specified strength of 3,000 psi or less]	ACCEPTANCE Certification	503.02 708.02		ITD-914 with mill test reports attached	Total Quantity Paid	See QA Manual Section 230.01 and Section 230.03 No samples required
Manufacturer			Manufacturer				

BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES, OR ADDITIONAL DIRECTIONS
		SAMPLED BY	TESTED BY			
STANDARD SPECIFICATION SECTION: MISCELLANEOUS BUILDING ITEMS						
Compaction	ACCEPTANCE Density	205.03	FOP for AASHTO T 310 Method B	ITD-850	At least 1 per project	
		ITD Project Personnel	ITD Project Personnel			
Structural Concrete (Footings, Foundations, Piers)	FOLLOW MTR TABLE STANDARD SPECIFICATION SECTION 502					
Non-Structural Concrete (Sidewalks, Driveways, Slabs)	ACCEPTANCE Certification	502.02 (B)		ITD-875 with QC test results attached	Total Quantity Paid	See QA Manual Section 230.06  Concrete Supplier's certification Note locations on ITD-875
		Concrete Supplier	Concrete Supplier			
Metal Reinforcement (for structural concrete-footings, foundations, piers)	FOLLOW MTR TABLE STANDARD SPECIFICATION SECTION 503					
Paint	FOLLOW MTR TABLE STANDARD SPECIFICATION SECTION 627 (No sampling or testing required when total project quantity is less than 25 gallons.)					

MISCELLANEOUS BUILDING ITEMS

MISCELLANEOUS BUILDING ITEMS

BID ITEM/ MATERIAL	PURPOSE OF TESTING	ITD SPEC. REF.	TEST METHOD	REQUIRED REPORT FORM NO.	MINIMUM REQUIRED FREQUENCY	REMARKS, NOTES OR ADDITIONAL DIRECTIONS	
		SAMPLED BY	TESTED BY				
MISCELLANEOUS ITEMS	STANDARD SPECIFICATION SECTION: MISCELLANEOUS ITEMS						
	Magnesium Chloride for Dust Control	ACCEPTANCE Laboratory Tests	[Special Provision]	Per Specs	ITD-1044 (Sample Data) ITD-1822	Each 100 tons or 1 per project	Follow Special Provision requirements for acceptance; either by test or by certification.  See QA Manual Section 230.01 for certification requirements.
			ITD Project Personnel	ITD Central Lab			
		ACCEPTANCE Certification	[Special Provision]		ITD-851	Total Quantity Paid	
			Manufacturer	Manufacturer			
	Epoxies	ACCEPTANCE Certification	720.04		ITD-851	Total Quantity Paid	See QA Manual Section 230.01
			Manufacturer	Manufacturer			
	Methyl Methacrylate (MMA) Pavement Markings (8)	ACCEPTANCE Laboratory Tests			ITD -1831	Each lot used on Project	Manufacturer provides samples to Central Materials Laboratory. Allow 14 days for pre-test results.
			Manufacturer	ITD Central Lab			
		ACCEPTANCE Certification(6)			ITD-851	Total Quantity Paid	See QA Manual Section 230.01
			Manufacturer	Manufacturer			
	(6) Acceptance by manufacturer's certification when total project quantity is less than 55 gallons.						
(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.							

**275.00 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).

**275.01 Calculations Performed by Spreadsheets.** When calculations are performed within a Department provided Excel spreadsheet, workbook, or web-based application, the published values on the sheets will follow the guidance in this section. However, the internal calculated values will not be rounded and will maintain all the digits carried in the software application.

Use Table 275.01.1 to determine conformance with these specifications.

**Table 275.01.1**

	Title	Calculate To:	Report To:
<b>Idaho Standards – Idaho Standard Method of Test (IT)</b>			
Idaho IT-61	Seal Coat Emulsion Acceptance Viscosity Testing	1.0	1
Idaho IT-72	Evaluating Cleanness of Cover Coat Material	1	1
Idaho IT-74	Instruction on Use of AKDOT&PF ATM-212, ITD IT-74, WSDOT TM 606, or WFLHD Humphreys Curves	0.01	0.1
Idaho IT-144	Fine Aggregate Specific Gravity by CoreLok	G <sub>sb</sub> : 0.001 Absorption: 0.001%	G <sub>sb</sub> : 0.001 Absorption: 0.1%
Idaho IT-146	Determination of Reclaimed Asphalt Pavement (RAP) Aggregate Bulk Specific Gravity	G <sub>sb</sub> : 0.001 Absorption: 0.001%	G <sub>sb</sub> : 0.001 Absorption: 0.1%
<b>AASHTO FOP</b>			
AASHTO T 11	Materials Finer Than 75 µm (No. 200) sieve in Mineral Aggregates by Washing	#200 sieve: 0.1 All other sieves: 1%	#200 sieve: 0.1 All other sieves: 1%
AASHTO T 27	Sieve Analysis of Fine and Coarse Aggregates	#200 sieve: 0.1 All other sieves: 1%	#200 sieve: 0.1 All other sieves: 1%
AASHTO T 30	Mechanical Analysis of Extracted Aggregate	#200 sieve: 0.1 All other sieves: 1%	#200 sieve: 0.1 All other sieves: 1%

AASHTO T 85	Specific Gravity and Absorption of Coarse Aggregate	G <sub>sb</sub> : 0.001 Absorption: 0.001%	G <sub>sb</sub> : 0.001 Absorption: 0.1%
AASHTO T 89	Determining the Liquid Limit of Soils	0.1%	1%
AASHTO T 90	Determining the Plastic Limit and Plasticity Index of Soils	0.1%	1%
AASHTO T 99	Moisture-Density Relations of Soils Using a 2.5-kg (5.5-lb) Rammer and 305-mm (12-in.) Drop	0.01	0.1
AASHTO T 119	Slump of Hydraulic Cement Concrete	¼ inch	¼ inch
AASHTO T 121	Mass per Cubic Meter (Cubic Foot), Yield, and Air Content (Gravimetric) of Concrete	Air: 0.01	0.1
		Yield: 0.01	0.1
AASHTO T 152	Air Content of Freshly Mixed Concrete by the Pressure Method	0.01	0.1
AASHTO T 166	Bulk Specific Gravity of Compacted Bituminous Mixtures Using Saturated Surface-Dry Specimens	0.001	0.001
AASHTO T 176	Plastic Fines in Graded Aggregates and Soils by Use of the Sand Equivalent Test	0.1	1%
AASHTO T 180	Moisture-Density Relations of Soils Using a 4.54-kg (10-lb) Rammer and 457-mm (18-in.) Drop	0.01	0.1
AASHTO T 209	Theoretical Maximum Specific Gravity and Density of Bituminous Paving Mixtures	0.001	0.001
AASHTO T 255	Total Moisture Content of Aggregate by Drying	0.01	0.1
AASHTO T 265	Laboratory Determination of Moisture Content of Soils	0.01	0.1
AASHTO T 308	Determining the Asphalt Binder Content of Hot Mix Asphalt (HMA) by the Ignition Method	0.01	0.01
AASHTO T 309	Temperature of Freshly Mixed Portland Cement Concrete	1	1
AASHTO T 310	In-Place Density and Moisture Content of Soil and Soil-Aggregate by the Nuclear Method	0.01	0.1
AASHTO T 329	Moisture Content Of Hot Mix Asphalt (HMA) By Oven Method	0.01	0.01
AASHTO T 335	Determining the Percentage of Fracture in Coarse Aggregate	1%	1%
AASHTO T 331	Bulk Specific Gravity and Density of Compacted Asphalt Mixtures Using Automatic Vacuum Sealing Method	0.001	0.001
AASHTO T 355	In-Place Density of Asphalt Mixtures by Nuclear Methods	0.01	0.01

**Idaho FOP**

ASTM D 4791	Flat and Elongated Particles in Coarse Aggregate	0.01	0.1
AASHTO T 304	Uncompacted Void Content Of Fine Aggregate	0.01	0.1
AASHTO T 359	Pavement Thickness by Magnetic Pulse Induction	0.05	0.1

**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.**

320.01 Independent Assurance Program Forms.

**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. 390.03

Superpave HMA.





## 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, Independent Assurance (IA) Programs.

**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. Individuals serving in an IA capacity will not have any other responsibilities on the project under IA review.
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. 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.
7. Perform District audit of Materials Summary Report (MSR). See Section 460.00.
8. Draft the project Final Materials Certification Letter for the District Materials Engineer's review and the District Engineer's signature. See Section 470.00.
9. Assist in training samplers and testers and WAQTC tester training as time permits.
- 10.

**320.01 Independent Assurance Program Forms.** A number of forms are available for the Independent Assurance Inspector:

- ITD 0796 - Independent Assurance Inspector Diary.
- ITD 0857 - Independent Assurance Test Report.
- ITD 0858 – Materials Summary Report District IA Audit per QA Manual Section 460.00.
- ITD 0860 - Independent Assurance Test Log.
- ITD 0862 – Quality Acceptance and IA Sample Schedule.

## **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 challenge resolution arises and IR-153 is used. 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 R 90.
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 and copies of the original source documents 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 calendar 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 calendar 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 must 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)**

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**380.00.1: Minimum Frequency for IA Evaluations (split samples)**

<b>Bid Schedule Item No.</b>	<b>Item Description</b>	<b>Tests (including sampling &amp; splitting)</b>	<b>Frequency Of IA Duplicate Tests Recommended To Test Within The First Five (5) Days</b>
205	Granular Borrow	Sand Equivalent FOP for (AASHTO R 90, R 76, T 176)	200,000 CY
301	Granular Subbase	Gradation, SE FOP for (AASHTO R 90, R 76, T 27, T 176)	110,000 tons
302	Emulsion Treated Base	Gradation, SE FOP for (AASHTO R 90, R 76, T 11, T 27, T 176)	14,000 CY /20,000 tons
303	Aggregate Base	Gradation, SE FOP for (AASHTO R 90, R 76, T 11, T 27, T 176, T 335)	14,000 CY/20,000 tons
307	Open-Graded Rock Base	Gradation FOP for (AASHTO R 76, T 27)	14,000 CY/20,000 tons

**380.00.1: Minimum Frequency for IA Evaluations (split samples) (Continued)**

403/404	Cover Coat Material	Gradation, CV, Fracture FOP for (AASHTO R 90, R 76, T 11, T 27, T 335, Idaho IT 72)	5,600 CY/8,000 tons
405	Plant Mix Aggregate at Cold Feed (Acceptance Test Strip)	SE, Fine Aggregate Angularity, Flat and Elongated, Fracture FOP for (AASHTO R 90, R 76, T 176, ASTM D 4791, AASHTO T 304, T 335)	15,000 tons
405	Superpave HMA Aggregate @ Cold Feed (Acceptance Test Strip)	Fracture (FOP for AASHTO T 335)	One (1) per project
405	Superpave HMA Acceptance Test Strip	Loose Mix Sample Testing & Core Bulk Density FOP for (AASHTO R 97, T 312, T 166 Method A, T 209, T 308, T 30, R 47, T 329, T 166 Method C/A,) AASHTO T 269	One (1) per project
405	Superpave HMA Pavement	Sampling Loose Mix, Asphalt Content by Ignition Method, Gradation, $G_{mm}$ , $G_{mb}$ , Moisture FOP for (AASHTO T 30, R 97, T 308, R 47, T 329, T 312, T 209)	One (1) per project
406/407	Road Mix /Scrub Coat Aggregate	Gradation, SE, Fracture FOP for (AASHTO R 90, R 76, T 11, T 27, T 176, T 335)	14,000 CY/20,000 tons

**380.00.1 Minimum Frequency for IA Evaluations (split samples) (Continued)**

<b>Bid Schedule Item No.</b>	<b>Item Description</b>	<b>Tests (including sampling &amp; splitting)</b>	<b>Frequency Of IA Duplicate Tests Recommended To Test Within The First Five (5) Days</b>
409	PCC Pavement Aggregate	Gradation, (course and fine plus SE on fine) FOP for (AASHTO R 90, R 76, T 11, T 27, T 176)	13,400 CY
409	PCC Production	Field tests** FOP for (WAQTC TM 2, AASHTO T 119, T 152, T 309, T 121)	6,000 CY
502, 506, 510	Concrete (Production) Aggregate	Gradation, (course and fine plus SE on fine) FOP for (AASHTO R 90, R 76, T 11, T 27, T 176)	6,000 CY
502, 506, 510	Concrete (Production)	Field Tests** FOP for (WAQTC TM 2, AASHTO T 119, T 152, T 309, T 121)	2,000 CY
635	Anti-skid	Gradation, (course and fine) FOP for (AASHTO R 90, R 76, T 11, T 27)	20,000 Tons

\*\*Field tests: Air, slump, temperature, and unit weight.

**380.00.2 Minimum Frequency for IA Evaluations by Observation**

<b>Bid Schedule Item No.</b>	<b>Item Description</b>	<b>Tests Evaluated</b>	<b>Frequency Of IA Observation Evaluations - * Recommended To Observe Within The First Five (5) Days</b>
205	Excavation, Borrow, Granular Borrow	Development of Density Standard & In-place Density FOP for (AASHTO T 99, T 180, T 272, T 310, R 75)	Every 90 days /One (1) per project
210	Compacting Backfill for structure, retaining wall, or pipe backfill	Development of Density Standard & In-place Density FOP for (AASHTO T 99, T 180, T 272, T 310, R 75)	Every 90 days /One (1) per project
301	Granular Subbase	Development of Density Standard & In-place Density FOP for (AASHTO T 180, T 272, T 310, R 75 Idaho IT 74)	Every 90 days /One (1) per project
302	Emulsified Treated Base	Development of Density Standard & In-place Density FOP for (AASHTO T 180, T 272, T 310, R 75 Idaho IT 74)	Every 90 days /One (1) per project
303	Aggregate for Base	Development of Density Standard & In-place Density FOP for (AASHTO T 180, T 272, T 310, R 75 Idaho IT 74)	Every 90 days /One (1) per project
403 / 404	Emulsified Asphalt	Saybolt Viscosity (Idaho IT 61)	Every 90 days/One (1) per project
405	SuperPave HMA Pavement	Density (percent compaction) (Fop for AASHTO T 355 Method A)	Every 90 days /One (1) per project
405	Asphalt Binder	Presence of Anti-Strip Additive ( Idaho IT-99)	Every 90 days /One (1) per project
409 & 502	Concrete Production	Making cylinders (Fop for AASHTO T 23)	Every 90 days /One (1) per project
506 & 510	Concrete Production	Making cylinders (FOP for AASHTO T 23)	Every 90 days /One (1) per project

\* 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.
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**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**

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

**Table 390.01.2: Allowable Aggregate Sample Test Variations**

<u>Test</u>	<u>Allowable Variation</u>
Sand Equivalent	8
Cleanliness Value	6
Fracture Count	5%
Flat & Elongated	2%
Fine Aggregate Angularity	1%

**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**

Test	Allowable Variation
Air Content	0.5%
Slump	3/4"
Density for Yield	1.0 lb/ft. <sup>3</sup>
Temperature	2°F

**390.03 Superpave HMA.** When split sample tests on a single sample of Superpave HMA are taken, the results should not vary more than shown in Table 390.03.1.

**Table 390.03.1: Split Sample Test Variation**

Test	Allowable Variation
Binder Content, %	±0.4
Gradation	See Table 390.01.1, Plant Mix Aggregate
G <sub>mm</sub>	0.020
G <sub>mb</sub>	0.020
Moisture, %	0.1

## **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**

Type of Project	Are there materials incorporated in the project?	HQ Submittal Materials		District Engineer Final Letter of Acceptance
		Materials Certification Checklist (ITD-852)	Materials Certification Letter and Materials Summary Report (including IA Log & RE Letter)	
Federal-Aid On State Highway System	Yes	Yes	Yes	Yes
	No	Yes	No	Yes
Federal-Local On-System No State Funds	Yes	Yes	Yes	Yes
	No	Yes	No	Yes
Federal-Local Off-System No State Funds Federal-Aid Limit \$500k or more	Yes	Yes	Yes	Yes
	No	Yes	No	Yes
Federal-Local Off-System No State Funds Federal-Aid Limit less than \$500k	Yes	Yes	No	Yes
	No	Yes	No	Yes
State-funded on NHS	Yes	Yes	Yes	Yes
	No	Yes	No	Yes
State-funded off NHS	Yes	Yes	Yes	Yes
	No	Yes	No	Yes



**SECTION 410.00 – REPORTS AND DOCUMENTATION.** The Department and its employees and consultants must use AASHTOWare Project Construct Module and ProjectWise for project related reports and documentation. All field test reports, laboratory test reports, source documents, certifications, and other miscellaneous records/documents 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 (e.g., survey notes, quantity measurements). These records form the basis for certifying compliance with specification requirements of the contract to Department staff, 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 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 ProjectWise.
- 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 (e.g., aluminum sheet, reflective coating) 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.
- 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.
- Document compaction effort (e.g., bridge abutments, back fill, embankment) 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**

Acceptance Type from MTR Tables	Postings Required in the MSR
Statistical Analysis (QA Special Provision)	
	Remarks explaining actions taken when any lot falls below 60 PWL
	Copy of lot summary report for each lot of production testing
	Remarks to indicate evaluation procedures taken when there is a failure
Field Tests (other than statistical analysis) <sup>1</sup>	Date sampled
	Test number
	Indication of pass or fail test results
	A remark indicating the location of the in-place density test for pipe or structure backfill
	Remarks to indicate tests that are considered check tests for failing tests
	Remarks to indicate the corrective action taken for a failing test
	Remarks to indicate acceptance when testing is not performed, such as, too granular to test
Manufacturer's or Fabricator's Certification	Date certification statement signed
	Quantity of material certified
	Manufacturer or fabricator company signing certification
Laboratory Verification Tests	Date sampled
	Sample number
	Laboratory number
	Indication of pass or fail test results
	Remarks to indicate corrective action or price adjustment for a failing test
Laboratory Acceptance Tests	Date sampled
	Sample number
	Laboratory number
	Indication of pass or fail test results
	Remarks to indicate corrective action or price adjustment for a failing test
Pre-Tested or Pre-Approved Tests (Approved Lists)	Remarks to indicate the material/product used on the project is included on the approved list maintained by HQ Materials Section
Acceptance by Inspection	Item will be shown on the <u>ITD-854</u> , Resident Engineer's Letter of Inspection
Small Quantity or Non-Standard Acceptance (see <u>Section 270.04 &amp; 270.05</u> )	Remarks to summarize the basis of acceptance including the following where applicable: <ul style="list-style-type: none"> <li>• Remarks to indicate aggregates obtained from approved materials source</li> <li>• Remarks to indicate mix design approval for plant mix or concrete</li> <li>• Post core test results for plant mix paving on mainlines or intersections</li> <li>• Remarks to indicate visual inspection during installation, placement or compaction</li> </ul>
<sup>1</sup> (field tests are: in-place density, gradation, sand equivalent, fracture count, cleanness 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)	

Acceptance Type from MTR Tables	Postings Required in the MSR
Special Provisions (see <a href="#">Section 270.06</a> )	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 <a href="#">Section 270.07</a> )	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 0.60 PWL 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 0.60 PWL and a description of action taken.
- QA Special Provision item where t 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

**470.03 Materials Certification Letter Example (Full Oversight Project)****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.

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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**

<a href="#"><u>IT-13-17</u></a>	<a href="#"><u>Measuring Mortar-Making Properties of Fine Aggregate</u></a>
<a href="#"><u>IT-15-19</u></a>	<a href="#"><u>Idaho Degradation</u></a>
<a href="#"><u>IT-72-19</u></a>	<a href="#"><u>Evaluating Cleanness of Cover Coat Material</u></a>
<a href="#"><u>IT-74-98</u></a>	<a href="#"><u>Vibratory Spring-Load Compaction for Coarse Granular Material</u></a>
<a href="#"><u>IT-116-13</u></a>	<a href="#"><u>Disintegration of Quarry Aggregates (Ethylene Glycol)</u></a>
<a href="#"><u>IR-142-19</u></a>	<a href="#"><u>Investigation of Aggregate and Borrow Deposits</u></a>
<a href="#"><u>IT-144-19</u></a>	<a href="#"><u>Specific Gravity and Absorption of Fine Aggregate Using Automatic Vacuum Sealing (CoreLok) Method</u></a>

**SECTION 520.00 - BITUMINOUS MATERIALS**

<a href="#"><u>IT-61-08</u></a>	<a href="#"><u>Sampling and Viscosity Testing Emulsified Asphalt Binders in the Field</u></a>
<a href="#"><u>IR-63-13</u></a>	<a href="#"><u>Design of Seal Coats and Single Surface Treatments by the McLeod Method</u></a>
<a href="#"><u>IT-99-17</u></a>	<a href="#"><u>Detection of Anti-Stripping Additive in Asphalt</u></a>
<a href="#"><u>IR-125-19</u></a>	<a href="#"><u>Acceptance Test Strip for Asphalt Mixtures</u></a>
<a href="#"><u>IT-137-17</u></a>	<a href="#"><u>Effectiveness of Anti-Strip Agents After Hot Storage in Asphalt Binder Using Bottle and Sand</u></a>
<a href="#"><u>IT-146-19</u></a>	<a href="#"><u>Determination Of Reclaimed Asphalt Pavement (Rap) Aggregate Bulk (Dry) Specific Gravity (<math>G_{sb}</math>)</u></a>
<a href="#"><u>IR-150-19</u></a>	<a href="#"><u>Superpave Volumetric Mix Design</u></a>
<a href="#"><u>IR-151-19</u></a>	<a href="#"><u>Superpave Mix Design Evaluation</u></a>
<a href="#"><u>IR-152-19</u></a>	<a href="#"><u>Asphalt Mixtures Quality Control Plan (QCP) Development and Implementation</u></a>
<a href="#"><u>IR-153-19</u></a>	<a href="#"><u>Split Sample Comparison</u></a>
<a href="#"><u>IR-154-19</u></a>	<a href="#"><u>Nuclear Gauge Correlation</u></a>
<a href="#"><u>IR-155-19</u></a>	<a href="#"><u>Procedures for Checking Asphalt Drum Mix Plant Calibrations</u></a>
<a href="#"><u>IR-156-19</u></a>	<a href="#"><u>Method for Determining Rolling <math>G_{mm}</math></u></a>
<a href="#"><u>IR-157-19</u></a>	<a href="#"><u>Method for Determining NCAT Correction Factor</u></a>

**SECTION 530.00 – CONCRETE**

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

**SECTION 540.00 - PAINT**

<a href="#"><u>IR-7-04</u></a>	<a href="#"><u>Inspecting/Sampling Paint and Curing Compound</u></a>
<a href="#"><u>IT-121-98</u></a>	<a href="#"><u>Determining Total Solids-Latex Percent</u></a>

**SECTION 550.00 - SOILS**

<a href="#"><u>IT-8-17</u></a>	<a href="#"><u>Resistance R-Value and Expansion Pressure of Compacted Soils and Aggregates</u></a>
<a href="#"><u>IR-62-17</u></a>	<a href="#"><u>Taking Undisturbed Soil Samples for Laboratory Consolidation, Shear and Permeability Tests</u></a>

**SECTION 560.00 - MISCELLANEOUS**

<a href="#"><u>IR-12-17</u></a>	<a href="#"><u>Calibrating Torque-Wrenches, Tightening and Testing Bolt Tensions</u></a>
<a href="#"><u>IR-17-98</u></a>	<a href="#"><u>Calibrating the Skidmore-Wilhelm Torque-Wrench Calibration Unit</u></a>
<a href="#"><u>IR-87-17</u></a>	<a href="#"><u>Pavement Straightedge Procedures</u></a>
<a href="#"><u>IT-120-17</u></a>	<a href="#"><u>Determining Volume of Liquids in Horizontal or Vertical Storage Tanks</u></a>
<a href="#"><u>IR-148-19</u></a>	<a href="#"><u>Stratified Random Sampling</u></a>
<a href="#"><u>IR-158-19</u></a>	<a href="#"><u>Quality Control Plan Development and Implementation</u></a>
<a href="#"><u>IR-159-19</u></a>	<a href="#"><u>Quality Control Plan Review Process</u></a>
<a href="#"><u>IR-160-19</u></a>	<a href="#"><u>Develop, Evaluate, and Approve Plant QC</u></a>

Please do not forget to check HIGHLIGHTED TEST Methods for Modifications

## SECTION 570.00 – WAQTC / IDAHO FIELD OPERATING PROCEDURES

### 570.01 AGGREGATE.

1. [AASHTO R 90 \(18\)](#) [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 \(19\) &](#) [Sieve Analysis of Fine and Coarse Aggregates &](#)
5. [AASHTO T 11 \(19\)](#) [Materials Finer Than 75 µm \(No. 200\) sieve in Mineral Aggregates by Washing](#)
6. [AASHTO T 335 \(17\)](#) [Determining the Percentage of Fracture in Coarse Aggregate](#)
7. [AASHTO T 176 \(19\)](#) [Plastic Fines in Graded Aggregates and Soils by Use of the Sand Equivalent Test](#)

### 570.02 ASPHALT I & II.

1. [AASHTO R 97 \(19\)](#) [Sampling of Asphalt Mixtures](#)
2. [AASHTO R 47 \(19\)](#) [Reducing Samples of Asphalt Mixtures to Testing Size](#)
3. [AASHTO T 329 \(16\)](#) [Moisture Content of Asphalt Mixtures by Oven Method](#)
4. [AASHTO T 308 \(19\)](#) [Determining the Asphalt Binder Content of Asphalt Mixtures by the Ignition Method](#)
5. [AASHTO T 30 \(19\)](#) [Mechanical Analysis of Extracted Aggregate](#)
6. [AASHTO T 209 \(19\)](#) [Theoretical Maximum Specific Gravity \( \$G\_{mm}\$ \) and Density of Asphalt Mixtures](#)
7. [AASHTO T 166 \(18\)](#) [Bulk Specific Gravity of Compacted Asphalt Mixtures Using Saturated Surface-Dry Specimens](#)
8. [AASHTO R 66 \(16\)](#) [Sampling Asphalt Materials](#)
9. [AASHTO T 312 \(19\)](#) [Asphalt Mixtures Specimens by Means of the Superpave Gyratory Compactor](#)
10. [WAQTC TM 13 \(19\)](#) [Volumetric Properties of Asphalt Mixtures](#)

Please do not forget to check HIGHLIGHTED TEST Methods for Modifications

### **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 \(19\)](#) [Slump of Hydraulic Cement Concrete](#)
4. [AASHTO T 121 \(19\)](#) [Density \(Unit Weight\), Yield, and Air Content \(Gravimetric\) of Concrete](#)
5. [AASHTO T 152 \(19\)](#) [Air Content of Freshly Mixed Concrete by the Pressure Method](#)
6. [AASHTO T 23 \(18\)](#) [Method of Making and Curing Concrete Test Specimens in the Field](#)

### **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 \(19\) &](#) [Moisture-Density Relations of Soils Using a 2.5-kg \(5.5-lb\) Rammer and 305-mm \(12-in.\) Drop &](#)  
[AASHTO T 180 \(19\)](#) [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](#)

### **570.05 IN-PLACE DENSITY**

1. [AASHTO T 355 \(18\)](#) [In-Place Density of Asphalt Mixtures by Nuclear Method.](#)
2. [AASHTO T 310 \(19\)](#) [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 \(18\)](#) [One-Point Method for Determining Maximum Dry Density and Optimum Moisture](#)
5. [Humphreys Curves \(16\)](#) [Use of AKDOT&PF ATM-212, ITD T-74, WSDOT TM 606, or WFLHD Humphreys Curves](#)

**SECTION 580.00 – IDAHO Field Operating Procedures**

ASTM D 4791	Flat and Elongated Particles in Coarse Aggregate
AASHTO R 64	Standard Practice for Field Sampling and Fabrication of 50-mm (2-in) Cube Specimens Using Grout (Non-Shrink) or Mortar
AASHTO T 304	Uncompacted Void Content Of Fine Aggregate
AASHTO T 359	Pavement Thickness by Magnetic Pulsed Induction

**SECTION 590.00 – IDAHO Transportation Dept. (ITD) Sampler/Tester Qualification Program (STQC)****Aggregates**

<a href="#"><u>Idaho IT 72</u></a>	<a href="#"><u>Evaluating Cleanness of Cover Coat Material</u></a>
<a href="#"><u>Idaho IT 144</u></a>	<a href="#"><u>Specific Gravity and Absorption of Fine Aggregate Using Automatic Vacuum Sealing (CoreLok) Method</u></a>
<a href="#"><u>AASHTO T 19</u></a>	<a href="#"><u>Bulk Density (“Unit Weight”) and Voids in Aggregate</u></a>
<a href="#"><u>AASHTO T 84</u></a>	<a href="#"><u>Specific Gravity and Absorption of Fine Aggregate</u></a>
<a href="#"><u>AASHTO T 304</u></a>	<a href="#"><u>Uncompacted Void Content Of Fine Aggregate</u></a>
<a href="#"><u>ASTM D4791</u></a>	<a href="#"><u>Flat and Elongated Particles in Coarse Aggregate</u></a>

**Bituminous Materials**

<a href="#"><u>Idaho IT 61</u></a>	<a href="#"><u>Sampling and Viscosity Testing Emulsified Asphalt Binders in the Field</u></a>
<a href="#"><u>Idaho IT 99</u></a>	<a href="#"><u>Detection of Anti-Stripping Additive in Asphalt</u></a>
<a href="#"><u>AASHTO T 324</u></a>	<a href="#"><u>Hamburg Wheel Track Testing of Compacted Asphalt Mixtures</u></a>
<a href="#"><u>ASTM D8255</u></a>	<a href="#"><u>Cracking Tolerance Index of Asphalt Mixtures Using the Indirect Tensile Cracking Test at Intermediate Temperatures</u></a>
<a href="#"><u>AASHTO T 331</u></a>	<a href="#"><u>Bulk Specific Gravity and Density of Compacted Hot Mix Asphalt (HMA) using Automatic Vacuum Sealing Method (CoreLok)</u></a>
<a href="#"><u>AASHTO R 67</u></a>	<a href="#"><u>Sampling Asphalt Mixtures after Compaction (Obtaining Cores)</u></a>

**Soils**

<a href="#"><u>AASHTO T 90</u></a>	<a href="#"><u>Determining the Plastic Limit and Plasticity Index of Soils</u></a>
<a href="#"><u>AASHTO T 89</u></a>	<a href="#"><u>Determining the Liquid Limit of Soils</u></a>
<a href="#"><u>AASHTO T 100</u></a>	<a href="#"><u>Specific Gravity of Soils</u></a>

**Concrete**

<a href="#"><u>AASHTO R 64</u></a>	<a href="#"><u>Standard Practice for Field Sampling and Fabrication of 50-mm (2-in) Cube Specimens using Grout (Non-Shrink) or Mortar</u></a>
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**Idaho Standard Method of Test for****Measuring Mortar-Making Properties of Fine Aggregate)****IDAHO Designation: IT-13-17**

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**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.*

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**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*
- C 778, Standard Specification for Standard Sand

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**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

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#### 4. TEMPERATURE AND HUMIDITY

- 4.1. The temperature of the mixing water, the Moist Closet, and the storage tank water shall be maintained at  $73.4 \pm 3^{\circ} \text{F}$  ( $23.0 \pm 1.7^{\circ} \text{C}$ ).
- 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.

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#### 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  $73.4 \pm 3^{\circ} \text{F}$  ( $23.0 \pm 1.7^{\circ} \text{C}$ ).

- 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.

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## 6. FLOW TEST

- 6.1. Fill the cone in two layers, 20 blows per layer with the hard rubber tamping tool. The mixture should overflow 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.

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## 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  $\pm 1$  hour for 3 day tests,  $\pm 2$  hours for 7 day tests, and  $\pm 20$  hours for 28 day tests, from the time of molding.

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## 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.

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**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.

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**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.

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## Idaho Standard Method of Test for

# Idaho Degradation

### IDAHO Designation: IT-15-19



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## 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.*

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## 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
  - R 76, Reducing Field Samples of Aggregates to Testing Size.
  - R 90, Sampling Aggregate Products
  - T 176, Plastic Fines in Graded Aggregates and Soils by Use of the Sand Equivalent Test.
- 2.2 *ASTM Standards*
- E11, Woven Wire Test Sieve Cloth and Test Sieves

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## 3. APPARATUS

- 3.1. *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 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.
- 3.2. *Containers* Wide mouth one-gallon jars with lids. The lids are fitted with solid 1/8 in. thick rubber gaskets.
- 3.3. *Sieves* A set of U.S. Standard, 8 in. diameter sieves 3/4 in. through No. 200. These sieves shall meet ASTM E11 specifications.
- 3.4. *Sand Equivalent apparatus* as described in [AASHTO T 176](#).
- 3.5. Scoop, brush and rust proof drying container approximately 18 in. x 12 in. x 2 in. deep.
- 3.6. *Drying Oven* 140°F maximum.
- 3.7. *Balance*—A balance that conforms to AASHTO M 231 with a 2,000 g capacity sensitive to 0.1 g.

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## 4. PREPARATION OF SAMPLE

4.1. Sample makeup (Oven-dry at 140°F max.)

4.1.1. The sample for testing with 1/2 in or larger size aggregate shall have the following gradation:

16.7% passing the 3/4 in. and retained on the 1/2 in	183 g.
16.6% passing the 1/2 in. and retained on the 3/8 in	183 g.
16.7% passing the 3/8 in. and retained on the No. 4	184 g.
50% passing the No. 4	550 g.
Total	1100 g.

4.1.2. The sample for testing with 3/8" size aggregate shall have the following gradation:

25% passing the 1/2" and retained on the 3/8 in.	275 g.
25% passing the 3/8 in. and retained on the No. 4	275 g.
50% passing the No. 4	550 g.
Total	1100 g.

4.1.3. The sample for testing with No. 4 size aggregate shall have the following gradation:

50% passing the 3/8 in. and retained on the No. 4	550 g.
50% passing the No. 4	550 g.
Total	1100 g.

4.2. 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 materials by the method of quartering or by the use of a sample splitter as described in AASHTO R 76.

4.3. **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.

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## 5. PROCEDURE

5.1. Place the prepared oven dried material (maximum temperature 140°F in a wide mouth jar and enough water to cover the aggregate to a depth of approximately 1/2 in.

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

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

5.4. 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.

5.5. 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.

5.6. At the end of the test period empty the contents of the jar over a No. 4 sieve placed over a container to catch all the No. 4 material and water.

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

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

- 5.9. Stir the minus No. 4 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.
- 5.10. When the cast point is reached, run sand equivalent on the minus No. 4 material according to AASHTO T 176.
- 5.11. Retain the material from the sand equivalent test and return it to the minus portion.
- 5.12. Wash entire minus No. 4 portion over No. 200, dry and sieve as described in AASHTO T 11.
- 5.13. 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.

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## 6. REPORT

- 6.1. 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 sieve is measured by sieve analysis of a representative sample for which the % Passing No. 4 is 50%, the before test percentages for No. 4 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 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 in the representative before-test gradation sample. For example, if the No. 4 and finer before-test percentages are determined on a sample consisting of 100% minus No. 4 material, the adjustment factor is  $50/100 = .050$ . Similarly, if the sample for determining before-test gradation has 40% minus No. 4, the adjustment factor for No. 4 and finer sieves is  $50/40 = 1.25$ .

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

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## 7. PRECAUTIONS

- 7.1. Avoid baking sample during drying period prior to sand equivalent test.
- 7.2. Be sure to return all of the material from the sand equivalent test back into the minus No. 4 portion.



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**Idaho Standard Method of Test for****Evaluating Cleanness of Cover Coat Material****IDAHO Designation: IT-72-19**

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**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 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.
- R 90, Sampling aggregate Products

**2.2 ASTM Standards**

- E11, Woven Wire Test Sieve Cloth and Test Sieves

**2.3 Other Standards**

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

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**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. *Sieves* No. 8 (2.36mm) & No. 200 (0.75mm) 8 inch brass wire sieves, Meeting the requirements of ASTM E11.
- 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.

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#### 4. **SAMPLE PREPARATION**

- 4.1. Obtain a sample of cover coat material (CCM) in accordance with the FOP for AASHTO R 90 and reduce to  $1000 \pm 50$  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).

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#### 5. **PROCEDURE**

- 5.1. Place the  $1000 \pm 50$  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.



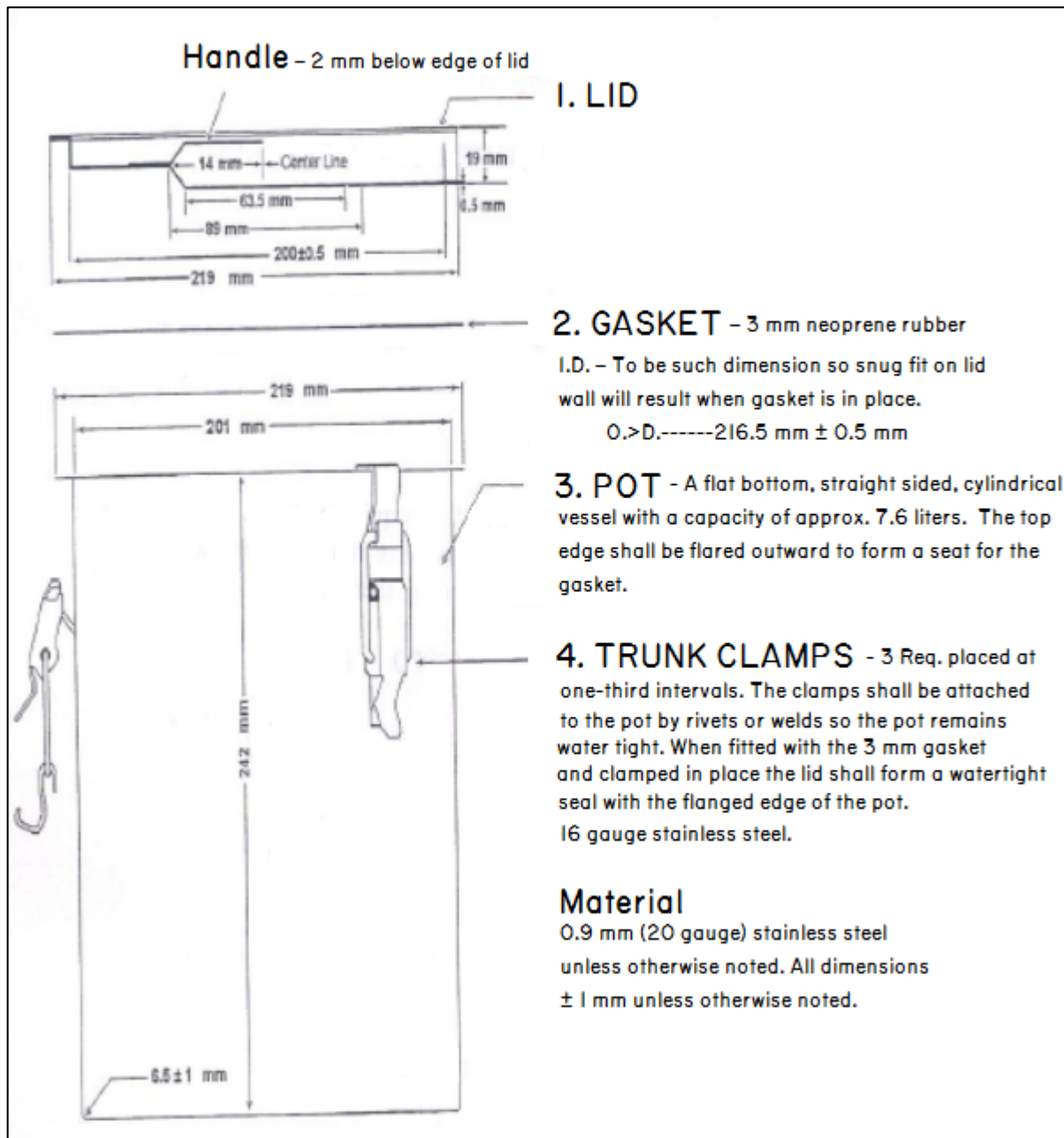


Figure 1—Washing Vessel

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.

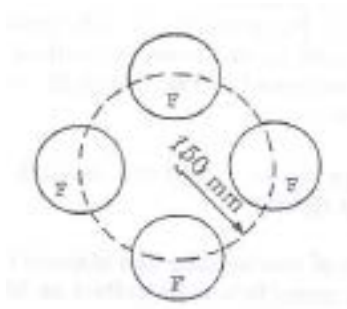


Figure 2—Path of Jar During Agitation Period

**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.

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## 6. MEASURE FOR CLEANNES

- 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 180o 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  $\pm$  15 seconds.
- 6.7. After 20 minutes, read and record to the nearest 0.1 inch the height of the column of sediment.

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## 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****CLEANNES VALUE – IDAHO T 72**

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

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

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**

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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  $\frac{3}{4}$ " 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.

<b>Test Method Selection Table</b>	
<b>Fine Material</b>	
<b>Soil Type</b>	<b>Test Method</b>
Sandy, Non Plastic, Permeable	T606 Test 1
Silt, Some Plasticity, Low Permeability	T 99 Method A
Sandy Silt, Some Plasticity, Permeable	T 606 Test 1 / T 99 Method A (use higher results)
<b>Coarse Material</b>	
No more than 15% by weight of original aggregate specimen exceeds $\frac{3}{4}$ " (19 mm)	T 606 Test 2 Procedure 1
15% or more by weight of original aggregate specimen is greater than $\frac{3}{4}$ " (19 mm), but does not exceed 3 in. (76 mm)	T 606 Test 2 Procedure 2

**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 ( $\pm 0.002$  in), ID 6 in ( $\pm 0.002$  in). The wall thickness of the mold shall be no less than  $\frac{1}{4}$  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  $5 \frac{7}{8}$  in (150 mm) OD and an overall height of 2 in. The top of the piston shall have a  $2 \frac{1}{4}$  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  $230^{\circ} \pm 5^{\circ}\text{F}$  ( $110 \pm 5^{\circ}\text{C}$ ) 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 —  $\frac{5}{8}$  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: *Wt. of water = (decimal percent water)(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.

l. If moisture is observed at the base of the mold continue applying loads at the following rates:

Load in lbs (kg)	Time in Minutes
100 to 500 lbs (45 to 227)	1
500 lbs to 1,000 lbs (227 to 454)	1/2
1,000 lbs to 2,000 lbs (454 to 908)	1/2

**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<sup>3</sup>

H<sub>1</sub>= Inside height of the mold, in

H<sub>2</sub>= Height from top of the specimen to the top of the mold,

in B = Inside bottom area of the mold, in<sup>2</sup>

$$\text{Wet Density (pcf)} = \frac{\text{Wet Mass (Weight, lbs.)}}{\text{Volume (cu. ft.)}}$$

$$\text{Dry Density (pcf)} = \frac{\text{Wet Density (pcf)}}{1 + \text{Moisture Content (in decimal)}} *$$

\*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  $\frac{3}{4}$  in (19 mm). Procedure 2 is used when 15% or more by weight of the original specimen of the aggregate is greater than  $\frac{3}{4}$  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  $\frac{3}{4}$  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 ft<sup>3</sup> (0.0028 m<sup>3</sup>) 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/ft<sup>3</sup> (kg/m<sup>3</sup>). 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.  $\frac{1}{2} \text{ ft}^3$  ( $0.014 \text{ m}^3$ ) standard aggregate measure.
- b. A metal piston having a diameter  $\frac{1}{8}$  in (3 mm) less than the inside diameter of the  $\frac{1}{2} \text{ ft}^3$  ( $0.014 \text{ m}^3$ ) 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  $\text{lbs/ft}^3$  ( $\text{kg/m}^3$ ) (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  $68^{\circ} \pm 1^{\circ} \text{ F}$  ( $20^{\circ} \pm 0.5^{\circ} \text{ C}$ ) 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.



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**Idaho Standard Method of Test for****Disintegration of Quarry Aggregates (Ethylene Glycol)****IDAHO Designation: IT-116-13**

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**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.*

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**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

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**3. APPARATUS**

- 3.1. Oven  $60 \pm 2^{\circ}\text{C}$
- 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

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**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.





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**Idaho Standard Practice for**

# Investigation of Aggregate and Borrow Deposits

**IDAHO Designation: IR-142-19**

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**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.*

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**2. REFERENCE DOCUMENTS**

- 2.1. *Idaho Standards*
- ITD Standard Specifications for Highway Construction.
  - ITD Quality Assurance Manual.
  - ITD Materials Manual, Section 300.00, Materials Sources.
  - Idaho Code, Sections 54-2081 and 54-2802.
- 2.2. *AASHTO Standards*
- R 90, Sampling Aggregate Products
- 2.3. *ASTM Standards*
- D75, Standard Practice for Sampling Aggregates, Appendix X1
  - D420, Standard Guide to Site Characterization for Engineering, Design, and Construction Purposes.

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**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.

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**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.

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**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 R 90, ASTM D75, Appendix X1; and ASTM D 420.
- 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 R 90, ASTM D75, Appendix X1; and ASTM D 420. 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.

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## **6. TESTING**

- 6.1. Required test data for aggregate sources shall conform to Standard Specifications Section 703 – Aggregates, and ITD Contract Specifications.
- 6.1.1. Required test data for borrow and granular borrow sources shall conform to Standard Specifications Section 205 – Excavation and Embankment, 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.

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## **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 drawing 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.

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**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).

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**Idaho Standard Method of Test for**

# Specific Gravity and Absorption of Fine Aggregate Using Automatic Vacuum Sealing (CoreLok) Method

**IDAHO Designation: IT-144-19**

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**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.*

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**2. REFERENCE DOCUMENTS**

- 2.1. *AASHTO Standards*
  - M 231, Weighing Devices Used in the Testing of Materials
  - R 90, Sampling Aggregate Products
  - 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 (InstroTek, Inc.)

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**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  $110 \pm 5^{\circ}\text{C}$  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.

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## 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).

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## 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  $25 \pm 1^\circ \text{C}$  ( $77 \pm 2^\circ \text{F}$ ).

**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  $\pm 1$  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  $137 \pm 0.13$  mm ( $5.375 \pm 0.005$  in.) inside diameter (ID) and  $89 \pm 0.41$  mm ( $3.5 \pm 0.016$  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  $5^\circ$  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  $40^\circ\text{C}$  ( $100^\circ\text{F}$ ) accurate to  $\pm 1^\circ$ .
- 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.

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## 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  $25 \pm 1^\circ\text{C}$  ( $77 \pm 2^\circ\text{F}$ ) by placing it inside a bucket of water that is maintained at  $25 \pm 1^\circ\text{C}$  ( $77 \pm 2^\circ\text{F}$ ). 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  $25 \pm 1^\circ\text{C}$  ( $77 \pm 2^\circ\text{F}$ ).
- 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  $25 \pm 1^\circ\text{C}$  ( $77 \pm 2^\circ\text{F}$ ) 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  $25 \pm 1^\circ\text{C}$  ( $77 \pm 2^\circ\text{F}$ ) 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.

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## 7. SAMPLING

- 7.1. Sampling shall be performed in accordance with AASHTO R 90.
- 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 to a mass as close as possible to the required testing size. Addition or removal of material is allowed to achieve a sample mass within the stated tolerance.

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## 8. PROCEDURES

### 8.1. *Equipment Preparation*

**Note 4** – Make certain water temperature used for this test remains at  $25 \pm 1^\circ\text{C}$  ( $77 \pm 2^\circ\text{F}$ ).

- 8.1.1. Prior to testing, condition the pycnometer to  $25 \pm 1^\circ\text{C}$  ( $77 \pm 2^\circ\text{F}$ ) by placing it inside a bucket of water that is maintained at  $25 \pm 1^\circ\text{C}$  ( $77 \pm 2^\circ\text{F}$ ).
- 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  $25 \pm 1^{\circ}\text{C}$  ( $77 \pm 2^{\circ}\text{F}$ ).
- 8.2.3. Determine the mass of a  $500 \pm 1$  gram dry sample, Trial 1, that is at  $25 \pm 1^{\circ}\text{C}$  ( $77 \pm 2^{\circ}\text{F}$ ) 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  $25 \pm 1^{\circ}\text{C}$  ( $77 \pm 2^{\circ}\text{F}$ ) 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  $25 \pm 1^{\circ}\text{C}$  ( $77 \pm 2^{\circ}\text{F}$ ) 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  $500 \pm 1$  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  $500 \pm 1$  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  $1000 \pm 1$  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- $\mu\text{m}$  (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 10 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.

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**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.			1.	1.	2.	3.	Avg.	
Sample Number or Label	Trial Number		<b>A</b> Dry Sample Mass (500 g)	<b>B</b> Mass of pycnometer with sample and water (g)	<b>C</b> Plastic Bag Mass (g)	<b>D</b> Mass of two rubber sheets (g)	<b>E</b> Dry Sample Mass (1000 g)	<b>F</b> Mass of Sealed sample opened under water
	1							
	2							
	3*							
	Avg							
	1							
	2							
	3*							
	Avg							
	1							
	2							
	3*							
	Avg							

\* 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

Participant Name \_\_\_\_\_ Exam Date \_\_\_\_\_

Record 'P' For Passing "F" for failing each step of the checklist.

Verification Element	Trial 1	Trial 2
1. Pycnometer and lid placed inside a bucket of water at $25 \pm 1\text{C}$ ( $77 \pm 2\text{F}$ )	_____	_____
2. Pycnometer and lid removed from water dried well and placed on clamping device until it makes contact with stops?	_____	_____
3. Pycnometer filled with $25 \pm 1\text{C}$ ( $77 \pm 2\text{F}$ ) water to 10mm (3/8") of top, sprayed with Isopropyl alcohol to remove air?	_____	_____
4. Lid gently placed on Pycnometer and clamped?	_____	_____
5. A syringe filled with $25 \pm 1\text{C}$ ( $77 \pm 2\text{F}$ ) inserted in top of lid and gently added until water is expelled through the 3mm (1/8") hole?	_____	_____
6. Water wiped from lid, device water and pycnometer weighed and recorded to	_____	_____
7. Procedure repeated two additional times (no greater than 0.5 g difference) recorded to work sheet and averaged?	_____	_____
Procedure Element	Trial 1	Trial 2
8. Representative samples obtained per FOP for AASHTO R 90?	_____	_____
9. Reduced per FOP for AASHTO R 76?	_____	_____
10. Dried per FOP for AASHTO T 255?	_____	_____
11. Samples cooled to $25 \pm 1\text{C}$ ( $77 \pm 2\text{F}$ )?	_____	_____
12. Three samples obtained @ 500g $\pm 1\text{g}$ and one @ 1000g $\pm 1\text{g}$ ?	_____	_____
13. Pycnometer and lid removed from water, dried and pycnometer placed on clamping device until it makes contact with stops?	_____	_____
14. Water added to pycnometer (at $25 \pm 1\text{C}$ , $77 \pm 2\text{F}$ ) to approximately half full?	_____	_____

Procedure Element	Trial 1	Trial 2
15. Sample at 500 g $\pm$ 1g slowly added to pycnometer?		
16. Metal spatula inserted against side of pycnometer and slowly pushed to center removed, repeated in eight equal increments?		
17. Water added at 25 $\pm$ 1C (77 $\pm$ 2F) to within 10mm (3/8") of rim?		
18. Sprayed with isopropyl alcohol to remove air?		
19. Lid gently placed on pycnometer with 3mm (1/8") hole to the front and clamped?		
20. Syringe filled with 25 $\pm$ 1C (77 $\pm$ 2F) water inserted in top of lid and water slowly added until it is expelled through 3mm (1/8") hole?		
21. Excess water wiped from lid?		
22. Clamping device, pycnometer and sample mass recorded to 0.1 g?		
23. Clamping device, pycnometer and sample mass determined no more than 2 minutes from time sample was submerged?		
24. Second 500g $\pm$ 1 g sample tested and mass recorded?		
25. If recorded mass of first and second sample greater than 1 g, was a third 500 g $\pm$ 1 g sample tested?		
26. Vacuum device set at manufacture's recommended setting?		
27. Small plastic bag inspected and mass determined to 0.1 g and recorded?		
28. 1000 g $\pm$ 1 g sample mass determined and recorded?		
29. 1000 g $\pm$ 1 g sample placed in the bag, supported by a smooth surface to prevent punctures?		
30. Sample placed in vacuum device and spread flat by grasping both sides of bag and gently shaking?		
31. Open end of bag placed over seal bar and closed?		
32. Sample removed from vacuum chamber when door opens and submerged in 25 $\pm$ 1C (77 $\pm$ 2F) water bath within 5 seconds?		
33. Bag maintained at a minimum depth of two inches?		
34. A small cut made at corner of bag approximately 25 to 50mm (1" to 2")?		
35. Submerged bag held open until water flows freely into bag (approximately 45 seconds)		

Procedure Element	Trial 1	Trial 2
36. A second cut approximately 25 to 50mm (1" to 2") made to opposite side of bag?	_____	_____
37. Residual air removed from bag by running fingers across top of submerged bag?	_____	_____
38. Bag placed in weighing basket and water allowed to flow freely into bag?	_____	_____
39. Sample mass determined and recorded after 15 minutes but not more than 20 minutes and recorded to 0.1g?	_____	_____
40. Test data entered into manufacture's software to obtain test results?	_____	_____

**COMMENTS:** First Attempt: Pass ☐ Fail ☐ Second Attempt: Pass ☐ Fail ☐

Examiner Signature: \_\_\_\_\_ Sampler / Tester Qualification # \_\_\_\_\_

Examiner Signature: \_\_\_\_\_ Sampler / Tester Qualification # \_\_\_\_\_





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**Idaho Standard Method of Test for**

# Sampling and Viscosity Testing of Emulsified Asphalt Binders in the Field

**IDAHO Designation: IT-61-08**

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**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
- 3.8. *Plastic Jar*- 1-quart (1 liter) wide 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

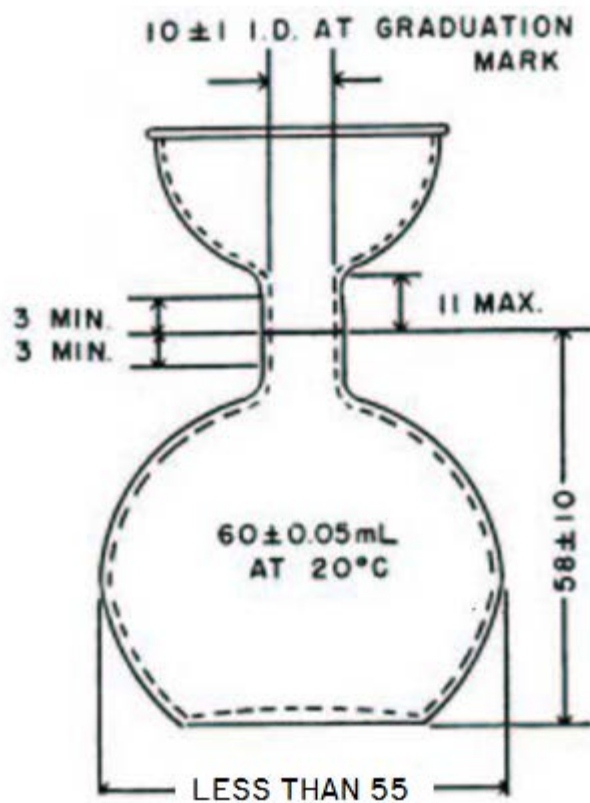
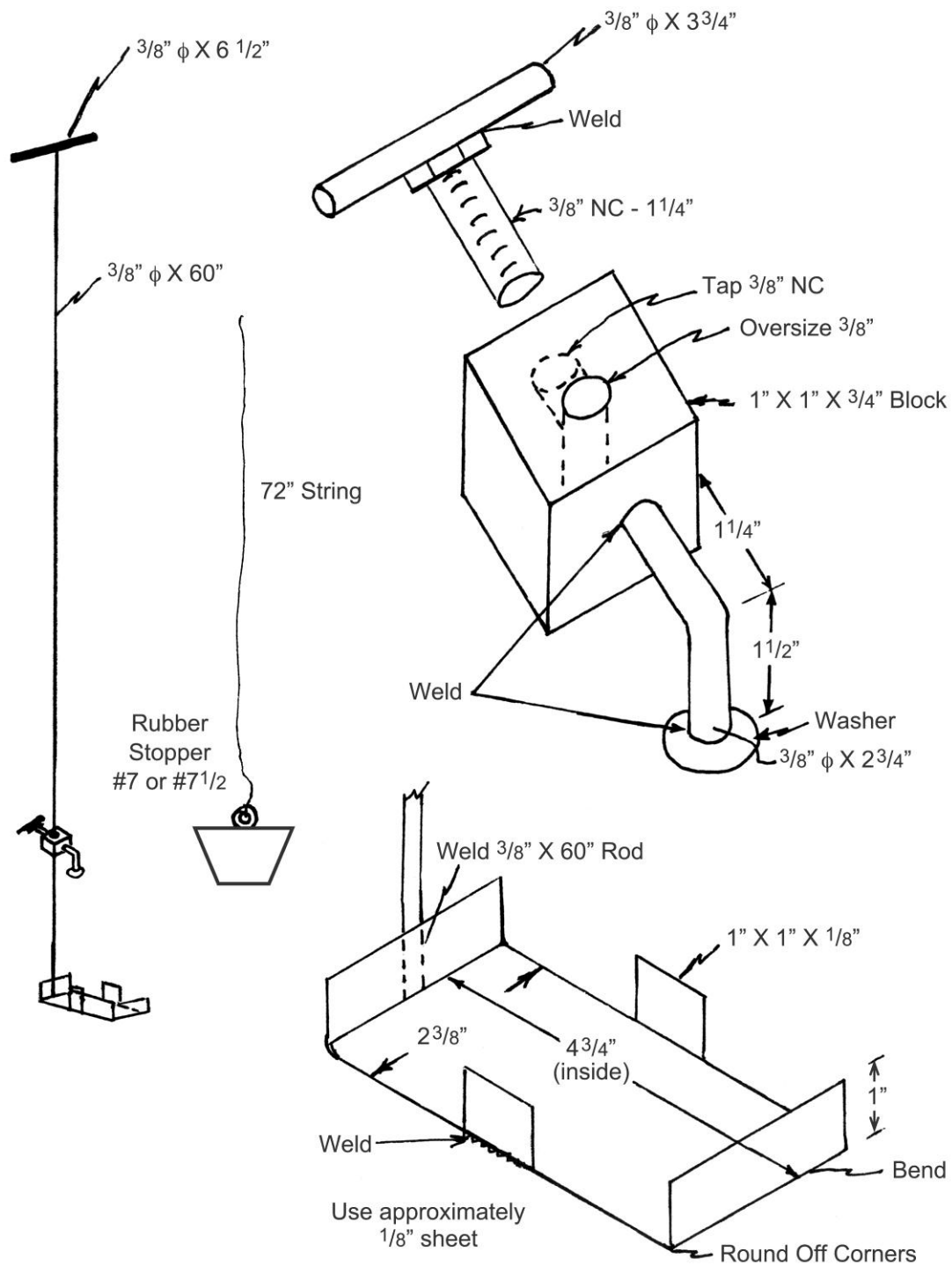


Figure 1: Receiving Flask



**Figure 2: Thief Sampling Device (Dip Method Device)**

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**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  $50 \pm 0.05^{\circ}\text{C}$  ( $122 \pm 0.09^{\circ}\text{F}$ ).
- 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  $51.7 \pm 0.3^{\circ}\text{C}$  ( $125 \pm 0.5^{\circ}\text{F}$ ).

**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  $50^{\circ}\text{C} \pm 0.3^{\circ}\text{C}$  ( $122^{\circ}\text{F} \pm 0.5^{\circ}\text{F}$ ). 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

#### Trial 1    Trial 2

- |  |     |       |       |
|--|-----|-------|-------|
| 1. Sample taken using a valve:   |     |       |       |
| a. Minimum of 4 L (1 gal) allowed to flow before sample taken?   | 1a. | _____ | _____ |
| b. Sample taken in clean 1 L (1 quart) wide mouth jar?   | 1b. | _____ | _____ |
| 2. Sample taken with Thief device.   |     |       |       |
| a. Sample can immersed approximately to middle of tanker?  | 2a. | _____ | _____ |
| b. Rubber stopper removed from can and sample taken from the middle of the tanker / tank?  | 2b. | _____ | _____ |
| 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? | 3.  | _____ | _____ |

#### Equipment

- |  |    |       |       |
|--|----|-------|-------|
| 4. Temperature of the viscometer bath at 50°C (122°F)? |    |       |       |
| 5. Viscosity tube clean and dry and cork installed?    | 5. | _____ | _____ |

#### Testing

- |  |     |       |       |
|--|-----|-------|-------|
| 6. Sample cooled to 51.7 ±0.3°C (125 ±0.5°F)?  |     |       |       |
| 7. Sample poured through a #20 sieve prior to entering the brass viscosity tube?   | 7.  | _____ | _____ |
| 8. Enough sample poured into the tube to allow overflow into gallery?  | 8.  | _____ | _____ |
| 9. Thermometer placed into tube and sample stirred slowly until testing temperature reached?                             | 9.  | _____ | _____ |
| 10. Thermometer withdrawn and excess in the overflow gallery siphoned out using a pipette without touching overflow rim? | 10. | _____ | _____ |
| 11. Emulsified asphalt sample in viscometer immediately covered?   | 11. | _____ | _____ |
| 12. Cork pulled allowing the sample roll down the inside lip of the receiving flask?                                     | 12. | _____ | _____ |
| 13. Timer immediately started when cork is pulled?   | 13. | _____ | _____ |
| 14. Timer stopped when bottom of sample meniscus reaches graduation mark?  | 14. | _____ | _____ |
| 15. Test results reported to nearest 1 second on ITD-1045 form?  | 15. | _____ | _____ |

**First Attempt: Pass** ☐    **Fail** ☐    **Second Attempt: Pass** ☐    **Fail** ☐

Comments: \_\_\_\_\_

Participant Name \_\_\_\_\_ Exam Date \_\_\_\_\_ WAQTC# \_\_\_\_\_

Examiner's Name: \_\_\_\_\_ Signature \_\_\_\_\_

WAQTC #: \_\_\_\_\_





## 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:

- |  |
|--|
| 1. 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. |
| 2. The voids in the aggregate layer need to be 70 percent filled with asphalt for good performance on pavements with moderate levels of traffic.   |

---

### 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:

Sieve Sizes
1 inch
$\frac{3}{4}$ inch
$\frac{1}{2}$ inch
Inch
$\frac{1}{4}$ inch
No. 4
No. 8

No. 16
No. 50
No. 200

**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:

**Equation 63-1** 
$$H = M / [1.139285 + (0.011506) FI]$$

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:

**Equation 63-2** 
$$V = 1 - W / (62.4G)$$

Where:

V = Voids in the loose aggregate, in percent expressed as a decimal

W = Loose unit weight of the cover aggregate, lbs/ft<sup>3</sup>

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.

<b>Table 63-1, Traffic Correction Factor, T</b>				
<b>Traffic Factor*</b>				
<b>Traffic – Vehicles per day</b>				
Under 100	100 to 500	500 to 1000	1000 to 2000	Over 2000
0.85	0.75	0.70	0.65	0.60
*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.

<b>Table 63-2. Aggregate Wastage Factor, E*</b>	
<b>Percentage Waste Allowed for Traffic Whip-Off and Handling</b>	<b>Wastage Factor, E</b>
1	1.01
2	1.02
3	1.03
4	1.04

5	1.05
6	1.06
7	1.07
8	1.08
9	1.09
10	1.10
11	1.11
12	1.12
13	1.13
14	1.14
15	1.15
*(Source: Asphalt Institute MS-19, March 1979).	

**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 63-3, Surface Correction Factor, S.	
Existing Pavement Texture	Correction, S
Black, flushed asphalt surface	-0.01 to 0.06
Smooth, nonporous surface	0.00
Slightly porous, oxidized surface	+ 0.03
Slightly pocked, porous, oxidized surface	+ 0.06
Badly pocked, porous, oxidized surface	+0.09

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**       $C = 46.8 (1 - 0.4V) HGE$

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**                      
$$B = (2.244HTV + S + A) / R$$

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.



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**Idaho Standard Method of Test for**

# Detection of Anti-Stripping Additive in Asphalt Binder

**IDAHO Designation: IT-99-17**

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**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**

- 3.1. Standard Specifications for Highway Construction, Subsection 702.04.

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**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.

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## 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	<u>Trial 1</u>	<u>Trial 2</u>
<b>General</b>		
1. All containers and or stir sticks were clean and chemical solutions were fresh.	1. _____	_____
<b>Detection test by Color Method only</b>		
2. A control blank was performed.	2. _____	_____
3. 40ml of Reagent Isopropyl Alcohol or equivalent was used.	3. _____	_____
4. The asphalt mixture was heated on a hot plate.	4. _____	_____
5. Heating of sample was stopped before mixture became too dark.	5. _____	_____
6. The same amount of Bromophenol Blue Indicator was added to both mixtures.	6. _____	_____
7. Test results were accurately interpreted and recorded on the proper ITD form. (Blue color as positive; report any other color change as negative).	7. _____	_____

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

Testing Technician's Name: \_\_\_\_\_ WAQTC # : \_\_\_\_\_ Date: \_\_\_\_\_

Examiner's Name: \_\_\_\_\_ Signature \_\_\_\_\_



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**Idaho Standard Practice for****Acceptance Test Strip for Asphalt Mixtures****IDAHO Designation: IR-125-19**

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**1. SCOPE**

- 1.1. This Standard Practice is used to evaluate asphalt mixtures produced through a hot plant for conformance to the mix design and JMF and for acceptance.
- 1.2. *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the user's responsibility of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations before use.*

---

**2. REFERENCE DOCUMENTS****2.1 AASHTO Standards**

- FOP for T 27, Particle Size Distribution of Aggregate
- FOP for T 11 Method A or B, Materials Finer than 75um (No. 200) Sieve in Mineral Aggregate by Washing
- FOP for T 30, Mechanical Analysis of Extracted Aggregate
- FOP for T 312, Preparing and Determining the Density of Hot Mix Asphalt (HMA) Specimens by Means of the Superpave Gyratory Compactor
- R 35, Superpave Volumetric Design for Hot Mix Asphalt (HMA)
- FOP for T 335, Method 1, Determining the Percentage of Fracture in Coarse Aggregate
- T 269, Percent Air Voids in Compacted Dense and Open Bituminous Paving Mixtures
- FOP for AASHTO T 209, Bowl Method, Theoretical Maximum Specific Gravity and Density of Bituminous Paving Mixtures
- FOP for AASHTO R 67, Sampling Asphalt Mixtures after Compaction (Obtaining Cores)
- R 57, Standard Practice for Operating Inertial Profilers and Evaluating Pavement Profiles
- FOP for T 308, Determining the Asphalt Binder Content of Hot Mix Asphalt (HMA) by the Ignition Method
- R 97, Sampling Asphalt Mixtures
- FOP for R 47, Reducing Samples of Hot Mix Asphalt to Testing Size
- FOP for T 329, Moisture Content of Hot Mix Asphalt (HMA) by Oven Method
- FOP for T 176, Alternate Method #2 Mechanical Pre-Wet, Plastic Fines in Graded Aggregate and Soils By Use of the Sand Equivalent Test
- T 304, Method A, Uncompacted Void Content of Fine Aggregate
- FOP for R 66, Sampling Asphalt Materials

- M 323, Superpave Volumetric Mix Design
- T 344, Evaluation of the Superpave Gyratory Compactor (SGC) Internal angle of Gyration Using Simulated Loading
- T 331, Bulk Specific Gravity and Density of Compacted Asphalt Mixtures Using Automatic Vacuum Sealing Method
- R 79, Standard Practice for Rapid Drying of Compacted Asphalt Specimens Using Vacuum Drying Apparatus
- T 164, Quantitative Extraction of Bitumen from Bituminous Paving Mixtures
- T 319, Quantitative Extraction and Recovery of Asphalt Binder from Asphalt Mixtures
- FOP for T 166, Method A, Bulk Specific Gravity of Compacted Bituminous Mixtures Using Saturated Surface Dry Specimens
- FOP for T 355, In-Place Density of Asphalt Mixtures by Nuclear Methods
- T 324, Hamburg Wheel-Track Testing of Compacted Hot Mix Asphalt (HMA)

## 2.2

*ASTM Standards*

- D 1075, Standard Test Method for Effect of Water on Compressive Strength of Compacted Bituminous Mixtures (Immersion-Compression)
- D 4791, Standard Test Method for Flat Particles, Elongated Particles, or Flat and Elongated Particles in Coarse Aggregate
- D 6857, Standard Test Method for Maximum Specific Gravity and Density of Bituminous Paving Mixtures Using Automatic Vacuum Sealing Method
- 8159, Standard Test Method for Automated Extraction of Asphalt Binder From Asphalt Mixtures (Asphalt Analyzer™)
- 8225, Standard Method of Test for Determination of Cracking Tolerance Index of Asphalt Mixture Using the Indirect Tensile Cracking Test at Intermediate Temperature

## 2.3

*Idaho Standards*

- Idaho IR 87, Pavement Straightedge Procedures
- IT 120, Determining Volume of Liquids in Horizontal or Vertical Storage Tanks
- IR 125, Acceptance Test Strip for Hot Mix Asphalt (HMA) Pavement
- IT 144, Specific Gravity and Absorption of Aggregate Using Automatic Vacuum Sealing Method
- IT 146, Determination of Recycled Asphalt Pavement (RAP) Aggregate Dry Bulk Specific Gravity ( $G_{sb}$ )
- IR 148, Stratified Random Sampling
- IR 150, Superpave Mix Design
- IR 151, Superpave Mix Design Evaluation
- IR 152, HMA Quality Control Plan Development and Implementation
- IR 153, Split Sample Comparison
- IR 154, Nuclear Density Gauge Correlation
- IR 155, Evaluation and Approval of HMA Plants and Equipment
- IR 156, Method for Determining Rolling  $G_{mm}$

- IR 157, NCAT Correction Factor

#### 2.4 *Other Standards*

- Standard Specifications, Subsection 106.03
- Standard Specifications, Section 405
- Quality Assurance Manual, Section 220

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### 3. GENERAL TEST STRIP REQUIREMENTS

- 3.1. The date, time, and location of the acceptance test strip will be agreed to by the Engineer and the Contractor.
- 3.2. The Engineer must witness all sampling of material to be used for acceptance. Any acceptance sample obtained that is not witnessed by the Engineer will be discarded.
- 3.3. The Contractor is responsible for sampling of material. The Contractor will have a qualified technician available for the duration of the test strip. The Contractor will immediately give the samples to the Engineer.

---

### 4. IDENTIFYING THE TYPE OF TEST STRIP

- 4.1. There are 2 types of test strips, an onsite test strip and an off-site test strip (i.e., off-site mix verification). The onsite test strip is performed at the start of production paving operations and encompasses the first lot of production paving. The off-site test strip is performed before beginning production paving.
- 4.2. Determine if the Contractor will perform an onsite test strip or off-site test strip to verify the JMF.
- 4.3. For an onsite test strip, the test strip will be the first day of production with the following exception:
  - 4.3.1. If the total estimated quantity of material for the bid item is between 750 and 2,250 tons, the entire quantity of material will be considered the test strip, use the modified sampling schedule found in Annex 1 – On-Site Test Strip Procedure for Smaller Production Runs.
- 4.4. For an off-site test strip, the test strip sampling will be performed while the Contractor is producing the JMF.

---

### 5. DETERMINING THE TEST STRIP SAMPLING SCHEDULE

- 5.1. Before the test strip, determine, in conjunction with the Contractor, the anticipated quantity of material that will be produced for the test strip.  
***Note:** It is recommended to do this via email or other written communication to ensure adequate documentation for the project records.*
- 5.2. Calculate the testing frequency by dividing the anticipated quantity of material that will be produced for the test strip by the required number of samples needed.

- 5.3. Using the value calculated in 5.2, perform Idaho IR 148 to determine the sampling schedule to obtain the required number of stratified, random samples.
- 5.4. Repeat step 5.2 and step 5.3 for each material to be sampled. See **Example of Determining the Test Strip Sampling Schedule**.

---

## 6. MATERIAL SAMPLING REQUIREMENTS

- 6.1. Before obtaining the first sample, confirm at the hot plant that the JMF is being produced and that the most current hot plant calibrations have been verified in accordance with Idaho IR 155.
- 6.2. The Contractor will sample the required materials as shown in Table 6.1 at the intervals given in the test strip sampling schedule.
- 6.2.1. Each sample must be clearly labeled and secured in the Engineer's possession immediately after the sample is taken.
- 6.2.2. Each sample must be accompanied by the appropriate sample tracking form with all sampling information included and signed by the WAQTC sampling technician.
- 6.3. Continue to monitor that the proper mix is being produced throughout the test strip.
- 6.4. Immediately after completion of the test strip, obtain the hot plant printouts and calibration records.
- 6.5. The testing timeframe begins once the Engineer has received all test strip samples, sample tracking forms, and hot plant printouts and calibration records. Submit samples, and original sample tracking forms to the acceptance lab for testing.

Table 6.1-Sampling Requirements

Material	Sampling Procedure	Number of Samples	Minimum Sample Size	Sample Container
Mix	AASHTO R 97	6	100 lbs	Cardboard box <sup>(a)</sup>
Aggregate	AASHTO R 90	3	50 lbs	5-gallon bucket <sup>(b)</sup>
RAP	AASHTO R 97	2	50 lbs	5-gallon bucket <sup>(b)</sup>
Binder	FOP for AASHTO R 66	1	Three 1-quart containers	Screw top can <sup>(a)</sup>
Field Compacted Mix	FOP for AASHTO R 67	10	One 6-inch diameter core	Suitable protective container <sup>(c)</sup>

<sup>(a)</sup> See Quality Assurance Manual Table 220.01.1.

<sup>(b)</sup> Clean 5-gallon bucket with a screw on lid.

<sup>(c)</sup> See FOP for AASHTO R 67 for guidance on packaging and transporting samples.

---

## 7. SAMPLING AND TESTING FIELD COMPACTED MIX

- 7.1. Field compacted mix acceptance will be based on the results of cores sampled in accordance with AASHTO R 67.
- 7.2. When nuclear density gauge results are to be used for acceptance for lots after the completion of the acceptance test strip, correlate the nuclear density gauge(s) in accordance with Idaho IR 154.



---

**8. TEST STRIP DOCUMENTAION**

- 8.1. Maintain in Project Wise the following records, *at a minimum*, for the test strip sampling:
  - 8.1.1. Sampling schedule.
  - 8.1.2. The carbon copy of the appropriate sample tracking form for each sample obtained.
  - 8.1.3. A daily work report (DWR) or daily diary documenting the day's events.
  - 8.1.4. A copy of the hot plant calibration records and a hot plant printout showing recorded data every 15 minutes.
- 8.2. Ensure the documentation listed under 8.1 is available in ProjectWise within 2 business days after the completion of the test strip.

---

**9. ACCEPTANCE LAB RECIEVING PROCEDURE**

- 9.1. Upon receiving the samples and associated sample tracking forms, ensure that all required documentation is included.
- 9.2. Document condition of samples, and date and time received.
- 9.3. Notify the Engineer of receipt and provide a time of estimated completion and review of all testing.
- 9.4. *With the mix samples:*
  - 9.4.1. Select 1 sample for Idaho IT 157.
  - 9.4.2. Select 3 samples for volumetric testing shown in Table 10.1.
  - 9.4.3. Select 2 samples for performance testing shown in Table 10.2.
  - 9.4.4. Select 1 sample for additional testing as needed.
  - 9.4.5. Test the mix samples in accordance with Section 10.
- 9.5. *With the aggregate samples:*
  - 9.5.1. Test the aggregate samples in accordance with Section 11.
- 9.6. *With the RAP samples:*
  - 9.6.1. Test the RAP samples in accordance with Section 12.
- 9.7. *With the binder sample:*
  - 9.7.1. Test the binder sample in accordance with Section 13.
- 9.8. *With the field compacted mix samples:*
  - 9.8.1. Test the field compacted mix samples in accordance with Section 14.

---

**10. ACCEPTANCE LAB MIX TESTING REQUIREMENTS**

- 10.1. With the 1 sample selected in Section 9.4.1, perform Idaho IT 157.
- 10.2. With each of the 3 samples selected in Section 9.4.2 retain 1 box of each sample for dispute resolution testing. With the remaining box from each sample, reduce in accordance with FOP for AASHTO R 47 and perform the volumetric testing shown in Table 10.1.
- 10.2.1. Report results on the most current ITD-773 form and include copies of all original source documents.

**Table 10.1 – Test Strip Mix Volumetric Testing Requirements.**

Test Method	Increments Per Sample
FOP for AASHTO T 308	1
FOP for AASHTO T 30	1
FOP for AASHTO T 312	2
FOP for AASHTO T 166 Method A	2
FOP for AASHTO T 209	2
FOP for AASHTO T 329	1

- 10.3. With each of the 2 samples selected in Section 9.4.3 retain 1 box of each sample for dispute resolution testing. With the remaining box from each sample, perform the performance testing shown in Table 10.2.

**Table 10.2 – Test Strip Mix Performance Testing Requirements.**

Test Method	Increments Per Sample
AASHTO T 324	2
ASTM D 8225	3

- 10.4. With the 1 sample selected in 9.4.4, retain the sample for future testing.

---

**11. ACCEPTANCE LAB AGGREGATE TESTING REQUIREMENTS**

- 11.1. With each of the 3 samples selected in Section 9.5.1, reduce in accordance with FOP for AASHTO R 76 and perform the testing shown in Table 11.1.
- 11.1.1. Report results on the most current Department forms, include copies of all original source documents.

**Table 11.1 – Test Strip Aggregate Testing Requirements.**

Test Method	Increments Per Sample
FOP for AASHTO T 335	1
FOP for AASHTO T 255	1
AASHTO T 304 Method A	1
FOP for ASTM D 4791	2

FOP for AASHTO T 176 (Alternate Method 2, Mechanical)	2
AASHTO T 85 <sup>(a)</sup>	3
Idaho IT 144 <sup>(a)</sup>	3

<sup>(a)</sup> Department may elect to perform to confirm  $G_{sb}$ .

---

## 12. ACCEPTANCE LAB RAP TESTING REQUIREMENTS

12.1. With each of the 2 samples selected in Section 9.6.1, reduce in accordance with FOP for AASHTO R 76 and perform the testing shown in Table 12.1.

12.1.1. Report results on the most current Department forms include copies of all original source documents.

**Table 12.1 – Test Strip RAP Testing Requirements.**

Test Method	Increments Per Sample
FOP for AASHTO T 255 (Controlled Heat Source)	1
Idaho IT 146 <sup>(a)</sup>	1
ASTM D 8159 <sup>(a)</sup>	1
AASHTO T 30 <sup>(a)</sup>	1
AASHTO T 308 <sup>(a)</sup>	1

<sup>(a)</sup> Department may elect to perform to confirm RAP properties and verify  $G_{sb}$ .

---

## 13. ACCEPTANCE LAB BINDER TESTING REQUIREMENTS

13.1. With the one sample selected in Section 9.7.1, select 2 quarts for Department acceptance testing and 1 quart for challenge resolution. Perform the testing shown in Table 13.1.

13.1.1. Report results on the most current Department forms, include copies of all original source documents.

**Table 13.1 – Test Strip Binder Testing Requirements.**

Test Method	Increments Per Sample
Idaho IT 99	1
AASHTO M 320 <sup>(a)</sup>	1
ASTM D 8159 <sup>(a)</sup>	1

<sup>(a)</sup> See QA Manual Sections 230.10. Meet the requirements of Standard Specifications Sections 702.01 and 702.06.

---

## 14. ACCEPTANCE LAB FIELD COMPACTED MIX TESTING REQUIREMENTS

14.1. With the each of the 10 samples selected in Section 9.8.1, separate two or more pavement courses, lifts, or layers per FOP for AASHTO R 67. Perform the testing shown in Table 14.1.

- 14.1.1. Report results on the most current Department forms, include copies of all original source documents.

**Table 14.1** – Field Compacted Mix Testing Requirements.

Test Method	Increments Per Sample
FOP for AASHTO T 166 Method A or AASHTO T 331 <sup>(a)</sup>	1

<sup>(a)</sup>Use the average  $G_{mm}$  from testing performed in Section 10 to compute the in-place density of the cores.

---

## 15. ACCEPTANCE LAB TEST STRIP RESULTS REPORTING PROCEDURE

- 15.1. Report the results of each test performed on the most current Department forms, include copies of all original source documents and sample tracking forms in the report.
- 15.1.1. Each original source document will be signed by the testing technician.
- 15.2. The lab manager or the lab manager's qualified designated agent will fully review the report and all supporting documents for completeness.
- 15.3. Submit a complete electronic copy of the report to the Engineer for distribution within the allocated testing timeframe.

---

## 16. EVALUATING ACCEPTANCE TEST STRIP RESULTS

- 16.1. The Engineer, upon receipt of the results from 15.3, will determine acceptance of the test strip as follows:
- 16.1.1. Use the Department approved method (e.g., Department provided spreadsheet or web portal) to perform the quality level analysis and determine acceptance as specified in 106.03.B and 405.03.I of the Standard Specifications.
- 16.2. *Review of hot plant calibration records:*
- 16.2.1. Verify that the calibration records meet Idaho IR 155. If they do not, perform a calibration verification in accordance with Idaho IR 155
- 16.3. *Review of hot plant printout:*
- 16.3.1. Use the ITD-774 to verify that the hot plant printout indicates the individual cold feed percentage for aggregate and cold feed percentage for RAP meet the requirements of Table 405.03-5 of the Standard Specifications.

---

## 17. ACCEPTANCE OF THE TEST STRIP

- 17.1. The test strip is considered acceptable when it meets all specifications.
- 17.2. The test strip does not meet the contract requirement if any of the following occurs:
- 17.2.1. The test strip does not meet the criteria in 405.03.I.5 of the Standard Specifications.

- 17.2.2. The hot plant printout indicates non-conformance to the JMF.
- 17.2.3. The results of the calibration verification indicates improper calibration.
- 17.2.4. The test strip was not produced according to the JMF.

---

## 18. EXAMPLE OF DETERMINING THE TEST STRIP SAMPLING SCHEDULE

Example: During the pre-construction meeting, the Contractor informs the Engineer that they will be performing an onsite test strip on April 19<sup>th</sup>. They anticipate paving 2,130 tons.

The Engineer will use this information to develop a test strip sampling schedule as follows:

*For plant mix:*

- The plant mix sampling frequency is calculated by dividing 2,130 by 6.
- Sampling frequency for plant mix is 1 sample per 355 tons.
- Use a 355 ton sample frequency and 6 samples, perform Idaho IR 148 to determine the sampling schedule to obtain 6 stratified random, samples of plant mix.
- Obtain plant mix samples in accordance with AASHTO R 97 per the sampling schedule.

*For cold feed aggregate:*

- The cold feed aggregate sampling frequency is calculated by dividing 2,130 by 3.
- Use a 710 ton sample frequency and 3 samples, perform Idaho IR 148 to determine the sampling schedule to obtain 3 stratified, random samples of cold feed aggregate.
- Obtain cold feed aggregate sample in accordance with AASHTO R 90 per the sampling schedule.

*For RAP (if used):*

- The RAP sampling frequency is calculated by dividing 2,130 by 2.
- Use a 1,065 ton sample frequency and 2 samples, perform Idaho IR 148 to determine the sampling schedule to obtain 2 stratified, random samples of RAP.
- Obtain RAP samples in accordance with AASHTO R 90 per the sampling schedule.

*For binder:*

- The binder sampling frequency is calculated by dividing 2,130 by 1.
- Use a 2,130 ton sample frequency and 1 sample, perform Idaho IR 148 to determine the sampling schedule to 1 stratified, random samples of binder.
- Obtain binder sample in accordance with FOP for AASHTO R 66 per the sampling schedule.

*For field compacted mix:*

- The field compacted mix sampling frequency is calculated by dividing 2,130 by 10.
- Sampling frequency for plant mix is 1 sample per 213 tons.
- Use a 213 ton sample frequency and 10 samples, perform Idaho IR 148 to determine the sampling schedule to obtain 10 stratified random, samples of field compacted mix.
- Obtain field compacted mix samples in accordance with AASHTO R 67 per the sampling schedule.

---

## ANNEX 1. ON-SITE TEST STRIP PROCEDURE FOR SMALLER PRODUCTION RUNS

### A1.1. DETERMINING THE TEST STRIP SAMPLING SCHEDULE

- A1.1.1. Before the test strip, determine, in conjunction with the Contractor, the anticipated quantity of material that will be produced for the test strip.
- Note: It is recommended to do this via email or other written communication to ensure adequate documentation for the project records.*
- A1.1.2. Calculate the testing frequency by dividing the anticipated quantity of material that will be produced for the test strip by the required number of samples needed.
- A1.1.3. Using the value calculated in A1.1.2, perform Idaho IR 148 to determine the sampling schedule to obtain the required number of stratified, random samples.
- A1.1.4. Repeat step A1.1.2 and step A1.1.3 for each material to be sampled. See **Example of Determining the Test Strip Sampling Schedule**.

---

### A1.2. MATERIAL SAMPLING REQUIREMENTS

- A1.2.1. Before starting production paving, confirm at the hot plant that the JMF is being produced and that the most current hot plant calibrations have been verified in accordance with Idaho IR 155.
- A1.2.2. The Contractor will sample the required materials as shown in Table A1.2 at the intervals given in the test strip sampling schedule.
- A1.2.2.1. Each sample must be clearly labeled and secured in the Engineer's possession immediately after the sample is taken.
- A1.2.2.2. Each sample must be accompanied by the appropriate sample tracking form with all sampling information included and signed by the WAQTC sampling technician.
- A1.2.3. Continue to monitor that the proper mix is being produced throughout the test strip.
- A1.2.4. Immediately after completion each production run, obtain the hot plant printouts and calibration records.
- A1.2.5. The testing timeframe begins once the Engineer has received all test strip samples, sample tracking forms, and hot plant printouts and calibration records. Submit samples, and original sample tracking forms to the acceptance lab for testing.

Table A1.2.-Sampling Requirements

Material	Sampling Procedure	Number of Samples	Minimum Sample Size	Sample Container
Mix	AASHTO R 97	6	100 lbs <sup>(c)</sup>	Cardboard box <sup>(a)</sup>
Binder	FOP for AASHTO R 66	1 per day of production	Three 1-quart containers	Screw top can <sup>(a)</sup>
Field Compacted Mix	FOP for AASHTO R 67	10	One 6-inch diameter core	Suitable protective container <sup>(b)</sup>

- (a) See Quality Assurance Manual Table 220.01.1.
- (b) See FOP for AASHTO R 67 for guidance on packaging and transporting samples.
- (c) The minimum sample size for the first sample taken will be 200 lbs.

---

**A1.3. SAMPLING AND TESTING FIELD COMPACTED MIX**

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- A1.3.1. Field compacted mix acceptance will be based on the results of cores sampled in accordance with AASHTO R 67.

---

**A1.4. TEST STRIP DOCUMENTAION**

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- A1.4.1. Maintain in Project Wise the following records, *at a minimum*, for the test strip sampling:
- A1.4.1.1. Sampling schedule.
  - A1.4.1.2. The carbon copy of the appropriate sample tracking form for each sample obtained.
  - A1.4.1.3. A daily work report (DWR) or daily diary documenting the day's events for each day of paving.
  - A1.4.1.4. A copy of the hot plant calibration records and a hot plant printout showing recorded data every 15 minutes for each production run.
- A1.4.2. Ensure the documentation listed under A1.4.1 is available in ProjectWise within 2 business days after each production run.

---

**A1.5. ACCEPTANCE LAB RECIEVING PROCEDURE**

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- A1.5.1. Upon receiving the samples and associated sample tracking forms, ensure that all required documentation is included.
- A1.5.2. Document condition of samples, and date and time received.
- A1.5.3. Notify the Engineer of receipt and provide a time of estimated completion and review of all testing.
- A1.5.4. *With the first mix sample received for the bid item:*
- A1.5.4.1. Select 1 box of the sample for Idaho IT 157.
  - A1.5.4.2. Select 1 box of the sample for volumetric testing shown in Table 10.1.
  - A1.5.4.3. Select 1 box of the sample for performance testing shown in Table 10.2.
  - A1.5.4.4. Retain 1 box of the sample for dispute resolution testing.
  - A1.5.4.5. Test the mix samples in accordance with Section 10.
- A1.5.5. *With all subsequent mix samples received for the bid item:*
- A1.5.5.1. Select 1 box of the sample for volumetric testing shown in Table 10.1.
  - A1.5.5.2. Retain 1 box of the sample for dispute resolution testing.
- A1.5.5. *With the binder sample:*

- A1.5.5.1. Test the binder sample in accordance with Section 13.
- A1.5.6. *With the field compacted mix samples:*
- A1.5.6.1. Test the field compacted mix samples in accordance with Section 14.

---

## **A1.6. ACCEPTANCE LAB MIX TESTING REQUIREMENTS**

- A1.6.1. With the 1 sample selected in Section A1.5.4.1, perform Idaho IT 157.
- A1.6.2. With the box selected for volumetric testing in Section A1.5.4.2 or Section A1.5.5.1, reduce in accordance with FOP for AASHTO R 47 and perform the volumetric testing shown in Table A1.6.1.
- A1.6.2.1. Report results on the most current ITD-773 form and include copies of all original source documents.

**Table A1.6.1** – Test Strip Mix Volumetric Testing Requirements.

<b>Test Method</b>	<b>Increments Per Sample</b>
FOP for AASHTO T 308	1
FOP for AASHTO T 30	1
FOP for AASHTO T 312	2
FOP for AASHTO T 166 Method A	2
FOP for AASHTO T 209	2
FOP for AASHTO T 329	1

- A1.6.3. With the box selected for performance testing in Section A1.5.4 reduce in accordance with FOP for AASHTO R 47 and perform the performance testing shown in Table A1.6.2.

**Table A1.6.2** – Test Strip Mix Performance Testing Requirements.

<b>Test Method</b>	<b>Increments Per Sample</b>
AASHTO T 324	2
ASTM D 8225	2

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## **A1.7. ACCEPTANCE LAB BINDER TESTING REQUIREMENTS**

- A1.7.1. With the one sample selected in Section A1.5.5.1, select 2 quarts for Department acceptance testing and 1 quart for challenge resolution. Perform the testing shown in Table A1.7.1.
- A1.7.1.1. Report results on the most current Department forms, include copies of all original source documents.

**Table A1.7.1** – Test Strip Binder Testing Requirements.

<b>Test Method</b>	<b>Increments Per Sample</b>
Idaho IT 99	1
AASHTO M 320 <sup>(a)</sup>	1



ASTM D 8159<sup>(a)</sup>

1

<sup>(a)</sup>See QA Manual Sections 230.10. Meet the requirements of Standard Specifications Sections 702.01 and 702.06.

---

## **A1.8. ACCEPTANCE LAB FIELD COMPACTED MIX TESTING REQUIREMENTS**

A1.8.1. With the each of the 10 samples selected in Section A1.5.6.1, separate two or more pavement courses, lifts, or layers per FOP for AASHTO R 67. Perform the testing shown in Table A1.8.1.

A1.8.1.1. Report results on the most current Department forms, include copies of all original source documents.

**Table A1.8.1** – Field Compacted Mix Testing Requirements.

Test Method	Increments Per Sample
FOP for AASHTO T 166 Method A or AASHTO T 331 <sup>(a)</sup>	1

<sup>(a)</sup>Use the average  $G_{mm}$  from testing performed in A1.6.2 to compute the in-place density of the cores.

---

## **A1.9. ACCEPTANCE LAB TEST STRIP RESULTS REPORTING PROCEDURE**

A1.9.1. Report the results of each test performed on the most current Department forms, include copies of all original source documents and sample tracking forms in the report.

A1.9.1.1. Each original source document will be signed by the testing technician.

A1.9.2. The lab manager or the lab manager's qualified designated agent will fully review the report and all supporting documents for completeness.

A1.9.3. Submit a complete electronic copy of the report to the Engineer for distribution within the allocated testing timeframe.

---

## **A1.10. EVALUATING ACCEPTANCE TEST STRIP RESULTS**

A1.10.1. The Engineer, upon receipt of all the results from A1.9.3, will determine acceptance of the test strip as follows:

A1.10.1.1. Use the Department approved method (e.g., Department provided spreadsheet or web portal) to perform the quality level analysis and determine acceptance as specified in 106.03.B and 405.03.I of the Standard Specifications.

A1.10.2. *Review of hot plant calibration records:*

A1.10.2.1. Verify that the calibration records meet Idaho IR 155 for each production run. If they do not, perform a calibration verification in accordance with Idaho IR 155 prior to the following production run.

A1.10.3. *Review of hot plant printout:*

A1.10.3.1. Use the ITD-774 to verify that the hot plant printout indicates the individual cold feed percentage for aggregate and cold feed percentage for RAP meet the requirements of Table 405.03-5 of the Standard Specifications.

---

**A1.11. ACCEPTANCE OF THE TEST STRIP**

A1.11.1. The test strip is considered acceptable when it meets all specifications.

A1.11.2. The test strip is does not meet the contract requirement if any of the following occurs:

A1.11.2.1. The test strip does not meet the criteria in 405.03.I.5 of the Standard Specifications.

A1.11.2.2. The hot plant printout indicates non-conformance to the JMF.

A1.11.3. The results of the calibration verification indicates improper calibration.

A1.11.4. The test strip was not produced according to the JMF.

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**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**

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**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.*

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**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.

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**4. REAGENTS AND MATERIALS**

- 4.1. *Ottawa Sand*— ASTM C778, 20-30 Grading.
- 4.2. *Distilled Water*— ASTM D1193, Type I.
- 4.3. *Toluene*— Technical Grade
- 4.4. Asphalt binder
- 4.5. Anti-strip Additive

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**5. APPARATUS**

- 5.1. Oven capable of maintaining a temperature of  $325^{\circ}\text{F} \pm 5^{\circ}\text{F}$
- 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.

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**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  $330^{\circ}\text{F}$ .
- 6.2. Heat the anti-strip additive, do not exceed  $100^{\circ}\text{F}$  or manufacturers recommended temperature and mix thoroughly.
- 6.3. Place  $796 \pm 1.0$  g of asphalt binder into the one-quart metal can container.
- 6.4. Add  $4 \pm 0.1$  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  $325 \pm 5^{\circ}\text{F}$  for 96 hours.
- 6.6. Remove the sample from the oven and stir.
- 6.7. Pour  $25 \pm 1.0$  g of the binder and additive mixture into the 4 oz. tin container. Allow the liquid to cool to below  $140^{\circ}\text{F}$  but still remaining mixable.
- 6.8. Carefully add  $4.5 \pm 0.1$  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  $20 \pm 1$  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  $1 \pm 0.2$  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.

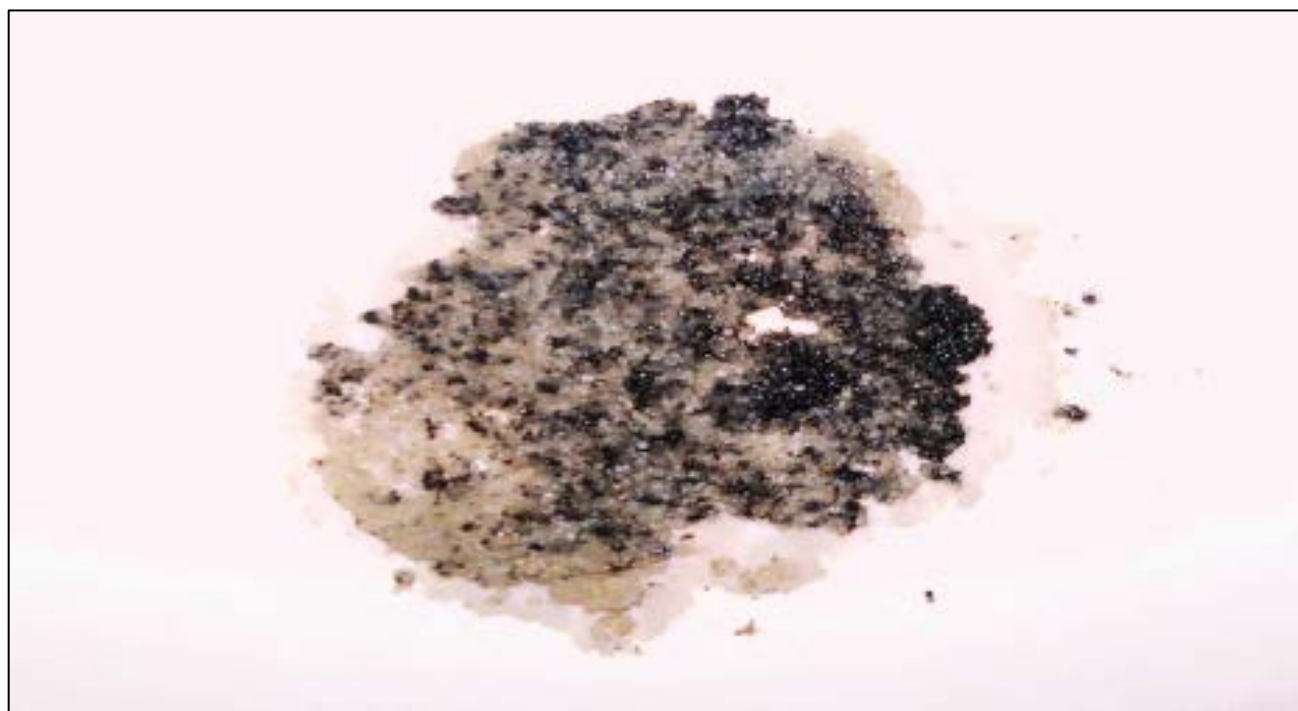
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## 7. REPORT

- 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.**

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**Idaho Standard Method of Test for****DETERMINATION OF RECLAIMED ASPHALT PAVEMENT (RAP)  
AGGREGATE BULK (DRY) SPECIFIC GRAVITY ( $G_{sb}$ )****IDAHO Designation: IT-146-19**

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**1. SCOPE**

- 1.1. This method covers the procedure for determining the Bulk (Dry) Aggregate Specific Gravity, ( $G_{sb}$ ) of a Recycled Asphalt Pavement, (RAP) aggregate from Maximum Theoretical Specific Gravity ( $G_{mm}$ ) tests of the RAP. An Effective Specific Gravity of Aggregate, ( $G_{se}$ ) is calculated and used to determine the  $G_{sb}$  of the RAP after adjusting the  $G_{se}$  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.*

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**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
  - R 90, Sampling Aggregate Products
  - T 85, Specific Gravity and Absorption of Coarse Aggregate
  - T 209, Theoretical Maximum Specific Gravity ( $G_{mm}$ ) 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:*
- McDaniel, R. and Anderson, R.M. (2001). *Recommended Use of Reclaimed Asphalt Pavement in the Superpave Mix Design Method: Technician's Manual*, NCHRP Report No. 452, Transportation Research Board, Washington, DC.
  - Copeland, A. (2011). *Reclaimed Asphalt Pavement in Asphalt Mixtures: State of the Practice*, Publication No. FHWA-HRT-11-021, Turner-Fairbank Research Center, Federal Highway Administration.
  - Advanced Asphalt Technologies, LLC (2011). *NCHRP Report 673 A Manual for Design of Hot Mix Asphalt with Commentary*, TRB, National Research Council, Washington DC
  - Asphalt Institute MS-2, Asphalt Mix Design Methods. 7th Edition, 2014, Lexington Kentucky
- 2.4. Standard Specifications, Subsection 720.07.

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**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 ( $G_{mm}$ ) tests so that an effective specific gravity ( $G_{se}$ ) can be calculated. Use the calculated  $G_{se}$  value and the assumed asphalt binder absorption of the RAP to determine the bulk (dry) specific gravity ( $G_{sb}$ ) of the RAP.

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**4. APPARATUS**

- 4.1. *Drying Oven.* Oven of sufficient capacity for containing the sample and capable of maintaining a temperature of  $230 \pm 9^{\circ}\text{F}$ .
- 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

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**5. SAMPLING**

- 5.1. Sample the RAP stockpile, per R 90, in its final usable form, by obtaining a minimum of eight representative locations from the RAP stockpile. Obtain a minimum 22 lb (10,000 grams) of RAP from each location. Thoroughly blend all the samples and reduce per R 76 to produce a minimum 20,000-gram sample.

**Note 1**—NCHRP Report 673 includes a recommended RAP Sampling Plan. (See Appendix X1)

**Note 2**—Sampling is typically performed by the Contractor and witnessed by the Department. The Department will take possession of a minimum of 100 pounds of RAP and reduce it by R 76 to the required size for this test. The remainder will be reserved for other testing.

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**6. PREPARATION OF SAMPLE**

- 6.1. Place a 20,000-gram sample into large flat pan(s).
- 6.1.1. Place sample into a preheated oven at  $230 \pm 9^{\circ}\text{F}$ . 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. Split out at least eight 2,000-gram minimum increments for use in Section 7.

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## 7. PROCEDURE

- 7.1. *Percent Asphalt Binder,  $P_b$  using Chemical Extraction/Ignition Furnace Correlation Factor:*
- 7.1.1. Randomly select four increments from 6.1.6 for binder content and gradation determination.
- 7.1.2. Select two increments for testing and keep the remaining increments in reserve.
- 7.1.3. Determine the  $P_b$  of two dried RAP increments according to FOP for AASHTO T 308. Calculate the uncorrected asphalt content of the two increments and if the difference exceeds 0.2 perform another pair of FOP for AASHTO T 308 tests. Throw out the high and low values, and average the two remaining results.
- 7.1.4. Compare the average uncorrected asphalt binder content from FOP for AASHTO T 308 with the Contractor's average uncorrected asphalt binder content from FOP for AASHTO T 308. (Use the 6 ignition furnace tests from the average of 6 chemical and 6 ignition furnace tests.) .
- 7.1.4.1. If the algebraic difference is within 0.33 accept the Contractor's asphalt binder correlation factor (from the average of 6 chemical and 6 ignition furnace tests).
- 7.1.4.2. If the algebraic difference exceeds 0.33 request new samples from the Contractor and repeat steps 5.1 through 7.1.
- 7.1.5. Calculate the RAP asphalt binder content using the average uncorrected FOP for AASHTO T 308 results from step 7.1.3 and apply the Contractor furnished asphalt binder correlation.
- 7.2. *Aggregate Gradation:*
- 7.2.1. Determine the gradation of the two RAP increments used in 7.1.3 according to FOP for AASHTO T 30. Calculate the gradation of the two increments used in 7.1.3 and determine the average.
- 7.2.2. Compare the average gradation with the Contractor's Stockpile Average gradation from QC testing.
- 7.2.2.1. If the algebraic difference is within the allowed difference in Table 1, accept the RAP go to step 7.2.3.
- 7.2.2.2. If the algebraic difference exceeds allowed difference in Table 1, request new samples from the Contractor and repeat steps 5.1 through 7.1.

**Table 1 Permitted Sieving Differences**

Sieve	Allowable Difference
Sizes larger than or equal to No. 8 (2.36 mm)	± 8.0%
Sizes larger than No. 200 (0.75µm) and smaller than No. 8 (2.36 mm)	± 6.0%
Sizes No. 200 (0.75µm) and smaller	± 2.0%

- 7.2.3. Record the  $P_b$  and the aggregate gradation.

**Note 2**—This step is used to determine if the RAP submitted to the Department for RAP  $G_{sb}$  testing represents the RAP produced, stockpiled and used in the mix design and during production.

7.3. *Maximum Specific Gravity determination,  $G_{mm}$ :*

- 7.3.1. Combine the remaining four increments of the prepared RAP sample into one large sample for determining  $G_{mm}$ .
- 7.3.2. Dry the sample to a constant mass in an oven at  $230 \pm 9^\circ$  F. While drying, chop and break up the sample as you would with a standard  $G_{mm}$  sample. Record as “dry RAP mass”.
- 7.3.3. Place the sample in  $295^\circ \pm 5^\circ$  F. oven for one hour.
- 7.3.4. Add approximately 2 percent virgin asphalt binder (for example PG 64-28 or PG 58-28) at  $295^\circ \pm 5^\circ$  F. based on the “dry RAP mass” from step 7.3.2 to the RAP.
  - 7.3.4.1. Record mass of binder and calculate the actual percent of binder added.
  - 7.3.4.2. Thoroughly mix at  $295^\circ \pm 5^\circ$  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.

- 7.3.5. Split the prepared RAP sample into four 2,000-gram increments. Determine the  $G_{mm}$  of two of the prepared RAP increments according to T 209 and keep the remaining increments in reserve.
- 7.3.6. 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 7.3., 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 7.3. until individual results compare within 0.010.
- 7.3.7. Estimate the asphalt binder absorption of the RAP,  $P_{ba}$  from the water absorption of virgin aggregates used in the project.

**Note 3**—If the virgin aggregates used in the project are obviously different from those from the RAP, use other means to determine the water absorption. For example, use project specific source information for RAP removed from ITD roadways. Do not use water absorption values that do not represent the RAP aggregate.

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## 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)”.
    - 8.1.1.1. 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 =  $0.02 \times$  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  $P_b$ ”:

$$\text{Adjusted } P_b = \frac{\text{Mass of RAP AC} + \text{Mass of Virgin AC added}}{\text{New RAP Mass}} \times 100$$

- 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:

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

- 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 =  $0.02 \times \text{Dry RAP mass}$   
 $= 0.02 \times 3,000 \text{ grams}$   
 $= 60 \text{ grams}$

- 9.3.2. Determine “New RAP mass”  
 New RAP mass = Dry RAP mass + Mass of virgin AC added  
 $= 3,000 + 60$

$$= 3,060 \text{ grams}$$

- 9.4. Calculate “Adjusted  $P_b$ ”:

$$\text{Adjusted } P_b = \frac{\text{Mass of RAP AC} + \text{Mass of Virgin AC}}{\text{New RAP Mass}} \times 100$$

$$= \frac{147 \text{ grams} + 60 \text{ grams}}{3,060 \text{ grams}} \times 100$$

$$= 6.8\%$$

- 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%

$$P_{ba} = 1.2 \times 0.667$$

$$= 0.80\% \text{ asphalt absorption}$$

- 9.7. Calculate RAP  $G_{sb}$ :

$$G_{sb(RAP)} = \frac{G_{se(RAP)}}{\left(\frac{P_{ba(RAP)} \times G_{se(RAP)}}{100 \times G_{b(RAP)}}\right) + 1}$$

$G_{se(RAP)} = 2.726$

$P_{ba} = 0.80\%$

$G_b = 1.040$

$$G_{sb(RAP)} = \frac{2.726}{\left(\frac{0.80 \times 2.726}{100 \times 1.040}\right) + 1}$$

$$G_{sb(RAP)} = 2.670$$

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## 10. REPORT

- 10.1. Report the following information:

10.1.1. Results on approved forms. ITD 0XXX

10.1.2. Ignition furnace test temperature

10.1.3. Source number of aggregate used for water absorption estimate

10.1.4. Water absorption of virgin aggregate

- 10.1.5. RAP  $G_{se}$
- 10.1.6. RAP binder absorption (estimate)
- RAP  $G_{sb}$

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## APPENDIX

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(Nonmandatory Information)

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### X1. RAP SAMPLING PLAN

- X1.1. Excerpt from NCHRP Report 673 *A Manual for Design of Hot Mix Asphalt with Commentary*, Chapter 9 Reclaimed Asphalt Pavement. (Test methods AASHTO T 2 and T 248 were updated to Standard Practice R 90 and R 76 respectively.)

#### RAP Sampling

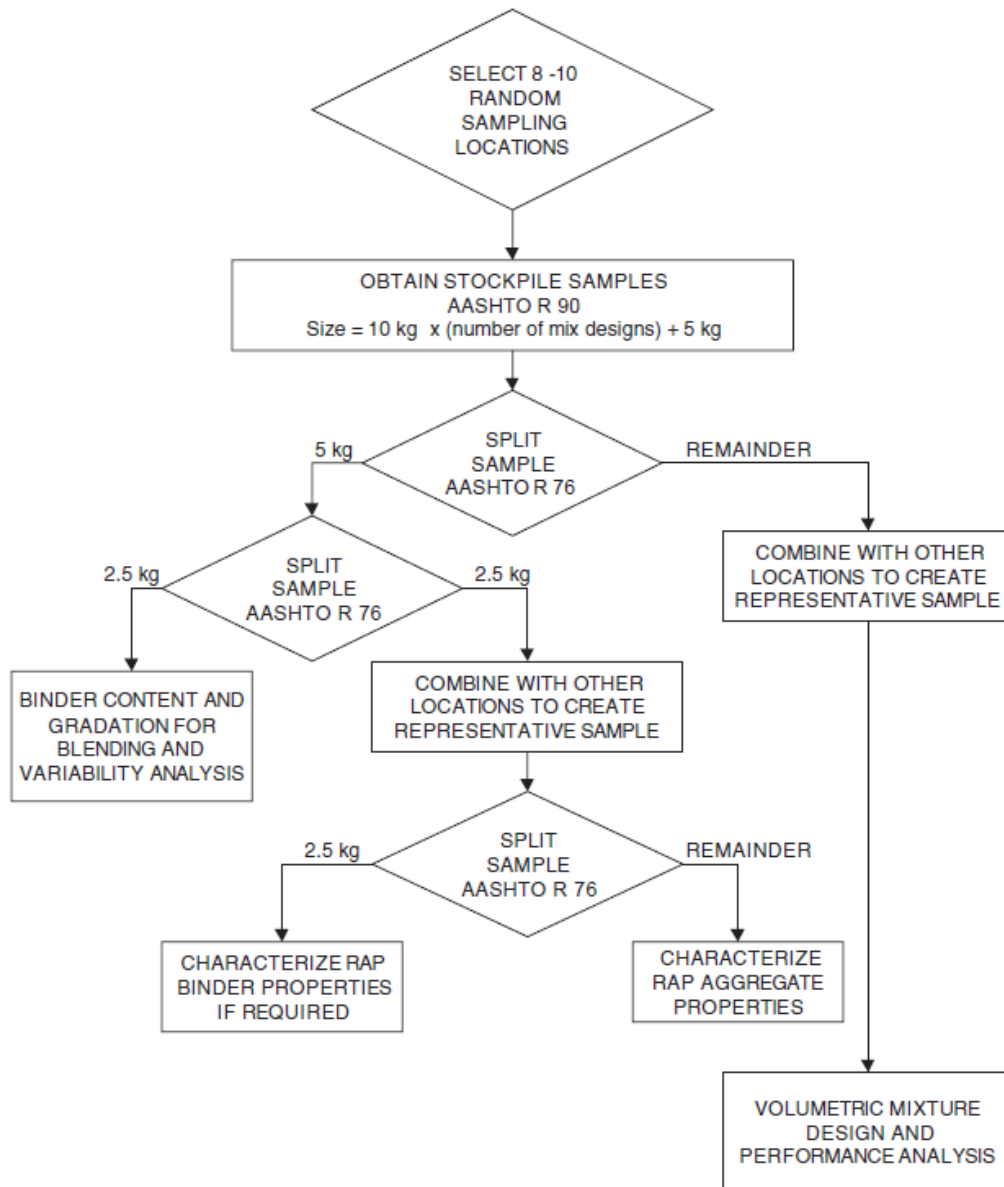
Samples of RAP can be obtained from several locations, including the roadway by coring, trucks hauling milled material for stockpiling, stockpiles prior to processing, and stockpiles after processing. Milling and processing operations break down some of the aggregate in the RAP, producing finer gradations with increased percentages passing the 0.075-mm (#200) sieve. Since a representative sample of RAP will be used directly in the mixture design process, it is critical that RAP samples obtained for HMA mixture design be representative of the RAP that will be used in the mixture. For this reason, the location recommended for sampling RAP is from stockpiles of the RAP after final processing.

Sampling RAP from a stockpile is similar to sampling aggregate from a stockpile, except crusts form on RAP stockpiles that must be removed before samples can be taken. General guidance for stockpile sampling is provided in AASHTO R 90. As discussed in AASHTO R 90, segregation is a major concern when sampling from stockpiles. The preferred approach for stockpile sampling is to use a loader or other power equipment to obtain smaller sampling piles from selected locations within the main stockpile. The RAP sample for each location is then taken from the smaller sampling pile.

RAP stockpiles should be sampled from at least five locations distributed throughout the pile. A larger number of samples—up to 20 or more—is desirable, since this will allow a more accurate characterization of the RAP and permit the highest possible RAP content in the final mix design(s). The sample size depends on the number of mixture designs that will be developed using the RAP in the stockpile. At each sampling location, obtain 10 kg (22 lb) of RAP for each mixture design that will be prepared, plus 5 kg (11 lb) for characterization of the RAP. For example, if three mixtures (a base, intermediate, and surface) will be designed using the same RAP, then obtain 35 kg (77 lb) of RAP at each sampling location. This sample size will provide sufficient material to characterize the properties and variability of the RAP stockpile and provide a representative sample for use in mixture design.

There are two objectives for the RAP sampling. The first is to determine the average and variability (in terms of standard deviation) of the binder content and aggregate gradation in the RAP in the stockpile. For this analysis, a 5 kg (11 lb) sub-sample should be split from the sample taken at each stockpile location using the methods described in AASHTO R 76. This sub-sample will then be tested to determine the average and standard deviation of the binder content and aggregate gradation within the RAP stockpile. As discussed in the next section, variability is an important consideration in the selection of feasible RAP contents that can be considered in design. The second objective of the sampling is to obtain representative materials for the mixture design. A representative sample is formed by combining the remaining portion of the samples from each sampling location. From this representative RAP sample, aggregate properties and, if required, binder properties will be determined and specimens for volumetric and performance analysis

prepared. Figure 9-2 is a general flowchart for sampling a RAP stockpile for use in HMA mixture design.



**Figure 9-2.** Flow chart for recommended sampling of RAP stockpiles.

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**Idaho Standard Practice for****Superpave Volumetric Mix Design****IDAHO Designation: IR-150-19**

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**1. SCOPE**

- 1.1. This practice describes the requirements for developing a Superpave mix design.
- 1.2. *This standard practice may involve hazardous materials, operations, and equipment. This standard practice 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 procedure to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

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**2. BACKGROUND**

- 2.1. Developing a mix design is a function of quality control (QC). A mix design is developed to find a combination of aggregates, recycled materials, asphalt, and additives to produce a roadway that meets the Department's specifications.
- 2.2. The end result of a successful mix design is a recommended mixture of aggregate and asphalt binder. This recommended mixture, which also includes aggregate gradation and asphalt binder type is the job mix formula (JMF).
- 2.3. A JMF is a recipe for the plant to make. The mix design is the development of that recipe. A mistake in the design process can disrupt a project's schedule dramatically and have a big impact to the overall quality of the finished roadway. The development of the JMF is a QC process. It is ultimately the responsibility of the Contractor to ensure that their mix design and resulting JMF will result in a mix that meets the contract requirements.
- Note:** A JMF is only as good as the information that was used to develop it. A good mix design can help limit issues in production.
- 2.4. The mix design evaluation is for the Department to use to validate that the recipe was properly developed and the resulting JMF appears that the mix produced will meet the contract requirements.

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**3. REFERENCE DOCUMENTS**

- 3.1. *AASHTO Standards*
- M 323, Superpave Volumetric Mix Design
  - R 30, Mixture Conditioning of Hot-Mix Asphalt (HMA)
  - R 35, Superpave Volumetric Design for Asphalt Mixtures
  - R 76, Reducing Samples of Aggregate to Testing Size
  - R 90, Sampling Aggregate Products
  - T 11, Materials Finer Than 75-µm (No. 200) Sieve in Mineral Aggregates by Washing
  - T 27, Sieve Analysis of Fine and Coarse Aggregates

- T 84, Specific Gravity and Absorption of Fine Aggregate
- T 85, Specific Gravity and Absorption of Coarse Aggregate
- T 166, Bulk Specific Gravity ( $G_{mb}$ ) of Compacted Asphalt Mixtures Using Saturated Surface-Dry Specimens
- T 209, Theoretical Maximum Specific Gravity ( $G_{mm}$ ) and Density of Hot Mix Asphalt (HMA)
- T 312, Preparing and Determining the Density of Asphalt Mixture Specimens by Means of the Superpave Gyratory Compactor
- T 324, Hamburg Wheel-Track Testing of Compacted Hot Mix Asphalt (HMA)
- T 331, Bulk Specific Gravity ( $G_{mb}$ ) and Density of Compacted Asphalt Mixtures Using Automatic Vacuum Sealing Method

3.2. *Idaho Standards:*

- IT 144, Specific Gravity and Absorption of Fine Aggregate Using Automatic Vacuum Sealing Method
- IT-146, Determination of Recycled Asphalt Pavement (RAP) Aggregate Dry Specific Gravity  $G_{sb}$
- Standard Specifications for Highway Construction

3.3. *WAQTC/Idaho FOPs*

- R 76, Reducing Samples of Aggregate to Testing Size
- R 90, Sampling Aggregate Products
- T 11, Materials Finer Than 75- $\mu$ m (No. 200) Sieve in Mineral Aggregates by Washing
- T 27, Sieve Analysis of Fine and Coarse Aggregates
- T 166, Bulk Specific Gravity ( $G_{mb}$ ) of Compacted Asphalt Mixtures Using Saturated Surface-Dry Specimens
- T 209, Theoretical Maximum Specific Gravity ( $G_{mm}$ ) and Density of Hot Mix Asphalt (HMA)
- T 312, Preparing and Determining the Density of Asphalt Mixture Specimens by Means of the Superpave Gyratory Compactor
- WAQTC TM 13, Volumetric Properties of Hot Mix Asphalt
- WAQTC TM 14, Laboratory Prepared Asphalt Mixture Specimens

3.4. *ASTM Standards*

- D8159, Automated Extraction of Asphalt Binder From Asphalt Mixtures (Asphalt Analyzer)
- D8255, Determination of cracking Tolerance Index of Asphalt Mixture Using the Indirect Tensile cracking Test at Intermediate Temperature

3.5. *Other Standards*

- Asphalt Institute MS-2, Asphalt Mix Design Methods, 7<sup>th</sup> Edition

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## 4. SPECIFIC GRAVITY OF AGGREGATE AND RAP

- 4.1. Use the bulk dry specific gravity of aggregate ( $G_{sb}$ ) established by the Department for each stockpile when developing the mix design and performing calculations.



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**5. MIX DESIGN REQUIREMENTS**

- 5.1. Develop a Superpave mix design in accordance with AASHTO R 35 that will result in a plant produced mixture that meets the contract requirements.
- 5.2. The mix design must be developed by an individual that is qualified by the Department as a Superpave mix design technician (SPMDT).
- 5.3. The mix design must be reviewed, approved, signed, and sealed by an Idaho licensed professional engineer responsible for the mix design.
  - 5.3.1. At a minimum, the ITD-773 Form must be stamped by an Idaho licensed professional engineer.
- 5.4. Use a Department qualified laboratory for developing the design.

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**6. MIX DESIGN REPORT REQUIREMENTS**

- 6.1. Provide a single job mix formula (JMF) reported on an ITD-773 Form.
- 6.2. Attach all supporting documentation and data used in developing the JMF.
  - 6.2.1. Include signature and WAQTC/PE license number for testers, and reviewers on each sheet.  
**Note:** The design will be reviewed by the Department in accordance with Idaho IR 151. Ensure that the report has all information required to complete the review. Incomplete or missing information will result in rejection of the mix design.

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**7. MIX DESIGN SUBMITTAL**

- 7.1. Submit the mix design and all supporting documentation via email to [mixdesigns@itd.idaho.gov](mailto:mixdesigns@itd.idaho.gov) and the Engineer.
- 7.2. Each mix design submitted for approval must be accompanied by a Microsoft® Excel® electronic version of the ITD-773 form specific to the mix design.
- 7.3. Only 1 mix design per email notification will be accepted. Submit the mix design for evaluation a minimum of 5 business days before paving is scheduled to begin.
- 7.4. Upon submittal, the Department will give the mix design a unique identifier number. This will be the mix design number. Keep this number for your records.

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**8. AMENDING THE MIX DESIGN**

- 8.1. If the mix design is required to be amended per 405.03.B.1.b.i.1, amend the mix design the following process:
  - 8.1.1. Each page of the mix design that is revised or added is required to include the Project key lead number, bid item number, date of revision, and means of identifying the revision. The amendment is required to be signed and dated by the Contractor's representative who is responsible for developing the mix design and subsequently signed and dated when approved by the Engineer.
- 8.2. Amending the mix design or JMF is not allowed once the mix design has been approved by the Department.

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**9. APPROVED MIX DESIGNS**

- 9.1. The Department will maintain a list of approved mix designs listed by Department generated mix design number. Mix designs are not approved for use unless they are listed.

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**Idaho Standard Practice for****Superpave Mix Design Evaluation****IDAHO Designation: IR-151-19**

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**1. SCOPE**

- 1.1. This practice describes the procedures for evaluating a Superpave mix design, mix design requirements, and the time required to perform the evaluation.
- 1.2. *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the user's responsibility of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations before use.*

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**2. BACKGROUND**

- 2.1. When reviewing a mix design, it is important to keep in mind the following:
- 2.2. A mix design is solely a function of quality control (QC). A mix design is developed to find a combination of aggregates, recycled materials, asphalt, and additives to use to produce a roadway that meets the Department's specifications.
- 2.3. The end result of a successful mix design is a recommended mixture of aggregate and asphalt binder. This recommended mixture, which also includes aggregate gradation and asphalt binder type is the job mix formula (JMF).
- 2.4. A JMF is a recipe for the plant to make. The mix design is the development of that recipe. A mistake in the design process can disrupt a project's schedule dramatically and have a big impact to the overall quality of the finished roadway. However, developing the JMF is a QC process. It is ultimately the responsibility of the Contractor to ensure that their mix design and resulting JMF will result in mix that meets the contract requirements.
- Note:** A JMF is only as good as the information that was used to develop it. A good mix design can help limit issues in production.
- 2.5. The mix design evaluation is for the Department to use to validate that the recipe was properly developed and the resulting JMF appears that the mix produced will meet the contract requirements.

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**3. REFERENCE DOCUMENTS**

- 3.1. *Idaho Procedures:*
- IT-150, Superpave Volumetric Mix Design
- 3.2. *Other Standards*
- Standard Specifications for Highway Construction

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**4. SUBMITTAL OF MIX DESIGN**

- 4.1. The Contractor must submit the asphalt mix design in accordance with Idaho IR 150.

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**5. RECEIPT OF MIX DESIGN SUBMITTAL**

- 5.1. Upon receipt of the mix design submittal, the mix design will be given a unique identifier number.

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**6. REVIEW OF MIX DESIGN SUBMITTAL**

- 6.1. The Department will review all Superpave mix designs proposed for use prior to use. The Department recognizes that the risk associated with each paving application varies. Therefore, the extent of each mix design review will be in accordance with these potential risks.
- 6.2. The mix design will be reviewed by the Resident Engineer, the Central Materials Laboratory, and the State Construction and Materials Engineer.
- 6.3. All mix designs will be reviewed for the following:
- 6.3.1. Accuracy.
- 6.3.2. Completeness.
- 6.3.3. Reasonableness. Examples of items that will be check for reasonableness include, but are not limited to ensuring that calculations were done correctly and that the volumetric data follows the expected trends.
- 6.3.4. Compliance with specifications.
- 6.3.5. Compliance with Idaho IR 150
- 6.4. When amendments are made to the mix design submittal, the current review will be ended and the amended mix design will be considered a new submittal.
- 6.4.1. Amendments must meet the requirements of Idaho IR 150.

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**7. REVIEW OF PREVIOUSLY USED MIX DESIGNS**

- 7.1. A mix design reviewed and accepted for a previous or current project may be submitted in writing for use on a new project. Acceptance of the mix design will be based on meeting the following requirements in addition to the requirements of Section 3:
- 7.1.1. The proposed mix design is of the type required for the new project.
- 7.1.2. The mix produced on previous projects utilizing the proposed mix design was of good quality (e.g. the average PWL on the previous project(s) was  $\geq 90$  PWL for all mix quality characteristics).
- 7.1.3. The mix design is not classified as expired in accordance with 405.03.B.2 of the Standard Specifications.

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**8. MIX DESIGN REVIEW TIMEFRAME**

- 8.1. The Department will review the mix design within 5 business days after receiving the full submittal package.

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**9. APPROVAL OF MIX DESIGN**

- 9.1. The Department will maintain a list of approved mix designs. Upon approval, the mix design will be placed on this list.

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**10. REJECTION OF MIX DESIGN**

- 10.1. The Department will notify the Contractor upon rejection of a mix design via email.
- 10.1.1. The Department will provide details as to why the mix design was rejected.
- 10.2. Notification of the rejection will be sent to the email address given on the ITD-774.

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**Idaho Standard Practice for****ASPHALT MIXTURES QUALITY CONTROL PLAN (QCP)  
DEVELOPMENT AND IMPLEMENTATION****IDAHO Designation: IR-152-19**

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**1. PURPOSE**

- 1.1. The purpose of this guide is to establish minimum requirements for the Contractor's quality control system and quality control plan (QCP) for asphalt mixtures. It is intended that these requirements be used as a procedural guide in detailing the inspection, sampling, and testing deemed necessary to maintain compliance with the Department's specifications.

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**2. SCOPE**

- 2.1. This procedure is applicable to the production and construction of asphalt mixtures.

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**3. REFERENCE DOCUMENTS**

- 3.1. Idaho Standards
- IR 158, Quality Control Plan Development.
  - IR 160, Evaluation and Approval of HMA Plants and Equipment.
  - IR 155, Procedures for Checking Asphalt Drum Mix Plants

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**4. GENERAL REQUIREMENTS**

- 4.1. As stated in the Standard Specifications for Highway Construction, a QCP must be developed by the Contractor/producer and submitted in writing to the Engineer at the preconstruction conference. Acceptance of the QCP by the Engineer will be contingent upon its concurrence with the Standard Specifications and this standard method. For this reason, the QCP will clearly describe the methods by which the quality control program will be conducted. For example, the items to be controlled, tests to be performed, testing frequencies, sampling locations, and techniques will be included with each item listed separately. Also include a table stating what actions will occur when test results indicate specification limits are approached or exceeded. See **Table 1** at end of this guide for an example. Also, a detailed plan of action regarding disposition of non-specification material will be included. Such a plan will provide for immediate notification of all parties involved in the Quality Assurance process in the event nonconforming situations are detected. **Example 1. HMA Quality Control Plan** may be used as an example.
- 4.2. Inspection and testing records must be maintained, kept current, and made available for review by Department personnel throughout the life of the contract. All other documentation, such as date of inspections, tests performed, temperature measurements, and accuracy, calibration or re-calibration checks performed on production of testing equipment, will be recorded.
- 4.3. The Contractor will maintain standard equipment and qualified personnel in accordance with the contract and specification requirements for the item(s) being produced.

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**5. QUALITY CONTROL PLAN**

- 5.1. Operation quality control plans will be submitted for each contract/project to the Engineer for review and approval. Include a Plant Quality Control Plan that meets the requirements of Idaho IR 160. Distribution of the approved quality control plans will be made by the Engineer.
- 5.2. Follow Example 1. HMA Quality Control Plan as a general guideline.

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**6. ADDENDA TO THE QUALITY CONTROL PLAN**

- 6.1. Addenda are defined as an addition or deletion to the QCP. Each page of the QCP that is revised is required to include the Project key lead number, bid item number, date of revision, and means of identifying the revision. The addenda are required to be signed and dated by the Contractor's representative who is responsible for insuring that all items of work will comply with Department Specifications and subsequently signed and dated when approved by the Engineer.

Table 1: Example of QC Actions to Implement When Approaching or Exceeding Specification Limits

Test Description	Test Method	QC Action Limits		Situation		Action
		Single Test	4-Point Moving Avg. or Daily Avg.	Single Test	4-Point Moving Avg. or Daily Avg.	
Binder Content, P <sub>b</sub>	FOP for AASHTO T 168 and FOP for AASHTO R 47 and FOP for AASHTO T 308 and FOP for AASHTO T 329	± 0.6	± 0.3	Approaching Limit	Approaching Limit	Discuss with hot mix plant, operator, and may suspend construction process
Aggregate Gradation	FOP for AASHTO T 30 (wash method used for all gradation measurements)	NA	C-JMF	4 percent on + #4 2 percent on - #4	Approaching Limit	Increase frequency of tests and prepare for process modification
Air Voids @ N <sub>design</sub> , P <sub>a</sub>	WAQTC TM 13	± 1.0%	NA	2 tests over ± 1%	NA	Initiate C-JMF Modifications
VMA @ N <sub>design</sub>	WAQTC TM 13	<= 1% min	>= min	3 tests over ± 1%	Approaching Limit	Discuss with the Engineer & Process Modification
Dust Proportion, DP	WAQTC TM 13	NA	>= min <= max	Approaching Limit	Approaching Limit	Modify C-JMF
G <sub>mm</sub>	FOP for AASHTO T 168 and FOP for AASHTO R 47 and FOP for AASHTO T 209 (Bowl Method)	C-JMF	C-JMF	Approaching Limit	Approaching Limit	Modify C-JMF or Redesign
G <sub>se</sub>	WAQTC TM 13	C-JMF	C-JMF	Approaching Limit	Approaching Limit	Modify C-JMF or Redesign
Rut Depth, mm	AASHTO T 324	>= min	NA	Approaching Limit	NA	Discuss with the Engineer & initiate investigation, modification, or redesign
Stripping, passes	AASHTO T 324	>= min	NA	Approaching Limit	NA	Discuss with the Engineer & initiate investigation, modification, or redesign
Cracking, FI	AASHTO TP 124	>= min	NA	Approaching Limit	NA	Discuss with the Engineer & initiate investigation, modification, or redesign
Mainline Density	Idaho IR 156, and FOP for AASHTO T 355 or FOP for AASHTO T 343	NA	>= min	Approaching < 92%	<= 100% Pay	Notify the Engineer

Note: When 2 consecutive test results fail or if any of the 4-point moving average values fail, production will be suspended and the situation discussed with the Engineer. The process will be corrected before production resumes.



**EXAMPLE 1**  
**HMA Quality Control Plan**

Date:

To: (RESIDENT ENGINEER)

From: (CONTRACTOR(s) NAME)

Subject: HMA Quality Control Plan

**1. Project Information**

- 1.1. We are submitting our HMA Quality Control Plan, developed in accordance with Idaho IR 152, Idaho IR 160, and Idaho IR 158 for:

Project Number: \_\_\_\_\_

Lead Key Number: \_\_\_\_\_

Bid Item Number: \_\_\_\_\_

Date Submitted: \_\_\_\_\_

- 1.2. (NAME) will be responsible for insuring that all items of work will comply with the contract and Department specifications.

**2. Hot Plant**

- 2.1. General Information:

Make: \_\_\_\_\_

Type: \_\_\_\_\_

Address of Plant: \_\_\_\_\_

- 2.2. The hot plant operation is under the direction of (NAME) who can be contacted at (ADDRESS, EMAIL, AND TELEPHONE).
- 2.3. Current calibration and verification status of plant and history of plant inspection program attached in Exhibit A.
- 2.4. The Hot Plant Quality Control Plan, developed in accordance with Idaho IR 160 and approved on (DATE) by (NAME OF PERSON(s)) is attached in Exhibit B.

**3. Mix Designs**

- 3.1. Mix designs will be the responsibility of (NAME OF PERSON(s)), WAQTC number (NUMBER(s)).
- 3.2. The HMA design(s) to be used are attached in Exhibit C.
- 3.3. Before production, (NAME), (WAQTC NUMBER), will submit our HMA mix design for each type of mix in accordance with the contract and specifications by (DATE). Only allowable and approved materials will be incorporated in the mix.

**4. Delivery and Placement**

- 4.1. The field operation is under the direction of (NAME) who can be contacted at (ADDRESS, EMAIL, AND TELEPHONE).
- 4.2. (LIST OF EQUIPMENT TYPE, YEAR, MAKE, MODEL)
- 4.3. (DETAILED DESCRIPTION OF THE PRODUCTION AND PLACEMENT PROCESS)

**5. Quality Control Sampling and Testing,**

- 5.1. The laboratory performing quality control testing is (LAB QUALIFICATION NUMBER), located at (LOCATION).
- 5.2. The quality control program is under the direction of (NAME OF PERSON), who can be contacted at (ADDRESS, EMAIL, AND TELEPHONE).
- 5.3. During the placement operations of the HMA pavement we will perform at a minimum quality control tests per attached schedule. Sampling and testing will be the responsibility of (NAME(s), WAQTC number (NUMBER(s)).
- 5.4. Sampling and testing will be the responsibility of (NAME OF PERSON(s), WAQTC number (NUMBER(s)).
- 5.5. During the production operations of the HMA (NAMES) will perform, at a minimum, quality control tests in accordance with the attached schedule. Also attached are the proposed method to select locations and/or times for sampling. See Exhibit D.
- 5.6. All testing will be completed by (NAME(s)), (WAQTC NUMBER(s)), within (HOURS) hours of sampling and all original documentation of results will be completed on the attached original documentation forms. See Exhibit E.
- 5.7. Testing reports and original source documents will be reviewed and checked by (NAME(s)), (WAQTC NUMBER(s)), within (HOURS) hours of testing being completed. All reporting will be completed on the attached forms. See Exhibit F.

**EXAMPLE 1 (CONTINUED)**  
**HMA Quality Control Plan**

**6. Records.**

- 6.1. Testing reports and all backup documentation will be located at (LOCATION) for review by the Department between the hours of (TIME) and (TIME) during the life of the contract/project.
- 6.2. Testing reports and all backup documentation will be located at (LOCATION) for review by the Department between the hours of (TIME) and (TIME) for (YEARS) after the completion of the project.

**7. Notifications.**

- 7.1. Any material found to be noncomplying will be addressed by (NAME) who will notify the Engineer immediately.
- 7.2. (NAME) will notify all appropriate Department personnel at least 48 hours before any work is to begin.

**8. Nonconforming Material.**

- 8.1. (STATE THE PROCESS FOR DISPOSITION OF NONCONFORMING MATERIAL)
- 8.2. See the Exhibit G for what actions will occur when test results indicate specification limits are approached or exceeded.

**Attachments:**

**Exhibit A** – Current calibration and verification status of plant and history of plant inspection program.

**Exhibit B** – Hot Plant Quality Control Plan

**Exhibit C** – HMA Mix Design

**Exhibit D** – Minimum QC Testing Schedule, Sampling and Testing Methods, and Location(s)

**Exhibit E** – Original Test Documentation Form Template(s)

**Exhibit F** – Test Reporting Form Template(s)

**Exhibit G** – Table of QC actions when approaching or exceeding specification limits

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# Idaho Standard Practice for

## Split Sample Comparison



### IDAHO Designation: IR-153-19

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#### 1. SCOPE

- 1.1. This Standard Practice is used to compare 2 or more sets of test results in order to measure the testing variability of different parties (e.g., Department vs. Contractor).
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#### 2. BACKGROUND

- 2.1. There are 4 primary components or sources of inherent variability in individual test results for material samples. These components of inherent variability are:
- Sampling Variability
  - Testing Variability
  - Material Variability
  - Construction Variability
- 2.1.1. **Sampling variability** is caused by variation that is inherent in the sampling methods or procedures used to obtain a material sample. Even when the person obtaining a sample carefully follows standard sampling methods or procedures, some amount of sampling variability will occur.
- 2.1.2. **Testing variability** is the result of variation inherent in performing a test method and variation inherent in the test equipment. Even when the person performing a test carefully follows standard testing methods and even when the test equipment is properly calibrated, some amount of testing variability will occur.
- 2.1.3. **Material variability** is essentially due to the inherent variation that naturally exists in a given material. It is quite unrealistic to expect perfect homogeneity in any raw or processed source of construction materials (e.g., soils, aggregate, HMA, PCC, steel, paint). The inherent variation for most construction materials, on a relative basis, is usually small.
- 2.1.4. **Construction variability** is the result of variation that is inherent in production methods and construction operations. The largest amount of construction variability is generally attributed to the production and placement process.
- 2.1.5. Additional construction variability (i.e., beyond the expected or accepted range) can be introduced through inconsistent production methods and construction operations. This is why good, consistent quality control, both at the source/plant and in the field, is essential in minimizing the amount of construction variability as a component of overall inherent variability.
- 2.1.6. Additional sampling variability and testing variability (i.e., beyond the expected or accepted range) can be introduced through deviations from standard sampling method and test procedures by the person(s) performing the sampling and testing, or as a result of test equipment that is not properly calibrated or properly functioning. Sampling and testing variability, combined, have been stated as comprising up to 50 percent of the total overall variation in test results. Specification

limits were developed to take this variability into account. However, it is important not to compound or add to the expected range of inherent variability due to sloppy practices. Consistent and careful adherence to proper sampling and testing procedures can minimize these two components of overall inherent variability.

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### 3. REFERENCE DOCUMENTS

#### 3.1. *AASHTO Standards*

- FOP for R 90, Sampling of Aggregates
- R 76, Reducing Samples of Aggregates to Testing Size
- T 255, Total Evaporable Moisture Content of Aggregate by Drying
- FOP for T 27, Particle Size Distribution of Aggregate
- FOP for T 11, With Materials Finer than 75um (No. 200) Sieve in Mineral Aggregate by Washing
- T 335, Determining the Percentage of Fracture in Coarse Aggregate
- T 176, Plastic Fines in Graded Aggregates and Soils by Use of the Sand Equivalent Test
- R 97, Sampling Asphalt Mixtures
- R 47, Reducing Samples of Hot Mix Asphalt (HMA) to Testing Size
- T 329, Moisture Content of Hot Mix Asphalt (HMA) by Oven Method
- T 308, Determining the Asphalt Binder Content of Hot Mix Asphalt (HMA) by the Ignition Method
- T30, Mechanical Analysis of Extracted Aggregate
- T 209, Theoretical Maximum Specific Gravity and Density of Hot Mix Asphalt Paving Mixtures
- T 167, Standard Method of Test for Compressive Strength of Hot Mix Asphalt
- T 166, Bulk Specific Gravity of Compacted Hot Mix Asphalt using Saturated Surface-Dry Specimens
- R 30, Mixture Conditioning of Hot-Mix Asphalt (HMA)
- FOP for R 66, Sampling Asphalt Materials
- T 164, Quantitative Extraction of Bitumen from Bituminous Paving Mixtures
- T 319, Quantitative Extraction and Recovery of Asphalt Binder from Asphalt Mixtures
- T 303, Lime for Asphalt Mixtures
- T 312, Asphalt Mixture Specimens by Means of the Superpave Gyratory Compactor
- T 324, Hamburg Wheel-Track Testing of Compacted Hot Mix Asphalt (HMA)
- T 33, Bulk Specific Gravity and Density of Compacted Asphalt Mixtures Using Automatic Vacuum Sealing Method
- R 79, Standard Practice for Rapid Drying of Compacted Asphalt Specimens Using Vacuum Drying Apparatus
- T 269, Percent Air Voids in Compacted Dense and Open Bituminous Paving Mixtures
- T 283, Resistance of Compacted Asphalt Mixtures to Moisture-Induced Damage
- TM 13, Volumetric Properties of Hot Mix Asphalt

- R 67, Sampling Asphalt Mixtures after Compaction (Obtaining Cores)
- T 309, Temperature of Freshly Mixed Portland Cement Concrete
- T 119, Slump of Hydraulic Cement Concrete
- T 121, Density (Unit Weight), Yield, and Air Content (Gravimetric) of Concrete
- T 152, Air Content of Freshly Mixed Concrete by the Pressure Method
- T 23, Method of Making and Curing Concrete Test Specimens in the Field
- T 265, Laboratory Determination of Moisture Content of Soils
- T 99, Moisture-Density Relations of Soils Using a 2.5-kg (5.5-lb) Rammer and 305-mm (12-in.) Drop
- T 180, Moisture-Density Relations of Soils Using a 4.54-kg (10-lb) Rammer and 457-mm (18-in.) Drop
- T 85, Specific Gravity and Absorption of Course Aggregate
- T 355, Determining the Percentage of Fracture in Coarse Aggregate
- T 310, In-Place Density and Moisture Content of Soil and Soil-Aggregate by Nuclear Methods (Shallow Depth)
- T 272, One-Point Method for Determining Maximum Dry Density and Optimum Moisture
- T 304, Uncompacted Void Content of Fine Aggregate
- R 64, Standard Practice for Field Sampling and Fabrication of 50-mm (2-in) Cube Specimens using Grout (Non-Shrink) or Mortar
- T 359, Pavement Thickness by Magnetic Pulse Induction

## 3.2.

*ASTM Standards*

- FOP for D4791, Flat and Elongated Particles in Coarse Aggregate
- D1075, Standard Test Method for Effect of Water on Compressive Strength of Compacted Bituminous Mixtures (Immersion-Compression)
- D6857, Standard Test Method for Maximum Specific Gravity and Density of Bituminous Paving Mixtures Using Automatic Vacuum Sealing Method
- D8159, Standard Test Method for Automated Extraction of Asphalt Binder From Asphalt Mixtures (Asphalt Analyzer™)
- D8225, Standard Method of Test for Determination of Cracking Tolerance Index of Asphalt Mixture Using the Indirect Tensile Cracking Test at Intermediate Temperature

## 3.3.

*Idaho Standards*

- IT 13, Measuring Mortar-Making Properties of Fine Aggregate Idaho
- IT 15, Degradation
- IT 72, Evaluating Cleanness of Cover Coat Material
- IT 74, Vibratory Spring-Load Compaction for Coarse Granular Material
- IT 116, Disintegration of Quarry Aggregates (Ethylene Glycol)
- IT 144, Specific Gravity and Absorption of Fine Aggregate Using Automatic Vacuum Sealing (CoreLok) Method
- IT 61, Sampling and Viscosity Testing Emulsified Asphalt Binders in the Field

- IT 146, Determination of Reclaimed Asphalt Pavement (RAP) Aggregate Bulk (Dry) Specific Gravity ( $G_{sb}$ )
- IR 128, Sampling Concrete for Chloride Analysis
- IT 131, Total Chloride Content of Hardened Concrete by Gran Plot Method
- IT 133, Determination of the Rate of Evaporation of Surface Moisture from Concrete
- IR 143, Field Sampling of Hydraulic Cement and Fly Ash
- IT 147, Measuring Texture Depth of Portland Cement Concrete Using a Tire Tread Depth Gauge
- IR 7, Inspecting/Sampling Paint and Curing Compound
- IT 121, Determining Total Solids-Latex Percent
- IT 8, Resistance R-Value and Expansion Pressure of Compacted Soils and Aggregates
- IR 162, Taking Undisturbed Soil Samples for Laboratory Consolidation, Shear and Permeability Tests
- Idaho Transportation Department Quality Assurance Manual
- IR 87, Pavement Straightedge Procedures
- IT 120, Determining Volume of Liquids in Horizontal or Vertical Storage Tanks

3.4. *WAQTC Standards*

- TM 13, Volumetric Properties of Hot Mix Asphalt
- TM 2, Sampling Freshly Mixed Concrete

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## 4. SUMMARY OF THE PRACTICE

- 4.1. This practice describes the testing and analysis needed to perform a comparison of split samples tested by different parties against an allowable degree of test result difference attributed to testing variability.

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## 5. TERMINOLOGY

- 5.1. *Individual Split Sample Acceptable Range*— The allowable tolerance between individual split sample test results when properly sampled and split.
- 5.2. *Paired t-Test*— Uses the difference between each pair of tests of the split samples and determines whether the difference is much different from zero.
- 5.3. *Split Increment*— A representative portion of a split sample that is larger than the minimum-size needed for a single party to perform the desired testing.
- 5.4. *Split Sample*— A sample that will be used for split sample comparison testing.

---

## 6. MATERIAL SAMPLING AND SPLITTING AND TESTING

- 6.1. Obtain a sample in accordance with the Department's approved sampling procedure.
- 6.1.1. Ensure that the sample is large enough for each party to receive a split increment larger than the minimum sample size.

- 6.2. Split each sample in accordance with the Department's approved splitting procedure.
- 6.2.1. Ensure that each split increment meets the minimum sample size for the testing to be performed.
- 6.3. Each party will test in accordance with Department's approved testing procedures.
- 6.4. Repeat steps 6.1 to 6.3 until the desired number of split samples are obtained to perform the analysis.
- Note:** It is recommended to compare a minimum of 3 split samples for material that will be subject to statistical based acceptance (e.g., HMA, aggregates)

## 7. COMPARISON OF RESULTS

- 7.1. Compare the split increments for each split sample using the D2S limits (Section 9).
- 7.2. Compare the sets of split increments for all split samples using the paired t-test (Section 8).  
**Note:** The D2S comparison is simple and can be done for each split sample that is obtained. However, this procedure compares only 2 test results (from one split sample), and is not very powerful due to the limited amount of data being evaluated. The paired t-test, compares multiple sets of split samples, and is a better method for comparison since this test uses the differences between multiple pairs of tests and determines whether the average difference is statistically different from zero.
- 7.3. Use the ITD-1237 form to perform and report the comparison.
- 7.4. When differences in results have been identified, the parties will collaborate and investigate to determine the source of the inconsistency and make necessary corrections.
- 7.5. The possible source of the inconsistencies and any corrections made will be documented on the ITD-1237 form.

## 8. PAIRED T-TEST COMPARISON (RECOMMENDED)

- 8.1. Determine the individual difference between split sample test results ( $X_{dif}$ ) for each split sample.

$$x_{dif} = x_A - x_B$$

Where:

$X_{dif}$  = Individual difference between split sample test results.

$x_A$  = Party A's individual test value.

$x_B$  = Party B's individual test value.

**Note:** This difference is not the absolute difference, it is the algebraic difference. The subtraction (i.e., Party A's test value minus Party B's test value) is performed in the same direction for every set of split samples.

- 8.2. Determine the mean of the differences between the split sample test results, calculated as follows:

$$\bar{X}_{dif} = \frac{(x_{dif1} + x_{dif2} + \dots x_{difn})}{n}$$

Where:

$\bar{X}_{dif}$  = Mean of the differences between the split sample test results.

$n$  = Number of split samples.



- 8.3. Compute the standard deviation of the differences between the split sample test results, calculated as follows:

$$S_{\text{dif}} = \sqrt{\frac{\sum (x_{\text{dif}} - \bar{X}_{\text{dif}})^2}{n - 1.0}}$$

Where:

$S_{\text{dif}}$  = Standard deviation of the differences between the split sample test results.

- 8.4. Compute the paired t-statistic ( $t_{\text{pair}}$ ) using the following equation:

$$t_{\text{pair}} = \frac{|\bar{X}_{\text{dif}}|}{\left(\frac{S_{\text{dif}}}{\sqrt{n}}\right)}$$

- 8.5. Compute the degrees of freedom (df). The degrees of freedom are the number of sample pairs (n) minus one, used to compute the t-statistic.

$$\text{df} = n - 1$$

- 8.6. Determine the two-tailed probability distribution (P-value) for the 2 data sets using the degrees of freedom (df) for a two-tailed t-test.

- 8.7. Compare the P-value to  $\alpha$  (0.05).

- 8.7.1. If the P-value is greater than  $\alpha$ , the paired t-test passes. There is reason to believe that the paired test results are similar and it can be concluded they are from the same population. (i.e., no differences in testing has been identified)

- 8.7.2. If the P-value is less than  $\alpha$ , the paired t-test fails. The difference between the paired test results of the split samples is greater than is likely to occur from chance and therefore the results are not similar. (i.e., difference in testing has been identified)

---

## 9. D2S COMPARISON

- 9.1. Determine the individual difference between split sample test results ( $X_{\text{dif}}$ ).

$$X_{\text{dif}} = X_A - X_B$$

Where:

$X_{\text{dif}}$  = Individual difference between split sample test results.

$X_A$  = Party A's individual test value.

$X_B$  = Party B's individual test value.

- 9.1.1. For aggregates, compare  $X_{\text{dif}}$  to the QA Manual Table 390.01.1.
- 9.1.2. For concrete, compare  $X_{\text{dif}}$  to the QA Manual Table 390.01.2.
- 9.1.3. For HMA, compare  $X_{\text{dif}}$  to Table 1 in this method.
- 9.1.4. For all other materials, compare  $X_{\text{dif}}$  to the precision statement in the test method performed (if available).

- 9.2. If  $X_{dif}$  is greater than the individual split sample acceptable range, they are considered outside of allowable tolerances. (i.e., a difference in testing has been identified)

Table 1 – Allowable HMA Single Individual Split Sample Variations

Test Method	Quality Characteristic	Acceptable Range of Split Sample Results
AASHTO T 308	Asphalt Content (%)	0.15
AASHTO T 30	95 to 100% passing a sieve	1.6
	40 to 94% passing a sieve	3.5
	25 to 39% passing a sieve	2.4
	10 to 24% passing a sieve	2.3
	5 to 9% passing a sieve	1.6
	2 to 4% passing a sieve	1.2
	0 to 1% passing a sieve	0.9
AASHTO T 209	$G_{mm}$	0.012
AASHTO T 166	$G_{mb}$	0.017
WAQTC TM 13	$G_{se}$	0.012
	$P_a$	0.30
	VMA	0.30
	DP	0.15

## 10. EXAMPLES

- 10.1. A Department lab and a Contractor lab performed a split sample comparison on 5 samples. The table below presents the split sample test results for theoretical maximum specific gravity ( $G_{mm}$ ) to determine whether a difference exists between the Department's and the Contractor's results.

Example 10.1 – AASHTO T 209 Results			
Split Sample Number	Contractor's Results	Department's Results	Difference ( $X_{dif}$ )
1	2.396	2.405	-0.009
2	2.368	2.374	-0.006
3	2.377	2.381	-0.004
4	2.395	2.390	0.005
5	2.381	2.379	0.002
$\bar{X}_{dif} =$			-0.0024
$S_{dif} =$			0.00577
P-value =			0.405

- 10.1.1. Conclusion: Since the calculated P-value is greater than 0.05 (Section 8) and the  $X_{dif}$  of each test is less than the individual split sample acceptable range (Section 9), the split sample comparison indicates that there is not a significant difference in testing between these labs.

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# Idaho Standard Practice for Nuclear Density Gauge Correlation



## IDAHO Designation: IR-154-19

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### 1. SCOPE

- 1.1. This Standard Practice is used to determine the nuclear density gauge correlation for each nuclear gauge used for acceptance testing.
- 1.2. *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the user's responsibility of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations before use.*

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### 2. REFERENCE DOCUMENTS

- 2.1 *AASHTO Standards*
- FOP for T 355, Method A, In-Place Density of Asphalt Mixtures by Nuclear Methods
  - FOP for R 67, Sampling Asphalt Mixtures After Compaction (Obtaining Cores)
  - FOP for T 166, Method A, Bulk Specific Gravity of Compacted Bituminous Mixtures Using Saturated Surface Dry Specimens
  - T 331, Bulk Specific Gravity and Density of Compacted Asphalt Mixtures using Automatic Vacuum Sealing Method
- 2.2 *Idaho Standards*
- Idaho IR 148, Stratified Random Sampling

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### 3. SUMMARY OF THE PRACTICE

- 3.1. The bulk specific gravity ( $G_{mb}$ ) of the core is a physical measurement of the in-place asphalt mixture and can be compared with the nuclear density gauge readings. Comparing the core value to the corresponding gauge values, a correlation can be established.
- 3.2. 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 will be correlated to the core locations before removal of the core.
- 3.3. Correlation of the nuclear density gauge with pavement cores must be made on the first day's paving (within 24 hours) or anytime a change of the testing conditions occurs (see Section 8).

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**4. APPARATUS**

- 4.1. *Density Gauge*— With accessory equipment as specified in FOP for AASHTO T 355.
- 4.2. *Coring Equipment*— With accessories as specified in FOP for AASHTO R 67 for collecting 6-inch diameter pavement cores.
- 4.3. *Measuring Device*— Approved measuring device capable of measuring gauge correlation section and sub-section lengths.

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**5. TERMINOLOGY**

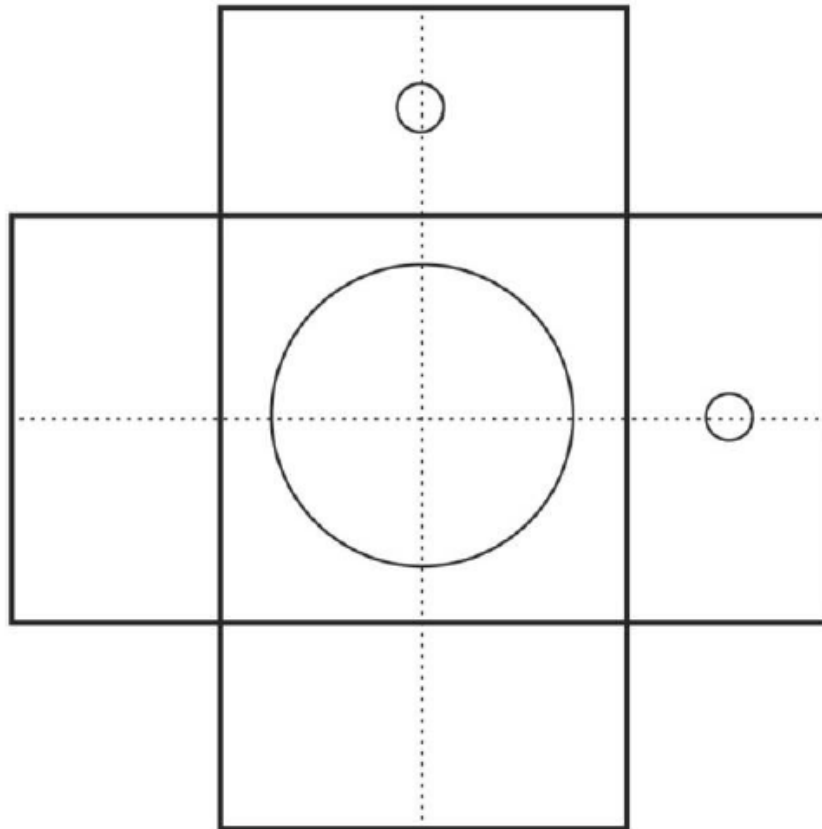
- 5.1. *Gauge Correlation Section*— Pavement placed during production paving that is used to correlate the nuclear density gauge(s) used for acceptance. The gauge correlation section must be constructed to the same placement width and thickness as the course it represents.
- 5.2. *Gauge Correlation Sub-Section*— A portion of the gauge correlation section in equal length to other sub-sections that is represented by a single test location.
- 5.3. *Job Mix Formula (JMF)*— End result of a successful mix design that is the Contractor's selected mixture to be produced and includes the aggregate gradation and asphalt binder percentage.
- 5.4. *Test Location*— The stratified random location within a gauge correlation sub-section where testing will be performed.
- 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 without applying a gauge correlation factor. Filler material must be applied as required in the procedure before taking test site density readings.
- 5.6. *Stratified Random Sampling* —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 in accordance to Idaho IR 148.

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**6. PROCEDURE**

- 6.1. *Determine the gauge correlation section and testing locations as follows:*
  - 6.1.1. A gauge correlation section will consist of the first lot of production and anytime there is a change of conditions (Section 8).
  - 6.1.2. Divide the total length of the gauge correlation section into 10 equal length sub-sections.
  - 6.1.3. Identify a test location for each gauge correlation sub-section in accordance with IR 148.
- 6.2. *Determine the in-place density using the nuclear density gauge for each test location as follows:*
  - 6.2.1. Determine in-place density using the nuclear density gauge(s) for each test location in accordance with FOP for AASHTO T 355.  
*Note: It is recommended that the Contractor's QC personnel also determine in-place density at each test location to develop a correlation factor for QC purposes.*

- 6.2.2. The ITD-820 form will be used by the Department personnel as the original source document to record the test site densities for each gauge at each test location.
- 6.3. *Determine the bulk specific gravity ( $G_{mb}$ ) for each sub-section as follows:*
- 6.3.1. After the pavement has cooled sufficiently to avoid deformation during coring, the Contractor will obtain 1 core at each test site from each segment in accordance with FOP for AASHTO R 67 in the Engineer's presence. The Engineer will immediately receive the cores. The relative position of the core to the nuclear gauge readings for each test location is illustrated in Figure 1.
- 6.3.2. Determine the  $G_{mb}$  of each core in accordance with FOP for AASHTO T 166 Method A or AASHTO T 331.
- Note:** *Determine the  $G_{mb}$  of all cores for the gauge correlation section using the same procedure.*
- 6.3.2.1. Determine the bulk density of the each core by multiplying  $G_{mb}$  by 62.245 lb/ft<sup>3</sup> and report the value to the nearest 0.1 lb/ft<sup>3</sup>.
- 6.3.3. The ITD-820 form from Section 6.2.2 will be used by the Department personnel as the chain of custody documentation and the original source document used to record the  $G_{mb}$  of each core.



**Figure 1.** *Footprint of the gauge test site. Core location in the center of the test site.*

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**7. CALCULATION OF CORRELATION**

- 7.1. *Calculate a correlation factor for the nuclear gauge reading as follows:*
- 7.1.1. Calculate the difference between the core density and nuclear gauge density at each test site to the nearest 0.1 lb/ft<sup>3</sup>. Calculate the average difference and standard deviation of the differences for the entire data set to the nearest 0.1 lb/ft<sup>3</sup>.
- 7.1.2. If the standard deviation of the differences is equal to or less than 2.5 lb/ft<sup>3</sup>, the correlation factor applied to the nuclear density gauge reading will be the average difference calculated in Section 7.1.1.
- 7.1.3. If the standard deviation of the differences is greater than 2.5 lb/ft<sup>3</sup>, the test location with the greatest variation from the average difference must be eliminated from the data set, and the data set properties and the correlation factor recalculated following Sections 7.1.1 and 7.1.2.
- If the standard deviation of the modified data set still exceeds the maximum specified in Section 7.1.2, additional test sites will be eliminated from the data set, and the data set properties and the correlation factor will be recalculated following Sections 7.1.1 and 7.1.2. If the data set consists of less than 5 test locations, additional test sites must be established.

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**8. CHANGE OF CONDITIONS**

- 8.1. A correlation factor is valid only for:
- 8.1.1. A specific project.
- 8.1.2. A specific JMF.
- 8.1.3. For a specific nuclear density gauge.
- 8.1.4. Specific gauge thickness setting.
- 8.1.5. Specific gauge mode setting.
- 8.1.6. Specific underlying material.
- 8.1.7. Specific pavement thickness.
- 8.1.8. A specific pavement lift.
- 8.1.9. A specific calendar year.
- 8.2. Re-correlation of the gauge must occur when any of the above conditions change.

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**9. REPORT**

- 9.1. The Department will report the results of testing on the ITD-820 form.
- 9.2. Project information.
- 9.3. Make, model, and serial number of the nuclear density gauge.
- 9.4. Stratified, random numbers.

- 9.5. Location of test and thickness of layer tested.
- 9.6. Underlying material.
- 9.7. Mixture type.
- 9.8. JMF identification.
- 9.9. Date.
- 9.10. Density standard.
- 9.11. Gauge readings.
- 9.12. Name and signature of individual performing AASHTO T 355.
- 9.13. Name and signature of individual performing AASHTO R 67.
- 9.14. Name and signature of individual performing AASHTO T 166 or T 331.
- 9.15. Nuclear gauge correlation to 0.1 lb/ft<sup>3</sup>.





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**Idaho Standard Practice for****Procedures for Checking Asphalt Drum  
Mix Plant Calibrations****IDAHO Designation: IR-155-19**

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**1. SCOPE**

- 1.1. These procedures are used in conjunction with the Department's Standard Specifications for Highway Construction for checking asphalt drum mix plants to assure plant conformance. This procedure is used for original plant approval, annual plant approval, after plant relocation, trouble shooting, or anytime at the Engineer's discretion. Some variations from this procedure may be necessary depending upon the configuration of the plant, including volumetric plants.
- 1.2. All test procedures stated below are required to be completed by the plant before notifying the Department for plant verification. Documentation will be provided to the Department that the tests have been completed and meet specification tolerances.
- 1.3. *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the user's responsibility of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations before use.*

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**2. MEASURING DEVICES**

- 2.1. Any weighing device used for payment must meet Section 109.01.A.6.b.
- 2.2. All measuring devices must meet the current edition of the National Institute of Standards and Technology Handbook 44, except as modified by Table 2.1. The producer shall provide all personnel and equipment for calibrating measuring devices.
- 2.3. Balance and zero conditions of scales shall be checked daily, and at any other time requested by the Department. The Engineer may, at any time, direct that any measuring device be tested by the producer or an outside agency if there is any doubt about the accuracy of the measuring device. Certificates of inspection shall be posted in a prominent place in the plant, and a copy shall be promptly submitted to the Engineer.
- 2.4. Production plant tolerances shall meet the following table:

Table 2.1

Material	Maintenance Tolerance <sup>(a)</sup>	Unit of Measure
Aggregate	0.2%	Weight
RAP	0.2%	Weight
Asphalt	0.2%	Weight or Volume
Additives	0.5%	Weight or Volume

(a) Maintenance tolerance will be the specified percent of the total capacity of the scale or the smallest scale graduation, whichever is greater.

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**3. BELT SCALES ON COLD FEEDERS**

- 3.1. Plants will check each individual belt scale, including RAP, at its high range and low range, as rated by the manufacturer; also considering the plant's actual production rates. A minimum of ten tons of material will be used per test run. The allowable error shall not exceed  $\pm 1.0\%$ . A minimum of two tests will be run at each range to check for repeatability and eliminate any outliers.
- 3.2. The Department will check belt scales at the mid-range using the procedure listed below.
- Plant Test Procedure:***
- 3.3. Each bin and its belt scale are tested individually.
- 3.3.1. Some plants may have to use a zero percent moisture input to ensure accuracy.
- 3.3.2. Check the belt scale accuracy at both high range and low range by running material over the belt scale and checking the indicated computer weight (accumulator) against the actual net weight of
- 3.3.3. the material in the truck
- The allowable error shall not exceed  $\pm 1.0\%$  from the actual truck scale weight.
- 3.3.4. The final belt scale (totalizer) will be checked at its high range and low range, as rated by the manufacturer; also considering the plant's production rate. A minimum of ten tons of material
- 3.3.5. will be used per test run. The allowable error shall not exceed  $\pm 0.5\%$
- Department Verification Procedure:***
- 3.4. Randomly select two or more cold-feed bins.
- 3.4.1. Check the belt scale accuracy at mid-range by running material over the belt scale and checking the indicated computer weight (accumulator) against the actual net weight of the material in the truck.
- 3.4.2. If one failure occurs at mid-range, run a second check. If two failures occur, the plant must recalibrate the failing feeder and notify the Department to schedule another check.
- 3.4.3.

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**4. BELT SCALE ON VOLUMETRIC PLANTS**

- 4.1. ***Plant Test Procedure:***
- 4.1.1. The final belt scale will be tested using two high-range runs and two low-range runs. The allowable error shall not exceed  $\pm 0.5\%$ .
- 4.2. ***Department Verification Procedure:***
- 4.2.1. Check the belt scale accuracy at mid-range by running material over the belt scale and checking the indicated computer weight (accumulator) against the actual net weight of the material in the truck.
- 4.2.2. If one failure occurs at mid-range, run a second check. If two failures occur, the plant must recalibrate the failing belt scale and notify the Department to schedule another check.

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**5. ASPHALT METER ACCURACY**

- 5.1. The asphalt meter is checked at its estimated highest and lowest production rate. Run two checks at each rate.
- 5.2. *Test Procedure:*
- 5.2.1. Enter the correct specific gravity or lb/gal for the liquid asphalt being used for the test into the computer system. A minimum of 1,000 gallons liquid asphalt will be run through the meter. The accuracy requirement is  $\pm 0.5\%$ . The result equals the allowable variation of the metered asphalt quantity, weighed on a state-approved scale, and compared to the computer (accumulator) quantity. A minimum of two test runs at the high rate and low rate will provide repeatability and eliminate any outliers. If one failure occurs at either high or low range, the plant must recalibrate. If a second failure occurs the plant must recalibrate the system and schedule another check with the Department.
- 5.3. *Department Verification Procedure:*
- 5.3.1. Same as the test procedure in 5.2.1.

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**6. MINERAL FILLER SYSTEM**

- 6.1. If mineral filler is added separately and does not come into contact with the other aggregates until it is in the drum mixer, it is handled in the same manner as the Asphalt Meter check.
- 6.2. *Materials and Equipment:*
- 6.2.1. Tanker truck with sufficient capacity for calibrating mineral filler.
- 6.3. *Test Procedure:*
- 6.3.1. The mineral filler is pumped through its meter into a tared truck where it is weighed on an approved truck scale and compared against the quantity as recorded by the plant automation. Repeatability of two tests must meet  $\pm 0.5\%$ ; if not, the plant must recalibrate the mineral filler system and notify the Department.
- 6.4. *Department Verification Procedure:*
- 6.4.1. Same as the test procedure in 6.3.

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**7. ANTI-STRIP ADDITIVE CALIBRATION**

- 7.1. Anti-stripping additive calibration check shall be performed in a manner satisfactory to the Engineer; with at least two different production rates and two different percentages of additive rates.

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**8. NO-FLOW SYSTEM**

- 8.1. Aggregate and Asphalt Interlocks must shut the plant down if a no-flow situation occurs.
- 8.2. *Test Procedure:*

- 8.2.1. The no-flow test will be run on each cold feed bin including RAP.
- 8.2.2. Material will be placed in the bin, and the bin will be allowed to run empty. A warning must occur immediately followed by plant shutdown.
- 8.2.3. The Asphalt System will be placed in a “No-Flow” condition and a warning must occur immediately followed by plant shutdown.
- 8.3. ***Department Verification Procedure:***
- 8.3.1. Same as the test procedure in 8.2.

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## **9. VOLUMETRIC BACKUP SYSTEM**

- 9.1. This section is for plants using belt scales on all the cold feeders.
- 9.2. A volumetric backup system will be approved in accordance with Section 10.
- 9.3. ***Reports:***
- 9.3.1. After the Plant Calibration is complete, the producer will supply the Engineer with a printout of all calibration numbers which verify the accuracy of the system and show that it meets all Department specifications.
- 9.3.2. The producer will supply upon request either a display or printout of all calibration numbers that verify the accuracy of the system has not changed since the annual calibration and still meets Department specifications.

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# Idaho Standard Practice for

## Determining Rolling $G_{mm}$



### IDAHO Designation: IR-156-19

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#### 1. SCOPE

- 1.1. This Standard Practice is used to determine the maximum theoretical specific gravity ( $G_{mm}$ ) used for calculating percent compaction of in-place density during production paving.
- 1.2. *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the user's responsibility of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations before use.*

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#### 2. REFERENCE DOCUMENTS

- 2.1 *AASHTO Standards*
- FOP for T 209, Bowl Method, Theoretical Maximum Specific Gravity and Density of Bituminous Paving Mixtures
  - FOP for T 355, In-Place Density of Asphalt Mixtures by Nuclear Method
  - FOP for R 97, Sampling Asphalt Mixtures
  - FOP for R 47, Reducing Samples of Hot Mix Asphalt to Testing Size
- 2.2 *Idaho Standards*
- Idaho IR 148, Stratified Random Sampling
  - Idaho IR 125, Acceptance Test Strip for Hot Mix Asphalt (HMA)

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#### 3. SUMMARY OF THE PRACTICE

- 3.1. The maximum theoretical specific gravity ( $G_{mm}$ ) for determining the percent compaction will be determined using a rolling, consecutive 2-lot average (i.e., the most recent 2 completed lots) of the Department's acceptance test results. For the first 2 lots of production paving, the average  $G_{mm}$  from the test strip is used for determining percent compaction.

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#### 4. PROCEDURE

- 4.1. *Determine the rolling  $G_{mm}$  for each lot as follows:*
- 4.1.1. For the first 2 lots of production paving, use the average of all Department acceptance  $G_{mm}$  results from the test strip.
- 4.1.2. For all other lots of production paving, use the average of all Department acceptance  $G_{mm}$  results from the previous 2 lots.
- 4.2. The rolling  $G_{mm}$  established in this procedure is used for performing the calculations in the FOP for AASHTO T 355 for the current lot.

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## 5. PROCEDURE FOR TEST RESULT CHALLENGE

- 5.1. When test result challenge resolution is performed in accordance with Subsection 106.07 of the Standard Specifications, the original Department acceptance test results are replaced with the challenge resolution test results and the rolling  $G_{mm}$  for the subsequent lots will be re-determined.
- 5.2. The rolling  $G_{mm}$  established in 5.1 will be used for performing the calculations in place of the  $G_{mm}$  determined in Section 4.
- 

## 6. EXAMPLE

- 6.1. The table below presents the  $G_{mm}$  results from the samples for the first 4 completed lots of production paving. Lot 1 was the test strip. The rolling  $G_{mm}$  for the first 5 lots are calculated as follows:
- 6.1.1. Lot 1 rolling  $G_{mm} = 2.402$  (average of lot 1 combined  $G_{mm}$ )
- 6.1.2. Lot 2 rolling  $G_{mm} = 2.402$  (average of lot 1 combined  $G_{mm}$ )
- 6.1.3. Lot 3 rolling  $G_{mm} = 2.399$  (average of lot 1 and lot 2 combined  $G_{mm}$ )
- 6.1.4. Lot 4 rolling  $G_{mm} = 2.398$  (average of lot 2 and lot 3 combined  $G_{mm}$ )
- 6.1.5. Lot 5 rolling  $G_{mm} = 2.392$  (average of lot 3 and lot 4 combined  $G_{mm}$ )

Lot Number	Sample Number	Combined $G_{mm}$
1	1	2.396
1	2	2.410
1	3	2.401
2	4	2.395
2	5	2.419
2	6	2.389
2	7	2.391
2	8	2.392
3	9	2.381
3	10	2.422
3	11	2.398
4	12	2.379
4	13	2.388
4	14	2.391
4	15	2.385

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**Idaho Standard Practice for****Determining NCAT Correction Factor****IDAHO Designation: IR-157-19**

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**1. SCOPE**

- 1.1. This Standard Practice is used to determine the NCAT correction factor for NCAT ovens used on production paving projects to determine asphalt content.
- 1.2. *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the user's responsibility of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations before use.*

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**2. REFERENCE DOCUMENTS**

- 2.1 *AASHTO Standards*
- FOP for T 308, Determining the Asphalt Binder Content of Hot Mix Asphalt (HMA) by the Ignition Method
  - FOP for T 30, Mechanical Analysis of Extracted Aggregate
  - T 30, Mechanical Analysis of Extracted Aggregate
  - FOP for R 97, Sampling Asphalt Mixtures
  - FOP for R 47, Reducing Samples of Hot Mix Asphalt to Testing Size
- 2.2 *ASTM Standards*
- D8159, Standard Test Method for Automated Extraction of Asphalt Binder From Asphalt Mixtures (Asphalt Analyzer™)
- 2.3 *Idaho Standards*
- Idaho IR 148, Stratified Random Sampling
  - Idaho IR 125, Acceptance Test Strip for Hot Mix Asphalt (HMA)

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**3. SUMMARY**

- 3.1. 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). Each ignition furnace will have its own unique correction factor determined in the location where testing will be performed.
- 3.2. 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 will require a new correction factor.
- 3.3. All correction samples used for acceptance will be prepared by the Department's Central Materials Laboratory.

- 3.4. Mix design laboratories and quality control laboratories can use this procedure, or FOP for AASHTO T 308 Annex – Correction Factors, or another Department approved method as described the approved quality control plan for determining correction factors for QC labs.
- 3.5. **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 (i.e., > 1.00 percent). Such mixes must be corrected and tested at a lower temperature as described below.
- 3.6. **Aggregate correction factor:** Due to potential aggregate breakdown during the ignition process, a correction factor will need to be determined.
- 3.7. This correction factor will be used to adjust the acceptance gradation test results obtained according to the FOP for AASHTO T 30.

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#### 4. PRODUCING CORRECTION FACTOR SAMPLES

- 4.1. Obtain sample of HMA in accordance with the FOP for AASHTO R 97 and Idaho IR 125.
- 4.2. Reduce the sample of HMA in accordance with the FOP for AASHTO R 47 for the following:
- 4.2.1. Provide 3 correction factor samples for each ignition furnace to be used for acceptance.
- 4.2.1.1. Correction factor sample size is determined by AASHTO T 308 Step 4.
- 4.2.2. Provide 3 correction factor samples for the Central Materials Laboratory's Asphalt Analyzer™.
- 4.2.3. Six (6) additional correction factor samples for use as needed.

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#### 5. DETERMINING THE ACTUAL ASPHALT CONTENT AND GRADATION

- 5.1. Test 3 correction factor samples in accordance with ASTM D8159 and AASHTO T 30 and average the results. Each sample must be dried to constant mass according to the FOP for AASHTO 329 prior to performing ASTM D8159.
- 5.2. The average of the results are considered to be the actual asphalt content and actual gradation.
- 5.2.1. The asphalt content will be calculated and reported to 0.01 percent.
- 5.2.2. The gradation results will be calculated and reported to 0.1 percent.

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#### 6. PROCEDURE

- 6.1. For each ignition furnace that will be used to determine acceptance, perform Steps 7.1 through 7.4 and Steps 8.1 through 8.4.
- 6.2. The correction factors are unique to each furnace and each JMF.

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#### 7. DETERMINING THE IGNITION FURNACE CORRECTION FACTOR

- 7.1. Test 3 correction factor samples in accordance with FOP for AASHTO T 308. Each sample must be dried to constant mass according to the FOP for AASHTO T 329 prior to performing FOP for AASHTO T 308.



- 7.2. Once all 3 of the correction specimens have been burned, determine the measured asphalt binder content for each specimen from the printed oven tickets.
- 7.3. Determine the average measured binder content of the 3 correction specimens.
- 7.4. The asphalt binder correction factor,  $C_b$ , is the difference between the average actual and average measured asphalt binder contents for each specimen to 0.01 percent.
- 7.5. If the asphalt binder correction factor exceeds 1.00 percent, the test temperature must be lowered to  $482 \pm 5^\circ\text{C}$  ( $900 \pm 9^\circ\text{F}$ ) 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.

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## 8. DETERMINING THE AGGREGATE CORRECTION FACTOR

- 8.1. For each of the 3 correction specimens from Section 7, perform a gradation analysis on the residual aggregate in accordance with FOP for AASHTO T 30.
- 8.2. Determine the average measured gradation for each of the 3 correction specimens. The results will be utilized in developing an aggregate correction factor and should be calculated and reported to 0.1 percent.
- 8.3. Determine the difference between the average actual and average measured gradation results.
- 8.4. If the difference for any single sieve exceeds the allowable difference of that sieve as listed in Table 8.1, then aggregate gradation correction factors (equal to the resultant average differences) for all sieves must be applied to all acceptance gradation test results determined by the FOP for AASHTO T 30. If the 75  $\mu\text{m}$  (No. 200) is the only sieve outside the limits in Table 2, apply the aggregate correction factor to only the 75  $\mu\text{m}$  (No. 200) sieve.

**Table 8.1 – Permitted Sieving Difference**

Sieve	Allowable Difference
Sizes larger than or equal to 2.36 mm (No. 8)	$\pm 5.0\%$
Sizes larger than 75 $\mu\text{m}$ (No. 200) and smaller than 2.36 mm (No. 8)	$\pm 3.0\%$
Sizes 75 $\mu\text{m}$ (No. 200) and smaller	$\pm 0.5\%$



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**Idaho Standard Practice for**

# Sampling Concrete for Chloride Analysis

**IDAHO Designation: IR-128-17**

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**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.*

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**2. REFERENCE DOCUMENTS**

- 2.1 *AASHTO Standards*
  - T 260, Sampling and Testing for Chloride Ion in Concrete and Concrete Raw Materials

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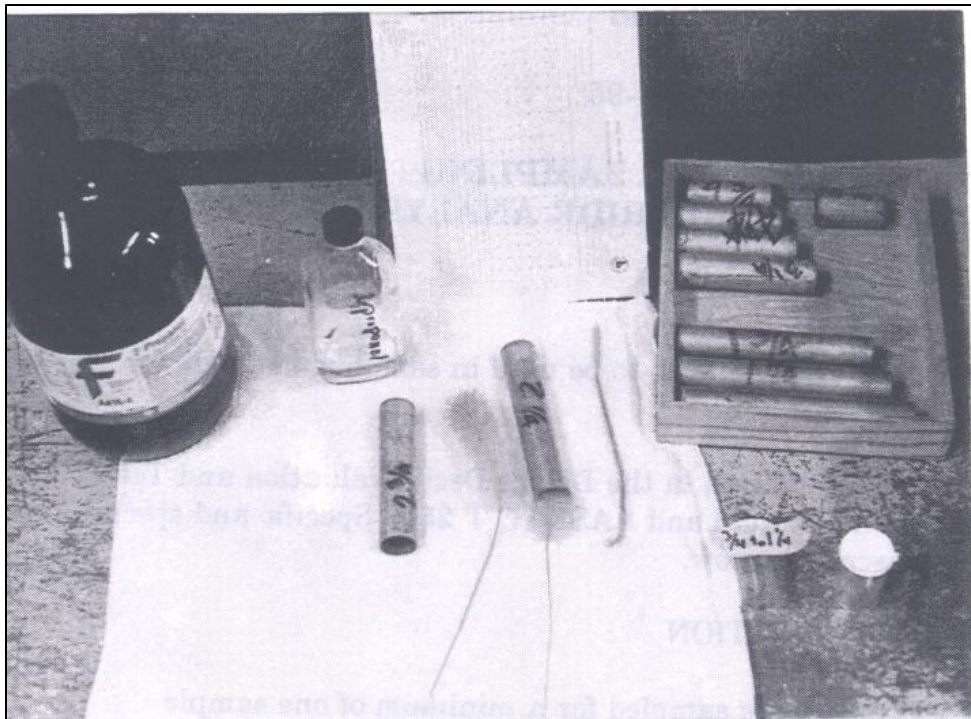
**3. GENERAL SAMPLING INFORMATION**

- 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.

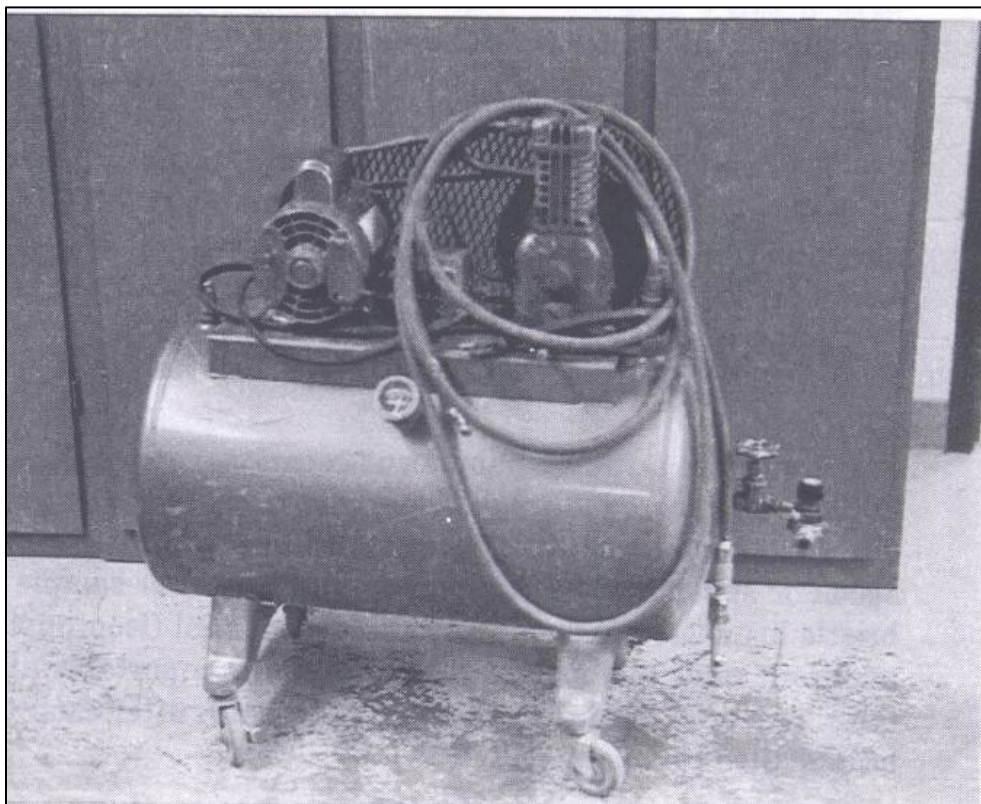
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**4. SAMPLING PROCEDURES AND GUIDELINES**

- 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.

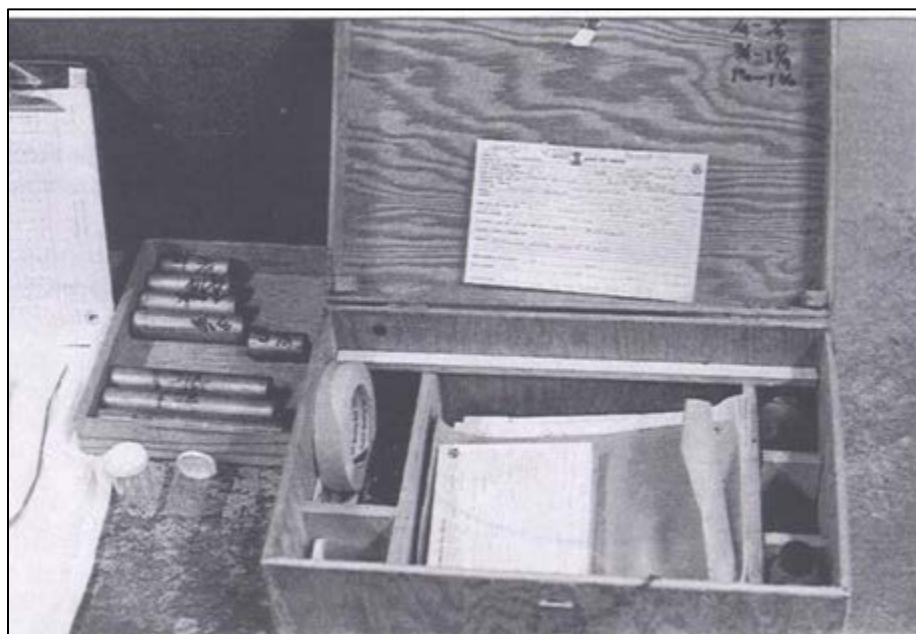


**Illustration B:** Portable Air Compressor for Cleaning Between Samples.

- 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 1 Nominal Drilling Depths in 1/2 inch Increments (15 mm)			
ENGLISH MEASUREMENT		METRIC MEASUREMENT	
From	To	From	To
1/4 inch	3/4 inch	5 mm	20 mm
3/4 inch	1 1/4 inch	20 mm	35 mm
1 1/4 inch	1 3/4 inch	35 mm	50 mm
1 3/4 inch	2 1/4 inch	50 mm	65 mm
2 1/4 inch	2 3/4 inch	65 mm	80 mm
2 3/4 inch	3 1/4 inch	80 mm	95 mm
3 1/4 inch	3 3/4 inch	95 mm	110 mm

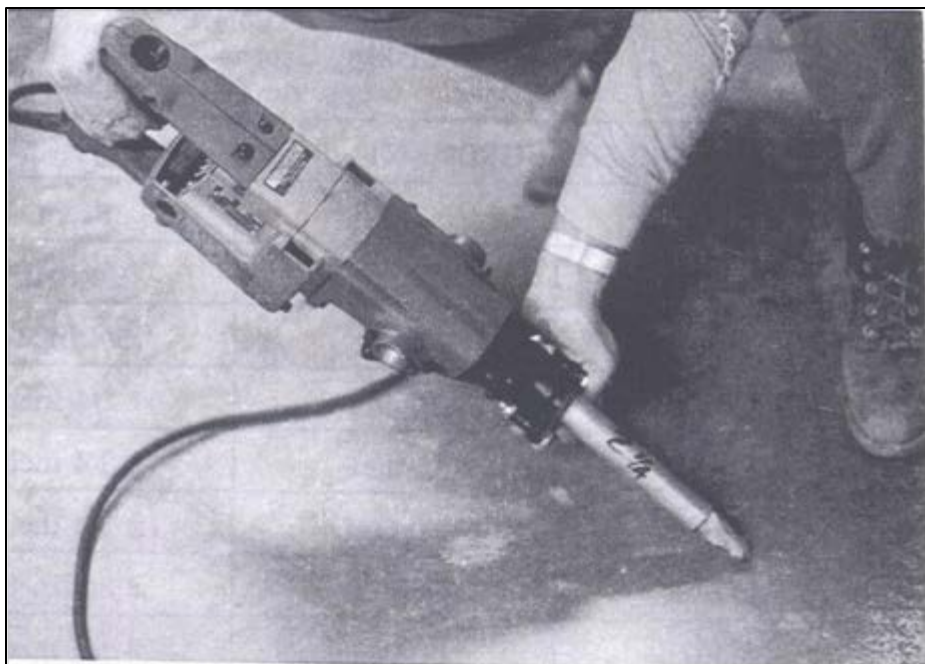
**Note**— Millimeters (mm) are the metric sample depths and are based upon approximations of the English measurements



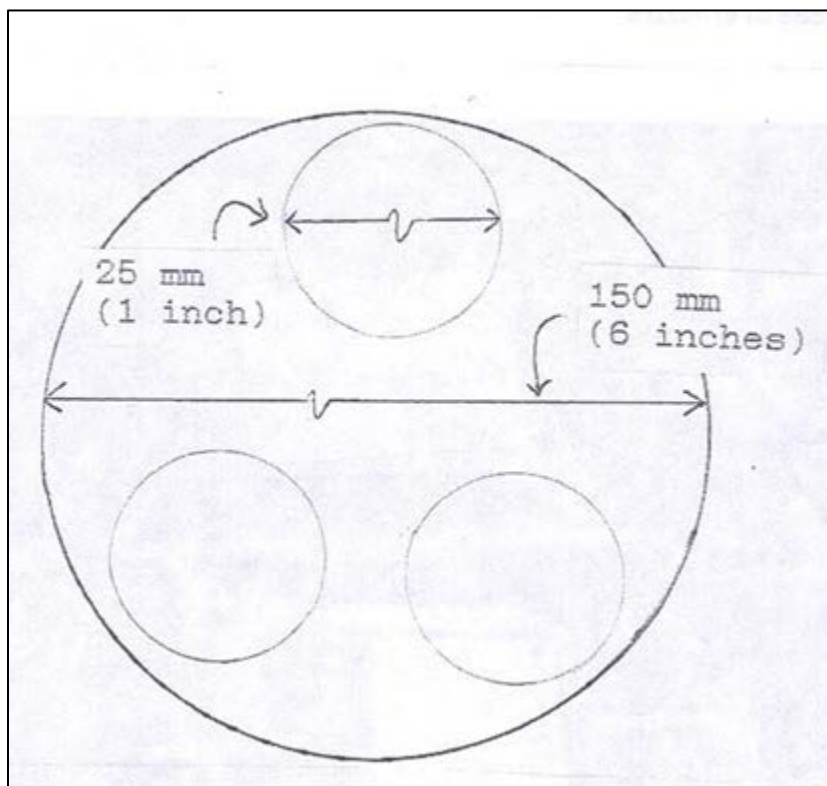
**Illustration C:** Chloride Sampling Kit.

- 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.

- 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.



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**Idaho Standard Method of Test for**

# Acid Soluble Chloride Content of Hardened Concrete by Gran Plot Method

**IDAHO Designation: IT-131-17**

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**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.*

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**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

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**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.

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**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.
- 4.1.6. Balance complying with M 231, Class G2.
- 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.

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## 5. REAGENTS

- 5.1. *Reagents for Chemical Testing.*
  - 5.1.1. Concentrated HNO<sub>3</sub> (specific gravity 1.42).
  - 5.1.2. Sodium chloride, NaCl, reagent grade (primary standard).
  - 5.1.3. Standard 0.01normality 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 H<sub>2</sub>O, and transfer to a 1 liter volumetric flask. Make up to the mark with distilled H<sub>2</sub>O and mix. Calculate the exact normality as follows:
$$N_{NaCl} = 0.0100 \frac{(Wt_{Actual})}{(0.5844)}$$

where:

W<sub>t actual</sub> = actual weight of NaCl

N<sub>NaCl</sub> = normality of NaCl solution
  - 5.1.4. *Standard 0.01Normality AgNO<sub>3</sub>.* Weigh 1.7 grams of reagent AgNO<sub>3</sub>, 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 H<sub>2</sub>O swirling to bring the powder into suspension. Add 3 ml of concentrated HNO<sub>3</sub> with continued swirling until the material is completely decomposed. Break up any lumps with a stirring rod and dilute with hot H<sub>2</sub>O 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 HNO<sub>3</sub> 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 H<sub>2</sub>O. The known contains 10 ml of 100 ppm chloride (Cl<sup>-</sup>) 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 H<sub>2</sub>O 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 H<sub>2</sub>O; 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<sup>-</sup> 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  $\text{HNO}_3$ , and 10 ml 100 PPM- $\text{Cl}^-$  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- $\text{Cl}^-$  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  $\text{AgNO}_3$ .

Rinse electrodes with distilled water and dry. Fill a 25 ml buret with  $\text{AgNO}_3$  solution. Prepare a 250 ml beaker with 10 ml 0.01N NaCl solution, 3 ml conc.  $\text{HNO}_3$ , 87 ml distilled water, and stir bar. Place sample on magnetic stirplate with electrode in solution and while stirring record initial mV reading. Add  $\text{AgNO}_3$  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:

$$N_{\text{AgNO}_3} = \frac{(V_{\text{NaCl}})(N_{\text{NaCl}})}{V_{\text{AgNO}_3}}$$

$N_{\text{AgNO}_3}$  = normality of  $\text{AgNO}_3$  Solution

$V_{\text{NaCl}}$  = volume (ml) of NaCl Solution

$N_{\text{NaCl}}$  = normality of NaCl Solution

$V_{\text{AgNO}_3}$  = volume (ml) of  $\text{AgNO}_3$  Solution (Use blank and volume corrected end point) Follow steps 5.4.1 through 5.4.3 for correct calculation of  $V_{\text{AgNO}_3}$ .

5.4. Chloride Sample Instrumental Analysis.

After calibration of Ionanalyzer and  $\text{AgNO}_3$  solution prepare sample filtrate for mV readings. Weigh filtrate, record weight and add distilled water to bring volume to  $100 \pm 1$  grams. Place rinsed and dry electrodes in sample solution. Read and record millivolt reading for sample before  $\text{AgNO}_3$  is added. Using the 25 ml buret, titrate the sample between 300-310 mV with standard 0.01 N  $\text{AgNO}_3$  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:

$$V_{\text{correct}} = \frac{V_{\text{record}}}{Wt./100}$$

Where:

Wt = original solution weight in grams.

$V_{\text{record}}$  = volumes recorded in ml.

If filtrate weight is  $100 \pm 1$  grams, then  $V_{\text{correct}} = V_{\text{record}}$ .

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:

$$E_a = (E_g) \left( \frac{Wt.}{100} \right)$$

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- $\text{Cl}^-$  or final lb.  $\text{Cl}^-$  /c.y. concrete calculations.

Wt = 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  $Wt_r$  as:

$$Wt_r = Wt + X$$

Where:

Wt = original solution weight in grams

X = the constant

Then calculate corrected volumes for each recorded volume as:

$$V_{\text{Correct}} = \frac{V_{\text{record}} - X}{Wt_r / 100}$$

Plot these values and determine the graph endpoint  $E_g$ , as described in Section 5.42, above.

#### 5.5. The actual endpoint $E_a$ is then:

$$E_a = (E_g) \left( \frac{Wt_r}{100} \right) + X$$

where:

$E_a$  = actual endpoint in ml.

$E_g$  = endpoint from graph in ml with blank subtracted.

$Wt_r$  = 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:

$$PercentCl^- = \left(\frac{3.5453}{Wt_c}\right)(E_a)(N)$$

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<sup>3</sup> is often assumed for normal structural weight concrete when the actual unit weight is unknown.

Results are reported as lb.  $Cl^-$ /yd<sup>3</sup> 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  $\left(E_g\right)\left(\frac{Wt}{100}\right) - blank$

Idaho specifications for  $Cl^-$  value = 2 lb.  $Cl^-$ /yd<sup>3</sup> max.

Precision and Accuracy Data – As documented in AASHTO T 260.

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**Idaho Standard Method of Test for**

# Determination of the Rate of Evaporation of Surface Moisture from Concrete

**IDAHO Designation: IT-133-17**

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**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.*

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**2. REFERENCE DOCUMENTS**

- 2.1. ACI Manual of Concrete Practice, Section 305R.

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**3. APPARATUS**

- 3.1. Thermometer, 0°F to 180°F, Dial Type.
- 3.2. Wind meter.
- 3.3. Hygrometer, stationary mason's form.

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**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 .

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## 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.

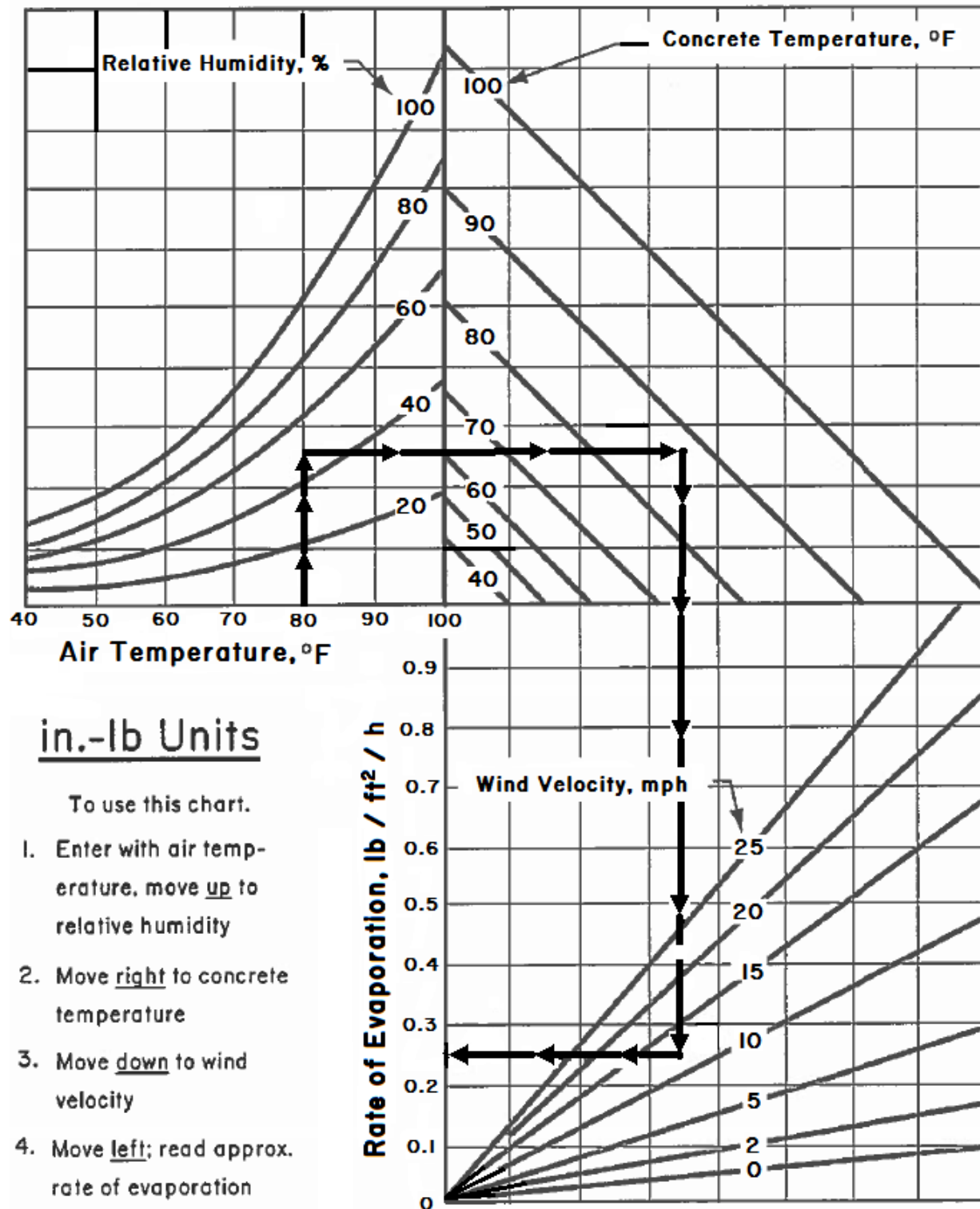
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## 6. RATE OF EVAPORATION

- 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.



[illegible]



*Effect of concrete and air temperatures, relative humidity, and wind velocity on the rate of evaporation of surface moisture from concrete.*

Figure 2: Evaporation Rate

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**Idaho Standard Practice for**

# Field Sampling of Hydraulic Cement and Fly Ash

**IDAHO Designation: IR-143-17**

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**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.*

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**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.

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**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.

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# Idaho Standard Method of Test for Measuring Texture Depth of Portland Cement Concrete Using a Tire Tread Depth Gauge

## IDAHO Designation: IT-147-17



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### 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.*

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### 2. REFERENCED DOCUMENTS

- 2.1. *AASHTO Standards*
  - T 261-78 (1999), Discontinued

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### 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.

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### 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.

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### 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.

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## **6. CALCULATIONS**

- 6.1. Calculate the average groove depth for each test area to the nearest 1/32-in.

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## **7. REPORT**

- 7.1. Report test results on Form ITD-798. See Figure 7.1.1







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**Idaho Standard Practice for**

# Inspecting / Sampling Paint and Curing Compound

**IDAHO Designation: IR-7-04**

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**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.*

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**2. REFERENCE DOCUMENTS**

- 2.1. *ASTM Standards*
- D3925, Standard Practice for Sampling Liquid Paints and Related Pigmented Coatings.
- 2.2. *Federal Standard Test Methods 141*
- Method 1022 Sampling for Inspection and Testing

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**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.

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#### **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.

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#### **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.

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#### **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.

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## 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.

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## 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 composites 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.

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**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

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**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.

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**11. TIME OF SAMPLING**

- 11.1. Samples shall be taken as soon as possible after manufacturing or delivery to a site location.

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**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.



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**Idaho Standard Method of Test for****Determining Total Solids-Latex Percent****IDAHO Designation: IT-121-98**

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**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.*

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**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  $285^{\circ}\text{F} \pm 2^{\circ}\text{F}$  ( $140^{\circ}\text{C} \pm 1^{\circ}\text{C}$ ).
- 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.

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**3. CALCULATIONS AND REPORT**

$$\text{Total Solids in percent} = \frac{(C - A)}{(B - A)} \times 100$$

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 g	Then C-A = 1.779	and	B-A = 2.356
	B = 2.356 g	- <u>1.374</u>		- <u>1.374</u>
	C = 1.779 g	0.405 g		0.982 g

Therefore:

$$\frac{(C - A)}{(B - A)} \times 100 = \frac{0.405}{0.982} \times 100 = 41.2\% \text{ solids}$$

- 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.



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**Idaho Method of Test for****Resistance R-Value and Expansion Pressure of  
Compacted Soils and Aggregates****IDAHO Designation: IT-8-17**

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**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.*

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**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.

Sieve	Original % Passing	Corrected % Passing	Corrected % Retained	Accumulated Weight, Lb.
1"	90			
3/4"	85	100	0	0
1/2"	75	88	12	1.6
No. 4	65	77	23	3.0
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 =  $2.5 \pm 0.05$  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.

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**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.

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**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 0.0000" 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.



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**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  $2.00 \pm 0.05$  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:

$$R - Value = 100 - \frac{100}{\left[\left(\frac{2.5}{D}\right)\left(\frac{P_v}{P_h}\right)\right] + 1}$$

Where: R = Resistance R-value

D = Turn Displacement

P<sub>v</sub> = 160 psi (Vertical pressure)

P<sub>h</sub> = 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).

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**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 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 follow:

$$\text{Dry Weight (g)} = \frac{\text{Original Weight (wet, g)}}{1 + \frac{\% \text{ water}}{100}}$$

$$\text{Weight of Water (g)} = \text{Original Weight (g)} - \text{DryWeight (g)}$$

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 follow:

$$\% \text{ Water} = \frac{\text{Total Water (g)}}{\text{Dry Weight (g)}} \times 100$$

- 7.3.3. The densities of the specimen are then computed from the following equations:

$$\text{Wet Density (pcf)} = \frac{\text{Net Weight of Soil, Wet (g)}}{\text{height, (inch)}} \times 100$$

$$\text{Dry Density (pcf)} = \frac{\text{Wet Density(pcf)}}{1 + \frac{\% \text{ water}}{100}}$$

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**8. REPORT**

- 8.1. Report Test Results on Form ITD-803.

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**ANNEX**

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(Mandatory Information)

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**A1. METHOD OF FABRICATING PAPER BASKETS FOR R-VALUE SPECIMENS**

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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.

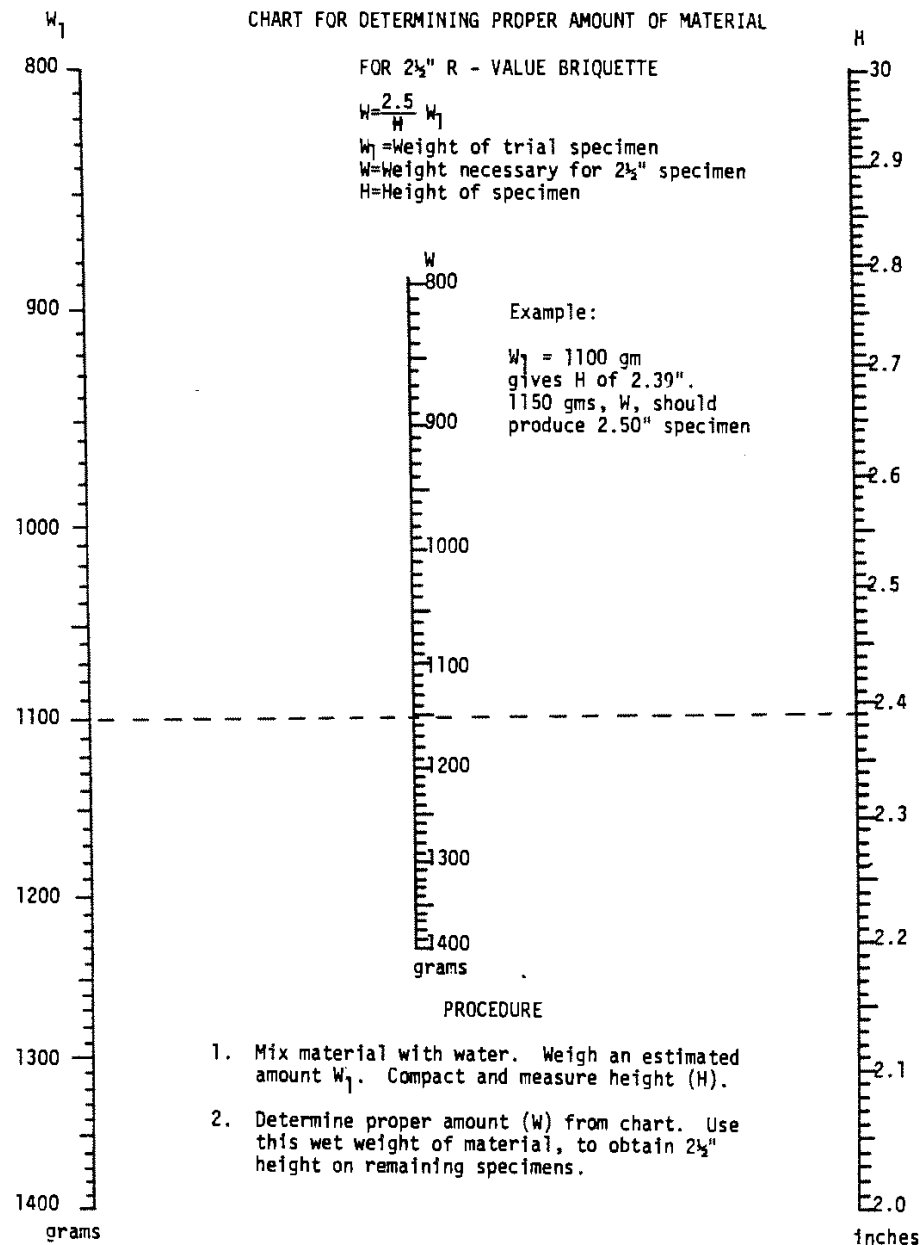
A1.3.2. Using four strips of 1/2" masking tape, tape phosphor-bronze disk to the paper so that the holes in the disk are not obscured in the process. See photos D and E of Figure A2.11.

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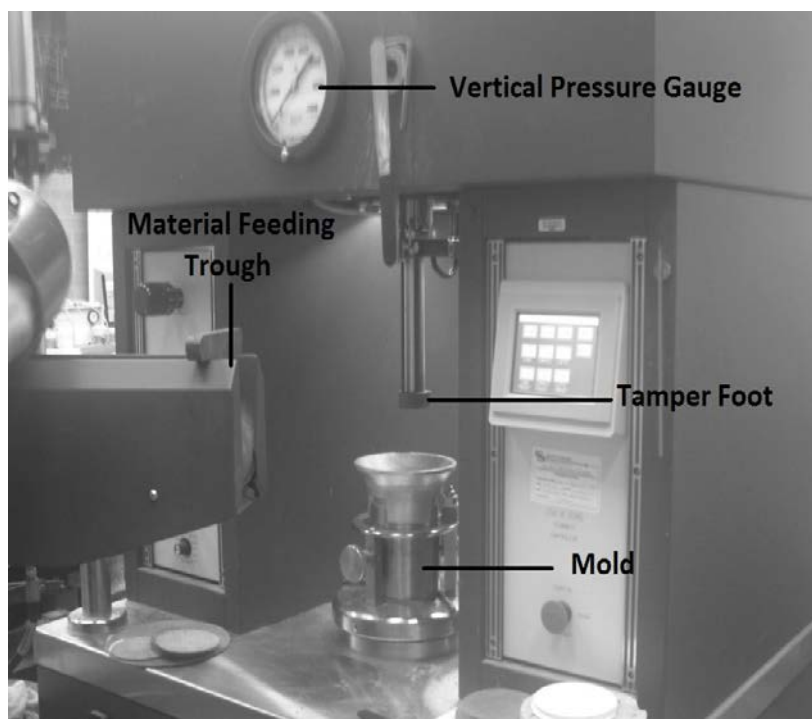
**A2. FIGURES DESCRIBED IN THIS METHOD**

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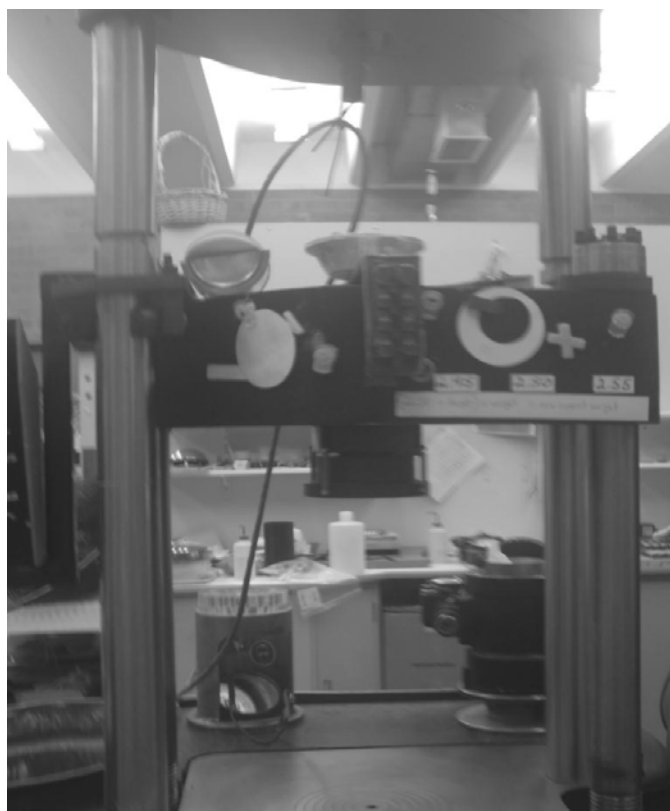
A2.1. This annex contains charts, photos of the apparatus, and worksheets used in this standard.



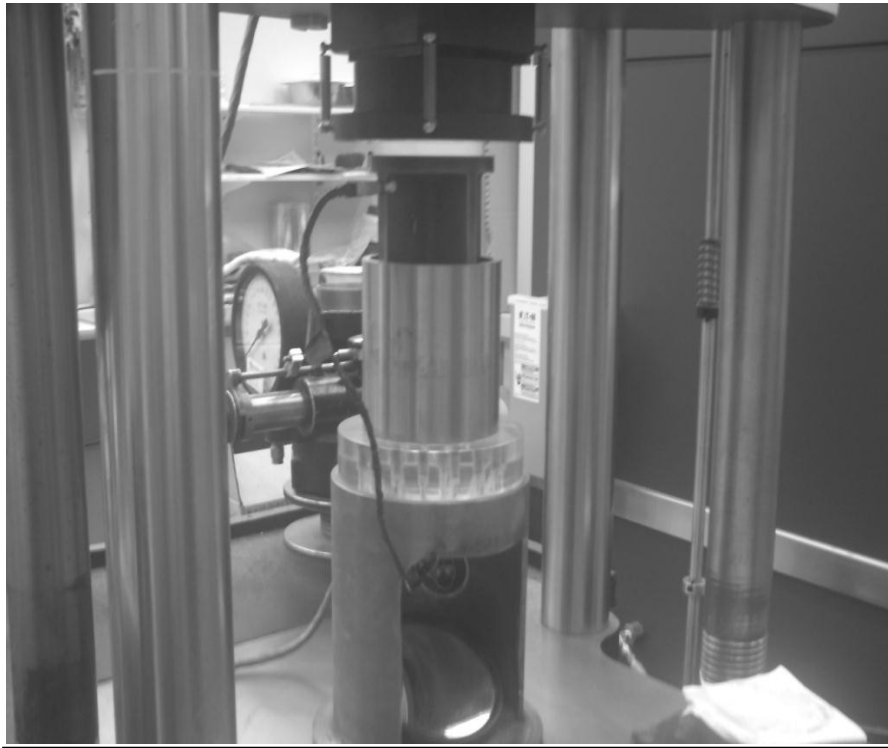
**Figure A2.1— Chart for Determining Proper Amount of Material  
for 2-1/2" R-Value Briquette**



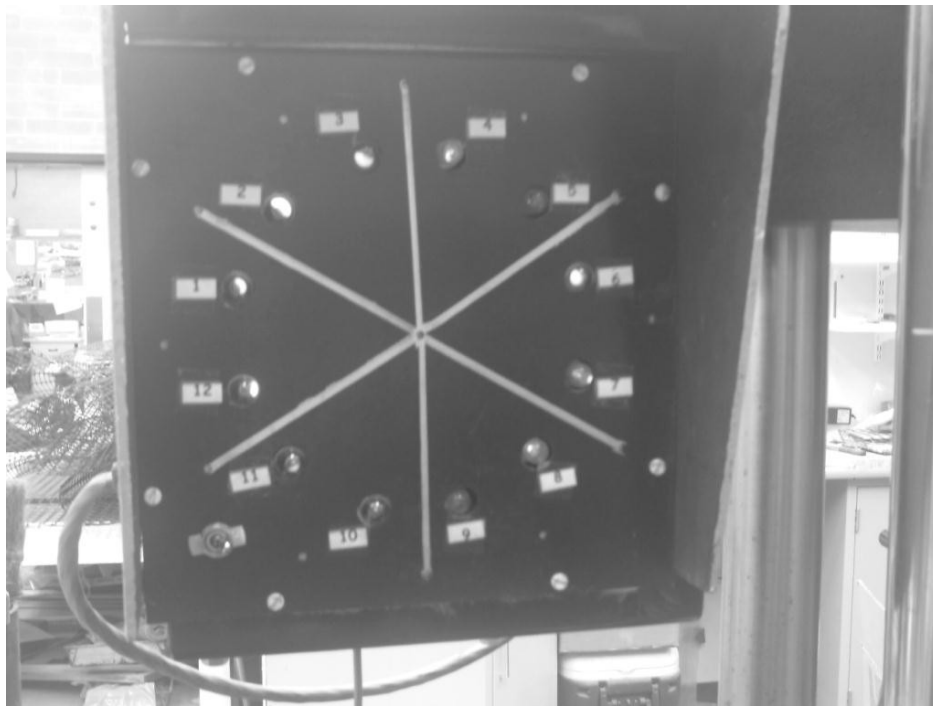
**Figure A2.2— Kneading Compactor**



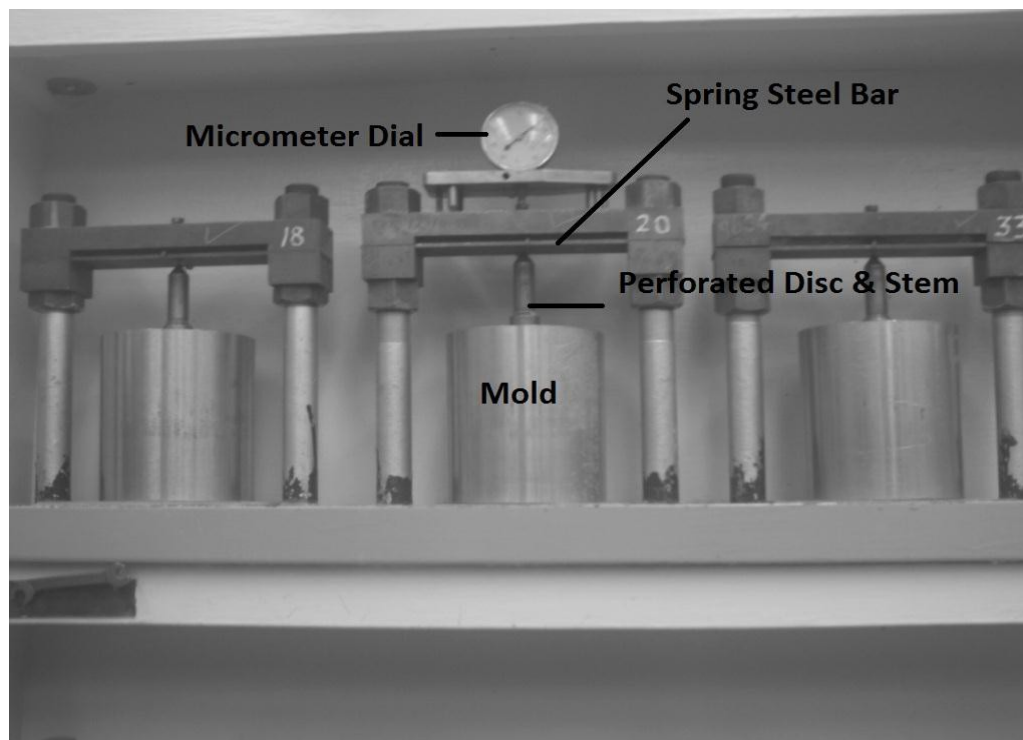
**Figure A2.3— Compression Testing Machine**



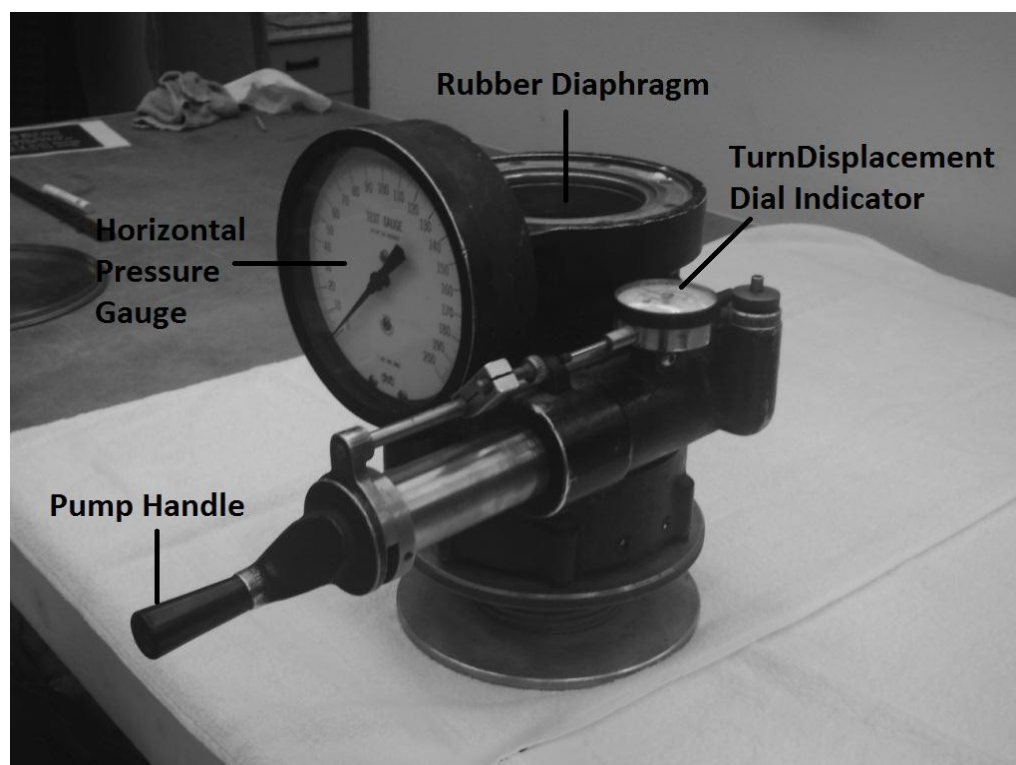
**Figure A2.4— Moisture Exudation Device**



**Figure A2.5— Moisture Exudation Indicator Device  
With 6 Light Sections**

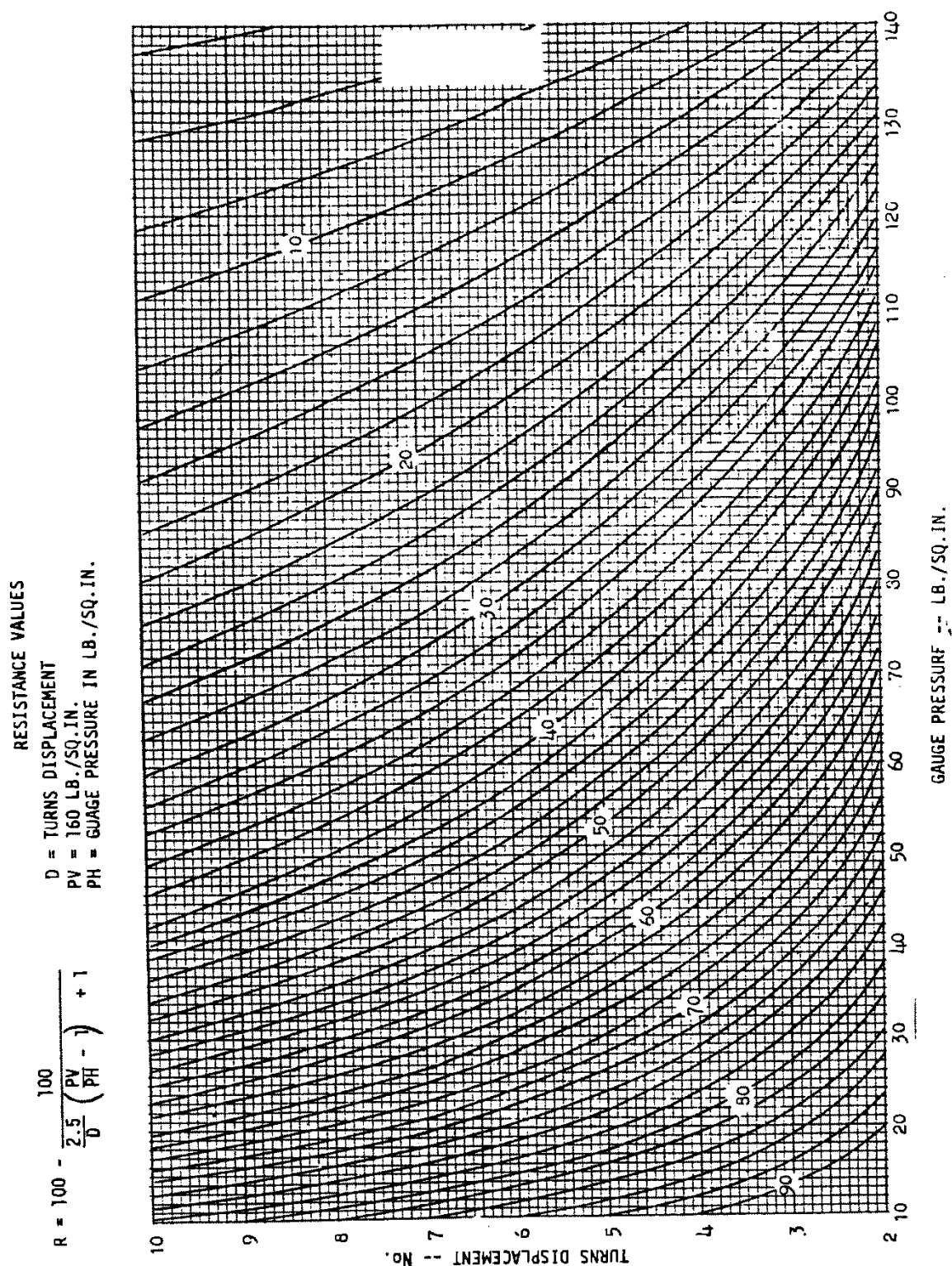


**Figure A2.6— Swell Frames for Measuring Expansion Pressure**



**Figure A2.7— Hveem Stabilometer**





**Figure A2.8— Chart for Determining Resistance R-Value**

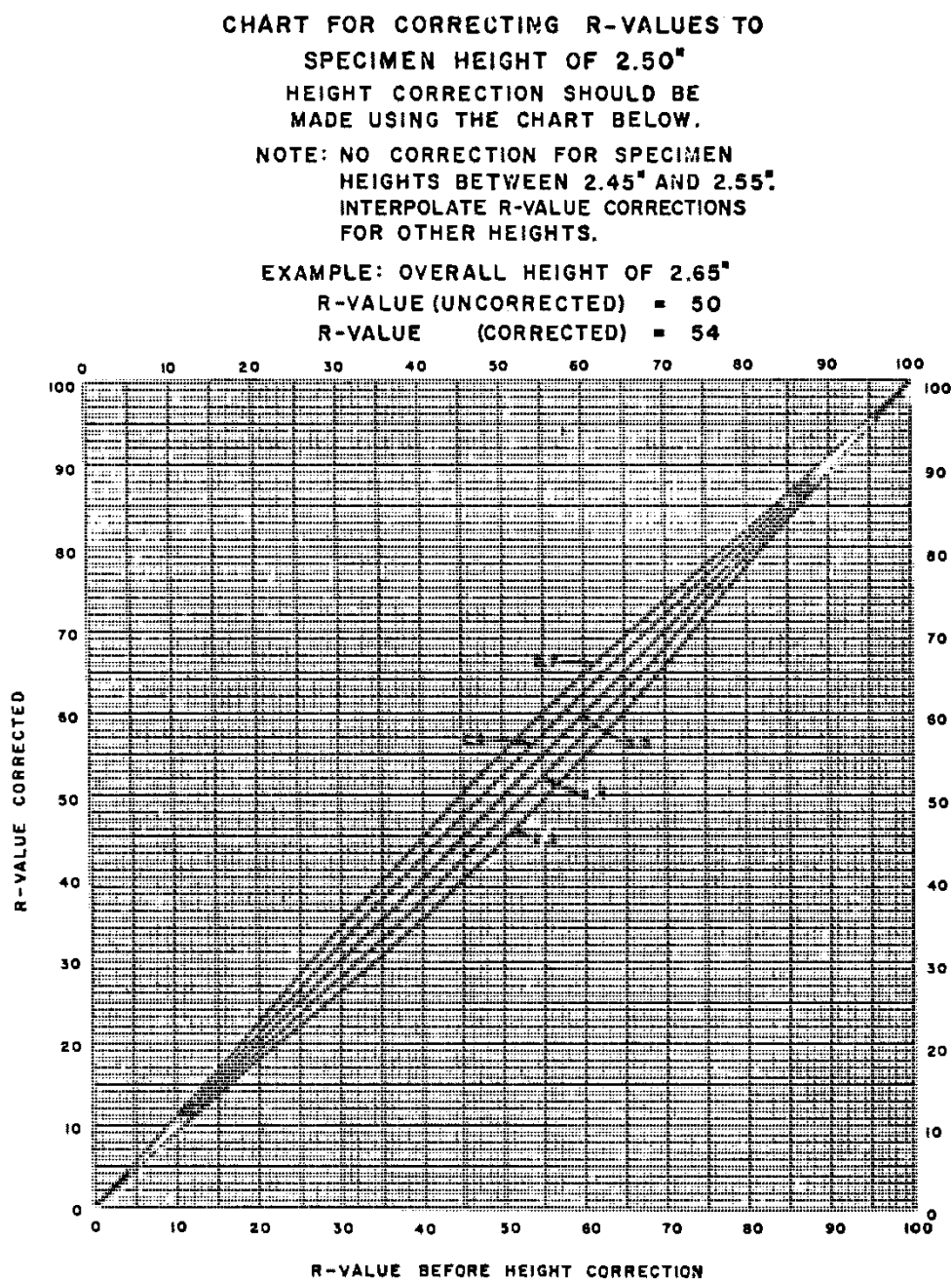


Figure A2.9— Chart for Correcting R-Value to Specimen Height of 2.5"

## R-VALUE WORKSHEET



Lab Number : \_\_\_\_\_

Project No. : \_\_\_\_\_

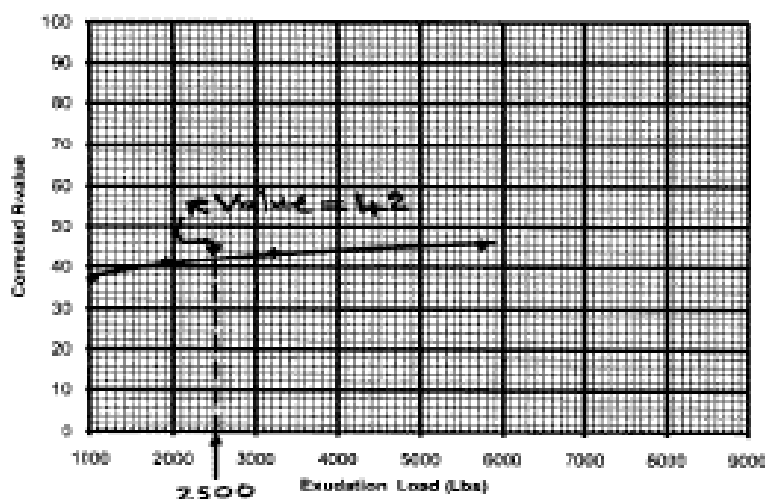
Key Number : \_\_\_\_\_

TRIAL	A	B	C	D	E
MOLD NUMBER	6	7	8	9	
ORIGINAL WEIGHT (grams)	750.6	800.7	790.6	770.9	
WEIGHT OF WATER (grams)	157	167	165	161	
WATER ADDED (grams)	75.01	64.11	58.79	49.89	
TOTAL WATER (grams)	232	231	224	211	
% WATER	30.9%	28.9%	28.6%	27.4%	
WT. OF MOLD + SOIL (grams)	2017.7	2053.7	2048.2	2020.9	
WT. OF MOLD + BASKET (grams)	2102.6	2094	2104.3	2105	
NET WT. OF SOIL, WET (grams)	815.1	859.7	843.9	815.9	
HEIGHT, INCHES	2.443	2.609	2.528	2.39	
WET DENSITY - Lbs/Cu.Ft	101.1	99.8	101.3	103.4	
DRY DENSITY - Lbs/Cu.Ft	73.7	73.2	74.6	76.9	
STABILITY Ph. 500	19	15	12	13	
Ph. 1000	33	28	23	24	
Ph. 1500	50	41	36	35	
Ph. 2000	72	62	53	49	
DISPLACEMENT	4.9	6.24	6.88	6.08	
IR VALUE	38	39	43	46	
IR VALUE - Corrected	37	41	44	46	
EXUDATION PRESS, LBS	1020	1817	3225	5747	
DRAINAGE	8L	8L	8L	8L	
GAGE READS	18	23	50	41	
EXPANSION PRESS, PSI	6.55	8.71	1.54	1.28	

Coarse R-value Make up Calculations					
Weight Of Sample				Grams	Lbs
Sieve Size	Corr. Accum. Lbs	% Passing	% Each Size	Grams Each Size	Accum. Grams
3/4 inch					
1/2 inch					
3/8 inch					
# 4					
Minus # 4					

Make Up Moisture Content Calculations		
To Achieve	% Moisture, Add	
	Grams Of Water	

Comments:	



CAN NUMBER		M-2	
WT. OF CAN + WET SOIL, GRAMS		487.81	
WT. OF CAN + DRY SOIL, GRAMS		402.86	
WT. OF WATER, GRAMS		84.95	
WT. OF CAN, GRAMS		42.43	
WT. OF DRY SOIL, GRAMS		360.23	
% WATER		26.4%	
TRIAL >>>>>	A	B	C
ORIGINAL WT (gram)	750.6	800.7	790.6
DRY WEIGHT (grams)	534	634	626
WATER (grams)	157	167	165

TRIAL >>>>>>>>>>	D	E
ORIGINAL WT (gram)	770.9	
DRY WEIGHT (grams)	610	
WATER (grams)	161	

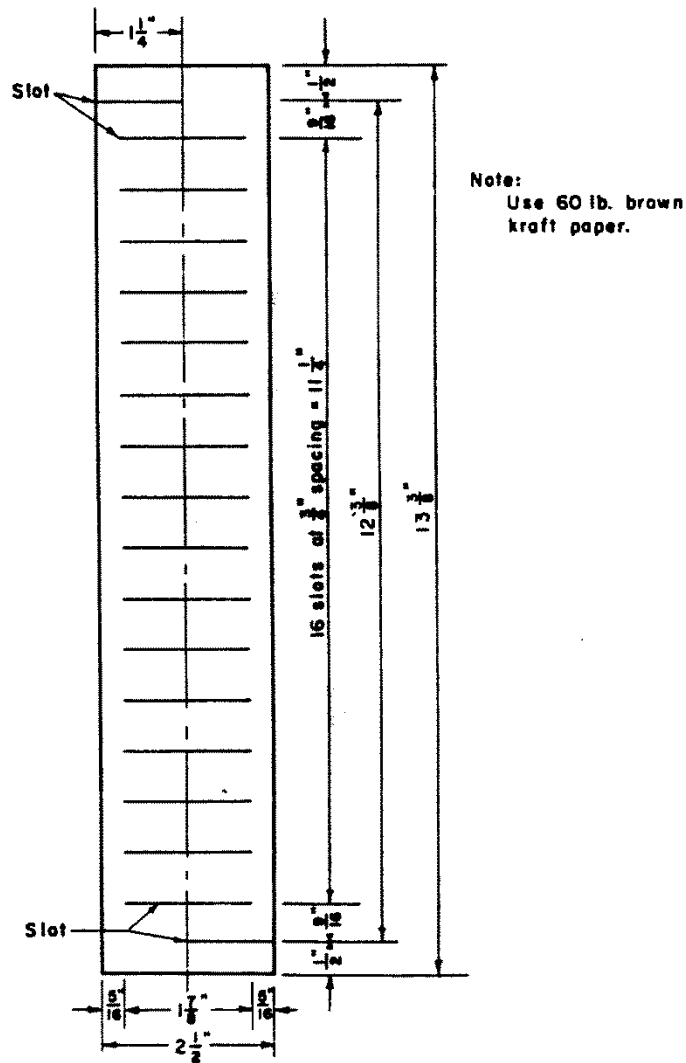
SOIL DATA	
TRAFFIC INDEX	
IR VALUE	42
EXPANSION PRESS, PSI	
BALLAST FROM "IR"	
FROM EXP. PRESSURE	

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**



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**Idaho Standard Practice for**

# Taking Undisturbed Soil Samples for Laboratory Consolidation, Shear and Permeability Tests

**IDAHO Designation: IR-62-17**

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**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.*

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**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.

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**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.

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#### **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<sup>3</sup> of a proposed embankment, should be recorded and the information supplied to the Central Materials Laboratory with the undisturbed sample.



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**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.*

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**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. *Manual Torque Wrenches:*

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.

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**Idaho Standard Practice for****Calibrating the Skidmore-Wilhelm Torque-Wrench Calibration Unit****IDAHO Designation: IR-17-98**

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**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.*

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**2. REFERENCE DOCUMENTS**

- 2.1. *ASTM Standards*
- E4-16, Standard Specification for Force Verification of Testing Machines.
- 2.2. *OTHER Standards*
- Manufacturer's Pamphlet

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**3. EQUIPMENT**

- 3.1. Testing machine with a capacity of at least as high as the Skidmore unit and calibrated to  $\pm 1\%$ .
- 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 forgoing 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.

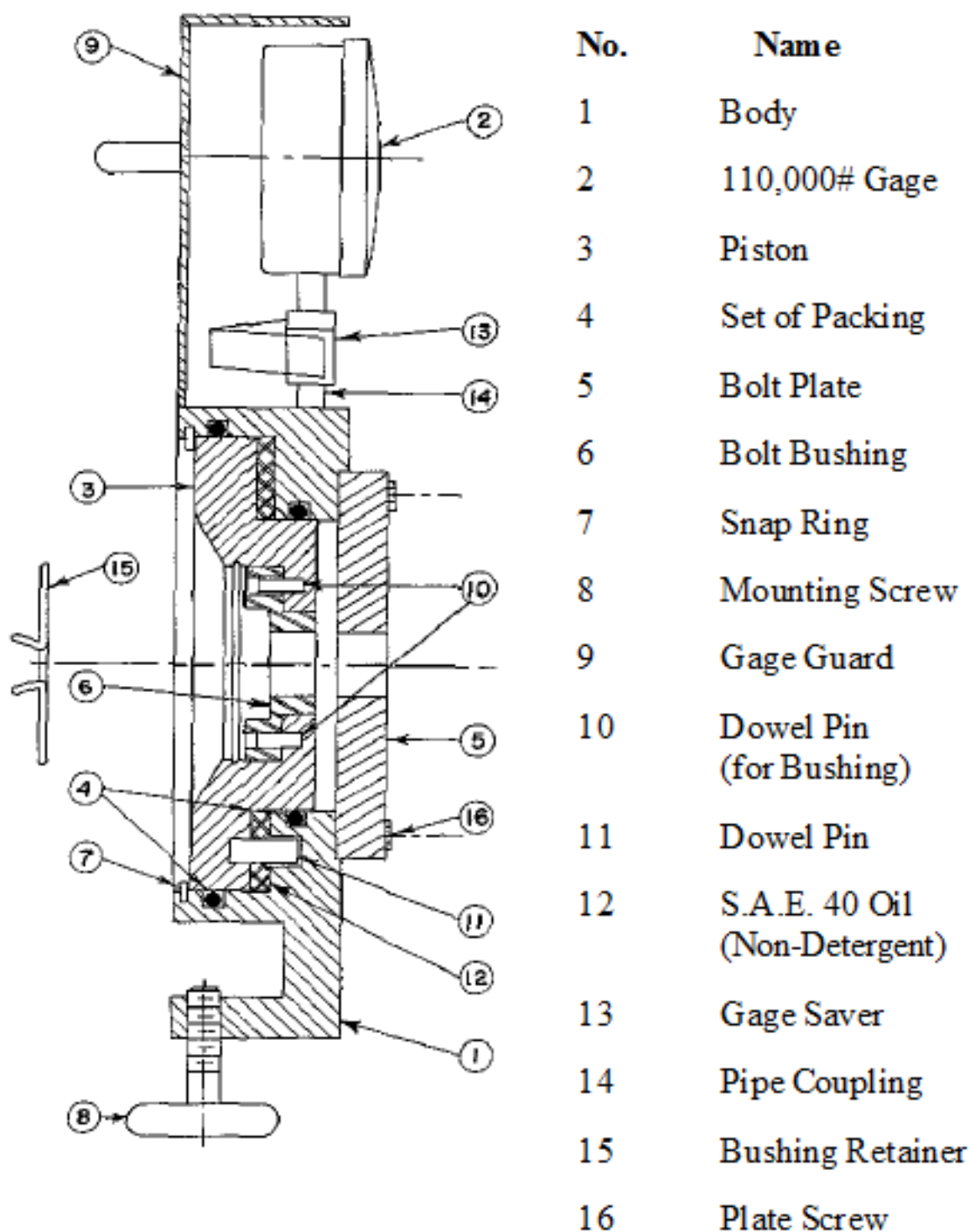


Figure 1—Skidmore-Wilhelm Torque-Wrench Calibration Unit



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**Idaho Standard Practice for****Pavement Straightedge Procedures****IDAHO Designation: IR-87-17**

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**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.*

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**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.

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**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.





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**Idaho Standard Method of Test for**

# Determining Volume of Liquids in horizontal or Vertical Storage Tanks

**IDAHO Designation: IT-120-17**

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**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.*

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**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.

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**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.

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**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:

$$V(gallons) = \frac{\pi D^2}{4} \times L \times 7.48$$

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.

$$Total\ Volume\ Liquid\ (hot) = \frac{V(gallons) \times \% of\ Capacity}{100}$$

#### 4.2. Vertical Tanks

- 4.2.1. Measure the inside diameter of the tank. Calculate the volume per foot as follows.

$$V(gallons) = \frac{\pi D^2}{4} \times 7.48$$

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:

$$Total\ Volume\ Liquid\ (hot) = V(gallons) \times h$$

- 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](#).

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## 5. 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**

% Depth Filled	% of Capacity	% Depth Filled	% of Capacity	% Depth Filled	% of Capacity
1	0.20	34	30.03	67	71.16
2	0.50	35	31.19	68	72.34
3	0.90	36	32.44	69	73.52
4	1.34	37	33.66	70	74.69
5	1.87	38	34.90	71	75.93
6	2.45	39	36.14	72	77.00
7	3.07	40	37.39	73	78.14
8	3.74	41	38.64	74	79.27
9	4.45	42	39.89	75	80.39
10	5.20	43	41.14	76	81.50
11	5.98	44	42.40	77	82.60
12	6.80	45	43.66	78	83.68
13	7.64	46	44.92	79	84.74
14	8.50	47	46.19	80	85.77
15	9.40	48	47.45	81	86.77
16	10.32	49	48.73	82	87.76
17	11.27	50	50.00	83	88.73
18	12.24	51	51.27	84	89.68
19	13.23	52	52.55	85	90.60
20	14.23	53	53.81	86	91.50
21	15.26	54	55.08	87	92.36
22	16.32	55	56.34	88	93.20
23	17.40	56	57.60	89	94.02
24	18.50	57	58.86	90	94.80
25	19.61	58	60.11	91	95.55
26	20.73	59	61.36	92	96.26
27	21.86	60	62.61	93	96.93
28	23.00	61	63.86	94	97.55
29	24.07	62	65.10	95	98.13
30	25.31	63	66.34	96	98.66
31	26.48	64	67.56	97	99.10
32	27.66	65	68.81	98	99.50
33	28.84	66	69.97	99	99.80

Asphalt Institute MS-6

**Table 2 — Weight and Volume Relations [60°F]**

SP. GR.	ENGLISH					
	Pounds per Gallon	Gallons per Ton		SP. GR.	Pounds per Gallon	Gallons per Ton
0.855	7.119	280.9		0.970	8.078	247.6
0.860	7.161	279.3		0.975	8.120	246.3
0.865	7.203	277.7		0.980	8.162	245.0
0.870	7.244	276.1		0.985	8.203	243.8
0.875	7.286	274.5		0.990	8.245	242.6
0.880	7.328	272.9		0.995	8.287	241.4
0.885	7.369	271.4		1.000	8.328	240.2
0.890	7.411	269.9		1.005	8.370	239.0
0.895	7.453	268.4		1.010	8.412	237.8
0.900	7.494	266.9		1.015	8.453	236.6
0.905	7.536	265.4		1.020	8.495	235.4
0.910	7.578	263.9		1.025	8.537	234.3
0.915	7.620	262.5		1.030	8.578	233.1
0.920	7.661	261.1		1.035	8.620	232.0
0.925	7.703	259.6		1.040	8.662	230.9
0.930	7.745	258.2		1.045	8.704	229.8
0.935	7.786	256.9		1.050	8.745	228.7
0.940	7.828	255.5		1.055	8.787	227.6
0.945	7.870	254.1		1.060	8.829	226.5
0.950	7.911	252.8		1.065	8.870	225.5
0.955	7.953	251.5		1.070	8.912	224.4
0.960	7.995	250.2		1.075	8.954	223.4
0.965	8.036	248.9				

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**Idaho Standard Practice for****STRATIFIED RANDOM SAMPLING****IDAHO Designation: IR-148-19**

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**1. SCOPE**

- 1.1. This method sets forth the accepted procedures to be used in the random selection of materials to be sampled and tested.
- 1.2. *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the user's responsibility of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations before use.*

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**2. REFERENCE DOCUMENTS**

- 2.1 *ASTM Standards*
- D3665, Standard Practice for Random Sampling of Construction Materials.

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**3. SIGNIFICANCE AND USE**

- 3.1. The sampling and testing procedures to be followed are specified in the procedures of the tests required.
- 3.2. The sampling of materials is one of the most critical steps in materials testing. If the material to be tested to determine conformity to specifications is not chosen randomly, the tests will not reflect the true characteristics of the material being evaluated. Most specifications require samples to be taken using a stratified, random process. Stratified random sampling requires that 1 random sample is selected from each sub lot or the quantity represented by the minimum sampling frequency. Stratified random sampling ensures that samples are selected uniformly throughout the entire production process.
- 3.3. Random sampling ensures that all produced material will have an equal chance of being selected for testing. No material is excluded from the chance of being selected unless otherwise specified in the test specification.
- 3.4. It is the nature of random testing that some of the samples will represent below average material, just as they will sometimes represent above average material.
- 3.5. Random number schedules will be predetermined using an established random process. The Department has developed a random schedule program that can be used for sampling all construction materials. The random schedule program is found on form finder as ITD-0954. Random number schedules used for sampling must not be shared with the Contractor or supplier before the sample is taken. The Contractor can generate their own random number schedules as needed using the random schedule program. Extra samples may be taken for the Contractor's use at the time of sampling.
- 3.6. Stratified random sampling is called for in most of the Department's specifications. However, some specifications have a minimum sampling frequency of 1 sample per day. Regardless of the quantity produced that day, a minimum of 1 sample is still required. A predetermined random

sampling schedule has no way of predicting what the daily production will be. It is the tester's responsibility to ensure that the minimum sampling frequency is met, based on the actual daily production. Other specifications require a minimum number of samples to be taken regardless of the produced quantity. In these cases, the planned quantity is divided by the number of required samples to determine the sampling frequency. A stratified, random schedule should be generated using the new sampling frequency.

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#### **4. THE DEPARTMENT'S RANDOM SCHEDULE PROGRAM**

- 4.1. The Department's random schedule program is found on form finder as form ITD-0954. It is written in Microsoft® Excel®, and can be used to generate a random sampling schedule for all materials.

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#### **5. GENERATING A RANDOM SAMPLING SCHEDULE**

- 5.1. Open the random schedule program. Enable the macros when asked. Instructions for using the program are included on the instructions worksheet. Read through the instructions before using the program. The program requires that Excel's Analysis ToolPak - VBA be installed before the macros will run properly. Follow the instructions worksheet to install the toolpak.
- 5.2. Move to the "Rand Nos" worksheet. Enter the project information into the green shaded cells. Click the "Clear No's" button to clear the worksheet. Click the "Generate Random Numbers" button to generate a set of random numbers. Click the "Print" button to print the random number schedule.
- 5.3. The random schedule program has the option of generating offset random numbers. Offset numbers are used to find a random transverse location. For example, the correct random location for an asphalt mat density test is the combination of 2 random numbers, the longitudinal (along the length of the pavement) and transverse (across the width of the pavement). The generation of transverse numbers can be turned off by changing the cell for generating offset numbers to "No". The "Transverse Convert" worksheet contains a table that can help you convert the transverse random number into feet and inches based on the pavement width.
- 5.4. The random schedule program can only generate up to 70 numbers at one time. To generate numbers in excess of 70, follow the instructions on the instructions worksheet.
- 5.5. Repeat the steps in Subsection 5.2 to generate a random schedule for all materials and test elements for the project.

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#### **6. COMPLETING THE RANDOM SCHEDULE FORM**

- 6.1. On the project, sample as close as possible to the values represented on the sampling schedule. Fill in the "Taken At" column of the random schedule form as samples are being selected. Major deviations from the sampling schedule should be noted and explained on the form or on additional pages as needed.

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**Idaho Standard Practice for****QUALITY CONTROL PLAN (QCP) DEVELOPMENT AND IMPLEMENTATION****IDAHO Designation: IR-158-19**

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**1. SCOPE**

- 1.1. The purpose of this guide is to establish minimum requirements for the Contractor's quality control system and quality control plan (QCP). It is intended that these requirements be used as a procedural guide in detailing the inspection, sampling, and testing deemed necessary to maintain compliance with the Department's specifications.

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**2. GENERAL REQUIREMENTS**

- 2.1. As stated in the Standard Specifications for Highway Construction, a QCP must be developed by the Contractor/producer and submitted in writing to the Engineer at the preconstruction conference. Acceptance of the QCP by the Engineer will be contingent upon its concurrence with the Standard Specifications and this standard method. For this reason, the QCP will clearly describe the methods by which the quality control program will be conducted. For example, the items to be controlled, tests to be performed, testing frequencies, sampling locations, and techniques will be included with each item listed separately. Also include a table stating what actions will occur when test results indicate specification limits are approached or exceeded. See **Table 1** at end of this guide for an example. Also, a detailed plan of action regarding disposition of non-specification material will be included. Such a plan will provide for immediate notification of all parties involved in the Quality Assurance process in the event nonconforming situations are detected. **Example 1. Quality Control Plan** may be used as an example.
- 2.2. Inspection and testing records must be maintained, kept current, and made available for review by Department personnel throughout the life of the contract. All other documentation, such as date of inspections, tests performed, temperature measurements, and accuracy, calibration or re-calibration checks performed on production of testing equipment, will be recorded.
- 2.3. The Contractor will maintain standard equipment and qualified personnel in accordance with the contract and specification requirements for the item(s) being produced.

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**3. QUALITY CONTROL PLAN**

- 3.1. Operation quality control plans will be submitted for each contract/project to the Engineer for approval. Distribution of the approved quality control plans will be made by the Engineer.
- 3.2. Follow Example 1. Quality Control Plan as a general guideline but at a minimum include the following:
- 3.2.1. Contract bid item covered by the quality control plan.
- 3.2.2. Sampling location and techniques.

- 3.2.3. Sampling plan.
- 3.2.4. Tests and test methods.
- 3.2.5. Testing frequencies.
- 3.2.6. Testing forms to be used.
- 3.2.7. Inspection frequencies and areas of inspection.
- 3.2.8. Detailed description of production and placement equipment and methods.
- 3.2.9. Detailed calibration processes and procedures (if applicable)
- 3.2.10. Documentation procedures, including:
  - 3.2.10.1. Inspection and test record requirements and document management.
  - 3.2.10.2. Temperature measurements.
  - 3.2.10.3. Accuracy, calibration, or recalibration checks performed on production or testing equipment.
- 3.2.11. QC personnel, including the company official ultimately responsible for the quality of work.

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#### **4. ADDENDA TO THE QUALITY CONTROL PLAN**

- 4.1. Addenda are defined as an addition or deletion to the QCP. Each page of the QCP that is revised is required to include the Project key lead number, bid item number, date of revision, and means of identifying the revision. The addenda are required to be signed and dated by the Contractor's representative who is responsible for insuring that all items of work will comply with Department Specifications and subsequently signed and dated when approved by the Engineer.



**EXAMPLE 1** **$\frac{3}{4}$ " Aggregate Type B Base Quality Control Plan**

Date:

To: (RESIDENT ENGINEER)

From: (CONTRACTOR(s) NAME)

Subject:  $\frac{3}{4}$ " Aggregate Type B for Base Quality Control Plan

**1. Project Information**

- 1.1. We are submitting our Quality Control Plan, developed in accordance with Idaho IR 158 for:

Project Number: \_\_\_\_\_

Lead Key Number: \_\_\_\_\_

Bid Item Number: \_\_\_\_\_

Date Submitted: \_\_\_\_\_

- 1.2. (NAME) will be responsible for insuring that all items of work will comply with the contract and Department specifications.

**2. Material Source**

- 2.1. General Information:

Source Number: \_\_\_\_\_

Address of Source: \_\_\_\_\_

- 2.2. The aggregate source operation is under the direction of (NAME) who can be contacted at (ADDRESS, EMAIL, AND TELEPHONE).

- 2.3. (DETAILED DESCRIPTION OF THE PRODUCTION PROCESS)

**3. Delivery and Placement**

- 3.1. The field operation is under the direction of (NAME) who can be contacted at (ADDRESS, EMAIL, AND TELEPHONE).

- 3.2. (LIST OF EQUIPMENT TYPE, YEAR, MAKE, MODEL)

- 3.3. (DETAILED DESCRIPTION OF THE PLACEMENT PROCESS)

**4. Quality Control Sampling and Testing,**

- 4.1. The laboratory performing quality control testing is (LAB QUALIFICATION NUMBER), located at (LOCATION).

- 4.2. The quality control program is under the direction of (NAME OF PERSON), who can be contacted at (ADDRESS, EMAIL, AND TELEPHONE).
- 4.3. During the production operations of the aggregate we will perform at a minimum quality control tests per attached schedule. Sampling and testing will be the responsibility of (NAME(s), WAQTC number (NUMBER(s)).
- 4.4. During the placement operations of the aggregate (NAMES) will perform, at a minimum, quality control tests in accordance with the attached schedule. Also attached are the proposed method to select locations and/or times for sampling.
- 4.5. All testing will be completed by (NAME(s)), (WAQTC NUMBER(s)), within (HOURS) hours of sampling and all original documentation of results will be completed on the attached original documentation forms.
- 4.6. Testing reports and original source documents will be reviewed and checked by (NAME(s)), (WAQTC NUMBER(s)), within (HOURS) hours of testing being completed. All reporting will be completed on the attached forms.

## **5. Records.**

- 5.1. Testing reports and all backup documentation will be located at (LOCATION) for review by the Department between the hours of (TIME) and (TIME) during the life of the contract/project.
- 5.2. Testing reports and all backup documentation will be located at (LOCATION) for review by the Department between the hours of (TIME) and (TIME) for (YEARS) after the completion of the project.

## **6. Notifications.**

- 6.1. Any material found to be noncomplying will be addressed by (NAME) who will notify the Engineer immediately.
- 6.2. (NAME) will notify all appropriate Department personnel at least 48 hours before any work is to begin.

## **7. Nonconforming Material.**

- 7.1. (STATE THE PROCESS FOR DISPOSITION OF NONCONFORMING MATERIAL)

Table 1: Example of QC Actions to Implement When Approaching or Exceeding Specification Limits

Test Description	Test Method	QC Action Limits		Situation		Action
		Single Test	4-Point Moving Avg. or Daily Avg.	Single Test	4-Point Moving Avg. or Daily Avg.	
Aggregate Gradation	FOP for AASHTO T 27 and AASHTO T 11	NA	Approaching Limit	5 percent on + #4 3 percent on - #4	Approaching Limit	Increase frequency of tests and prepare for process modification
Sand Equivalent	FOP for AASHTO T 76	NA	Approaching Limit	NA	Approaching Limit	Increase frequency of tests and prepare for process modification

Note: When 2 consecutive test results fail or if any of the 4-point moving average values fail, production will be suspended and corrective action will be taken. The process will be corrected before production resumes.



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**Idaho Standard Practice for****QUALITY CONTROL PLAN (QCP) REVIEW PROCESS****IDAHO Designation: IR-159-19**

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**1. SCOPE**

- 1.1. The purpose of this process is to establish a standard for reviewing the Contractor's quality control plan (QCP).

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**2. REFERENCE DOCUMENTS**

- 2.1. Idaho Standards:
- IR 158, Quality Control Plan Development and Implementation

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**3. GENERAL REQUIREMENTS**

- 3.1. As stated in the Department's Standard Specifications for Highway Construction, a QCP must be developed in accordance with Idaho IR 158 by the Contractor/producer and submitted in writing to the Engineer at the preconstruction conference. Acceptance of the QCP by the Engineer will be contingent upon its concurrence with the Standard Specifications and this standard method.

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**4. MINIMUM REQUIREMENTS OF A QUALITY CONTROL PLAN**

- 4.1. Requirements shown in Idaho IR 158.
- 4.2. Subsection 106.03.A.2 of the Standard Specifications
- 4.3. Requirements of the contract bid item covered by the quality control plan.
- 4.4. Sampling location and techniques.
- 4.5. Sampling plan.
- 4.6. Tests and test methods.
- 4.7. Testing frequencies.
- 4.8. Testing forms to be used, including examples.
- 4.9. Inspection frequencies and areas of inspection.
- 4.10. Detailed description of production and placement equipment and methods.
- 4.11. Detailed calibration processes and procedures (if applicable).
- 4.12. Documentation procedures, including:
- 4.12.1. Inspection and test record requirements and document management.

- 4.12.2. Temperature measurements.
- 4.12.3. Accuracy, calibration, or recalibration checks performed on production or testing equipment.
- 4.13. QC personnel, including the company official ultimately responsible for the quality of work.
- 4.14. Processes for addressing non-conforming material.

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**5. REVIEW OF THE QUALITY CONTROL PLAN**

- 5.1. Review the quality control plan to ensure it meets the minimum requirements in Section 4 and that adequate quality control measures are in place for the specific project.

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**6. REVIEW OF ADDENDA TO THE QUALITY CONTROL PLAN**

- 6.1. Addenda are defined as an addition or deletion to the QCP. Each page of the QCP that is revised is required to include the project key lead number, bid item number, date of revision, and means of identifying the revision. The addenda are required to be signed and dated by the Contractor's representative who is responsible for insuring that all items of work will comply with the Department's specifications.
- 6.2. Review addenda to the quality control plan to ensure the revised QCP meets the minimum requirements and that adequate quality control measures are in place for the specific project.

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**7. APPROVAL OF THE QUALITY CONTROL PLAN**

- 7.1. The QCP and each addenda will be approved only once the minimum requirements have been met.
- 7.2. The QCP, and addenda if applicable, as approved by the Department, is binding upon the Contractor as a contract requirement.

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**Idaho Standard Practice for****DEVELOPMENT, EVALUATION, AND APPROVAL  
OF HMA PLANT QUALITY CONTROL PLANS****IDAHO Designation: IR-160-19**

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**1. SCOPE**

- 1.1. This procedure covers requirements for plants producing hot mix asphalt (HMA) or warm mix asphalt (WMA) paving mixtures. The requirements in this procedure are the minimum requirements for a plant to meet 405.03.E of the Department's Standard Specifications for Highway Construction ("Standard Specifications").
- 1.2. *This procedure may involve hazardous materials, operations, and equipment and may not address all of the safety problems associated with the use of the test method. The user of this Idaho Standard Practice is responsible for establishing the appropriate safety and health practices and determining the applicability of regulatory limitations before use.*

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**2. REFERENCE DOCUMENTS**

- 2.1. AASHTO Standards:
- M 156, Standard Specifications for Requirements for Mixing Plants for Hot-Mixed, Hot-Laid Bituminous Paving Mixtures
  - R 66, Sampling Asphalt Materials
  - T 19M/T 19, Bulk Density ("Unit Weight") and Voids in Aggregate
  - T 27, Sieve Analysis of Fine and Coarse Aggregates
  - T 30, Mechanical Analysis of Extracted Aggregate
  - T 84, Specific Gravity and Absorption of Fine Aggregate
  - T 166, Bulk Specific Gravity ( $G_{mb}$ ) of Compacted Asphalt Mixtures Using Saturated Surface-Dry Specimens
  - R 97, Sampling Asphalt Mixtures
  - T 209, Theoretical Maximum Specific Gravity ( $G_{mm}$ ) and Density of Hot Mix Asphalt (HMA)
  - T 283, Resistance of Compacted Asphalt Mixtures to Moisture-Induced Damage
  - T 308, Determining the Asphalt Binder Content of Asphalt Mixtures by the Ignition Method
  - T 312, Preparing and Determining the Density of Asphalt Mixture Specimens by Means of the Superpave Gyratory Compactor

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**3. TERMINOLOGY**

- 3.1. Check—A specific type of inspection or measurement performed on equipment or materials to indicate compliance with the stated criteria (e.g., lime check, calibration check of the cold feed system).
- 3.2. Continuous Mix Plant—A manufacturing facility for producing asphalt paving mixtures that continuously proportions the aggregate, asphalt binder, and other chosen additives into the mix by a continuous volumetric proportioning system without definite batch intervals.
- 3.3. Drum Mix Plant—A manufacturing facility for producing asphalt paving mixtures that continuously proportions the aggregate, heats and dries it in a rotating drum, adds any chosen additives, and simultaneously mixes the material with a controlled amount of asphalt binder.
- 3.4. Hot Mix Plant (or Plant)—Any manufacturing facility used to produce asphalt paving mixtures.
- 3.5. Interlock—A system whereby plant production will be interrupted when any one of the interlocked raw material constituents fails to meet the targeted requirements established within the specifications or plant requirements.

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**4. PLANT REQUIREMENTS**

- 4.1. Prerequisite for Plant Approval:
- 4.1.1. Inspection of Equipment—The plant owner or manager will schedule an inspection of the plant facilities to determine compliance with this standard. The equipment will be maintained in a satisfactory operating condition and be capable of its intended function at all times during production.
- 4.1.2. Quality Control Program—Each plant will have a quality control program and have a designated person to administer the program. This program will include the testing and control of the individual component materials and the final product produced at the plant. Plant operations will be conducted in a manner to ensure a uniform product is produced which will meet specified requirements.
- 4.1.3. Truck Scales—Scales must meet the requirements of 109.01.A.6.b of the Standard Specifications.
- 4.1.4. Uniformity—The plant must be capable of producing homogenous asphalt mixtures even though the individual components include such diverse materials as various sizes of aggregate from stockpiles, reclaimed asphalt pavement (RAP), asphalt binder, and other admixtures, as required by the mix design.

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**5. WEIGHT MEASURING SYSTEMS**

- 5.1. Furnish (at the Contractor's expense) platform scales to weigh bulk asphalt plant mixtures, regardless of the type of weight measuring system used for payment.
- 5.2. Ensure that the documentation for platform scales complies with state and/or federal requirements. Platform scales must be certified at a minimum every 6 months, or at a frequency required by state and/or federal requirements. Platform scales must be certified/re-certified if they are moved or relocated.
- 5.3. Each platform scale system must be capable of taring truck weights with each load.



- 5.4. When not using platform scales, provide calibrated weighing devices that record the mixture's net weight delivered to the truck. Weighing devices will be calibrated at a minimum before the start of the paving season and each time a plant is moved to a new location. The weight of produced mixture should be verified periodically by platform scales. A net weigh system will include, but is not limited to, the following:
  - 5.4.1. Hopper weigh system that delivers asphalt mixture directly to the truck.
- 5.5. The weighing system used to determine the net weight will have a printing system used in conjunction with automatic mixing systems. All printing systems must be approved by the engineer.
- 5.6. Verify adequate installation of the net weight scale mechanism or device by the manufacturer to ensure acceptable performance and operation.
- 5.7. Provide information on the project tickets per Section 109.01 of the Standard Specifications.
- 5.8. Certify the accuracy of the weighing system by an approved registered scale service person at least once every 6 months or whenever the plant is moved or relocated. Verify by an independent calibrated or certified scale the accuracy of the weighing system at the beginning of project production and thereafter as directed by the Engineer.

---

## **6. EQUIPMENT FOR PREPARATION OF ASPHALT BINDER**

- 6.1. Tanks for storage of asphalt binder must provide adequate capacity to ensure proper continuous circulation between the storage tank and proportioning units during the entire operating period.
- 6.2. The circulating system for the asphalt binder must have adequate capacity to provide proper continuous circulation between the storage tank and proportioning units during the entire operating period.
- 6.3. Storage tank capacity must ensure continuous operation of the plant and uniform temperature of the asphalt binder when it is introduced into the aggregate. Metering devices must be calibrated accurately to within 1 percent of the actual weight being measured and must be accessible for measuring the volume of binder material at any time. Any additives based on liquid volume must be interlocked with the plant to result in a plant shutdown during no-flow conditions.
- 6.4. A sampling valve must be provided in the asphalt binder feed lines connecting the storage tanks to the asphalt binder control unit. The valve will be located in such a manner as to allow for maximum safety to the person drawing the sample. A sampling valve must also be provided on each individual tank.
- 6.5. Any tank used for storing polymer-modified asphalt binders must be equipped with an agitation system to ensure the liquid asphalt is maintained in a homogenous state without separation.
- 6.6. The mechanisms used to introduce WMA additives to asphalt mixture at the mixture plant must be capable of uniformly feeding and metering the additive. WMA additives typically consist of additives added at the binder production facility, dry material added through cold feeds, or water injection. Depending on the type of WMA process, the plant must be equipped with automatic controls to monitor the feed system and interrupt plant production if there is an interruption in the feed process. Equipment used to produce WMA must be approved by the Engineer before mixture production.

---

**7. COLD AGGREGATE FEEDERS**

- 7.1. A mechanism that must be capable of uniformly feeding the aggregates into the dryer to ensure uniform production and temperature. The mechanism must be capable of accurately blending aggregates from different storage bins.
- 7.2. Cold bins for storing aggregates before proportioning will be monitored to ensure that bins do not become empty or restricted. The bins will be interlocked so that a production interruption will occur if an interruption in supply of material from any cold feed occurs.
- 7.3. Adequate and convenient facilities must be provided for obtaining samples of the full flow of aggregate from each cold feed bin and from the total of the bins.
- 7.4. Control will be based on frequent samples from each component aggregate as well as samples taken from the combined cold aggregate feeders.
- 7.5. All plants are to be equipped with a means of diverting aggregate on the conveyor belt away from the dryer and into an empty haul truck for cold bin calibration purposes.

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**8. RECLAIMED ASPHALT PAVEMENT (RAP)**

- 8.1. The recycled mixture will be a homogenous mixture of RAP, virgin aggregate, hydrated lime (if required), asphalt binder, and any additives. If recycling capability is required, the plant will be equipped with mechanical means for feeding the desired weight of RAP into the mix.
- 8.2. RAP bins for storing material before proportioning will be monitored to ensure that the bins do not become empty or restricted. The bins will be interlocked so that a production interruption will occur if any interruption in supply of material from any cold feed occurs.
- 8.3. Adequate and convenient facilities will be provided for obtaining samples of the full flow of RAP material from each RAP bin.
- 8.4. Use a hot mix plant for the recycling process with necessary modifications to process the recycled material. The ratio of the RAP to virgin aggregate will be controlled by weight.
- 8.5. For drum and continuous mix plants, use electronic belt weighing devices to monitor the flow of RAP and the flow of virgin aggregate.
- 8.6. Equip plants with an interlocking system of feeders and conveyors that synchronize the RAP flow with the virgin aggregate flow. Ensure that the electronic controls monitor the flow rates indicated by the belt weighing devices and automatically maintain the desired ratio at varying production rates. Design the RAP feeder bins, conveyor system, and auxiliary bins (if used) to prevent the material from segregating and sticking. RAP will be screened before crossing the weigh bridge with a 2-inch or larger screen.

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**9. EMISSIONS CONTROLS FOR DUST COLLECTOR FINES**

- 9.1. A dust collection system must be provided. The system will be made to waste the material collected, or to return all or any part of the collected material uniformly to the mixture.
- 9.2. Other emissions, such as smoke with the exception of water vapor, will be controlled to be in compliance with applicable environmental limits.
- 9.3. *Control the dust collection as follows:*

- 9.3.1. When collecting airborne aggregate particles and returning them to the mixture, ensure the return system delivers all or part of the collected dust uniformly into the aggregate mixture and wastes the excess. The percentage of collected dust returned to the mixture is subject to the Engineer's approval.
- 9.3.2. When the collected dust is returned directly to the hot aggregate flow, interlock the dust feeder with the hot aggregate flow in order to maintain a constant, proportioned, and uniform flow.

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## **10. SURGE AND STORAGE SYSTEMS**

- 10.1. *Provide surge and storage bins as follows:*
- 10.1.1. Ensure that bins for mixture storage are insulated and have a working seal, top, and bottom to prevent outside air infiltration and to maintain an inert atmosphere during storage. Bins not intended for storage may be used as surge bins to hold asphalt mixtures for part of the working day; however, empty these surge bins completely at the end of each working day.
- 10.1.2. Ensure that surge and storage bins can retain a predetermined minimum level of mixture in the bin when trucks are loaded. All surge and storage bins must have a heated gate system.
- 10.1.3. Ensure that surge and storage systems do not contribute to mix segregation, loss of homogeneity, lumpiness, temperature loss, draindown, or stiffness.
- 10.2. A plant may be permitted to store asphalt mixtures in a silo after prior evaluation and approval by the Engineer. Use will conform with all limitations on retention time, type of mixture, heater operation, silo atmosphere, mix level, mix draindown time, or other characteristics set forth in the applicable specifications.
- 10.3. Approval of silos may be removed or restrictions may be applied if it is determined the silo contributes to segregation, does not maintain temperature, or fails in any other way to provide a homogeneous mix.

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## **11. MINERAL FILLER**

- 11.1. *When mineral filler is required as a mixture ingredient:*
- 11.2. Use a separate bin and feed system to store and proportion the required quantity into the mixture with uniform distribution.
- 11.3. *Control the feeder system with a proportioning device that meets the following:*
- 11.3.1. Is accurate to within  $\pm 10$  percent of the filler required by weight.
- 11.3.2. Has a convenient and accurate means of calibration.
- 11.3.3. Interlocks with the aggregate feed or weigh system to maintain the correct proportions for all rates of production.
- 11.4. Provide flow indicators or sensing devices for the mineral filler system and interlock them with the plant controls to interrupt mixture production if the mineral filler introduction fails to meet the required target value after no longer than 60 seconds.
- 11.5. *Add mineral filler to the mixture as follows, according to the plant type:*

- 11.5.1. Continuous Plants Using Dryer Drum Mixtures—Add the mineral filler so that the dry mixing is accomplished no less than 18 inches before the addition of the asphalt binder and ensure that the filler does not become entrained into the air stream of the dryer.

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## **12. HYDRATED LIME TREATMENT SYSTEM**

- 12.1. *When hydrated lime is required as a mixture ingredient:*
- 12.2. Use a separate bin and feed system to store and proportion the required quantity into the mixture.
- 12.3. Ensure that the aggregate is uniformly coated with hydrated lime at least 18 inches before the addition of the asphalt binder to the mixture. Ensure the hydrated lime does not become entrained in the exhaust system of the dryer or plant.
- 12.4. *Control the feeder system with a proportioning device that meets the following:*
- 12.4.1. Is accurate to within  $\pm 10$  percent of the hydrated lime required by weight.
- 12.4.2. Has a convenient and accurate means of calibration.
- 12.4.3. Interlocks with the aggregate feed or weigh system to maintain the correct proportions for all rates of production to ensure mixture produced is properly treated with lime.
- 12.5. Provide flow indicators or sensing devices for the hydrated lime system and interlock them with the plant controls to interrupt mixture production if hydrated lime introduction fails to meet the required target value after 60 seconds.

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## **13. FIBER SUPPLY SYSTEM**

- 13.1. *When stabilizing fiber is required as a mixture ingredient:*
- 13.2. Use a separate bin and feed system to store and uniformly proportion by weight the required quantity of fiber into the mixture.
- 13.3. Control the feeder system with a proportioning device that meets the following:
- 13.3.1. Is accurate to within  $\pm 10$  percent of the fiber required by weight. Automatically adjust the feed rate to maintain the material within this tolerance at all times.
- 13.3.2. Has a convenient and accurate means of calibration.
- 13.3.3. Provides in-process monitoring, consisting of a digital display of output of feed rate, in pounds (kilograms) per min, to verify feed rate.
- 13.3.4. Interlocks with the aggregate feed or weigh system to maintain the correct proportions for all rates of production.
- 13.4. Provides flow indicators or sensing devices for the fiber system and interlocks them with the plant controls to interrupt mixture production if the fiber introduction fails to meet the required target value.
- 13.5. *Introduce the fiber as follows, according to the plant type:*

- 13.5.1. When a continuous or dryer-drum-type plant is used, add the fiber uniformly to the aggregate and disperse it before the injection of the asphalt binder. Ensure the fibers will not become entrained in the exhaust system of the dryer.

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## **14. CALIBRATION OF PLANT EQUIPMENT**

- 14.1. Calibration of the plant must meet Idaho IR 155.
- 14.2. *Calibration will occur, at a minimum:*
- 14.2.1. If the material changes, or if a plant component supply system affecting the ingredient proportions has been repaired, replaced, or adjusted, recalibrate the proportions.
- 14.3. *Calibrate the mixing plant as follows:*
- 14.3.1. Before producing mixture for the project, calibrate by scale weight the electronic sensors or settings for proportioning the mixture ingredients.
- 14.3.2. Calibrate the ingredient proportioning for all rates of production.

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## **15. THERMOMETRIC EQUIPMENT**

- 15.1. Provide appropriate recording thermometers, of suitable temperature ranges, to accurately assess the temperature of the asphalt mixture at or near the discharge point. Harden the thermometer mechanism as necessary to ensure durability of the device and continuous operation. Thermometers must be calibrated by the manufacturer for the full range of mixture production temperatures. The thermometers must be verified periodically during production to ensure their accuracy.
- 15.2. Provide appropriate thermometric devices to measure the temperature at the discharge chute of the dryer, to display the temperature, and to record the temperature data automatically.

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## **16. PLANT LABORATORY**

- 16.1. The plant laboratory will have the minimum equipment necessary to perform the QC testing required.

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## **17. DEVELOPING AND MAINTAINING A PLANT QUALITY CONTROL PLAN**

- 17.1. Develop and maintain a Plant Quality Control Plan (Plant QCP). The plant must have an approved Plant QCP prior to the plant being used on Department projects. This plan must address each section of this procedure and describe how these requirements will or will not be met.
- 17.1.1. If any of the minimum requirements cannot be met; describe in explicit detail why, and how, the plant will mitigate any adverse effects from deviation of this procedure's minimum requirements.
- 17.2. See Section 20 (Plant QCP template) for a template of the plant quality control plan.

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## **18. PLANT QCP REVIEW**

- 18.1. The Department will review the Plant QCP at a minimum of once per calendar year.

- 18.2. Review the Plant QCP to ensure all requirements in the previous sections are met or that adequate processes and procedures are in place to mitigate any adverse effects (See Section 17.1.1)

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**19. PLANT QCP APPROVAL**

- 19.1. If the Plant QCP review finds that the plant's quality control plan is sufficient to ensure a quality product will be produced, the Plant QCP will be approved.
- 19.2. If the Plant QCP is approved, return a signed copy of the Plant QCP to the plant. The approval is valid for one calendar year.

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**20. PLANT QCP TEMPLATE**

Company Name:

Year:

# Plant Quality Control Plan

Quality Control Plan Administrator

Name

Contact Information

Reviewed By:

Reviewed Date:

Approved By:

Approval Date:

## Quality Control Plans for Plants

### Template

1. Plant Description
  - a. Plant Type (Drum/Batch)
  - b. Plant Address
  - c. Detailed narrative meeting the requirements of Subsection 17.1 and 17.1.1
2. Plant Laboratory Personnel
  - a. Qualified Personnel/Contact Information/WAQTC#/ Exp. Date (Scanned Copy)
3. Laboratory Qualification
  - a. Idaho Lab Qualification Number
    - i. Date last completed
    - ii. Certification Posted in Laboratory
  - b. AMRL accreditation (if applicable)
    - i. Date last completed
4. Plant Inspection
  - a. Performed Yearly
    - i. Certification is posted at plant
  - b. Plant complies with Idaho IR 160
5. Truck Scales
  - a. Calibration Frequency
  - b. Testing agency – copies on file
6. Plant Weighing/Measuring Devices
  - a. Calibration frequency
  - b. Testing agency – copies on file
7. Aggregate Stockpiles
  - a. Construction Method
    - i. Separation/Labeling
    - ii. Segregation Control
    - iii. Moisture Control (if applicable)
  - b. Testing (method/frequency)
8. RAP stockpile
  - a. Construction methods of stockpiles
    - i. Separation/Labeling
    - ii. Segregation Control
    - iii. Moisture Control (if applicable)



- b. Testing (method/frequency)
- 9. Plant Mix Temperatures
  - a. Plant Monitor/Control
  - b. Temperature checks
- 10. Binder
  - a. Storage
  - b. Hauling
  - c. Sampling (include location)
  - d. Source Change – Notification/Start-up testing
  - e. List how corrective action will be taken
- 11. Asphalt Mix Design
  - a. Responsibility
- 12. Asphalt Mix Sampling
  - a. Location for QC
  - b. Plant check processes and procedures
  - c. Sampling frequency
    - i. Low tonnage (< 200 tons)
    - ii. > 200 tons
- 13. Mix Gradation
  - a. Test method
- 14. Asphalt Content
  - a. Test method
- 15. Volumetric Properties
  - a. Test methods
- 16. Mix Diagnostic and Corrective Action Plan
  - a. Items to address: #13-15, and on-site density
- 17. Project Records – Idaho Standard Specs. 106.03.A.2.
  - a. Maintain and make available to the Engineer upon request complete records (including hand written worksheets) of sampling, testing, actions taken to correct problems, and quality control inspection results. Provide copies of the Reports when requested.
  - b. Control Charts
- 18. Truck Loading
  - a. Loading method
- 19. Warm Mix Capabilities (if applicable)
  - a. Plant used for WMA?
  - b. Type: Foamed, Additive, etc.

20. Anti-Strip

- a. Type/Brand
- b. Method of dosing

It is hereby certified that the information contained in this Plant Quality Control Plan meets the requirements of Idaho IR 160.

Company Name:

Signature:

First & Last Name:

Quality Control Plan Administrator

## **SAMPLING AGGREGATE PRODUCTS FOP FOR AASHTO R 90**

### **Scope**

This procedure covers sampling of coarse, fine, or a combination of coarse and fine aggregates (CA and FA) in accordance with AASHTO R 90-18. Sampling from conveyor belts, transport units, roadways, and stockpiles is covered.

### **Apparatus**

- Shovels or scoops, or both
- Brooms, brushes, and scraping tools
- 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**

<b>Nominal Maximum Size*</b>		<b>Minimum Mass</b>	
<b>mm (in.)</b>		<b>g (lb)</b>	
90	(3 1/2)	175,000	(385)
75	(3)	150,000	(330)
63	(2 1/2)	125,000	(275)
50	(2)	100,000	(220)
37.5	(1 1/2)	75,000	(165)
25.0	(1)	50,000	(110)
19.0	(3/4)	25,000	(55)
12.5	(1/2)	15,000	(35)
9.5	(3/8)	10,000	(25)
4.75	(No. 4)	10,000	(25)
2.36	(No. 8)	10,000	(25)

\* 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)**

- Obtain sample before spreading.
- 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.
- Obtain full cross-section samples of approximately equal size at each location. Take care to exclude the underlying material.
- 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)**

- Obtain sample after spreading and before compaction.
- Take the increments from at least three random locations.
- Obtain full-depth increments of approximately equal size from each location. Take care to exclude the underlying material.
- 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.

**Identification and Shipping**

- Identify samples according to agency standards.
- Include sample report (below).
- Ship samples in containers that will prevent loss, contamination, or damage of material.

**Report**

- On forms approved by the agency
- Date
- Time
- Sample ID
- Sampling method
- Location
- Quantity represented
- Material type
- Supplier





**PERFORMANCE EXAM CHECKLIST****SAMPLING AGGREGATE PRODUCTS  
FOP FOR AASHTO R 90**

Participant Name \_\_\_\_\_ Exam Date \_\_\_\_\_

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

<b>Procedure Element</b>	<b>Trial 1</b>	<b>Trial 2</b>
<b>Conveyor Belts – Method A (From the Belt)</b>		
1. Belt stopped?	_____	_____
2. Sampling template set on belt, avoiding intrusion of adjacent material?	_____	_____
3. Sample, including all fines, scooped off?	_____	_____
4. Samples taken in at least three approximately equal increments?	_____	_____
<b>Conveyor Belts – Method B (From the Belt Discharge)</b>		
5. Sampling device passed through full stream of material twice (once in each direction) as it runs off end of belt?	_____	_____
<b>Transport Units</b>		
6. Unit divided into four quadrants?	_____	_____
7. Increment obtained from each quadrant, 0.3 m (1ft.) below surface?	_____	_____
8. Increments combined to make up the sample?	_____	_____
<b>Roadways Method A (Berm or Windrow)</b>		
9. Sample taken before spreading?	_____	_____
10. Full depth of material taken?	_____	_____
11. Underlying material excluded?	_____	_____
12. Samples taken in at least three approximately equal increments?	_____	_____
<b>Roadways Method B (In-place)</b>		
13. Sample taken after spreading?	_____	_____
14. Full depth of material taken?	_____	_____
15. Underlying material excluded?	_____	_____
16. Samples taken in at least three approximately equal increments?	_____	_____

**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 \_\_\_\_\_

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Examiner Signature \_\_\_\_\_ WAQTC #: \_\_\_\_\_

**PERFORMANCE EXAM CHECKLIST (ORAL)****SAMPLING OF AGGREGATE PRODUCTS  
FOP FOR AASHTO R 90**

Participant Name \_\_\_\_\_ Exam Date \_\_\_\_\_

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

<b>Procedure Element</b>	<b>Trial 1</b>	<b>Trial 2</b>
<b>1. How is a sample obtained from a conveyor belt using Method A?</b>		
a. Stop the belt.	_____	_____
b. Set the sampling template on belt, avoiding intrusion of adjacent material.	_____	_____
c. All the material is removed from belt including all fines.	_____	_____
d. Take at least approximately three equal increments.	_____	_____
<b>2. How is a sample obtained from a conveyor belt using Method B?</b>		
a. Pass the sampling device through a full stream of material as it runs off the end of the belt.	_____	_____
b. The device must be passed through at least twice (once in each direction).	_____	_____
<b>3. How is a sample obtained from a Transport Unit?</b>		
a. Divide the unit into four quadrants.	_____	_____
b. Dig 0.3 m (1 ft.) below surface.	_____	_____
c. Obtain an increment from each quadrant.	_____	_____
<b>4. Describe the procedure for sampling from roadways Method A (Berm or Windrow).</b>		
a. Sample before spreading	_____	_____
b. Sample the material full depth without obtaining underlying material.	_____	_____
c. Take at least three approximately equal increments.	_____	_____

**OVER**

Procedure Element	Trial 1	Trial 2
<b>5. Describe the procedure for sampling from roadway Method B (In-place).</b>		
a. Sample after spreading, before compaction.	_____	_____
b. Sample the material full depth without obtaining underlying material.	_____	_____
c. Take at least three approximately equal increments.	_____	_____
<b>6. Describe the procedure for sampling a stockpile Method A (Loader Sampling).</b>		
a. Loader removes contaminates and creates sampling pile.	_____	_____
b. Loader back drags pile to create a flat surface.	_____	_____
c. Divide the flat surface into four quadrants.	_____	_____
d. Take an approximately equal increment from each quadrant, excluding the underlying material.	_____	_____
<b>7. Describe the procedure for sampling a stockpile Method B (Stockpile Face Sampling).</b>		
a. Create horizontal surfaces with vertical faces with a shovel.	_____	_____
b. At least one increment taken from each of the top, middle, and bottom thirds of the stockpile.	_____	_____
<b>8. Describe the procedure for sampling a stockpile Method C – Alternate Tube Method (Fine Aggregate).</b>		
a. Remove the outer layer of segregated material.	_____	_____
b. Obtain increments from at least five locations.	_____	_____
<b>9. After obtaining the increments what should you do before performing R 76?</b>		
a. Increments mixed thoroughly to form sample.	_____	_____

Comments: First attempt: Pass\_\_\_\_\_Fail\_\_\_\_\_ Second attempt: Pass\_\_\_\_\_Fail\_\_\_\_\_

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Examiner Signature \_\_\_\_\_ WAQTC #: \_\_\_\_\_

## **REDUCING SAMPLES OF AGGREGATES TO TESTING SIZE FOP FOR AASHTO R 76**

### **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.

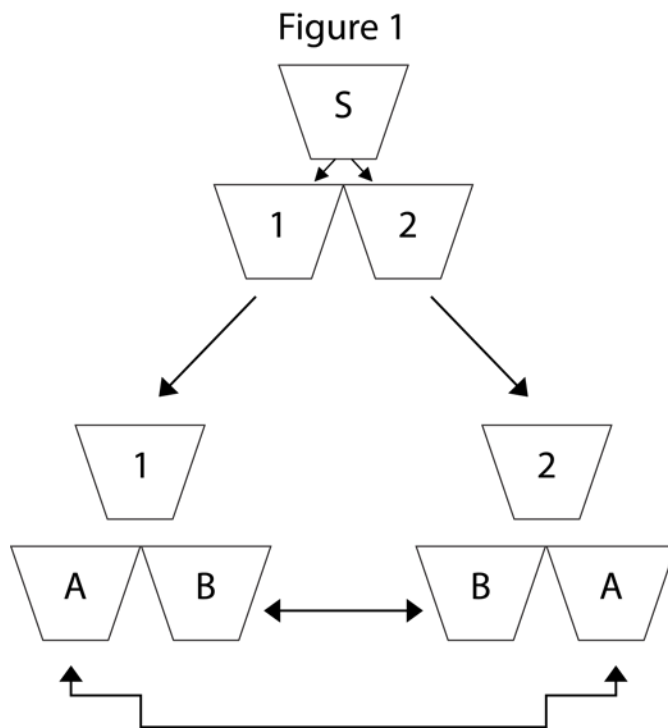
**Table 1**

	<b>Drier than SSD</b>	<b>Wetter than SSD</b>
Fine Aggregate (FA)	Method A (Mechanical)	Method B (Quartering)
Mixture of FA/CA	Either Method	Method B (Quartering)
Coarse Aggregate (CA)	Either Method	Either Method

## 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.



- 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

$$\frac{\text{Smaller Mass}}{\text{Larger Mass}} = \text{Ratio} \quad (1 - \text{ratio}) \times 100 = \% \text{ Difference}$$

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. Chutes appropriate size and number?                                  | _____ | _____ |
| 2. Material spread uniformly on feeder?                                 | _____ | _____ |
| 3. Rate of feed slow enough so that sample flows freely through chutes? | _____ | _____ |
| 4. 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 without loss of material?  | _____ | _____ |
| 4. Pile flattened to uniform thickness and diameter?  | _____ | _____ |
| 5. Diameter equal to about 4 to 8 times thickness?  | _____ | _____ |
| 6. Divided into 4 equal portions with shovel or trowel without loss of material?                | _____ | _____ |
| 7. Two diagonally opposite quarters, including all fine material, removed?                      | _____ | _____ |
| 8. 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\_\_\_\_

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**Examiner Signature** \_\_\_\_\_ **WAQTC #:** \_\_\_\_\_



## **TOTAL EVAPORABLE MOISTURE CONTENT OF AGGREGATE BY DRYING FOP FOR AASHTO T 255**

### **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 R 90 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**

<b>Nominal Maximum Size* mm (in.)</b>	<b>Minimum Sample Mass g (lb)</b>
150 (6)	50,000 (110)
100 (4)	25,000 (55)
90 (3 1/2)	16,000 (35)
75 (3)	13,000 (29)
63 (2 1/2)	10,000 (22)
50 (2)	8000 (18)
37.5 (1 1/2)	6000 (13)
25.0 (1)	4000 (9)
19.0 (3/4)	3000 (7)
12.5 (1/2)	2000 (4)
9.5 (3/8)	1500 (3.3)
4.75 (No. 4)	500 (1.1)

\* 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:
  - a. Controlled heat source (oven): at  $110 \pm 5^{\circ}\text{C}$  ( $230 \pm 9^{\circ}\text{F}$ ).
  - 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 (w) 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 2**  
**Methods of Drying**

Heat Source	Specific Instructions	Drying intervals to achieve constant mass (minutes)
<b>Controlled:</b> Forced Draft Oven (preferred), Ventilated Oven, or Convection Oven	$110 \pm 5^{\circ}\text{C}$ ( $230 \pm 9^{\circ}\text{F}$ )	30
<b>Uncontrolled:</b>		
Hot plate, Infrared heater, etc.	Stir frequently	10
Microwave	Heap sample and cover with ventilated lid	2



**Calculation****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

$M_n$  = 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

$$\% \text{ Change} = \frac{1405.1 \text{ g} - 1402.0 \text{ g}}{1405.1 \text{ g}} \times 100 = 0.22\%$$

*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

$$\% \text{ Change} = \frac{1402.0 \text{ g} - 1400.9 \text{ g}}{1402.0 \text{ g}} \times 100 = 0.08\%$$

*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:

$$w = \frac{M_W - M_D}{M_D} \times 100$$

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

$$w = \frac{1532.6 \text{ g} - 1401.4 \text{ g}}{1401.4 \text{ g}} \times 100 = \frac{131.7 \text{ g}}{1401.4 \text{ g}} = 9.40\% \text{ report } 9.4\%$$

**Report**

- Results on forms approved by the agency
- Sample ID
- $M_W$ , wet mass
- $M_D$ , dry mass
- Moisture content to the nearest 0.1 percent

**PERFORMANCE EXAM CHECKLIST**  
**TOTAL MOISTURE CONTENT OF AGGREGATE BY DRYING**  
**FOP FOR AASHTO T 255**

Participant Name \_\_\_\_\_ Exam Date \_\_\_\_\_

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

<b>Procedure Element</b>	<b>Trial 1</b>	<b>Trial 2</b>
1. Representative sample of appropriate mass obtained?	_____	_____
2. Mass of container determined to 0.1 percent or 0.1 g?	_____	_____
3. Sample placed in container and wet mass determined to 0.1 percent or 0.1 g?	_____	_____
4. Test sample mass conforms to the required mass?	_____	_____
5. Loss of moisture avoided prior to mass determination?	_____	_____
6. Sample dried by a suitable heat source?	_____	_____
7. If aggregate heated by means other than a controlled oven, is sample stirred to avoid localized overheating?	_____	_____
8. If heated in a microwave, heaped and covered with a ventilated lid	_____	_____
9. Is aggregate heated for the additional, specified time?	_____	_____
a. Forced draft, ventilated, convection ovens – 30 minutes		
b. Microwave – 2 minutes		
c. Other – 10 minutes		
10. Mass determined and compared to previous mass – showing less than 0.10 percent loss?	_____	_____
11. Sample cooled before dry mass determination to 0.1 percent or 0.1 g?	_____	_____
12. Calculations performed properly, and results reported to the nearest 0.1 percent?	_____	_____

**Comments:**      First attempt:   Pass \_\_\_\_\_ Fail \_\_\_\_\_      Second attempt:   Pass \_\_\_\_\_ Fail \_\_\_\_\_

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**Examiner Signature** \_\_\_\_\_ **WAQTC #:** \_\_\_\_\_



**SIEVE ANALYSIS OF FINE AND COARSE AGGREGATES**  
**FOP FOR AASHTO T 27**  
**MATERIALS FINER THAN 75  $\mu\text{m}$  (NO. 200) SIEVE IN MINERAL AGGREGATE**  
**BY WASHING**  
**FOP FOR AASHTO T 11**

**Scope**

A sieve analysis, or ‘gradation,’ measures distribution of aggregate particle sizes within a given sample.

Accurate determination of the amount of material smaller than 75  $\mu\text{m}$  (No. 200) cannot be made using just AASHTO T 27. If quantifying this material is required, use AASHTO T 11 in conjunction with AASHTO T 27.

This FOP covers sieve analysis in accordance with AASHTO T 27-14 and materials finer than 75  $\mu\text{m}$  (No. 200) in accordance with AASHTO T 11-05 performed in conjunction with AASHTO T 27. The procedure includes three methods: 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 ASTM E11
- Mechanical sieve shaker: Meeting the requirements of AASHTO T 27
- Suitable drying equipment (refer to FOP for AASHTO T 255)
- Containers and utensils: A pan or vessel of sufficient size to contain the sample covered with water and permit vigorous agitation without loss of material or water
- Optional
  - Mechanical washing device
  - Mallet: With a rubber or rawhide head having a mass of  $0.57 \pm 0.23$  kg ( $1.25 \pm 0.5$  lb)

**Sample Sieving**

- In all procedures, the sample is shaken in nested sieves. Sieves are selected to furnish information required by specification. Intermediate sieves are added for additional information or to avoid overloading sieves, or both.
- The sieves are nested in order of increasing size from the bottom to the top, and the sample, or a portion of the sample, is placed on the top sieve.
- The loaded sieves are shaken in a mechanical shaker for approximately 10 minutes, refer to Annex A; *Time Evaluation*.

- Care must be taken so that sieves are not overloaded, refer to Annex B; *Overload Determination*. The sample may be sieved in increments and the mass retained for each sieve added together from each sample increment to avoid overloading sieves.

### Sample Preparation

Obtain samples according to the FOP for AASHTO R 90 and reduce to sample size, shown in Table 1, according to the FOP for AASHTO R 76.

**TABLE 1**  
**Sample Sizes for Aggregate Gradation Test**

Nominal Maximum Size* mm (in.)		Minimum Dry Mass g (lb)	
125	(5)	300,000	(660)
100	(4)	150,000	(330)
90	(3 1/2)	100,000	(220)
75	(3)	60,000	(130)
63	(2 1/2)	35,000	(77)
50	(2)	20,000	(44)
37.5	(1 1/2)	15,000	(33)
25.0	(1)	10,000	(22)
19.0	(3/4)	5000	(11)
12.5	(1/2)	2000	(4)
9.5	(3/8)	1000	(2)
6.3	(1/4)	1000	(2)
4.75	(No. 4)	500	(1)

\*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.

Sample sizes in Table 1 are standard for aggregate sieve analysis, due to equipment restraints samples may need to be divided into several “subsamples.” For example, a gradation that requires 100 kg (220 lbs.) of material would not fit into a large tray shaker all at once.

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 sample sizes.

**Selection of Procedure**

Agencies may specify which method to perform. If a method is not specified, perform Method A.

**Overview****Method A**

- Determine original dry mass of the sample
- Wash over a 75µm (No. 200) sieve
- Determine dry mass of washed sample
- Sieve washed sample
- Calculate and report percent retained and passing each sieve

**Method B**

- Determine original dry mass of the sample
- Wash over a 75 µm (No. 200) sieve
- Determine dry mass of washed sample
- Sieve sample through coarse sieves, 4.75 mm (No. 4) sieves and larger
- Determine mass of fine material, minus 4.75 mm (No. 4)
- Reduce fine material
- Determine mass of reduced portion
- Sieve reduced portion
- Calculate and report percent retained and passing each sieve

**Method C**

- Determine original dry mass of the sample
- Sieve sample through coarse sieves, 4.75 mm (No. 4) sieves and larger
- Determine mass of fine material, minus 4.75 mm (No. 4)
- Reduce fine material
- Determine mass of reduced portion
- Wash reduced portion over a 75µm (No. 200) sieve
- Determine dry mass of washed reduced portion
- Sieve washed reduced portion
- Calculate and report percent retained and passing each sieve

## Procedure Method A

1. Dry the sample to constant mass according to the FOP for AASHTO T 255. Cool to room temperature. Determine and record the original dry mass of the sample to the nearest 0.1 percent or 0.1 g. Designate this mass as *M*.

When the specification does not require the amount of material finer than 75  $\mu\text{m}$  (No. 200) be determined by washing, skip to Step 11.

2. Nest a sieve, such as a 2.0 mm (No. 10), above the 75  $\mu\text{m}$  (No. 200) sieve.
3. Place the sample in a container and cover with water.

**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  $\mu\text{m}$  (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.

4. Agitate vigorously to ensure complete separation of the material finer than 75  $\mu\text{m}$  (No. 200) from coarser particles and bring the fine material into suspension above the coarser material. Avoid degradation of the sample when using a mechanical washing device.
5. Immediately pour the wash water containing the suspended material over the nested sieves; be careful not to pour out the coarser particles or over fill the 75  $\mu\text{m}$  (No. 200) sieve.
6. Add water to cover material remaining in the container, agitate, and repeat Step 5. Continue until the wash water is reasonably clear.
7. Remove the upper sieve and return material retained to the washed sample.
8. Rinse the material retained on the 75  $\mu\text{m}$  (No. 200) sieve until water passing through the sieve is reasonably clear and detergent or dispersing agent is removed, if used.
9. Return all material retained on the 75  $\mu\text{m}$  (No. 200) sieve to the container by rinsing into the washed sample.

**Note 2:** Excess water may be carefully removed with a bulb syringe; the removed water must be discharged back over the 75  $\mu\text{m}$  (No. 200) sieve to prevent loss of fines.

10. Dry the washed sample to constant mass according to the FOP for AASHTO T 255. Cool to room temperature. Determine and record the dry mass of the sample.
11. Select sieves required by the specification and those necessary to avoid overloading. With a pan on bottom, nest the sieves increasing in size starting with the 75  $\mu\text{m}$  (No. 200).
12. Place the washed sample, or a portion of the washed sample, on the top sieve. Sieves may already be in the mechanical shaker, if not 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, the time determined by Annex A).

**Note 3:** Excessive shaking (more than 10 minutes) may result in degradation of the sample.



13. Determine and record the individual or cumulative mass retained for each sieve and in the pan. Ensure that all material trapped in full openings of the sieve are removed and included in the mass retained.

**Note 4:** For sieves 4.75 mm (No. 4) and larger, check material trapped in less than a full opening 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, distribute the minus 4.75 mm (No. 4) among two or more sets of sieves to prevent overloading of individual sieves.

14. Perform the *Check Sum* calculation – Verify the *total mass after sieving* agrees with the *dry mass before sieving* to within 0.3 percent. The *dry mass before sieving* is the dry mass after wash or the original dry mass (*M*) if performing the sieve analysis without washing. Do not use test results for acceptance if the *Check Sum* result is greater than 0.3 percent.
15. Calculate the total percentages passing, and the individual or cumulative percentages retained to the nearest 0.1 percent by dividing the individual sieve masses or cumulative sieve masses by the original dry mass (*M*) of the sample.
16. Report total percent passing to 1 percent except report the 75 µm (No. 200) sieve to 0.1 percent.

## Method A Calculations

### Check Sum

$$\text{Check Sum} = \frac{\text{dry mass before sieving} - \text{total mass after sieving}}{\text{dry mass before sieving}} \times 100$$

### Percent Retained

$$\text{IPR} = \frac{\text{IMR}}{M} \times 100 \quad \text{or} \quad \text{CPR} = \frac{\text{CMR}}{M} \times 100$$

Where:

IPR	=	Individual Percent Retained
CPR	=	Cumulative Percent Retained
M	=	Original dry mass of the sample
IMR	=	Individual Mass Retained
CMR	=	Cumulative Mass Retained

**Percent Passing (PP)**

$$PP = PPP - IPR \quad \text{or} \quad PP = 100 - CPR$$

Where:

PP = Percent Passing

PPP = Previous Percent Passing

**Method A Example Individual Mass Retained**

Original dry mass of the sample (*M*): 5168.7 g

Dry mass of the sample after washing: 4911.3 g

Total mass after sieving equals

Sum of Individual Masses Retained (IMR),  
including minus 75  $\mu$ m (No. 200) in the pan: 4905.9 g

Amount of 75 $\mu$ m (No. 200) minus washed out (5168.7 g – 4911.3 g): 257.4 g

**Check Sum**

$$\text{Check Sum} = \frac{4911.3 \text{ g} - 4905.9 \text{ g}}{4911.3 \text{ g}} \times 100 = 0.1\%$$

The result is less than 0.3 percent therefore the results can be used for acceptance purposes.

**Individual Percent Retained (IPR) for 9.5 mm (3/8 in.) sieve:**

$$IPR = \frac{619.2 \text{ g}}{5168.7 \text{ g}} \times 100 = 12.0\%$$

**Percent Passing (PP) 9.5 mm (3/8 in.) sieve:**

$$PP = 86.0\% - 12.0\% = 74.0\%$$

**Reported Percent Passing = 74%**

**Method A Individual  
Gradation on All Sieves**

Sieve Size mm (in.)	Individual Mass Retained g (IMR)	Determine IPR Divide IMR by <i>M</i> and multiply by 100	Individual Percent Retained (IPR)	Determine PP by subtracting IPR from Previous PP	Percent Passing (PP)	Reported Percent Passing*
19.0 (3/4)	0		0		100.0	100
12.5 (1/2)	724.7	$\frac{724.7}{5168.7} \times 100 =$	14.0	$100.0 - 14.0 =$	86.0	86
9.5 (3/8)	619.2	$\frac{619.2}{5168.7} \times 100 =$	12.0	$86.0 - 12.0 =$	74.0	74
4.75 (No. 4)	1189.8	$\frac{1189.8}{5168.7} \times 100 =$	23.0	$74.0 - 23.0 =$	51.0	51
2.36 (No. 8)	877.6	$\frac{877.6}{5168.7} \times 100 =$	17.0	$51.0 - 17.0 =$	34.0	34
1.18 (No. 16)	574.8	$\frac{574.8}{5168.7} \times 100 =$	11.1	$34.0 - 11.1 =$	22.9	23
0.600 (No. 30)	329.8	$\frac{329.8}{5168.7} \times 100 =$	6.4	$22.9 - 6.4 =$	16.5	17
0.300 (No. 50)	228.5	$\frac{228.5}{5168.7} \times 100 =$	4.4	$16.5 - 4.4 =$	12.1	12
0.150 (No. 100)	205.7	$\frac{205.7}{5168.7} \times 100 =$	4.0	$12.1 - 4.0 =$	8.1	8
0.075 (No. 200)	135.4	$\frac{135.7}{5168.7} \times 100 =$	2.6	$8.1 - 2.6 =$	5.5	5.5
minus 0.075 (No. 200) in the pan	20.4					
Total mass after sieving = sum of sieves + mass in the pan = 4905.9 g						
Original dry mass of the sample ( <i>M</i> ): 5168.7g						

\* Report total percent passing to 1 percent except report the 75 µm (No. 200) sieve to 0.1 percent.

**Method A Example Cumulative Mass Retained**

Original dry mass of the sample (*M*): 5168.7 g

Dry mass of the sample after washing: 4911.3 g

Total mass after sieving equals Final Cumulative Mass Retained  
(FCMR) (includes minus 75 µm (No. 200) from the pan): 4905.9 g

Amount of 75µm (No. 200) minus washed out (5168.7 g – 4911.3 g): 257.4 g

**Check Sum**

$$Check\ Sum = \frac{4911.3\ g - 4905.9\ g}{4911.3\ g} \times 100 = 0.1\%$$

The result is less than 0.3 percent therefore the results can be used for acceptance purposes.

**Cumulative Percent Retained (CPR) for 9.5 mm (3/8 in.) sieve:**

$$CPR = \frac{1343.9\ g}{5168.7\ g} \times 100 = 26.0\%$$

**Percent Passing (PP) 9.5 mm (3/8 in.) sieve:**

$$PP = 100.0\% - 26.0\% = 74.0\%$$

**Reported Percent Passing = 74%**

**Method A Cumulative  
Gradation on All Sieves**

Sieve Size mm (in.)	Cumulative Mass Retained g (CMR)	Determine CPR Divide CMR by M and multiply by 100	Cumulative Percent Retained (CPR)	Determine PP by subtracting CPR from 100.0	Percent Passing (PP)	Reported Percent Passing*
19.0 (3/4)	0		0.0		100.0	100
12.5 (1/2)	724.7	$\frac{724.7}{5168.7} \times 100 =$	14.0	$100.0 - 14.0 =$	86.0	86
9.5 (3/8)	1343.9	$\frac{1343.9}{5168.7} \times 100 =$	26.0	$100.0 - 26.0 =$	74.0	74
4.75 (No. 4)	2533.7	$\frac{2533.7}{5168.7} \times 100 =$	49.0	$100.0 - 49.0 =$	51.0	51
2.36 (No. 8)	3411.3	$\frac{3411.3}{5168.7} \times 100 =$	66.0	$100.0 - 66.0 =$	34.0	34
1.18 (No. 16)	3986.1	$\frac{3986.1}{5168.7} \times 100 =$	77.1	$100.0 - 77.1 =$	22.9	23
0.600 (No. 30)	4315.9	$\frac{4315.9}{5168.7} \times 100 =$	83.5	$100.0 - 83.5 =$	16.5	17
0.300 (No. 50)	4544.4	$\frac{4544.4}{5168.7} \times 100 =$	87.9	$100.0 - 87.9 =$	12.1	12
0.150 (No. 100)	4750.1	$\frac{4750.1}{5168.7} \times 100 =$	91.9	$100.0 - 91.9 =$	8.1	8
0.075 (No. 200)	4885.5	$\frac{4885.5}{5168.7} \times 100 =$	94.5	$100.0 - 94.5 =$	5.5	5.5
FCMR	4905.9					
Total mass after sieving: 4905.9 g						
Original dry mass of the sample (M): 5168.7 g						

\* Report total percent passing to 1 percent except report the 75 µm (No. 200) sieve to 0.1 percent.

**Procedure Method B**

1. Dry the sample to constant mass according to the FOP for AASHTO T 255. Cool to room temperature. Determine and record the original dry mass of the sample to the nearest 0.1 percent or 0.1 g. Designate this mass as *M*.

When the specification does not require the amount of material finer than 75  $\mu\text{m}$  (No. 200) be determined by washing, skip to Step 11.

2. Nest a protective sieve, such as a 2.0 mm (No. 10), above the 75  $\mu\text{m}$  (No. 200) sieve.
3. Place the sample in a container and cover with water.

**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  $\mu\text{m}$  (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.

4. Agitate vigorously to ensure complete separation of the material finer than 75  $\mu\text{m}$  (No. 200) from coarser particles and bring the fine material into suspension above the coarser material. Avoid degradation of the sample when using a mechanical washing device.
5. Immediately pour the wash water containing the suspended material over the nested sieves; be careful not to pour out the coarser particles or over fill the 75  $\mu\text{m}$  (No. 200) sieve.
6. Add water to cover material remaining in the container, agitate, and repeat Step 5. Continue until the wash water is reasonably clear.
7. Remove the upper sieve and return material retained to the washed sample.
8. Rinse the material retained on the 75  $\mu\text{m}$  (No. 200) sieve until water passing through the sieve is reasonably clear and detergent or dispersing agent is removed, if used.
9. Return all material retained on the 75  $\mu\text{m}$  (No. 200) sieve to the container by rinsing into the washed sample.

**Note 2:** Excess water may be carefully removed with a bulb syringe; the removed water must be discharged back over the 75  $\mu\text{m}$  (No. 200) sieve to prevent loss of fines.

10. Dry the washed sample to constant mass according to the FOP for AASHTO T 255. Cool to room temperature. Determine and record the dry mass after wash.
11. Select sieves required by the specification and those necessary to avoid overloading. With a pan on bottom, nest the sieves increasing in size starting with the 4.75 mm (No. 4).
12. Place the washed sample, or a portion of the washed sample, on the top sieve. Sieves may already be in the mechanical shaker, if not 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, the time determined by Annex A).

**Note 3:** Excessive shaking (more than 10 minutes) may result in degradation of the sample.

13. Determine and record the individual or cumulative mass retained for each sieve. Ensure that all particles trapped in full openings of the sieve are removed and included in the mass retained.

**Note 4:** For sieves 4.75 mm (No. 4) and larger, check material trapped in less than a full opening by sieving over a full opening. Use coarse wire brushes to clean the 600  $\mu\text{m}$  (No. 30) and larger sieves, and soft hair bristle for smaller sieves.

14. Determine and record the mass of the minus 4.75 mm (No. 4) material in the pan. Designate this mass as  $M_1$ .
  15. Perform the *Coarse Check Sum* calculation – Verify the *total mass after coarse sieving* agrees with the *dry mass before sieving* to within 0.3 percent. The *dry mass before sieving* is the dry mass after wash or the original dry mass ( $M$ ) if performing the sieve analysis without washing. Do not use test results for acceptance if the *Check Sum* result is greater than 0.3 percent.
  16. Reduce the minus 4.75 mm (No. 4) according to the FOP for AASHTO R 76 to produce a sample with a minimum mass of 500 g. Determine and record the mass of the minus 4.75 mm (No. 4) split, designate this mass as  $M_2$ .
  17. Select sieves required by the specification and those necessary to avoid overloading. With a pan on bottom, nest the sieves increasing in size starting with the 75  $\mu\text{m}$  (No. 200) up to, but not including, the 4.75 mm (No. 4) sieve.
  18. Place the sample portion on the top sieve and place the sieves in the mechanical shaker. Shake for the minimum time determined to provide complete separation for the sieve shaker being used (approximately 10 minutes, the time determined by Annex A).
  19. Determine and record the individual or cumulative mass retained for each sieve and in the pan. Ensure that all particles trapped in full openings of the sieve are removed and included in the mass retained.
- Note 4:** For sieves 4.75 mm (No. 4) and larger, check material trapped in less than a full opening by sieving over a full opening. Use coarse wire brushes to clean the 600  $\mu\text{m}$  (No. 30) and larger sieves, and soft hair bristle for smaller sieves.
20. Perform the *Fine Check Sum* calculation – Verify the *total mass after sieving* agrees with the *dry mass before sieving* ( $M_2$ ) to within 0.3 percent. Do not use test results for acceptance if the *Check Sum* result is greater than 0.3 percent.
  21. Calculate to the nearest 0.1 percent, the Individual Mass Retained (IMR) or Cumulative Mass Retained (CMR) of the size increment of the reduced sample and the original sample.
  22. Calculate the total percent passing.
  23. Report total percent passing to 1 percent except report the 75  $\mu\text{m}$  (No. 200) sieve to 0.1 percent.

**Method B Calculations****Check Sum**

$$\text{Coarse Check Sum} = \frac{\text{dry mass before sieving} - \text{total mass after coarse sieving}}{\text{dry mass before sieving}} \times 100$$

$$\text{Fine Check Sum} = \frac{M_2 - \text{total mass after fine sieving}}{M_2} \times 100$$

**Percent Retained for 4.75 mm (No. 4) and larger**

$$IPR = \frac{IMR}{M} \times 100 \quad \text{or} \quad CPR = \frac{CMR}{M} \times 100$$

Where:

IPR	=	Individual Percent Retained
CPR	=	Cumulative Percent Retained
M	=	Original dry mass of the sample
IMR	=	Individual Mass Retained
CMR	=	Cumulative Mass Retained

**Percent Passing (PP) for 4.75 mm (No. 4) and larger**

$$PP = PPP - IPR \quad \text{or} \quad PP = 100 - CPR$$

Where:

PP	=	Percent Passing
PPP	=	Previous Percent Passing



**Minus 4.75mm (No. 4) adjustment factor (R)**

The mass of material retained for each sieve is multiplied by the adjustment factor, the total mass of the minus 4.75 mm (No. 4) from the pan,  $M_1$ , divided by the mass of the reduced split of minus 4.75 mm (No. 4),  $M_2$ . For consistency, this adjustment factor is carried to three decimal places.

$$R = \frac{M_1}{M_2}$$

where:

- R = minus 4.75 mm (No. 4) adjustment factor
- $M_1$  = total mass of minus 4.75 mm (No. 4) before reducing
- $M_2$  = mass of the reduced split of minus 4.75 mm (No. 4)

**Adjusted Individual Mass Retained (AIMR):**

$$AIMR = R \times B$$

where:

- AIMR = Adjusted Individual Mass Retained
- R = minus 4.75 mm (No. 4) adjustment factor
- B = individual mass of the size increment in the reduced portion sieved

**Adjusted Cumulative Mass Retained (ACMR)**

$$ACMR = (R \times B) + D$$

where:

- ACMR = Adjusted Cumulative Mass Retained
- R = minus 4.75 mm (No. 4) adjustment factor
- 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 Individual Mass Retained**

Dry mass of total sample, before washing: 3214.0 g

Dry mass of sample after washing: 3085.1 g

Total mass after sieving

Sum of Individual Masses Retained (IMR) plus the  
minus 4.75 mm (No. 4) from the pan: 3085.0 g

Amount of 75 µm (No. 200) minus washed out (3214.0 g – 3085.1 g): 128.9 g

**Coarse Check Sum**

$$\text{Coarse Check Sum} = \frac{3085.1 \text{ g} - 3085.0 \text{ g}}{3085.1 \text{ g}} \times 100 = 0.0\%$$

The result is less than 0.3 percent therefore the results can be used for acceptance purposes.

**Individual Percent Retained (IPR) for 9.5 mm (3/8 in.) sieve**

$$IPR = \frac{481.4 \text{ g}}{3214.0 \text{ g}} \times 100 = 15.0\%$$

**Percent Passing (PP) for 9.5 mm (3/8 in.) sieve:**

$$PP = 95.0\% - 15.0\% = 80.0\%$$

**Reported Percent Passing = 80%**

**Method B Individual  
Gradation on Coarse Sieves**

Sieve Size mm (in.)	Individual Mass Retained g (IMR)	Determine IPR Divide IMR by M and multiply by 100	Individual Percent Retained (IPR)	Determine PP by subtracting IPR from Previous PP	Percent Passing (PP)
16.0 (5/8)	0		0		100
12.5 (1/2)	161.1	$\frac{161.1}{3214.0} \times 100 =$	5.0	$100.0 - 5.0 =$	95.0
9.50 (3/8)	481.4	$\frac{481.4}{3214.0} \times 100 =$	15.0	$95.0 - 15.0 =$	80.0
4.75 (No. 4)	475.8	$\frac{475.8}{3214.0} \times 100 =$	14.8	$80.0 - 14.8 =$	65.2
Minus 4.75 (No. 4) in the pan	1966.7 ( $M_1$ )				
Total mass after sieving = sum of sieves + mass in the pan = 3085.0 g					
Original dry mass of the sample ( $M$ ): 3214.0 g					

**Fine Sample**

The minus 4.75 mm (No. 4) from the pan,  $M_1$  (1966.7 g), was reduced according to the FOP for AASHTO R 76, to at least 500 g. In this case, the reduced mass was determined to be **512.8 g**. This is  $M_2$ .

The reduced mass was sieved.

Total mass after sieving equals

Sum of Individual Masses Retained (IMR) including  
minus 75  $\mu$ m (No. 200) in the pan

511.8 g

**Fine Check Sum**

$$\text{Fine Check Sum} = \frac{512.8 \text{ g} - 511.8 \text{ g}}{512.8 \text{ g}} \times 100 = 0.2\%$$

The result is less than 0.3 percent therefore the results can be used for acceptance purposes.

**Adjustment Factor (*R*) for Adjusted Individual Mass Retained (AIMR) on minus 4.75 (No. 4) sieves**

The mass of material retained for each sieve is multiplied by the adjustment factor (*R*) carried to three decimal places.

$$R = \frac{M_1}{M_2} = \frac{1,966.7 \text{ g}}{512.8 \text{ g}} = 3.835$$

where:

*R* = minus 4.75 mm (No. 4) adjustment factor

*M*<sub>1</sub> = total mass of minus 4.75 mm (No. 4) from the pan

*M*<sub>2</sub> = mass of the reduced split of minus 4.75 mm (No. 4)

Each “individual mass retained” on the fine sieves must be multiplied by *R* to obtain the *Adjusted Individual Mass Retained*.

**Adjusted Individual Mass Retained (AIMR) for 2.00 mm (No. 10) sieve**

$$\text{AIMR} = 3.835 \times 207.1 \text{ g} = 794.2 \text{ g}$$

**Individual Percent Retained (IPR) for 2.00 mm (No. 10) sieve:**

$$\text{IPR} = \frac{794.2 \text{ g}}{3214.0 \text{ g}} \times 100 = 24.7\%$$

**Percent Passing (PP) 2 mm (No. 10) sieve:**

$$PP = 65.2\% - 24.7\% = 40.5\%$$

**Reported Percent Passing = 41%**

**Method B Individual  
Gradation on Fine Sieves**

Sieve Size mm (in.)	Individual Mass Retained g (IMR)	Determine TIMR Multiply IMR by $R \left( \frac{M_1}{M_2} \right)$	Total Individual Mass Retained (TIMR)
2.00 (No. 10)	207.1	$207.1 \times 3.835 =$	794.2
0.425 (No. 40)	187.9	$187.9 \times 3.835 =$	720.6
0.210 (No. 80)	59.9	$59.9 \times 3.835 =$	229.7
0.075 (No. 200)	49.1	$49.1 \times 3.835 =$	188.3
minus 0.075 (No. 200) in the pan	7.8		
Total mass after sieving = sum of fine sieves + the mass in the pan = 511.8 g			

**Method B Individual  
Final Gradation on All Sieves**

Sieve Size mm (in.)	Total Individual Mass Retained g (TIMR)	Determine IPR Divide TIMR by M and multiply by 100	Individual Percent Retained (IPR)	Determine PP by subtracting IPR from Previous PP	Percent Passing (PP)	Reported Percent Passing*
16.0 (5/8)	0		0		100	100
12.5 (1/2)	161.1	$\frac{161.1}{3214.0} \times 100 =$	5.0	$100.0 - 5.0 =$	95.0	95
9.50 (3/8)	481.4	$\frac{481.4}{3214.0} \times 100 =$	15.0	$95.0 - 15.0 =$	80.0	80
4.75 (No. 4)	475.8	$\frac{475.8}{3214.0} \times 100 =$	14.8	$80.0 - 14.8 =$	65.2	65
2.00 (No. 10)	794.2	$\frac{794.2}{3214.0} \times 100 =$	24.7	$65.2 - 24.7 =$	40.5	41
0.425 (No. 40)	720.6	$\frac{720.6}{3214.0} \times 100 =$	22.4	$40.5 - 22.4 =$	18.1	18
0.210 (No. 80)	229.7	$\frac{229.7}{3214.0} \times 100 =$	7.1	$18.1 - 7.1 =$	11.0	11
0.075 (No. 200)	188.3	$\frac{188.3}{3214.0} \times 100 =$	5.9	$11.0 - 5.9 =$	5.1	5.1
minus 0.075 (No. 200) in the pan	29.9					
Original dry mass of the sample (M): 3214.0 g						

\* Report total percent passing to 1 percent except report the 75 µm (No. 200) sieve to 0.1 percent.

**Method B Example Cumulative Mass Retained**

Original dry mass of the sample (*M*): 3214.0 g

Dry mass of sample after washing: 3085.1 g

Total mass after sieving equals

Cumulative Mass Retained (CMR) on the 4.75 (No. 4)  
plus the minus 4.75 mm (No. 4) in the pan: 3085.0 g

Amount of 75 µm (No. 200) minus washed out (3214.0 g – 3085.1 g): 128.9 g

**Coarse Check Sum**

$$\text{Coarse Check Sum} = \frac{3085.1 \text{ g} - 3085.0 \text{ g}}{3085.1 \text{ g}} \times 100 = 0.0\%$$

The result is less than 0.3 percent therefore the results can be used for acceptance purposes.

**Cumulative Percent Retained (CPR) for 9.5 mm (3/8 in.) sieve**

$$CPR = \frac{642.5 \text{ g}}{3214.0 \text{ g}} \times 100 = 20.0\%$$

**Percent Passing (PP) for 9.5 mm (3/8 in.) sieve**

$$PP = 100.0\% - 20.0\% = 80.0\%$$

**Reported Percent Passing = 80%**

**Method B Cumulative  
Gradation on Coarse Sieves**

Sieve Size mm (in.)	Cumulative Mass Retained g (CMR)	Determine CPR Divide CMR by M and multiply by 100	Cumulative Percent Retained (CPR)	Determine PP by subtracting CPR from 100.0	Percent Passing (PP)
16.0 (5/8)	0		0		100
12.5 (1/2)	161.1	$\frac{161.1}{3214.0} \times 100 =$	5.0	$100.0 - 5.0 =$	95.0
9.50 (3/8)	642.5	$\frac{642.5}{3214.0} \times 100 =$	20.0	$100.0 - 20.0 =$	80.0
4.75 (No. 4)	1118.3 (D)	$\frac{1118.3}{3214.0} \times 100 =$	34.8	$100.0 - 34.8 =$	65.2
Minus 4.75 (No. 4) in the pan	1966.7 ( $M_1$ )				
CMR: $1118.3 + 1966.7 = 3085.0$					
Original dry mass of the sample (M): 3214.0 g					

### Fine Sample

The mass of minus 4.75 mm (No. 4) material in the pan,  $M_1$  (1966.7 g), was reduced according to the FOP for AASHTO R 76, to at least 500 g. In this case, the reduced mass was determined to be **512.8 g**. This is  $M_2$ .

The reduced mass was sieved.

Total mass after fine sieving equals

Final Cumulative Mass Retained (FCMR) (includes minus  
75  $\mu\text{m}$  (No. 200) from the pan): 511.8 g

### Fine Check Sum

$$\text{Fine Check Sum} = \frac{512.8 \text{ g} - 511.8 \text{ g}}{512.8 \text{ g}} \times 100 = 0.2\%$$

The result is less than 0.3 percent therefore the results can be used for acceptance purposes.



The cumulative mass of material retained for each sieve is multiplied by the adjustment factor ( $R$ ) carried to three decimal places and added to the cumulative mass retained on the 4.75 mm (No. 4) sieve,  $D$ , to obtain the *Adjusted Cumulative Mass Retained (ACMR)*.

**Adjustment factor ( $R$ ) for Cumulative Mass Retained (CMR) in minus 4.75 (No. 4) sieves**

$$R = \frac{M_1}{M_2} = \frac{1,966.7 \text{ g}}{512.8 \text{ g}} = 3.835$$

where:

$R$  = minus 4.75 mm (No. 4) adjustment factor

$M_1$  = total mass of minus 4.75 mm (No. 4) from the pan

$M_2$  = mass of the reduced split of minus 4.75 mm (No. 4)

**Adjusted Cumulative Mass Retained (ACMR) for the 2.00 mm (No. 10) sieve**

$$ACMR = 3.835 \times 207.1 \text{ g} = 794.2 \text{ g}$$

**Total Cumulative Mass Retained (TCMR) for the 2.00 mm (No. 10) sieve**

$$TCMR = 794.2 \text{ g} + 1118.3 \text{ g} = 1912.5 \text{ g}$$

**Cumulative Percent Retained (CPR) for 2.00 mm (No. 10) sieve:**

$$CPR = \frac{1912.5 \text{ g}}{3214.0 \text{ g}} \times 100 = 59.5\%$$

**Percent Passing (PP) 2.00 mm (No. 10) sieve:**

$$PP = 100.0\% - 59.5\% = 40.5\%$$

**Reported Percent Passing = 41%**

**Method B Cumulative  
Gradation on Fine Sieves**

Sieve Size mm (in.)	Cumulative Mass Retained, g (CMR)	Determine AIMR Multiply IMR by $R \left( \frac{M_1}{M_2} \right)$ and adding D	Total Cumulative Mass Retained (TCMR)
2.00 (No. 10)	207.1	$207.1 \times 3.835 + 1118.3 =$	1912.5
0.425 (No. 40)	395.0	$395.0 \times 3.835 + 1118.3 =$	2633.1
0.210 (No. 80)	454.9	$454.9 \times 3.835 + 1118.3 =$	2862.8
0.075 (No. 200)	504.0	$504.0 \times 3.835 + 1118.3 =$	3051.1
FCMR	511.8		
Total sum of masses on fine sieves + minus 75 $\mu$ m (No. 200) in the pan = 511.8			

**Method B Cumulative  
Final Gradation on All Sieves**

Sieve Size mm (in.)	Cumulative Mass Retained g (CMR)	Determine CPR Divide CMR by M and multiply by 100	Cumulative Percent Retained (CPR)	Determine PP by subtracting CPR from 100.0	Percent Passing (PP)	Reported Percent Passing*
16.0 (5/8)	0		0		100.0	100
12.5 (1/2)	161.1	$\frac{161.1}{3214.0} \times 100 =$	5.0	$100.0 - 5.0 =$	95.0	95
9.5 (3/8)	642.5	$\frac{642.5}{3214.0} \times 100 =$	20.0	$100.0 - 20.0 =$	80.0	80
4.75 (No. 4)	1118.3 (D)	$\frac{1118.3}{3214.0} \times 100 =$	34.8	$100.0 - 34.8 =$	65.2	65
2.00 (No. 10)	1912.5	$\frac{1912.5}{3214.0} \times 100 =$	59.5	$100.0 - 59.5 =$	40.5	41
0.425 (No. 40)	2633.1	$\frac{2633.1}{3214.0} \times 100 =$	81.9	$100.0 - 81.9 =$	18.1	18
0.210 (No. 80)	2862.8	$\frac{2862.8}{3214.0} \times 100 =$	89.1	$100.0 - 89.1 =$	10.9	11
0.075 (No. 200)	3051.1	$\frac{3051.1}{3214.0} \times 100 =$	94.9	$100.0 - 94.9 =$	5.1	5.1
FCMR	3081.1					
Original dry mass of the sample (M): 3214.0 g						

\* Report total percent passing to 1 percent except report the 75 µm (No. 200) sieve to 0.1 percent.

## Procedure Method C

1. Dry the sample to constant mass according to the FOP for AASHTO T 255. Cool to room temperature. Determine and record the original dry mass of the sample to the nearest 0.1 percent or 0.1 g. Designate this mass as  $M$ .
2. Break up any aggregations or lumps of clay, silt or adhering fines to pass the 4.75 mm (No. 4) sieve.
3. Select sieves required by the specification and those necessary to avoid overloading. With a pan on bottom, nest the sieves increasing in size starting with the 4.75 mm (No. 4) sieve.
4. Place the sample, or a portion of the sample, on the top sieve. Sieves may already be in the mechanical shaker, if not 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, the time determined by Annex A).

**Note 3:** Excessive shaking (more than 10 minutes) may result in degradation of the sample.

5. Determine and record the cumulative mass retained for each sieve. Ensure that all material trapped in full openings of the sieve are removed and included in the mass retained.

**Note 4:** For sieves 4.75 mm (No. 4) and larger, check material trapped in less than a full opening sieving over a full opening. Use coarse wire brushes to clean the 600  $\mu\text{m}$  (No. 30) and larger sieves, and soft bristle brush for smaller sieves.

6. Determine and record the mass of the minus 4.75 mm (No. 4) material in the pan. Designate this mass as  $M_1$ .
7. Perform the *Coarse Check Sum* calculation –Verify the *total mass after coarse sieving* agrees with the *original dry mass (M)* within 0.3 percent.
8. Reduce the minus 4.75 mm (No. 4) according to the FOP for AASHTO R 76, to produce a sample with a minimum mass of 500 g.
9. Determine and record the mass of the minus 4.75 mm (No. 4) split, designate this mass as  $M_3$ .
10. Nest a protective sieve, such as a 2.0 mm (No. 10), above the 75  $\mu\text{m}$  (No. 200) sieve.
11. Place the sample in a container and cover with water.

**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  $\mu\text{m}$  (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.

12. Agitate vigorously to ensure complete separation of the material finer than 75  $\mu\text{m}$  (No. 200) from coarser particles and bring the fine material into suspension above the coarser material. Avoid degradation of the sample when using a mechanical washing device.
13. Immediately pour the wash water containing the suspended material over the nested sieves; be careful not to pour out the coarser particles or over fill the 75  $\mu\text{m}$  (No. 200) sieve.

14. Add water to cover material remaining in the container, agitate, and repeat Step 12. Repeat until the wash water is reasonably clear.
  15. Remove the upper sieve and return material retained to the washed sample.
  16. Rinse the material retained on the 75  $\mu\text{m}$  (No. 200) sieve until water passing through the sieve is reasonably clear and detergent or dispersing agent is removed, if used.
  17. Return all material retained on the 75  $\mu\text{m}$  (No. 200) sieve to the container by flushing into the washed sample.
- Note 2:** Excess water may be carefully removed with a bulb syringe; the removed water must be discharged back over the 75  $\mu\text{m}$  (No. 200) sieve to prevent loss of fines.
18. Dry the washed sample portion to constant mass according to the FOP for AASHTO T 255. Cool to room temperature. Determine and record the dry mass, designate this mass as *dry mass before sieving*.
  19. Select sieves required by the specification and those necessary to avoid overloading. With a pan on bottom, nest the sieves increasing in size starting with the 75  $\mu\text{m}$  (No. 200) sieve up to, but not including, the 4.75 mm (No. 4) sieve.
  20. Place the washed sample portion on the top sieve. 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, the time determined by Annex A).
- Note 3:** Excessive shaking (more than 10 minutes) may result in degradation of the sample.
21. Determine and record the cumulative mass retained for each sieve. Ensure that all material trapped in full openings of the sieve are removed and included in the mass retained.
- Note 4:** For sieves 4.75 mm (No. 4) and larger, check material trapped in less than a full opening by sieving over a full opening. Use coarse wire brushes to clean the 600  $\mu\text{m}$  (No. 30) and larger sieves, and soft bristle brushes for smaller sieves.
22. Perform the *Fine Check Sum* calculation – Verify the *total mass after fine sieving* agrees with the *dry mass before sieving* within 0.3 percent. Do not use test results for acceptance if the *Check Sum* is greater than 0.3 percent.
  23. Calculate the Cumulative Percent Retained (CPR) and Percent Passing (PP) for the 4.75 mm (No. 4) and larger.
  24. Calculate the Cumulative Percent Retained (CPR<sub>#4</sub>) and the Percent Passing (PP<sub>#4</sub>) for minus 4.75 mm (No. 4) split and Percent Passing (PP) for the minus 4.75 mm (No. 4).
  25. Report total percent passing to 1 percent except report the 75  $\mu\text{m}$  (No. 200) sieve to 0.1 percent.

**Method C Calculations****Check Sum**

$$\text{Coarse check sum} = \frac{M - \text{total mass after coarse sieving}}{M} \times 100$$

$$\text{Fine check sum} = \frac{\text{dry mass before sieving} - \text{total mass after fine sieving}}{\text{dry mass before sieving}} \times 100$$

where:

M = Original dry mass of the sample

**Cumulative Percent Retained (CPR) for 4.75 mm (No. 4) sieve and larger**

$$CPR = \frac{CMR}{M} \times 100$$

where:

CPR = Cumulative Percent Retained of the size increment for the total sample

CMR = Cumulative Mass Retained of the size increment for the total sample

M = Total dry sample mass before washing

**Percent Passing (PP) 4.75 mm (No. 4) sieve and larger**

$$PP = 100 - CPR$$

where:

PP = Percent Passing of the size increment for the total sample

CPR = Cumulative Percent Retained of the size increment for the total sample

**Or, calculate PP for sieves larger than 4.75 mm (No. 4) sieve without calculating CPR**

$$\frac{M - CMR}{M} \times 100$$

**Cumulative Percent Retained (CPR<sub>#4</sub>) for minus 4.75 mm (No. 4) split**

$$CPR_{\#4} = \frac{CMR_{\#4}}{M_3} \times 100$$

where:

CPR<sub>#4</sub> = Cumulative Percent Retained for the sieve sizes of M<sub>3</sub>

CMR<sub>#4</sub> = Cumulative Mass Retained for the sieve sizes of M<sub>3</sub>

M<sub>3</sub> = Total mass of the minus 4.75 mm (No. 4) split before washing

**Percent Passing (PP<sub>#4</sub>) for minus 4.75 mm (No. 4) split**

$$PP_{\#4} = 100 - CPR_{\#4}$$

where:

PP<sub>#4</sub> = Percent Passing for the sieve sizes of M<sub>3</sub>

CPR<sub>#4</sub> = Cumulative Percent Retained for the sieve sizes of M<sub>3</sub>

**Percent Passing (PP) for sieves smaller than 4.75 mm (No. 4) sieve**

$$PP = \frac{(PP_{\#4} \times \#4 PP)}{100}$$

where:

PP = Total Percent Passing

PP<sub>#4</sub> = Percent Passing for the sieve sizes of M<sub>3</sub>

#4 PP = Total Percent Passing the 4.75 mm (No. 4) sieve

**Or, calculate PP for sieves smaller than 4.75 mm (No. 4) sieve without calculating CPR-#4 and PP-#4**

$$PP = \frac{\#4 PP}{M_3} \times (M_3 - CMR_{\#4})$$

where:

- PP = Total Percent Passing
- #4 PP = Total Percent Passing the 4.75 mm (No. 4) sieve
- M<sub>3</sub> = Total mass of the minus 4.75 mm (No. 4) split before washing
- CMR-#4 = Cumulative Mass Retained for the sieve sizes of M<sub>3</sub>

### Method C Example

Original dry mass of the sample (M): 3304.5 g

Total mass after sieving equals

Cumulative Mass Retained (CMR) on the 4.75 (No. 4) plus the  
minus 4.75 mm (No. 4) from the pan: 3085.0 g

### Coarse Check Sum

$$Coarse Check Sum = \frac{3304.5 g - 3304.5 g}{3304.5 g} \times 100 = 0.0\%$$

The result is less than 0.3 percent therefore the results can be used for acceptance purposes.

**Cumulative Percent Retained (CPR) for the 9.5 mm (3/8 in.) sieve:**

$$CPR = \frac{604.1 g}{3304.5 g} \times 100 = 18.3\%$$



**Percent Passing (PP) for the 9.5 mm (3/8 in.) sieve:**

$$PP = 100.0\% - 18.3\% = 81.7\%$$

**Reported Percent Passing = 82%**

**Example for Alternate Percent Passing (PP) formula for the 9.5 mm (3/8 in.) sieve:**

$$PP = \frac{3304.5 - 604.1}{3304.5} \times 100 = 81.7\%$$

**Reported Percent Passing = 82%**

**Method C Cumulative  
Gradation on Coarse Sieves**

Sieve Size mm (in.)	Cumulative Mass Retained, g (CMR)	Determine CPR Divide CMR by M and multiply by 100	Cumulative Percent Retained (CPR)	Determine PP by subtracting CPR from 100.0	Percent Passing (PP)	Reported Percent Passing*
16.0 (5/8)	0		0.0		100.0	100
12.5 (1/2)	125.9	$\frac{125.9}{3304.5} \times 100 =$	3.8	$100.0 - 3.8 =$	96.2	96
9.50 (3/8)	604.1	$\frac{604.1}{3304.5} \times 100 =$	18.3	$100.0 - 18.3 =$	81.7	82
4.75 (No. 4)	1295.6	$\frac{1295.6}{3304.5} \times 100 =$	39.2	$100.0 - 39.2 =$	<b>60.8</b> <b>(#4 PP)</b>	61
Mass in pan	2008.9					
CMR: $1295.6 + 2008.9 = 3304.5$						
Original dry mass of the sample (M) = 3304.5						

**Fine Sample**

The pan (2008.9 g) was reduced according to the FOP for AASHTO R 76, to at least 500 g. In this case, the reduced mass was determined to be **527.6 g**. This is  $M_3$ .

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

Total mass after fine sieving equals

Final Cumulative Mass Retained (FCMR)  
(includes minus 75  $\mu\text{m}$  (No. 200) from the pan): 495.1 g

**Fine Check Sum**

$$\text{Fine Check Sum} = \frac{495.3 \text{ g} - 495.1 \text{ g}}{495.3 \text{ g}} \times 100 = 0.04\%$$

The result is less than 0.3 percent therefore the results can be used for acceptance purposes.

**Cumulative Percent Retained (CPR<sub>#4</sub>) for minus 4.75 mm (No. 4) for the 2.0 mm (No. 10) sieve:**

$$CPR_{\#4} = \frac{194.3 \text{ g}}{527.6 \text{ g}} \times 100 = 36.8\%$$

**Percent Passing (PP<sub>#4</sub>) for minus 4.75 mm (No. 4) for the 2.0 mm (No. 10) sieve:**

$$PP_{\#4} = 100.0\% - 36.8\% = 63.2\%$$

**Method C Cumulative  
Gradation on Fine Sieves**

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Sieve Size mm (in.)	Cumulative Mass Retained g (CMR <sub>#4</sub> )	Determine CPR <sub>#4</sub> Divide CMR by M <sub>3</sub> and multiply by 100	Cumulative Percent Retained <sub>#4</sub> (CPR <sub>#4</sub> )	Determine PP <sub>#4</sub> by subtracting CPR <sub>#4</sub> from 100.0	Percent Passing <sub>#4</sub> (PP <sub>#4</sub> )
2.0 (No. 10)	194.3	$\frac{194.3}{527.6} \times 100 =$	36.8	$100.0 - 36.8 =$	63.2
0.425 (No. 40)	365.6	$\frac{365.6}{527.6} \times 100 =$	69.3	$100.0 - 69.3 =$	30.7
0.210 (No. 80)	430.8	$\frac{430.8}{527.6} \times 100 =$	81.7	$100.0 - 81.7 =$	18.3
0.075 (No. 200)	484.4	$\frac{484.4}{527.6} \times 100 =$	91.8	$100.0 - 91.8 =$	8.2
FCMR	495.1				
Dry mass of minus 4.75mm (No. 4) reduced portion before wash (M <sub>3</sub> ): 527.6 g					
Dry mass after washing: 495.3 g					

**Percent Passing (PP) for the 2.0 mm (No. 10) sieve for the entire sample:**

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#4 PP (Total Percent Passing the 4.75 mm (No. 4) sieve) = 60.8%

$$PP = \frac{63.2\% \times 60.8\%}{100} = 38.4\%$$

**Reported Percent Passing = 38%**

**Method C Cumulative  
Final Gradation on All Sieves**

Sieve Size mm (in.)	Cumulative Mass Retained g (CMR)	Cumulative Percent Retained (CPR)	Percent Passing (PP -#4)	Determine PP multiply PP -#4 by #4 PP and divide by 100	Percent Passing (PP)	Reported Percent Passing*
16.0 (5/8)	0	0.0			100.0	100
12.5 (1/2)	125.9	3.8			96.2	96
9.5 (3/8)	604.1	18.3			81.7	82
4.75 (No. 4)	1295.6	39.2			<b>60.8</b> <b>(#4 PP)</b>	61
2.0 (No. 10)	194.3	36.8	63.2	$\frac{63.2 \times 60.8}{100} =$	38.4	38
0.425 (No. 40)	365.6	69.3	30.7	$\frac{30.7 \times 60.8}{100} =$	18.7	19
0.210 (No. 80)	430.8	81.7	18.3	$\frac{18.3 \times 60.8}{100} =$	11.1	11
0.075 (No. 200)	484.4	91.8	8.2	$\frac{8.2 \times 60.8}{100} =$	5.0	5.0
FCMR	495.1					

\* Report total percent passing to 1 percent except report the 75 µm (No. 200) sieve to 0.1 percent.

**Example for Alternate Percent Passing (PP) for the 4.75 mm (No. 4) sieve for the entire sample:**

#4 PP (Total Percent Passing the 4.75 mm (No. 4) sieve) = 60.8%

$$PP = \frac{60.8\%}{527.6} \times (527.6 - 194.3) = 38.4\%$$

**Reported Percent Passing = 38%**

**Alternate Method C Cumulative  
Gradation on Coarse Sieves**

Sieve Size mm (in.)	Cumulative Mass Retained, g (CMR)	Determine PP subtract CMR from M, divide result by M multiply by 100	Percent Passing (PP)	Reported Percent Passing*
16.0 (5/8)	0.0		100.0	100
12.5 (1/2)	125.9	$\frac{3304.5 - 125.9}{3304.5} \times 100 =$	96.2	96
9.5 (3/8)	604.1	$\frac{3304.5 - 604.1}{3304.5} \times 100 =$	81.7	82
4.75 (No. 4)	1295.6	$\frac{3304.5 - 1295.6}{3304.5} \times 100 =$	<b>60.8</b> <b>(#4 PP)</b>	61
Mass in Pan	2008.9			
Cumulative sieved mass: $1295.6 + 2008.9 = 3304.5$				
Original dry mass of the sample ( $M$ ) = 3304.5				

**Alternate Method C Cumulative  
Gradation on Fine Sieves**

<b>Sieve Size mm (in.)</b>	<b>Cumulative Mass Retained g (CMR<sub>#4</sub>)</b>	<b>Determine PP<sub>#4</sub> subtract CMR<sub>#4</sub> from M<sub>3</sub>, divide result by M<sub>3</sub> multiply by 100</b>	<b>Percent Passing<sub>#4</sub> (PP<sub>#4</sub>)</b>
2.0 (No. 10)	194.3	$\frac{527.6 - 194.3}{527.6} \times 100 =$	63.2
0.425 (No. 40)	365.6	$\frac{527.6 - 365.6}{527.6} \times 100 =$	30.7
0.210 (No. 80)	430.8	$\frac{527.6 - 430.8}{527.6} \times 100 =$	18.3
0.075 (No. 200)	484.4	$\frac{527.6 - 484.4}{527.6} \times 100 =$	8.2
FCMR	495.1		
Dry mass of minus 4.75mm (No. 4) reduced portion before wash (M <sub>3</sub> ): 527.6 g			
Dry mass after washing: 495.3 g			

**Alternate Method C Cumulative  
Final Gradation on All Sieves**

Sieve Size mm (in.)	Percent Passing <sup>#4</sup> (PP <sup>#4</sup> )	Determine PP multiply PP <sup>#4</sup> by #4 PP and divide by 100	Determined Percent Passing (PP)	Reported Percent Passing*
16.0 (5/8)			100.0	100
12.5 (1/2)			96.2	96
9.5 (3/8)			81.7	82
4.75 (No. 4)			<b>60.8</b> (#4 PP)	61
2.0 (No. 10)	63.2	$\frac{63.2 \times 60.8}{100} =$	38.4	38
0.425 (No. 40)	30.7	$\frac{30.7 \times 60.8}{100} =$	18.7	19
0.210 (No. 80)	18.3	$\frac{18.3 \times 60.8}{100} =$	11.1	11
0.075 (No. 200)	8.2	$\frac{8.2 \times 60.8}{100} =$	5.0	5.0

\* Report total percent passing to 1 percent except report the 75 µm (No. 200) sieve to 0.1 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 fine aggregate in PCC.

The sum of the cumulative percentages retained on specified sieves in the following table divided by 100 gives the FM.

### Sample Calculation

	Example A				Example B		
	Percent				Percent		
		Retained				Retained	
Sieve Size mm (in)	Passing		On Spec'd Sieves*		Passing		On Spec'd Sieves*
75*(3)	100	0	0		100	0	0
37.5*(11/2)	100	0	0		100	0	0
19*(3/4)	15	85	85		100	0	0
9.5*(3/8)	0	100	100		100	0	0
4.75*(No.4)	0	100	100		100	0	0
2.36*(No.8)	0	100	100		87	13	13
1.18*(No.16)	0	100	100		69	31	31
0.60*(No.30)	0	100	100		44	56	56
0.30*(No.50)	0	100	100		18	82	82
0.15*(100)	0	100	100		4	96	96
			$\Sigma = 785$				$\Sigma = 278$
			FM = 7.85				FM = 2.78

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
- Percent passing for each sieve
- Individual mass retained for each sieve
- Individual percent retained for each sieve
- or
- Cumulative mass retained for each sieve
- Cumulative percent retained for each sieve
- FM to the nearest 0.01

Report percentages to the nearest 1 percent except for the percent passing the 75  $\mu\text{m}$  (No. 200) sieve, which shall be reported to the nearest 0.1 percent.

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**ANNEX A****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.

**Note A1:** A mallet may be used instead of the heel of the hand if comparable force is used.

If more than 0.5 percent by mass of the total sample before sieving passes any sieve after one minute of continuous hand shaking 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.

**ANNEX B****Overload Determination**

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 overloading.

- For sieves with openings smaller than 4.75 mm (No. 4), the mass retained on any sieve shall not exceed 7 kg/m<sup>2</sup> (4 g/in<sup>2</sup>) 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 B1.

**TABLE B1**

**Maximum Allowable Mass of Material Retained on a Sieve, g**  
**Nominal Sieve Size, mm (in.)**  
**Exact size is smaller (see AASHTO T 27)**

Sieve Size		203 dia	305 dia	305 by 305	350 by 350	372 by 580
mm (in.)		(8)	(12)	(12 × 12)	(14 × 14)	(16 × 24)
Sieving Area m <sup>2</sup>						
		0.0285	0.0670	0.0929	0.1225	0.2158
90	(3 1/2)	*	15,100	20,900	27,600	48,500
75	(3)	*	12,600	17,400	23,000	40,500
63	(2 1/2)	*	10,600	14,600	19,300	34,000
50	(2)	3600	8400	11,600	15,300	27,000
37.5	(1 1/2)	2700	6300	8700	11,500	20,200
25.0	(1)	1800	4200	5800	7700	13,500
19.0	(3/4)	1400	3200	4400	5800	10,200
16.0	(5/8)	1100	2700	3700	4900	8600
12.5	(1/2)	890	2100	2900	3800	6700
9.5	(3/8)	670	1600	2200	2900	5100
6.3	(1/4)	440	1100	1500	1900	3400
4.75	(No. 4)	330	800	1100	1500	2600
-4.75	(-No. 4)	200	470	650	860	1510



**PERFORMANCE EXAM CHECKLIST****METHOD A****SIEVE ANALYSIS OF FINE AND COARSE AGGREGATES****FOP FOR AASHTO T 27****MATERIALS FINER THAN 75  $\mu\text{m}$  (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.**

<b>Procedure Element</b>	<b>Trial 1</b>	<b>Trial 2</b>
1. Minimum sample mass meets requirement of Table 1?	_____	_____
2. Sample dried to a constant mass by FOP for AASHTO T 255?	_____	_____
3. Sample cooled, and original dry mass of the sample recorded to the nearest 0.1 percent or 0.1 g?	_____	_____
4. Sample placed in container and covered with water?	_____	_____
5. Contents of the container vigorously agitated?	_____	_____
6. Suspension of minus 75 $\mu\text{m}$ (No. 200) achieved?	_____	_____
7. Wash water poured through nested sieves such as 2 mm (No. 10) and 75 $\mu\text{m}$ (No. 200)?	_____	_____
8. Operation continued until wash water is reasonably clear?	_____	_____
9. Material retained on sieves returned to washed sample?	_____	_____
10. Washed sample dried to a constant mass by FOP for AASHTO T 255?	_____	_____
11. Washed sample cooled, and dry mass recorded to the nearest 0.1 percent or 0.1 g?	_____	_____
12. Sample placed in nest of sieves specified? (Additional sieves may be used to prevent overloading as allowed in FOP.)	_____	_____
13. Material sieved in verified mechanical shaker for proper time?	_____	_____
14. Mass of material on each sieve and pan recorded to 0.1 g?	_____	_____
15. Total mass of material after sieving agrees with mass before sieving to within 0.3 percent (check sum)?	_____	_____

**OVER**

Procedure Element	Trial 1	Trial 2
16. Percentages calculated to the nearest 0.1 percent and reported to the nearest whole number, except 75 $\mu\text{m}$ (No. 200) which is reported to the nearest 0.1 percent?	_____	_____
17. Percentage calculations based on original dry mass of the sample?	_____	_____
18. Calculations performed properly?	_____	_____

Comments: First attempt: Pass \_\_\_\_\_ Fail \_\_\_\_\_ Second attempt: Pass \_\_\_\_\_ Fail \_\_\_\_\_

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Examiner Signature \_\_\_\_\_ WAQTC #: \_\_\_\_\_

**PERFORMANCE EXAM CHECKLIST****METHOD B****SIEVE ANALYSIS OF FINE AND COARSE AGGREGATES****FOP FOR AASHTO T 27****MATERIALS FINER THAN 75  $\mu\text{m}$  (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.**

<b>Procedure Element</b>	<b>Trial 1</b>	<b>Trial 2</b>
1. Minimum sample mass meets requirement of Table 1?	_____	_____
2. Sample dried to a constant mass by FOP for AASHTO T 255?	_____	_____
3. Sample cooled, and original dry mass of the sample recorded to the nearest 0.1 percent or 0.1 g?	_____	_____
4. Sample placed in container and covered with water?	_____	_____
5. Contents of the container vigorously agitated?	_____	_____
6. Suspension of minus 75 $\mu\text{m}$ (No. 200) achieved?	_____	_____
7. Wash water poured through nested sieves such as 2 mm (No. 10) and 75 $\mu\text{m}$ (No. 200)?	_____	_____
8. Operation continued until wash water is reasonably clear?	_____	_____
9. Material retained on sieves returned to washed sample?	_____	_____
10. Washed sample dried to a constant mass by FOP for AASHTO T 255?	_____	_____
11. Washed sample cooled, and dry mass recorded to nearest 0.1 percent or 0.1 g?	_____	_____
12. Sample placed in nest of sieves specified? (Additional sieves may be used to prevent overloading as allowed in FOP.)	_____	_____
13. Material sieved in verified mechanical shaker for proper time?	_____	_____
14. Mass of material on each sieve and pan determined to the nearest 0.1 percent or 0.1 g?	_____	_____
15. Total mass of material after sieving agrees with mass before sieving to within 0.3 percent (coarse check sum)?	_____	_____

**OVER**

Procedure Element	Trial 1	Trial 2
16. Material in pan reduced in accordance with FOP for AASHTO R 76 to at least 500 g?	_____	_____
17. Mass of minus 4.75 mm (No. 4) split recorded to the nearest 0.1 g?	_____	_____
18. Sample placed in nest of sieves specified? (Additional sieves may be used to prevent overloading as allowed in FOP.)	_____	_____
19. Material sieved in verified mechanical shaker for proper time?	_____	_____
20. Mass of material on each sieve and pan recorded to the nearest percent or 0.1 g?	_____	_____
21. Total mass of material after sieving agrees with mass before sieving to within 0.3 percent (fine check sum)?	_____	_____
22. Percentages calculated to the nearest 0.1 percent and reported to the nearest whole number, except 75 $\mu$ m (No.200) which is reported to the nearest 0.1 percent?	_____	_____
23. Percentage calculations based on original dry mass of the sample?	_____	_____
24. Calculations performed properly?	_____	_____

Comments: First attempt: Pass\_\_\_\_\_Fail\_\_\_\_\_ Second attempt: Pass\_\_\_\_\_Fail\_\_\_\_\_

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Examiner Signature \_\_\_\_\_ WAQTC #: \_\_\_\_\_



**PERFORMANCE EXAM CHECKLIST****METHOD C****SIEVE ANALYSIS OF FINE AND COARSE AGGREGATES****FOP FOR AASHTO T 27****MATERIALS FINER THAN 75  $\mu\text{m}$  (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.**

<b>Procedure Element</b>	<b>Trial 1</b>	<b>Trial 2</b>
1. Minimum sample mass meets requirement of Table 1?	_____	_____
2. Sample dried to a constant mass by FOP for AASHTO T 255?	_____	_____
3. Sample cooled, and original dry mass of the sample recorded to the nearest 0.1 percent or 0.1 g?	_____	_____
4. Material aggregations and clay lumps, silt, or adhering fines broken up?	_____	_____
5. Sample placed in nest of sieves specified? (Additional sieves may be used to prevent overloading as allowed in FOP.)	_____	_____
6. Material sieved in verified mechanical shaker for proper time?	_____	_____
7. Mass of material on each sieve and in pan determined to the nearest 0.1 percent or 0.1 g?	_____	_____
8. Complete separation of coarse and fine particles achieved?	_____	_____
9. Total mass of material after sieving agrees with original dry mass of sample to within 0.3 percent (coarse check sum)?	_____	_____
10. Material in pan reduced to test size for washing in accordance with FOP for AASHTO R 76?	_____	_____
11. Mass of the minus 4.75 mm (No. 4) split sample recorded to the nearest 0.1 g?	_____	_____
12. Test sample placed in container and covered with water?	_____	_____
13. Contents of the container vigorously agitated?	_____	_____
14. Suspension of minus 75 $\mu\text{m}$ (No. 200) achieved?	_____	_____

**OVER**

Procedure Element	Trial 1	Trial 2
15. Wash water poured through a set of nested sieves, such as a 2.0 mm (No. 10) over the 75 $\mu$ m (No. 200)?	_____	_____
16. Operation continued until wash water is reasonably clear?	_____	_____
17. Material retained on sieves returned to washed sample?	_____	_____
18. Washed test sample dried to a constant mass in accordance with FOP for AASHTO T 255?	_____	_____
19. Washed test sample cooled, and dry mass recorded to the nearest 0.1 g?	_____	_____
20. Test sample placed in nest of sieves specified? (Additional sieves may be used to prevent overloading as allowed in FOP.)	_____	_____
21. Material sieved in verified mechanical shaker for proper time?	_____	_____
22. Mass of material on each sieve and in pan determined to nearest 0.1g?	_____	_____
23. Total mass of material after sieving agrees with mass after washing to within 0.3 percent (fine check sum)?	_____	_____
24. Percentages calculated to the nearest 0.1 percent and reported to the nearest whole number, except 75 $\mu$ m (No. 200) which is reported to the nearest 0.1 percent?	_____	_____
25. Calculations performed, and results reported properly?	_____	_____
26. Percentage calculations based on original dry mass of the sample?	_____	_____

Comments: First attempt: Pass\_\_\_\_\_Fail\_\_\_\_\_ Second attempt: Pass\_\_\_\_\_Fail\_\_\_\_\_

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Examiner Signature \_\_\_\_\_ WAQTC #: \_\_\_\_\_

## **DETERMINING THE PERCENTAGE OF FRACTURE IN COARSE AGGREGATE FOP FOR AASHTO T 335**

### **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 the FOP for AASHTO T 27/T 11.
- 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 R 90 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**  
**Sample Size**  
**Method 1 (Combined Sieve Fracture)**

Nominal Maximum Size* mm (in.)	Minimum Cumulative Sample Mass Retained on 4.75 mm (No. 4) Sieve g (lb)
37.5 (1 1/2)	2500 (6)
25.0 (1)	1500 (3.5)
19.0 (3/4)	1000 (2.5)
12.5 (1/2)	700 (1.5)
9.5 (3/8)	400 (0.9)
4.75 (No. 4)	200 (0.4)

\* 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 2**  
**Sample Size**  
**Method 2 (Individual Sieve Fracture)**

Sieve Size mm (in.)	Minimum Sample Mass g (lb)
31.5 (1 1/4)	1500 (3.5)
25.0 (1)	1000 (2.2)
19.0 (3/4)	700 (1.5)
16.0 (5/8)	500 (1.0)
12.5 (1/2)	300 (0.7)
9.5 (3/8)	200 (0.5)
6.3 (1/4)	100 (0.2)
4.75 (No. 4)	100 (0.2)
2.36 (No. 8)	25 (0.1)
2.00 (No. 10)	25 (0.1)

**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.
2. Examine each particle face and determine if the particle meets the fracture criteria.
3. Separate the sample into three categories:
  - Fractured particles meeting the criteria
  - Particles not meeting the criteria
  - Questionable or borderline particles
4. Determine the dry mass of particles in each category to the nearest 0.1 g.
5. Calculate the percent questionable particles.

6. Resort the questionable particles when more than 15 percent is present. Continue sorting until there is no more than 15 percent in the questionable category.
7. Calculate the percent fractured particles meeting criteria to nearest 0.1 percent. Report to 1 percent.

### Calculation

Calculate the mass percentage of questionable 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:

$$\%Q = \frac{97.6 \text{ g}}{632.6 \text{ g} + 97.6 \text{ g} + 352.6 \text{ g}} \times 100 = 9.0\%$$

where:

Mass of fractured particles = 632.6 g  
Mass of questionable particles = 97.6 g  
Mass of unfractured particles = 352.6 g

Calculate the mass percentage of fractured faces to the nearest 0.1 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:**

$$P = \frac{\frac{97.6 \text{ g}}{2} + 632.6 \text{ g}}{632.6 \text{ g} + 97.6 \text{ g} + 352.6 \text{ g}} \times 100 = 62.9\% \quad \text{Report 63\%}$$

where:

Mass of fractured particles	=	632.6 g,
Mass of questionable particles	=	97.6 g
Mass of unfractured particles	=	352.6 g

**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.**

<b>Procedure Element</b>	<b>Trial 1</b>	<b>Trial 2</b>
1. Sample properly sieved through specified sieve(s)?	_____	_____
2. Sample reduced to correct size?	_____	_____
3. Sample dried and cooled, if necessary?	_____	_____
4. Particles separated into fractured, unfractured, and questionable categories?	_____	_____
5. Dry mass of each category determined to nearest 0.1 g?	_____	_____
6. Questionable category resorted if more than 15 percent of total mass falls in that category?	_____	_____
7. Fracture calculation performed correctly?	_____	_____

Comments: First attempt: Pass\_\_\_\_Fail\_\_\_\_ Second attempt: Pass\_\_\_\_Fail\_\_\_\_

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**Examiner Signature** \_\_\_\_\_ **WAQTC #:** \_\_\_\_\_



## **PLASTIC FINES IN GRADED AGGREGATES AND SOILS BY THE USE OF THE SAND EQUIVALENT TEST FOP FOR AASHTO T 176**

### **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  $1000 \pm 5\text{g}$ . 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  $915 \pm 25\text{ mm}$  ( $36 \pm 1\text{ in.}$ ) above the work surface.
- Measuring can: With a capacity of  $85 \pm 5\text{ mL}$  (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  $45 \pm 5$  seconds, with a hand assisted half stroke length of  $127 \pm 5$  mm ( $5 \pm 0.2$  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  $110 \pm 5^{\circ}\text{C}$  ( $230 \pm 9^{\circ}\text{F}$ ).
- Thermometer: Calibrated liquid-in-glass or electronic digital type designed for total immersion and accurate to  $0.1^{\circ}\text{C}$  ( $0.2^{\circ}\text{F}$ ).

## Materials

- Stock calcium chloride solution: Obtain commercially prepared calcium chloride stock solution meeting AASHTO requirements.
- Working calcium chloride solution: Make 3.8 L (1 gal) of working solution. Fill the bottle with 2 L (1/2 gal) of distilled or demineralized water, add one 3 oz. measuring can ( $85 \pm 5$  mL) of stock calcium chloride solution. Agitate vigorously for 1 to 2 minutes. Add the remainder of the water, approximately 2 L (1/2 gal.) for a total of 3.8 L (1 gal) of working solution. Repeat the agitation process. Tap water may be used if it is proven to be non-detrimental to the test and if it is allowed by the agency. The shelf life of the working solution is approximately 30 days. Label working solution with the date mixed. 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.

## Control

The temperature of the working solution should be maintained at  $22 \pm 3^{\circ}\text{C}$  ( $72 \pm 5^{\circ}\text{F}$ ) 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 R 90 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.

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 2:** 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 3:** 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 4:** Clean sands having little 75  $\mu\text{m}$  (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. Siphon  $101.6 \pm 2.5$  mm ( $4 \pm 0.1$  in.) of working calcium chloride solution into the plastic cylinder.
2. Pour the prepared test sample from the measuring can into the plastic cylinder, using the funnel to avoid spilling.
3. 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.
4. Allow the wetted sample to stand undisturbed for  $10 \pm 1$  minutes.
5. 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.
6. 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  $45 \pm 1$  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  $229 \text{ mm} \pm 25 \text{ mm}$  ( $9 \pm 1$  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.

7. Set the cylinder upright on the work table and remove the stopper.
8. 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 5:** 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.

9. Allow the cylinder and contents to stand undisturbed for 20 minutes  $\pm 15$  seconds. Start timing immediately after withdrawing the irrigator tube.

**Note 6:** 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.

10. 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 7:** 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  $\pm 4$ , 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  $\pm 4$ , based on the average result, additional tests shall be run.

## Calculations

Calculate the SE to the nearest 0.1 using the following formula:

$$SE = \frac{\text{Sand Reading}}{\text{Clay Reading}} \times 100$$

### Example:

$$\begin{array}{lcl} \text{Sand Reading} & = & 3.3 \\ \text{Clay Reading} & = & 8.0 \end{array}$$

$$SE = \frac{3.3}{8.0} \times 100 = 41.25 \text{ or } 41.3 \quad \text{Report 42}$$

**Note 8:** This example reflects the use of equipment made with English units. At this time, equipment made with metric units is not available.

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.

When averaging two or more samples, raise each calculated SE value to the next higher whole number (reported value) before averaging.

### Example:

$$\begin{array}{lcl} \text{calculated value 1} & = & 41.3 \\ \text{calculated value 2} & = & 42.8 \end{array}$$

These values are reported as 42 and 43, respectively.



Average the two reported values:

$$\text{Average SE} = \frac{42 + 43}{2} = 42.5 \quad \text{Report 43}$$

If the average value is not a whole number, raise it to the next higher whole number.

## Report

- Results on forms approved by the agency
- Sample ID
- Results to the next higher 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.**

<b>Procedure Element</b>	<b>Trial 1</b>	<b>Trial 2</b>
<b>Sample Preparation</b>		
1. Sample passed through 4.75 mm (No. 4) sieve?	_____	_____
2. Material in clods broken up and re-screened?	_____	_____
3. Split or quarter 1,000 to 1,500 g 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.	_____	_____
4. No fines lost?	_____	_____
5. Working solution dated?	_____	_____
6. Temperature of working solution $22 \pm 3^{\circ}\text{C}$ ( $72 \pm 5^{\circ}\text{F}$ )?	_____	_____
7. Working calcium chloride solution $915 \pm 25$ mm ( $36 \pm 1$ in) above the work surface?	_____	_____
8. $101.6 \pm 2.5$ mm ( $4 \pm 0.1$ in) working calcium chloride solution siphoned into cylinder?	_____	_____
9. Material checked for moisture condition by tightly squeezing small portion in palm of hand and forming a cast?	_____	_____
10. Sample at proper water content?		
a. If too dry (cast crumbles easily) water added, re-mixed, covered, and allowed to stand for at least 15 minutes?	_____	_____
b. If too wet (shows free water) sample drained, air dried and mixed frequently?	_____	_____
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?	_____	_____
12. Is material thoroughly mixed?	_____	_____
13. When material appears to be homogeneous, mixing finished with sample in a pile near center of cloth?	_____	_____
14. Fill the 85 mL (3 oz) tin by pushing through base of pile with other hand on opposite side of pile?	_____	_____

**OVER**

Procedure Element	Trial 1	Trial 2
15. Material fills tin to overflowing?	_____	_____
16. Material compacted into tin with palm of hand?	_____	_____
17. Tin struck off level full using spatula or straightedge?	_____	_____
18. Prepared sample funneled into cylinder with no loss of fines?	_____	_____
19. Bottom of cylinder tapped sharply on heel of hand several times to release air bubbles?	_____	_____
20. Wetted sample allowed to stand undisturbed for 10 min. $\pm 1$ min.?	_____	_____
21. Cylinder stoppered and material loosened from bottom by shaking?	_____	_____
22. Stoppered cylinder placed properly in mechanical shaker and cylinder shaken $45 \pm 1$ seconds?	_____	_____
23. Following shaking, cylinder set vertical on work surface and stopper removed?	_____	_____
24. Irrigator tube inserted in cylinder and material rinsed from cylinder walls as irrigator is lowered?	_____	_____
25. Irrigator tube forced through material to bottom of cylinder by gentle stabbing and twisting action?	_____	_____
26. Stabbing and twisting motion applied until cylinder filled to 381 mm (15 in.) mark?	_____	_____
27. Liquid raised and maintained at 381 mm (15 in.) mark while irrigator is being withdrawn?	_____	_____
28. Liquid at the 381 mm (15 in.) mark?	_____	_____
29. Contents let stand 20 minutes $\pm 15$ seconds?	_____	_____
30. Timing started immediately after withdrawal of irrigator?	_____	_____
31. No vibration or disturbance of the sample?	_____	_____
32. Readings taken at 20 minutes or up to 30 minutes, when a definite line appears?	_____	_____
33. Clay level correctly read, rounded, and recorded?	_____	_____
34. Weighted foot assembly lowered into cylinder without hitting mouth of cylinder?	_____	_____
35. Sand level correctly read, rounded, and recorded?	_____	_____
36. Calculations performed correctly?	_____	_____
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

**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 6a:

Only the Mechanical Method will be used.

**Delete** Step 6b and 6c.



## **SAMPLING OF ASPHALT MIXTURES FOP FOR AASHTO R 97**

### **Scope**

This procedure covers the sampling of asphalt mixtures from plants, haul units, and roadways in accordance with AASHTO R 47-19. Sampling is as important as testing, use care to obtain a representative sample and to avoid segregation and contamination of the material during sampling.

### **Apparatus**

- Shovel or Metal Scoops, or Other Equipment: square-head metal shovels at least 125 mm (5.5 in.) wide.
- Sample containers: such as cardboard boxes, metal cans, stainless steel bowls, or other agency-approved containers
- 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. A minimum of one hole 6 mm (0.25 in.) in diameter must be provided in a corner of the plate.
- 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 50 mm (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: a permanently attached device that allows a sample receptacle 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.
- Release agent: a non-stick product that prevents the asphalt mixture from sticking to the apparatus and does not contain solvents or petroleum-based products that could affect asphalt binder properties.

### **Sample Size**

Sample size depends on the test methods specified by the agency for acceptance. Check agency requirement for the size required.

### **Procedure**

#### **General**

- Select sample locations using a random or stratified random sampling procedure, as specified by the agency. 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.

- Ensure the container(s) and sampling equipment are clean and dry before sampling.
- 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 asphalt binder will not migrate from the aggregate.

### **Attached Sampling Devices**

These are normally permanently attached devices that allow a sample container to pass perpendicularly through the entire stream of material. Operation may be hydraulic, pneumatic, or manual and allows the sample container to pass through the stream twice, once in each direction, without overfilling. A sampling device may also divert the entire stream into a sampling receptacle.

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. Transfer the asphalt mixture to an agency-approved container without loss of material.
4. Repeat until proper sample size has been obtained.
5. Combine the increments to form a single sample.

### **Conveyor Belts**

1. Avoid sampling at the beginning or end of an asphalt mixture production run due to the potential for segregation.
2. Stop the belt containing asphalt mixture.
3. Set the sampling template into the asphalt mixture on the belt, avoiding intrusion by adjacent material.
4. Remove the asphalt mixture from inside the template, including all fines, and place in a sample container.
5. Repeat, obtaining equal size increments, until proper sample size has been obtained.
6. Combine the increments to form a single sample.



## 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.

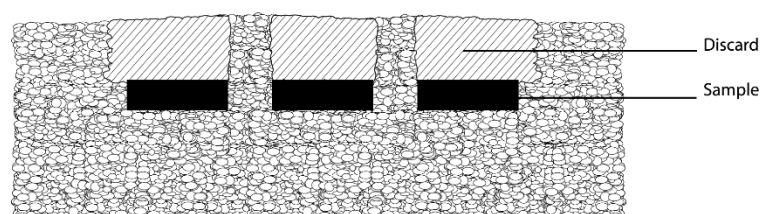
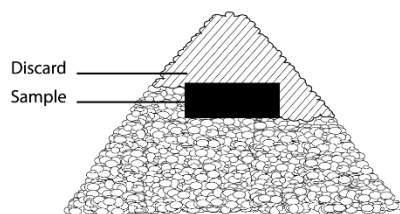
## Paver Auger

1. Obtain samples from the end of the auger using a square head shovel.
2. Place the shovel in front of the auger extension, with the shovel blade flat upon the surface to be paved over.
3. Allow the front face of the auger stream to cover the shovel with asphalt mixture, remove the shovel before the auger reaches it by lifting as vertically as possible.
4. Place asphalt mixture in a sample container.
5. Repeat until proper sample size has been obtained.
6. Combine the increments to form a sample of the required size.

**Note 1:** First full shovel of material may be discarded to preheat and 'butter' the shovel.

## Windrow

1. Obtain samples from the windrow of a transport unit. Avoid the beginning or the end of the windrow section.
2. Visually divide the windrow into approximately three equal sections.
3. Remove approximately 0.3 m (1 ft) from the top of each section.
4. Fully insert the shovel into the flat surface as vertically as possible, exclude the underlying material, roll back the shovel and lift the material slowly out of the windrow to avoid material rolling off the shovel.
5. Place in a sample container.
6. Repeat, obtaining equal size increments, in each of the remaining thirds.
7. Combine the increments to form a sample of the required size.



## Roadway before Compaction

There are two conditions that will be encountered when sampling asphalt mixtures from the roadway before compaction. The two conditions are:

- Laying asphalt mixture on grade or untreated base material requires Method 1.
- Laying asphalt mixture on existing asphalt or laying a second lift of asphalt mixture 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 asphalt mixture.

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 (Plate Method)**

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.

*Note 2:* The plate may be secured by driving a nail through the hole in the lead corner of the plate.

2. Pull the wire, attached to the outside corner of the plate, taut past the edge of the asphalt mixture mat and secure it. Let the paving operation pass over the plate and wire.
3. Using the exposed end of the wire, pull the wire up through the fresh asphalt mixture to locate the corner of the plate.

- a. Plate only:
  - i. Using a small square head shovel or scoop, or both, remove the full depth of the asphalt mixture from the plate. Take care to prevent sloughing of adjacent material.
  - ii. Place asphalt mixture, including any material adhering to the plate and scoop or shovel in a sample container.
- b. “Cookie Cutter”:
  - i. 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 asphalt mixture to the plate.
  - ii. Using a small square tipped shovel or scoop, or both, carefully remove all the asphalt mixture from inside of the cutter and place in a sample container.
  - iii. Remove the sample cutter and the plate from the roadway. The hole made from the sampling must be filled by the contractor with loose asphalt mixture.

### **Method 2 - Obtaining a Sample on Asphalt Surface (Non-plate Method)**

1. After the paving machine has passed the sampling point, immediately place the “cookie cutter” sampling device on the location to be sampled.
2. Push the cutter down through the asphalt mixture until it is flat against the underlying asphalt mat.
3. Using a small square tipped shovel or scoop, or both, carefully remove all the asphalt mixture from inside of the cutter and place in a sample container.
4. Remove the cutter from the roadway. The hole made from the sampling must be filled by the contractor with loose asphalt mixture.

### **Stockpiles**

Remove at least 0.1 m (4 in.) from the surface before sampling; mixtures in a stockpile may develop an oxidized crust.

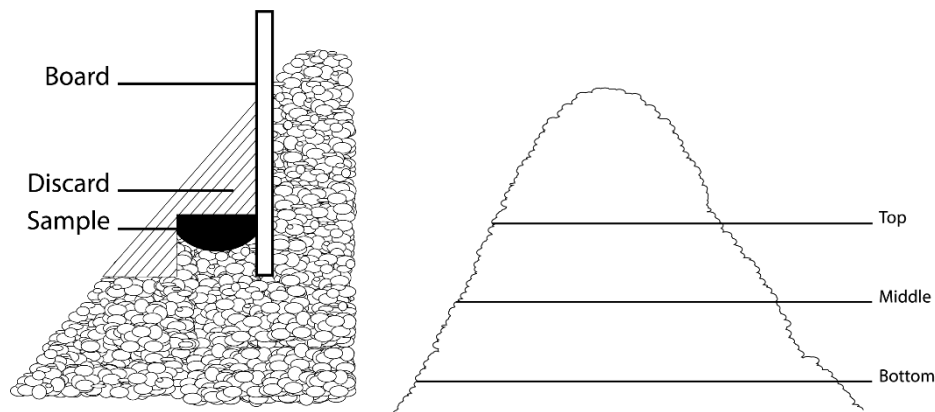
#### **Method 1 – Loader**

1. Direct the loader operator to enter the stockpile with the bucket at least 0.3 m (1 ft) above ground level without contaminating the stockpile.
2. Obtain a full loader bucket of the asphalt mixture; tilt the bucket back and up.
3. Form a small sampling pile at the base of the stockpile by gently rolling the asphalt mixture out of the bucket with the bucket just high enough to permit free-flow of the mixture. Repeat as necessary.

4. Create a flat surface by having the loader "back-drag" the small pile.
5. Obtain approximately equal increments from at least three randomly selected locations on the flat surface at least 0.3 m (1 ft) from the edge.
6. Fully insert the shovel, exclude the underlying material, roll back the shovel and lift the asphalt mixture slowly out of the pile to avoid mixture rolling off the shovel.
7. Combine the increments to form a sample.

## Method 2 – Stockpile Face

1. Create horizontal surfaces with vertical faces in the top, middle, and bottom third of the stockpile with a shovel or a loader if one is available.
2. Shove a flat board against the vertical face behind the sampling location to prevent sloughing of asphalt mixture. Discard the sloughed mixture to create the horizontal surface.
3. Obtain the sample from the horizontal surface as close as possible to the intersection of the horizontal and vertical faces.
4. Obtain at least one sample 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.



## 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 ASPHALT MIXTURES FOP FOR AASHTO R 97

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
<b>Attached Sampling Device</b>		
1. Container coated or preheated or both?	_____	_____
2. Sampling device passed through stream twice perpendicular to material?	_____	_____
3. Sampling device not over filled?	_____	_____
<b>Conveyor Belt</b>		
4. Belt stopped?	_____	_____
5. Sampling template set on belt, avoiding intrusion of adjacent material?	_____	_____
6. Sample, including all fines, scooped off?	_____	_____
<b>Haul Units</b>		
7. Unit divided into four quadrants?	_____	_____
8. Increment obtained from each quadrant, 0.3 m (1ft.) below surface?	_____	_____
9. Increments combined to make up the sample?	_____	_____
<b>Paver Auger</b>		
10. Shovel blade flat on the surface to be paved?	_____	_____
11. Shovel lifted vertically after it is filled?	_____	_____
<b>Windrow</b>		
12. Beginning and end avoided?	_____	_____
13. Equal increments obtained from three sections?	_____	_____
14. Approximately 0.3 m (1 ft) removed from top of each section?	_____	_____
15. Underlying material excluded?	_____	_____
<b>Roadway Before Compaction (Method 1)</b>		
16. Plate placed well in front of paver?	_____	_____
17. Wire pulled to locate plate corner?	_____	_____

**OVER**

Procedure Element	Trial 1	Trial 2
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18. Cookie cutter (if used) placed on asphalt and pushed through to plate?	_____	_____
--	-------	-------

19. All material removed from inside the cutter?	_____	_____
--	-------	-------

**Roadway Before Compaction (Method 2)**

20. Cookie cutter placed on asphalt and pushed through to underlying material?	_____	_____
--	-------	-------

21. All material removed from inside the cutter?	_____	_____
--	-------	-------

**Stockpile Method 1– (Loader sampling)**

22. Loader operator directed to enter the stockpile with the bucket at least 0.3 m (1 ft) above ground level without contaminating the stockpile?	_____	_____
---	-------	-------

23. The loader obtained a full loader bucket of the material with the bucket tilted back and up?	_____	_____
--	-------	-------

24. 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?	_____	_____
--	-------	-------

25. A flat surface created by the loader back dragging the small pile?	_____	_____
--	-------	-------

26. Increment sampled from three locations at least 0.3 m (1 ft) from the edge by fully inserting the shovel into the flat pile as vertically as possible, care taken to exclude the underlying material?	_____	_____
---	-------	-------

**Stockpile Method 2 (Stockpile Face)**

27. Created horizontal surfaces with vertical faces?	_____	_____
--	-------	-------

28. Sample obtained from the horizontal face as close as possible to the vertical face?	_____	_____
---	-------	-------

29. At least one increment taken from each of the top, middle, and bottom thirds of the stockpile?	_____	_____
--	-------	-------

**General**

30. Sample placed in appropriate container?	_____	_____
---	-------	-------

31. Sample size meets agency requirements?	_____	_____
--	-------	-------

32. Sample identified as required?	_____	_____
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Comments:	First attempt: Pass_____Fail_____	Second attempt: Pass_____Fail_____	
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**Examiner Signature** \_\_\_\_\_

**WAQTC #:** \_\_\_\_\_



## PERFORMANCE EXAM CHECKLIST (ORAL)

### SAMPLING ASPHALT MIXTURES FOP FOR AASHTO R 97

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
<b>1. At the hot plant, how must a sample be obtained using an attached sampling device?</b>		
a. Coat or preheat sample container.	_____	_____
b. Sampling device passed through stream twice perpendicular to material.	_____	_____
c. The sampling device cannot be overfilled.	_____	_____
<b>2. How is a sample obtained from a conveyor belt?</b>		
a. Stop the belt.	_____	_____
b. Set the sampling template on belt, avoiding intrusion of adjacent material.	_____	_____
c. All the material is removed from belt including all fines.	_____	_____
<b>3. What must be done to sample from transport units?</b>		
a. Divide the unit into four quadrants.	_____	_____
b. Obtain increments from each quadrant, 0.3 m (1 ft) below surface.	_____	_____
<b>4. How is a sample obtained from the paver auger?</b>		
a. Shovel blade is placed flat on the surface to be paved in front of the auger extension?	_____	_____
b. Shovel is filled and removed by lifting as vertically as possible?	_____	_____
<b>5. Describe the procedure for sampling from a windrow.</b>		
a. Do not sample from the beginning or end of the windrow.	_____	_____
b. Approximately 0.3 m (1 ft) removed from the top.	_____	_____
c. Underlying material is excluded	_____	_____
d. Equal increments obtained from 3 locations along the windrow.	_____	_____

**OVER**

<b>Procedure Element</b>	<b>Trial 1</b>	<b>Trial 2</b>
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**6. Describe how to take samples from the roadway using Method 1 (plate).**

- |  |       |       |
|--|-------|-------|
| a. Place the plate well in front of the paver.   | _____ | _____ |
| b. Pull the wire to locate the corner of the plate.  | _____ | _____ |
| c. Place the cutter (if used) on the asphalt material above the plate and push it down to the plate. | _____ | _____ |
| d. Collect all the material inside the cutter.   | _____ | _____ |

**7. Describe how to take samples from the roadway using Method 2.**

- |  |       |       |
|--|-------|-------|
| a. Place the cutter on the asphalt material and push it down to the underlying material. | _____ | _____ |
| b. Collect all the material inside the cutter.   | _____ | _____ |

**8. Describe the procedure for sampling a stockpile Method 1 (Loader Sampling).**

- |   |       |       |
|---|-------|-------|
| a. Loader removes surface and creates sampling pile.  | _____ | _____ |
| b. Loader back drags pile to create a flat surface.   | _____ | _____ |
| c. Take three approximately equal increments from at least 0.3 m (1 ft) from the edge, excluding the underlying material. | _____ | _____ |

**9. Describe the procedure for sampling a stockpile Method 2 (Stockpile Face Sampling).**

- |   |       |       |
|---|-------|-------|
| a. Create horizontal surfaces with vertical faces with a shovel.                                  | _____ | _____ |
| b. At least one increment taken from each of the top, middle, and bottom thirds of the stockpile. | _____ | _____ |

**10. Increments combined to form a sample of required size?**

_____	_____	_____
-------	-------	-------

**11. What types of containers can be used?**

- |   |       |       |
|---|-------|-------|
| a. Cardboard boxes, stainless steel bowls, or other agency approved containers. | _____ | _____ |
|---|-------|-------|

**12. What dictates size of sample?**

- |                              |       |       |
|------------------------------|-------|-------|
| a. Agency requirements.      | _____ | _____ |
| b. Specified by test method. | _____ | _____ |

Comments:      First attempt:    Pass\_\_\_\_\_Fail\_\_\_\_\_      Second attempt:    Pass\_\_\_\_\_Fail\_\_\_\_\_

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Examiner Signature \_\_\_\_\_      WAQTC #: \_\_\_\_\_

## **FOP for AASHTO R 97**

### Sampling of Bituminous Paving Mixtures

#### **Sampling from the Roadway Prior to Compaction (Plate Method).**

**Add** the following after the fourth paragraph

When the sample container is large enough to accommodate the full dimensions of the sampling plate a sample may be obtained without using the “cookie cutter”, see Method 3.

**Add** the following after Method 2

#### **Method 3 - Obtaining Sample Without the “Cookie Cutter” Device:**

1. Following the safety rules detailed above, smooth out a location in front of the paver at least 2 ft. inside the edge of the mat.
2. 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.
3. Secure the plate in place by driving a nail through the hole in the lead corner of the plate.
4. Pull the wire, attached to the outside corner of the plate, taut past the edge of the HMA mat and secure with a nail.
5. Let the paving operation proceed over the plate and wire. Immediately proceed with the sampling.
6. Using the exposed end of the wire, pull the wire up through the fresh HMA to locate the corner of the plate.
7. Lift the sampling plate and the HMA sample carefully placed directly into the sample container.
8. 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.



## **REDUCING SAMPLES OF ASPHALT MIXTURES TO TESTING SIZE FOP FOR AASHTO R 47**

### **Scope**

This procedure covers sample reduction of asphalt mixtures to testing size in accordance with AASHTO R 47-19. 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 asphalt mixture samples from the quartering device, cleaning surfaces used for splitting, etc.
- Square-tipped, flat-bottom scoop, shovel or trowel for mixing asphalt mixture before quartering.
- Miscellaneous equipment including hot plate, non-asbestos heat-resistant gloves or mittens, pans, buckets, and cans.
- Sheeting: Non-stick heavy paper 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 B (Riffle): having a minimum of eight equal-width chutes discharging alternately to each side with a minimum chute width of at least 50 percent 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 asphalt mixture through the chutes without segregation or loss of material. Sample receptacles of sufficient width and capacity to receive the reduced portions of asphalt mixture from the 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 asphalt mixture by an amount allowing complete separation of the quartered sample. Height of the sides must exceed the thickness of the flattened cone of asphalt mixture.
- Non-stick mixing surface that is hard, heat-resistant, clean, level, and large enough to permit asphalt mixture samples to be mixed without contamination or loss of material.

### **Sampling**

Obtain samples according to the FOP for AASHTO R 97.

## 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 asphalt mixture may be performed by a combination of the following methods, as approved by the agency. The methods for reduction are:

- Mechanical Splitter Type B (Riffle) Method
- Quartering Method
  - Full Quartering
  - By Apex
- Incremental Method

## Procedure

When heating of the equipment is desired, it shall be heated to a temperature not to exceed the maximum mixing temperature of the job mix formula (JMF).

### Mechanical Splitter Type B (Riffle) Method

1. Clean the splitter and apply a light coating of approved release agent to the surfaces that will come in contact with asphalt mixture (hopper or straight-edged pan, chutes, receptacles).
2. Place two empty receptacles under the splitter.
3. Carefully empty the asphalt mixture 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.
4. Discharge the asphalt mixture at a uniform rate, allowing it to flow freely through the chutes.
5. Any asphalt mixture that is retained on the surface of the splitter shall be removed and placed into the appropriate receptacle.
6. Reduce the remaining asphalt mixture as needed by this method or a combination of the following methods as approved by the agency.

7. Using one of the two receptacles containing asphalt mixture, repeat the reduction process until the asphalt mixture contained in one of the two receptacles is the appropriate size for the required test.
8. After each split, remember to clean the splitter hopper and chute surfaces if needed.
9. Retain and properly identify the remaining unused asphalt mixture sample for further testing if required by the agency.

### **Quartering Method**

1. If needed, apply a light coating of release agent to quartering template.
2. 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.
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. 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.
5. Divide the flattened cone into four equal quarters using the quartering template or straightedges assuring complete separation.
6. Reduce to appropriate sample mass by full quartering or by apex.

### **Full Quartering**

- a. Remove diagonally opposite quarters, including all of the fine material, and place in a container to be retained.
- b. Remove the quartering template, if used.
- c. Combine the remaining quarters.
- d. If further reduction is necessary, repeat Quartering Method Steps 3 through 6.
- e. Repeat until appropriate sample mass is obtained. The final sample must consist of the two remaining diagonally opposite quarters.
- f. Retain and properly identify the remaining unused portion of the asphalt mixture sample for further testing if required by the agency.

**Reducing by Apex**

- a. Using a straightedge, slice through a quarter of the asphalt mixture from the center point to the outer edge of the quarter.
- b. Pull or drag the material from the quarter with two straight edges or hold one edge of the straightedge in contact with quartering device.
- c. Remove an equal portion from the diagonally opposite quarter and combine these increments to create the appropriate sample mass.
- d. Continue using the apex method with the unused portion of the asphalt mixture until samples have been obtained for all required tests.
- e. Retain and properly identify the remaining unused portion of the asphalt mixture 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:
  - a. Use a flat-bottom scoop; or
  - b. Alternately lift each corner of the sheeting and pull it over the sample diagonally toward the opposite corner, causing the material to be rolled.
4. 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. 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.
6. Remove one quarter of the length of the loaf and place in a container to be saved; by either:
  - a. Pull sheeting over edge of counter and drop material into container.
  - b. Use a straightedge at least as wide as the full loaf to slice off material and place into container.
7. Obtain an appropriate sample mass for the test to be performed; by either:
  - a. Pull sheeting over edge of counter and drop cross sections of the material into container until proper sample mass has been obtained.
  - b. Use a straightedge at least as wide as the full loaf to slice off cross sections of the material until proper sample mass has been obtained and place into container.

**Note 1:** 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. Repeat Step 7 until all the samples for testing have been obtained or until final quarter of the original loaf is reached.
9. Retain and properly identify the remaining unused portion of the asphalt mixture sample for further testing if required by the agency.



## PERFORMANCE EXAM CHECKLIST

### REDUCING SAMPLES OF ASPHALT MIXTURES 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.**

<b>Procedure Element</b>	<b>Trial 1</b>	<b>Trial 2</b>
1. Sample made soft enough to separate easily without exceeding temperature limits?	_____	_____
2. Splitting apparatus and tools, if preheated, not exceeding maximum mixing temperature from the JMF?	_____	_____
<b>Mechanical Splitter Type B (Riffle) Method</b>		
1. Splitter cleaned, and surfaces coated with release agent?	_____	_____
2. Two empty receptacles placed under splitter?	_____	_____
3. Sample placed in hopper or straight edged pan without loss of material and uniformly distributed from side to side?	_____	_____
4. Material discharged across chute assembly at controlled rate allowing free flow of asphalt mixture through chutes?	_____	_____
5. Splitter surfaces cleaned of all retained asphalt mixture allowing it to fall into appropriate receptacles?	_____	_____
6. Further reduction with the riffle splitter:		
a. Material from one receptacle discharged across chute assembly at controlled rate, allowing free flow of asphalt mixture through chutes?	_____	_____
b. Splitting process continued until appropriate sample mass obtained, with splitter surfaces cleaned of all retained asphalt mixture after every split?	_____	_____
7. Remaining unused asphalt mixture stored in suitable container, properly labeled?	_____	_____

**OVER**

Procedure Element	Trial 1	Trial 2
<b>Quartering Method</b>		
1. Sample placed in a conical pile on a hard, non-stick, heat-resistant splitting surface such as metal or sheeting?	_____	_____
2. Sample mixed by turning the entire sample over a minimum of 4 times?	_____	_____
3. Conical pile formed and then flattened uniformly to diameter equal to about 4 to 8 times thickness?	_____	_____
4. Sample divided into 4 equal portions either with a metal quartering template or straightedges such as drywall taping knives?	_____	_____
5. Reduction by Full Quartering:		
a. Two diagonally opposite quarters removed and placed in a container to be retained?	_____	_____
b. Two other diagonally opposite quarters combined?	_____	_____
c. Process continued, if necessary, until appropriate sample mass has been achieved?	_____	_____
6. Reduction by Apex:		
a. Using two straightedges or a quartering device and one straightedge, was one of the quarters split from apex to outer edge of material?	_____	_____
b. Similar amount of material taken from the diagonally opposite quarter?	_____	_____
c. Increments combined to produce appropriate sample mass?	_____	_____
7. Remaining unused asphalt mixture stored in suitable container, properly labeled?	_____	_____

**OVER**

**Procedure Element**

**Trial 1    Trial 2**

**Incremental Method**

- |  |       |       |
|--|-------|-------|
| 1. Sample placed on hard, non-stick, heat-resistant splitting surface covered with sheeting?           | _____ | _____ |
| 2. Sample mixed by turning the entire sample over a minimum of 4 times?                                | _____ | _____ |
| 3. Conical pile formed?  | _____ | _____ |
| 4. Asphalt mixture rolled into loaf and then flattened?  | _____ | _____ |
| 5. The first quarter of the loaf removed by slicing off or dropping off edge of counter and set aside? | _____ | _____ |
| 6. Proper sample mass sliced off or dropped off edge of counter into sample container?                 | _____ | _____ |
| 7. Process continued until all samples are obtained or final quarter is remaining?                     | _____ | _____ |
| 8. All remaining unused asphalt mixture stored in suitable container, properly labeled?                | _____ | _____ |

**Comments:**      First attempt:    Pass\_\_\_\_Fail\_\_\_\_      Second attempt:    Pass\_\_\_\_Fail\_\_\_\_

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**Examiner Signature** \_\_\_\_\_ **WAQTC #:** \_\_\_\_\_



## MOISTURE CONTENT OF ASPHALT MIXTURES BY OVEN METHOD FOP FOR AASHTO T 329

### 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  $163 \pm 14^{\circ}\text{C}$  ( $325 \pm 25^{\circ}\text{F}$ ).
- 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  $10\text{-}260^{\circ}\text{C}$  ( $50\text{-}500^{\circ}\text{F}$ ).

### Sample

The test sample shall be obtained in accordance with the FOP for AASHTO R 97 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  $163 \pm 14^{\circ}\text{C}$  ( $325 \pm 25^{\circ}\text{F}$ ) is to be used.

**Note 1:** For repeatability between laboratories, the preferred practice is to dry the sample at no less than  $9^{\circ}\text{C}$  ( $15^{\circ}\text{F}$ ) 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  $90 \pm 5$  minutes, and its mass determined. Then it shall be dried at  $30 \pm 5$  minute intervals until further drying does not alter the mass by more than 0.05 percent.
8. Cool the sample container and test sample to  $\pm 9^\circ\text{C}$  ( $\pm 15^\circ\text{F}$ ) 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.
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 3:** 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:

$$\% \text{ Change} = \frac{M_p - M_n}{M_p} \times 100$$

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:  $1360.4 \text{ g} - 232.6 \text{ g} = 1127.8 \text{ g}$

$$\% \text{ Change} = \frac{1129.2 \text{ g} - 1127.8 \text{ g}}{1129.2 \text{ g}} \times 100 = 0.12\%$$

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:  $1359.9 \text{ g} - 232.6 \text{ g} = 1127.3 \text{ g}$

$$\% \text{ Change} = \frac{1127.8 \text{ g} - 1127.3 \text{ g}}{1127.8 \text{ g}} \times 100 = 0.04\%$$

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.

$$\text{Moisture Content} = \frac{M_i - M_f}{M_f} \times 100$$

Where:

$M_i$  = initial, moist mass

$M_f$  = final, dry mass

**Example:**

$$M_i = 1134.9 \text{ g}$$

$$M_f = 1127.3 \text{ g}$$

$$\text{Moisture Content} = \frac{1134.9 \text{ g} - 1127.3 \text{ g}}{1127.3 \text{ g}} \times 100 = 0.674, \text{ say } 0.67\%$$

**Report**

- Results on forms approved by the agency
- Sample ID
- Moisture content to the nearest 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.**

Procedure Element	Trial 1	Trial 2
1. Mass of clean dry container including release media determined to 0.1 g?	_____	_____
2. Representative sample obtained; 1000 g minimum?	_____	_____
3. Initial temperature taken and recorded?	_____	_____
4. Mass of sample determined to 0.1 g?	_____	_____
5. Sample placed in drying oven for 90 ±5 minutes?	_____	_____
6. Sample dried at a temperature not to exceed the JMF mixing temp?	_____	_____
7. Constant mass checked at 30 ±5 minute intervals and reached?	_____	_____
8. Sample and container cooled to ±9°C (15°F) of the initial temperature before final mass determined to 0.1 g?	_____	_____
9. Calculation of moisture content performed correctly to 0.01 percent?	_____	_____

$$\text{Moisture Content} = \frac{M_i - M_f}{M_f} \times 100$$

Comments:      First attempt:   Pass\_\_\_\_\_Fail\_\_\_\_\_      Second attempt:   Pass\_\_\_\_\_Fail\_\_\_\_\_

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**Examiner Signature** \_\_\_\_\_ **WAQTC #:** \_\_\_\_\_



## **DETERMINING THE ASPHALT BINDER CONTENT OF ASPHALT MIXTURES BY THE IGNITION METHOD FOP FOR AASHTO T 308**

### **Scope**

This procedure covers the determination of asphalt binder content of asphalt mixtures by ignition of the binder in accordance with AASHTO T 308-18.

### **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 asphalt mixtures. When using recycled asphalt mixtures, check with the agency for specific correction procedures.

Asphalt binder in the asphalt mixture is ignited in a furnace. Asphalt binder content is calculated as the percentage difference between the initial mass of the asphalt mixture 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.

The apparatus for the Methods A and B is the same except that the furnace for Method A requires 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  $538 \pm 5^{\circ}\text{C}$  ( $1000 \pm 9^{\circ}\text{F}$ ).

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 asphalt 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. Perform lift test according to manufacturer’s instructions weekly during use, if applicable.

**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 asphalt 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 asphalt mixture in accordance with the FOP for AASHTO R 97.
2. Reduce asphalt mixture 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 asphalt binder content.

**Table 1**

<b>Nominal Maximum Aggregate Size* mm (in.)</b>	<b>Minimum Mass Specimen g</b>	<b>Maximum Mass Specimen g</b>
37.5 (1 ½)	4000	4500
25.0 (1)	3000	3500
19.0 (¾)	2000	2500
12.5 (½)	1500	2000
9.5 (¾)	1200	1700
4.75 (No. 4)	1200	1700

\* 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  $538 \pm 5^{\circ}\text{C}$  ( $1000 \pm 9^{\circ}\text{F}$ ) or to the temperature determined in the “Correction Factor” section, Step 9 of this method. Manually record the furnace temperature (set point) before 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 at room temperature 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 asphalt mixture.
7. Input the initial mass of the sample ( $M_i$ ) into the ignition furnace controller. Verify that the correct mass has been entered.

**CAUTION:** Operator should wear safety equipment – high temperature gloves, face shield, fire-retardant shop coat – when opening the door to load or unload the sample.

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  $\pm 5$  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 asphalt 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.

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 correction factor is not entered into the furnace controller

where:

$P_b$  = the corrected asphalt binder content as a percent by mass of the asphalt mixture

$BC$  = asphalt binder content shown on printed ticket

$MC$  = moisture content of the companion asphalt mixture sample, percent, as determined by the FOP for AASHTO T 329 (if the specimen was oven-dried before initiating the procedure,  $MC=0$ )

$C_f$  = correction factor as a percent by mass of the asphalt mixture sample

## Procedure – Method B (External Balance)

1. Preheat the ignition furnace to  $538 \pm 5^\circ\text{C}$  ( $1000 \pm 9^\circ\text{F}$ ) or to the temperature determined in the “Correction Factor” section, Step 9 of this method. Manually record the furnace temperature (set point) before 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 at room temperature 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 asphalt mixture.
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 asphalt mixture 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  $M_f$ .
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 asphalt mixture sample

$M_f$  = the final mass of aggregate remaining after ignition

$M_i$  = the initial mass of the asphalt mixture sample before ignition

MC = moisture content of the companion asphalt mixture sample, percent, as determined by the FOP for AASHTO T 329 (if the specimen was oven-dried before initiating the procedure, MC = 0).

$C_f$  = correction factor as a percent by mass of the asphalt mixture 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 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  $M_f = 2222.7 \text{ g}$

$$P_b = \frac{2361.2 \text{ g} - 2222.7 \text{ g}}{2361.2 \text{ g}} \times 100 - 0.42\% - 0.04\% = 5.41\%$$

**$P_b = 5.41\%$**

## Gradation

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 (Method A only)
- 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 R 90.
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 before 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 before 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 asphalt mixture.
9. If the asphalt binder correction factor exceeds 1.00 percent, the test temperature must be lowered to  $482 \pm 5^\circ\text{C}$  ( $900 \pm 9^\circ\text{F}$ ) and new samples must be burned. If the correction factor is the same or higher at the lower temperature, it is permissible to use the higher temperature. The temperature for determining the asphalt binder content of asphalt mixture 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 asphalt mixture 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  $\mu\text{m}$  (No. 200) is the only sieve outside the limits in Table 2, apply the aggregate correction factor to only the 75  $\mu\text{m}$  (No. 200) sieve.

**Table 2**  
**Permitted Sieving Difference**

Sieve	Allowable Difference
Sizes larger than or equal to 2.36 mm (No.8)	± 5.0%
Sizes larger than to 75 µm (No.200) and smaller than 2.36 mm (No.8)	± 3.0%
Sizes 75 µm (No.200) and smaller	± 0.5%

**Examples:**

Sieve Size mm (in.)	Correction Factor Blank Sample % Passing	Correction Factor Sample #1 % Passing	Correction Factor Sample #2 % Passing	Difference 1 / 2	Avg. Diff.	Sieves to adjust
19.0 (3/4)	100	100	100	0/0	0.0	
12.5 (1/2)	86.3	87.4	86.4	-1.1/-0.1	-0.6	
9.5 (3/8)	77.4	76.5	78.8	+0.9/-1.4	-0.3	
4.75 (No. 4)	51.5	53.6	55.9	-2.1/-4.4	-3.3	
2.36 (No. 8)	34.7	36.1	37.2	-1.4/-2.5	-2.0	
01.18 (No. 16)	23.3	25.0	23.9	-1.7/-0.6	-1.2	
0.600 (No. 30)	16.4	19.2	18.1	-2.8/-1.7	-2.3	
0.300 (No. 50)	12.0	11.1	12.7	+0.9/-0.7	+0.1	
0.150 (No. 100)	8.1	9.9	6.3	-1.8/+1.8	0.0	
75 µm (No. 200)	5.5	5.9	6.2	-0.4/-0.7	-0.6	<b>- 0.6</b>

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.

Sieve Size mm (in.)	Correction Factor Blank Sample % Passing	Correction Factor Sample #1 % Passing	Correction Factor Sample #2 % Passing	Difference 1 / 2	Avg. Diff.	Sieves to adjust
19.0 (3/4)	100	100	100	0/0	0.0	0.0
12.5 (1/2)	86.3	87.4	86.4	-1.1/-0.1	-0.6	<b>-0.6</b>
9.5 (3/8)	77.4	76.5	78.8	+0.9/-1.4	-0.3	<b>-0.3</b>
4.75 (No. 4)	51.5	55.6	57.9	-4.1/-6.4	-5.3	<b>-5.3</b>
2.36 (No. 8)	34.7	36.1	37.2	-1.4/-2.5	-2.0	<b>-2.0</b>
01.18 (No. 16)	23.3	25.0	23.9	-1.7/-0.6	-1.2	<b>-1.2</b>
0.600 (No. 30)	16.4	19.2	18.1	-2.8/-1.7	-2.3	<b>-2.3</b>
0.300 (No. 50)	12.0	11.1	12.7	+0.9/-0.7	+0.1	<b>+0.1</b>
0.150 (No. 100)	8.1	9.9	6.3	-1.8/+1.8	0.0	0.0
75 µm (No. 200)	5.5	5.9	6.2	-0.4/-0.7	-0.6	<b>-0.6</b>



## PERFORMANCE EXAM CHECKLIST

### DETERMINING THE ASPHALT BINDER CONTENT OF ASPHALT MIXTURES 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.**

Procedure Element	Trial 1	Trial 2
1. Oven at correct temperature $538 \pm 5^{\circ}\text{C}$ ( $1000 \pm 9^{\circ}\text{F}$ ) or correction factor temperature?	_____	_____
Or: for IR ovens, correct burn profile applied?	_____	_____
2. Sample reduced to correct size?	_____	_____
3. Asphalt mixture sample or companion moisture sample taken and dried per FOP for AASHTO T 329?	_____	_____
4. Mass of sample basket assembly recorded to 0.1 g?	_____	_____
5. With pan below basket(s) sample evenly distributed in basket(s)?	_____	_____
6. Mass of sample basket and sample recorded to 0.1 g?	_____	_____
7. Sample mass conforms to the required mass?	_____	_____
8. Method A		
a. Initial mass entered into furnace controller?	_____	_____
b. Sample correctly placed into furnace?	_____	_____
c. Test continued until stable indicator signals?	_____	_____
d. Uncorrected asphalt binder content obtained on printed ticket?	_____	_____
e. Sample mass determined to nearest 0.1 g.?	_____	_____
9. Method B		
a. Sample correctly placed into furnace?	_____	_____
b. Sample burned for 45 min or time determined by correction process?	_____	_____
c. Sample cooled to room temperature?	_____	_____
d. Sample burned to constant mass?	_____	_____
e. Sample mass determined to nearest 0.1 g.?	_____	_____
f. Uncorrected asphalt binder content calculated correctly and recorded?	_____	_____

**OVER**

Procedure Element	Trial 1	Trial 2
10. Asphalt binder content corrected for Correction Factor if needed?	_____	_____
11. Asphalt binder content corrected for moisture per the FOP for AASHTO T 329 if needed?	_____	_____
12. Corrected asphalt binder content recorded?	_____	_____
13. Contents of the basket(s) carefully emptied into a pan?	_____	_____

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** the following from step 13

Asphalt binder content percentage can also be calculated using the formula from “Method B” Step 16.

**Add** the following Steps 14 & 15

14. Using  $M_i$  and  $M_f$  from above and formula in the “Calculation” portion of Method B calculate the asphalt binder content percent. Compare the results from the “Calculation” portion of Method A with the result from the “Calculation” portion from Method B. If the asphalt binder content from Method B is within 0.15% of the binder content from Method A use the results from Method A (Internal Balance) / printed ticket. If the difference is greater than 0.15% use the asphalt binder content percent as calculated from Method B’s formula.

15. Determine, correct, and record the source of the variation between the two results prior to further testing. When the source of variation cannot be corrected then the furnace shall be placed out-of-service until repaired.

- **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.



## **MECHANICAL ANALYSIS OF EXTRACTED AGGREGATE FOP FOR AASHTO T 30**

### **Scope**

This procedure covers mechanical analysis of aggregate recovered from asphalt mix samples in accordance with AASHTO T 30-19. This FOP utilizes the aggregate recovered from the ignition furnace 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, meeting the requirements of FOP for AASHTO T 27/T 11.
- Mechanical sieve shaker, meeting the requirements of FOP for AASHTO T 27/T 11.
- Mechanical Washing Apparatus (optional)
- Suitable drying equipment, meeting the requirements of the 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. Intermediate sieves are added for additional information or to avoid overloading sieves, or both.
- The sieves are nested in order of increasing size from the bottom to the top, and the test sample, or a portion of the test sample, is placed on the top sieve.
- The loaded sieves are shaken in a mechanical shaker for approximately 10 minutes, refer to Annex A; *Time Evaluation*.

### **Mass Verification**

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.

## Calculation

$$\text{Mass verification} = \frac{M_{f(T308)} - M_{(T30)}}{M_{f(T308)}} \times 100$$

Where:

$M_{f(T308)}$  = Mass of aggregate remaining after ignition from the FOP for AASHTO T 308

$M_{(T30)}$  = Mass of aggregate sample obtained from the FOP for AASHTO T 308

## Example:

$$\text{Mass verification} = \frac{2422.5 \text{ g} - 2422.3 \text{ g}}{2422.5 \text{ g}} \times 100 = 0.01\%$$

Where:

$M_{f(T308)} = 2422.5 \text{ g}$

$M_{(T30)} = 2422.3 \text{ g}$

## Procedure

1. Nest a sieve, such as a 2.0 mm (No. 10) or 1.18 mm (No. 16), above the 75 $\mu$ m (No. 200) sieve.
2. Place the test sample in a container and cover with water. Add a detergent, dispersing agent, or other wetting solution to the water to assure a thorough separation of the material finer than the 75 $\mu$ m (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 75 $\mu$ m (No. 200) from coarser particles and bring the fine material into suspension above the coarser material. Avoid degradation of the sample when using a mechanical washing device. 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 75 $\mu$ m (No. 200) sieve.

4. Immediately pour the wash water containing the suspended material over the nested sieves; be careful not to pour out the coarser particles or over fill the 75  $\mu$ m (No. 200) sieve.
5. Add water to cover material remaining in the container, agitate, and repeat Step 4. Continue until the wash water is reasonably clear.

6. Remove the upper sieve, return material retained to the washed sample.
  7. Rinse the material retained on the 75  $\mu\text{m}$  (No. 200) sieve until water passing through the sieve is reasonably clear and detergent or dispersing agent is removed.
  8. Return all material retained on the 75  $\mu\text{m}$  (No. 200) sieve to the washed sample by rinsing into the washed sample.
  9. Dry the washed test sample to constant mass according to the FOP for AASHTO T 255. Cool to room temperature. Determine and record the “dry mass after washing.”
  10. Select sieves required by the specification and those necessary to avoid overloading. With a pan on bottom, nest the sieves increasing in size starting with the 75  $\mu\text{m}$  (No. 200).
  11. Place the test sample, or a portion of the test sample, on the top sieve. 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, the time determined by Annex A).
- Note 2:** Excessive shaking (more than 10 minutes) may result in degradation of the sample.
12. Determine and record the individual or cumulative mass retained for each sieve including the pan. Ensure that all material trapped in full openings of the sieves are removed and included in the mass retained.
- Note 3:** For sieves 4.75 mm (No. 4) and larger, check material trapped in less than a full opening by sieving over a full opening. Use coarse wire brushes to clean the 600  $\mu\text{m}$  (No. 30) and larger sieves, and soft bristle brushes for smaller sieves.
13. Perform the *Check Sum* calculation – Verify the *total mass after sieving* of material agrees with the *dry mass after washing* within 0.2 percent. Do not use test results for acceptance if the *Check Sum* result is greater than 0.2 percent.
  14. Calculate the total percentages passing, and the individual or cumulative percentages retained, to the nearest 0.1 percent by dividing the individual sieve masses or cumulative sieve masses by the total mass of the initial dry sample.
  15. Apply the Aggregate Correction Factor (ACF) to the calculated percent passing, as required in the FOP for AASHTO T 308 “Correction Factor,” to obtain the reported percent passing.
  16. Report total percent passing to 1 percent except report the 75  $\mu\text{m}$  (No. 200) sieve to 0.1 percent.

**Calculations****Check Sum**

$$check\ sum = \frac{dry\ mass\ after\ washing - total\ mass\ after\ sieving}{dry\ mass\ after\ washing} \times 100$$

**Percent Retained****Individual**

$$IPR = \frac{IMR}{M_{T30}} \times 100$$

**Cumulative**

$$CPR = \frac{CMR}{M_{T30}} \times 100$$

Where:

IPR	=	Individual Percent Retained
CPR	=	Cumulative Percent Retained
M <sub>T30</sub>	=	Total dry sample mass before washing
IMR	=	Individual Mass Retained
CMR	=	Cumulative Mass Retained



## Percent Passing

### Individual

$$PP = PCP - IPR$$

### Cumulative

$$PP = 100 - CPR$$

Where:

- PP = Calculated Percent Passing
- PCP = Previous Calculated Percent Passing

## Reported Percent Passing

$$RPP = PP + ACF$$

Where:

- RPP = Reported Percent Passing
- ACF = Aggregate Correction Factor (if applicable)

## Example

Dry mass of total sample, before washing ( $M_{T30}$ ): 2422.3 g  
 Dry mass of sample, after washing out the 75  $\mu$ m (No. 200) minus: 2296.2 g  
 Amount of 75  $\mu$ m (No. 200) minus washed out (2422.3 g – 2296.2g): 126.1 g

## Check sum

$$check\ sum = \frac{2296.2\ g - 2295.3\ g}{2296.2\ g} \times 100 = 0.04\%$$

This is less than 0.2 percent therefore the results can be used for acceptance purposes.

**Percent Retained for the 75 µm (No. 200) sieve**

$$IPR = \frac{63.5 \text{ g}}{2422.3 \text{ g}} \times 100 = 2.6\%$$

*or*

$$CPR = \frac{2289.6 \text{ g}}{2422.3 \text{ g}} \times 100 = 94.5\%$$

**Percent Passing using IPR and PCP for the 75 µm (No. 200) sieve**

$$PP = 8.1\% - 2.6\% = 5.5\%$$

**Percent Passing using CPR for the 75 µm (No. 200) sieve**

$$PP = 100.0\% - 94.5\% = 5.5\%$$

**Reported Percent Passing**

$$RPP = 5.5\% = (-0.6\%) = 4.9\%$$

### Individual Gradation on All Sieves

Sieve Size mm (in.)	Individual Mass Retained g (IMR)	Determine IPR Divide IMR by <i>M</i> and multiply by 100	Individual Percent Retained (IPR)	Determine PP by subtracting IPR from Previous PP	Percent Passing (PP)	Agg. Corr. Factor from T 308 (ACF)	Reported Percent Passing*
19.0 (3/4)	0		0		100.0		100
12.5 (1/2)	346.9	$\frac{346.9}{2422.3} \times 100 =$	14.3	$100.0 - 14.3 =$	85.7		86
9.5 (3/8)	207.8	$\frac{207.8}{2422.3} \times 100 =$	8.6	$85.7 - 8.6 =$	77.1		77
4.75 (No. 4)	625.4	$\frac{625.4}{2422.3} \times 100 =$	25.8	$77.1 - 25.8 =$	51.3		51
2.36 (No. 8)	416.2	$\frac{416.2}{2422.3} \times 100 =$	17.2	$51.3 - 17.2 =$	34.1		34
1.18 (No. 16)	274.2	$\frac{274.2}{2422.3} \times 100 =$	11.3	$34.1 - 11.3 =$	22.8		23
0.600 (No. 30)	152.1	$\frac{152.1}{2422.3} \times 100 =$	6.3	$22.8 - 6.3 =$	16.5		17
0.300 (No. 50)	107.1	$\frac{107.1}{2422.3} \times 100 =$	4.4	$16.5 - 4.4 =$	12.1		12
0.150 (No. 100)	96.4	$\frac{96.4}{2422.3} \times 100 =$	4.0	$12.1 - 4.0 =$	8.1		8
0.075 (No. 200)	63.5	$\frac{63.5}{2422.3} \times 100 =$	2.6	$8.1 - 2.6 =$	5.5	-0.6 (5.5 - 0.6 =)	4.9
minus 75 µm (No. 200) in the pan	5.7						
Total mass after sieving = sum of sieves + mass in the pan = 2295.3 g							
Dry mass of total sample, before washing ( $M_{T30}$ ): 2422.3g							

\* Report total percent passing to 1 percent except report the 75 µm (No. 200) sieve to 0.1 percent.

**Cumulative  
Gradation on All Sieves**

Sieve Size mm (in.)	Cumulative Mass Retained g (CMR)	Determine CPR Divide CMR by M and multiply by 100	Cumulative Percent Retained (CPR)	Determine PP by subtracting CPR from 100.0	Percent Passing (PP)	Agg. Corr. Factor from T 308 (ACF)	Reported Percent Passing*
19.0 (3/4)	0		0.0		100.0		100
12.5 (1/2)	346.9	$\frac{346.9}{2422.3} \times 100 =$	14.3	$100.0 - 14.3 =$	85.7		86
9.5 (3/8)	554.7	$\frac{554.7}{2422.3} \times 100 =$	22.9	$100.0 - 22.9 =$	77.1		77
4.75 (No. 4)	1180.1	$\frac{1180.1}{2422.3} \times 100 =$	48.7	$100.0 - 48.7 =$	51.3		51
2.36 (No. 8)	1596.3	$\frac{1596.3}{2422.3} \times 100 =$	65.9	$100.0 - 65.9 =$	34.1		34
1.18 (No. 16)	1870.5	$\frac{1870.5}{2422.3} \times 100 =$	77.2	$100.0 - 77.2 =$	22.8		23
0.600 (No. 30)	2022.6	$\frac{2022.6}{2422.3} \times 100 =$	83.5	$100.0 - 83.5 =$	16.5		17
0.300 (No. 50)	2129.7	$\frac{2129.7}{2422.3} \times 100 =$	87.9	$100.0 - 87.9 =$	12.1		12
0.150 (No. 100)	2226.1	$\frac{2226.1}{2422.3} \times 100 =$	91.9	$100.0 - 91.9 =$	8.1		8
0.075 (No. 200)	2289.6	$\frac{2289.6}{2422.3} \times 100 =$	94.5	$100.0 - 94.5 =$	5.5	-0.6 (5.5 - 0.6 =)	4.9
minus 75 µm (No. 200) in the pan	2295.3						
Total mass after sieving = 2295.3 g							
Dry mass of total sample, before washing (M <sub>T30</sub> ): 2422.3g							

\* Report total percent passing to 1 percent except report the 75 µm (No. 200) sieve to 0.1 percent.

**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
- Percent passing to the nearest 1 percent, except 75  $\mu\text{m}$  (No. 200) sieve to the nearest 0.1 percent.

---

**ANNEX A 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 before 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.

## ANNEX B OVERLOAD DETERMINATION

- For sieves with openings smaller than 4.75 mm (No. 4), the mass retained on any sieve shall not exceed 7 kg/m<sup>2</sup> (4 g/in<sup>2</sup>) 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 B1.

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 B1**  
**Maximum Allowable Mass of Material Retained on a Sieve, g**  
**Nominal Sieve Size, mm (in.)**  
**Exact size is smaller (see AASHTO T 27)**

Sieve Size		203 dia	305 dia	305 by 305	350 by 350	372 by 580
mm (in.)		(8)	(12)	(12 × 12)	(14 × 14)	(16 × 24)
Sieving Area m <sup>2</sup>						
		0.0285	0.0670	0.0929	0.1225	0.2158
90	(3 1/2)	*	15,100	20,900	27,600	48,500
75	(3)	*	12,600	17,400	23,000	40,500
63	(2 1/2)	*	10,600	14,600	19,300	34,000
50	(2)	3600	8400	11,600	15,300	27,000
37.5	(1 1/2)	2700	6300	8700	11,500	20,200
25.0	(1)	1800	4200	5800	7700	13,500
19.0	(3/4)	1400	3200	4400	5800	10,200
16.0	(5/8)	1100	2700	3700	4900	8600
12.5	(1/2)	890	2100	2900	3800	6700
9.5	(3/8)	670	1600	2200	2900	5100
6.3	(1/4)	440	1100	1500	1900	3400
4.75	(No. 4)	330	800	1100	1500	2600
-4.75	(-No. 4)	200	470	650	860	1510





## 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.

Procedure Element	Trial 1	Trial 2
1. Total dry mass determined to 0.1 g	_____	_____
2. Dry mass agrees with sample mass after ignition ( $M_f$ ) from AASHTO T 308 within 0.1 percent?	_____	_____
3. Sample placed in container and covered with water?	_____	_____
4. Wetting agent added?	_____	_____
5. Contents of container agitated vigorously?	_____	_____
6. Wash water poured through proper nest of two sieves?	_____	_____
7. Washing continued until wash water is clear and no wetting agent remaining?	_____	_____
8. Retained material returned to washed sample?	_____	_____
9. Washed material coarser than 75 $\mu\text{m}$ (No. 200) dried to constant mass at $110 \pm 5^\circ\text{C}$ ( $230 \pm 9^\circ\text{F}$ )?	_____	_____
10. Sample cooled to room temperature?	_____	_____
11. Dry mass after washing determined to 0.1 g?	_____	_____
12. Material sieved on specified sieves?	_____	_____
13. Mass of each fraction of aggregate, including minus 75 $\mu\text{m}$ (No. 200), determined and recorded to 0.1 g?	_____	_____
14. Total mass of material after sieving agrees with mass before sieving to within 0.2 percent?	_____	_____
15. Percent passing each sieve determined correctly to the nearest 0.1 percent?	_____	_____
16. Aggregate correction factor applied, if applicable?	_____	_____
17. Percent passing on each sieve reported correctly to the nearest 1 percent and nearest 0.1 percent on the 75 $\mu\text{m}$ (No. 200)?	_____	_____

Comments: First attempt: Pass\_\_\_\_\_Fail\_\_\_\_\_ Second attempt: Pass\_\_\_\_\_Fail\_\_\_\_\_

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\_\_\_\_\_  
\_\_\_\_\_

Examiner Signature \_\_\_\_\_ WAQTC #: \_\_\_\_\_



## **THEORETICAL MAXIMUM SPECIFIC GRAVITY ( $G_{mm}$ ) AND DENSITY OF ASPHALT MIXTURES FOP FOR AASHTO T 209**

### **Scope**

This procedure covers the determination of the maximum specific gravity ( $G_{mm}$ ) of uncompacted asphalt mixtures in accordance with AASHTO T 209-19. 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
- Automatic vacuum control unit (optional)
- Timer

## Standardization of Pycnometer or Volumetric Flask

Use a pycnometer / volumetric flask that is standardized to accurately determine the mass of water, at  $25 \pm 0.5^\circ\text{C}$  ( $77 \pm 1^\circ\text{F}$ ), 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 R 97 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 1**  
**Test Sample Size for  $G_{mm}$**

<b>Nominal Maximum* Aggregate Size mm (in.)</b>	<b>Minimum Mass g</b>
37.5 or greater (1½)	4000
19 to 25 (¾ to 1)	2500
12.5 or smaller (½)	1500

\*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 (¼ 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  $25^\circ\text{C}$  ( $77^\circ\text{F}$ ) 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  $3.7 \pm 0.3$  kPa ( $27.5 \pm 2.5$  mm Hg) residual pressure for  $15 \pm 2$  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. Increase the pressure to atmospheric pressure in 10 to 15 seconds if the vacuum release is not automated. Turn off the vacuum pump and remove the lid. When performing the pycnometer / volumetric flask method, complete steps 12B through 16B within  $10 \pm 1$  minute.

### Procedure – Bowl

- 12A. Fill the water bath to overflow level with water at  $25 \pm 1^\circ\text{C}$  ( $77 \pm 2^\circ\text{F}$ ) 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  $25 \pm 1^\circ\text{C}$  ( $77 \pm 2^\circ\text{F}$ ) for  $10 \pm 1$  minute. 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  $25 \pm 1^{\circ}\text{C}$  ( $77 \pm 2^{\circ}\text{F}$ ).
- 14B. Finish filling the pycnometer / volumetric flask with water that is  $25 \pm 1^{\circ}\text{C}$  ( $77 \pm 2^{\circ}\text{F}$ ), 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  $10 \pm 1$  minute 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):**

Increment 1	Increment 2
A = 2200.3 g	A = 1960.2 g
D = 7502.5 g	D = 7525.5 g
E = 8812.0 g	E = 8690.8 g
Temperature = 26.2°C	Temperature = 25.0°C

$$G_{mm_1} = \frac{2200.3 \text{ g}}{2200.3 \text{ g} + 7502.5 \text{ g} - 8812.0 \text{ g}} = 2.470$$

$$G_{mm_2} = \frac{1960.2 \text{ g}}{1960.2 \text{ g} + 7525.5 \text{ g} - 8690.8 \text{ g}} \times 1.00000 = 2.466$$

Allowable variation is: 0.014

2.470 - 2.466 = 0.004, which is < 0.014, so they can be averaged.

Average:

$$2.470 + 2.466 = 4.936 \quad 4.936 \div 2 = \mathbf{2.468}$$

**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.

$$\text{Theoretical maximum density kg/m}^3 = G_{mm} \times 997.1 \text{ kg/ m}^3$$

$$2.468 \times 997.1 \text{ kg/ m}^3 = 2461 \text{ kg/ m}^3$$

or

$$\text{Theoretical maximum density lb/ft}^3 = G_{mm} \times 62.245 \text{ lb/ft}^3$$

$$2.468 \times 62.245 \text{ lb/ft}^3 = 153.6 \text{ lb/ft}^3$$



**Report**

- Results on forms approved by the agency
- Sample ID
- $G_{mm}$  to the nearest 0.001
- Theoretical maximum density to the nearest  $1 \text{ kg/m}^3$  ( $0.1 \text{ lb/ft}^3$ )



## PERFORMANCE EXAM CHECKLIST

### THEORETICAL MAXIMUM SPECIFIC GRAVITY AND DENSITY OF ASPHALT 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.

Procedure Element	Trial 1	Trial 2
1. Sample reduced to correct size?	_____	_____
2. Particles carefully separated insuring that aggregate is not fractured?	_____	_____
3. After separation, fine aggregate particles not larger than 6.3 mm (1/4 in.)?	_____	_____
4. Sample at room temperature?	_____	_____
5. Mass of container determined to 0.1 g?	_____	_____
6. Mass of sample and container determined to 0.1 g?	_____	_____
7. Mass of sample calculated and conforms to required size?	_____	_____
8. Water at approximately 25°C (77°F) added to cover sample?	_____	_____
9. Entrapped air removed using partial vacuum for 15 ±2 min?	_____	_____
10. Container and contents agitated continuously by mechanical device or manually by vigorous shaking at intervals of about 2 minutes?	_____	_____
11. Vacuum released to atmospheric pressure in 10 to 15 seconds if not auto controlled?	_____	_____
12. Vacuum pump turned off?	_____	_____
13. Bowl determination:		
a. Water bath filled to the overflow level?	_____	_____
b. Bowl and contents suspended in water at 25 ±1°C (77 ±2°F) for 10 ±1 minute?	_____	_____
c. Submerged weight of bowl and contents determined to 0.1 g?	_____	_____
d. Submerged weight of empty bowl determined to 0.1 g?	_____	_____
e. Net submerged weight of contents calculated?	_____	_____

**OVER**

**Procedure Element**

**Trial 1 Trial 2**

14. Pycnometer / Volumetric Flask determination:

- |   |       |       |
|---|-------|-------|
| a. Pycnometer / volumetric flask filled with water without reintroducing air into the sample?   | _____ | _____ |
| b. Contents stabilized at $25 \pm 1^{\circ}\text{C}$ ( $77 \pm 2^{\circ}\text{F}$ )   | _____ | _____ |
| c. Pycnometer / volumetric flask completely filled with water that is $25 \pm 1^{\circ}\text{C}$ ( $77 \pm 2^{\circ}\text{F}$ )?          | _____ | _____ |
| d. Mass of filled pycnometer / volumetric flask and cover determined to 0.1 g, 10 $\pm$ 1 min. after removal of entrapped air completed?  | _____ | _____ |
| e. Mass of pycnometer / volumetric flask, cover, and water obtained from the Standardization of Pycnometer or Volumetric Flask procedure? | _____ | _____ |

15.  $G_{mm}$  calculated correctly and reported to 0.001? \_\_\_\_\_

16. Density calculated correctly and reported to 1 kg/m<sup>3</sup> (0.1 lb/ft<sup>3</sup>)? \_\_\_\_\_

Comments: First attempt: Pass\_\_\_\_\_Fail\_\_\_\_\_ Second attempt: Pass\_\_\_\_\_Fail\_\_\_\_\_

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Examiner Signature \_\_\_\_\_ WAQTC #: \_\_\_\_\_

## **FOP for AASHTO T 209**

### Theoretical Maximum Specific Gravity ( $G_{mm}$ ) and Density of Hot-Mix Asphalt Paving Mixtures

#### **Test Sample Preparation**

**Add** the following to Step 1

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.

#### **Add** Step 3

3. The final test result will be determined from an average of the results from two specimens. The initial dry mass of these specimens shall have a variance not to exceed 50.0 grams. The allowable  $G_{mm}$  variance between these specimens is 0.014. When the variance is greater than 0.014 review testing procedures, check test equipment and make adjustments needed before performing the next random sample testing. Record in the "Remarks" section the reason for the variation. If the two specimens from the next sample have a variance greater than 0.014 no further testing can be performed until the Independent Assurance Inspector evaluates the tester, equipment, and testing procedure to determine the reason for the variation.

The IA will document the findings of the investigation. Make adjustments to correct deficiencies before performing the next random sample testing.

#### **Report.**

**Add** the following

Average result of two gyratory specimens to three decimal places

## **AASHTO T 209**

- **9. Sample Preparation**

- **9.1.**

**Add** the following

The final test result will be determined from an average of the results from two specimens. The initial dry mass of these specimens shall have a variance not to exceed 50.0 grams. The allowable  $G_{mm}$  variance between these specimens is 0.014. When the variance is greater than 0.014 review testing procedures, check test equipment and make adjustments needed before performing the next random sample testing. Record in the "Remarks" section the reason for the variation. If the two specimens from the next sample have a variance greater than 0.014 no further testing can be performed until the Independent Assurance Inspector evaluates the tester, equipment, and testing procedure to determine the reason for the variation.

The IA will document the findings of the investigation. Make adjustments to correct deficiencies before performing the next random sample testing.

- **9.2.**

**Delete** the first two sentences

**Add** the following first sentence:

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.

- **16. REPORT**

**Add** the following

16.1.1.1. Average result of two specimens reported to the nearest thousandth.

## **BULK SPECIFIC GRAVITY ( $G_{mb}$ ) OF COMPACTED ASPHALT MIXTURES USING SATURATED SURFACE-DRY SPECIMENS**

### **FOP FOR AASHTO T 166**

#### **Scope**

This procedure covers the determination of bulk specific gravity ( $G_{mb}$ ) of compacted asphalt mixtures 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 asphalt mixture 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 asphalt mixture 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  $110 \pm 5^{\circ}\text{C}$  ( $230 \pm 9^{\circ}\text{F}$ ) 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.
- Vacuum device: refer to AASHTO R 79 (optional)

### 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. Oven method

- i. Initially dry overnight at  $52 \pm 3^{\circ}\text{C}$  ( $125 \pm 5^{\circ}\text{F}$ ).
- ii. Determine and record the mass of the specimen ( $M_p$ ).
- iii. Return the specimen to the oven for at least 2 hours.
- iv. Determine and record the mass of the specimen ( $M_n$ ).
- v. Determine percent change by subtracting the new mass determination ( $M_n$ ) from the previous mass determination ( $M_p$ ), divide by the previous mass determination ( $M_p$ ), and multiply by 100.
- vi. Continue drying until there is no more than 0.05 percent change in specimen mass after 2-hour drying intervals (constant mass).
- vii. 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.

b. Vacuum dry method

- i. Perform vacuum drying procedure according to AASHTO R 79.
- ii. Determine and record the mass of the specimen ( $M_p$ ).
- iii. Perform a second vacuum drying procedure.
- iv. Determine and record the mass of the specimen ( $M_n$ ).
- v. Determine percent change by subtracting the new mass determination ( $M_n$ ) from the previous mass determination ( $M_p$ ), divide by the previous mass determination ( $M_p$ ), and multiply by 100.
- vi. Continue drying until there is no more than 0.05 percent change in specimen mass (constant mass).
- vii. Constant mass has been achieved; sample is defined as dry.



2. Cool the specimen in air to  $25 \pm 5^{\circ}\text{C}$  ( $77 \pm 9^{\circ}\text{F}$ ), 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  $25 \pm 1^{\circ}\text{C}$  ( $77 \pm 1.8^{\circ}\text{F}$ ) 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  $4 \pm 1$  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 saturated surface-dry (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 to exceed 15 seconds performing Steps 7 through 9.

### Calculations - Method A (Suspension)

#### Constant Mass:

Calculate constant mass using the following formula:

$$\%Change = \frac{M_p - M_n}{M_p} \times 100$$

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  $25 \pm 1^\circ\text{C}$  ( $77 \pm 1.8^\circ\text{F}$ ), g

**Example:**

$$G_{mb} = \frac{4833.6 \text{ g}}{4842.4 \text{ g} - 2881.3 \text{ g}} = 2.465$$

$$\% \text{ Water Absorbed (by volume)} = \frac{4842.4 \text{ g} - 4833.6 \text{ g}}{4842.4 \text{ g} - 2881.3 \text{ g}} \times 100 = 0.45\%$$

**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  $25 \pm 0.5^{\circ}\text{C}$  ( $77 \pm 0.9^{\circ}\text{F}$ ).
- Thermometer: Range of  $19$  to  $27^{\circ}\text{C}$  ( $66$  to  $80^{\circ}\text{F}$ ) and graduated in  $0.1^{\circ}\text{C}$  ( $0.2^{\circ}\text{F}$ ) 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  $110 \pm 5^{\circ}\text{C}$  ( $230 \pm 9^{\circ}\text{F}$ ) 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.
- Vacuum device: AASHTO R 79 (optional)

**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. Oven method:

- i. Initially dry overnight at  $52 \pm 3^{\circ}\text{C}$  ( $125 \pm 5^{\circ}\text{F}$ ).
- ii. Determine and record the mass of the specimen ( $M_p$ ).
- iii. Return the specimen to the oven for at least 2 hours.
- iv. Determine and record the mass of the specimen ( $M_n$ ).
- v. Determine percent change by subtracting the new mass determination ( $M_n$ ) from the previous mass determination ( $M_p$ ), divide by the previous mass determination ( $M_p$ ), and multiply by 100.
- vi. Continue drying until there is no more than 0.05 percent change in specimen mass after 2-hour drying intervals (constant mass).
- vii. 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.

b. Vacuum dry method

- i. Perform vacuum drying procedure according to AASHTO R 79.
- ii. Determine and record the mass of the specimen ( $M_p$ ).

- iii. Perform a second vacuum drying procedure.
  - iv. Determine and record the mass of the specimen ( $M_n$ ).
  - v. Determine percent change by subtracting the new mass determination ( $M_n$ ) from the previous mass determination ( $M_p$ ), divide by the previous mass determination ( $M_p$ ), and multiply by 100.
  - vi. Continue drying until there is no more than 0.05 percent change in specimen mass (constant mass).
  - vii. Constant mass has been achieved; sample is defined as dry.
2. Cool the specimen in air to  $25 \pm 5^\circ\text{C}$  ( $77 \pm 9^\circ\text{F}$ ), 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  $25 \pm 1^\circ\text{C}$  ( $77 \pm 1.8^\circ\text{F}$ ) making sure some water escapes through the capillary bore of the tapered lid.
  5. Wipe the volumeter dry. Determine the mass of the volumeter to the nearest 0.1 g. Designate this mass as “D.”
  6. 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.
  7. Immediately determine and record the mass of the SSD specimen to the 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.
  8. Place the specimen in the volumeter and let stand 60 seconds.
  9. Bring the temperature of the water to  $25 \pm 1^\circ\text{C}$  ( $77 \pm 1.8^\circ\text{F}$ ) 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:

$$\%Change = \frac{M_p - M_n}{M_p} \times 100$$

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:

$G_{mb}$  = Bulk specific gravity

A = Mass of dry specimen in air, g

B = Mass of SSD specimen in air, g

D = Mass of volumeter filled with water at  $25 \pm 1^\circ\text{C}$  ( $77 \pm 1.8^\circ\text{F}$ ), g

E = Mass of volumeter filled with specimen and water, g

### Example:

$$G_{mb} = \frac{4833.6 \text{ g}}{4842.4 \text{ g} + 2924.4 \text{ g} - 5806.0 \text{ g}} = 2.465$$

$$\% \text{ Water Absorbed (by volume)} = \frac{4842.4 \text{ g} - 4833.6 \text{ g}}{4842.4 \text{ g} + 2924.4 \text{ g} - 5806.0 \text{ g}} \times 100 = 0.45\%$$

**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 ( $M_p$ ).
7. Return the specimen to the oven for at least 2 hours.
8. Determine and record the mass of the specimen ( $M_n$ ).
9. Determine percent change by subtracting the new mass determination ( $M_n$ ) from the previous mass determination ( $M_p$ ), divide by the previous mass determination ( $M_p$ ), and multiply by 100.
10. Continue drying until there is no more 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.
12. Cool in air to 25 ±5°C (77 ±9°F).
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 the nearest 0.001
- Absorption to the nearest 0.01 percent
- Method performed.





## PERFORMANCE EXAM CHECKLIST

### BULK SPECIFIC GRAVITY OF COMPACTED ASPHALT MIXTURES 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.**

Procedure Element	Trial 1	Trial 2
<b>Method A:</b>		
1. Mass of dry sample determined.		
a. Sample dried to constant mass if required?	_____	_____
b. Cooled in air to $25 \pm 5^{\circ}\text{C}$ ( $77 \pm 9^{\circ}\text{F}$ )?	_____	_____
c. Dry mass determined to 0.1g?	_____	_____
2. Water at the overflow?	_____	_____
3. Balance zeroed?	_____	_____
4. Immersed weight determined.		
a. Water at $25 \pm 1^{\circ}\text{C}$ ( $77 \pm 1.8^{\circ}\text{F}$ )?	_____	_____
b. Immersed, shaken, on side, for $4 \pm 1$ min.?	_____	_____
c. Immersed weight determined to 0.1g?	_____	_____
5. Sample rapidly surface dried with damp towel and saturated surface dry (SSD) mass determined to 0.1 g (entire operation performed within 15 seconds)?	_____	_____
6. $G_{mb}$ calculated to the nearest 0.001?	_____	_____
7. Absorption calculated to the nearest 0.01 percent	_____	_____

**OVER**

Procedure Element	Trial 1	Trial 2
<b>Method B:</b>		
1. Specimen dried, cooled, and mass determined as in Method A?	_____	_____
2. Saturated surface-dry (SSD) mass determined to 0.1g.		
a. Immersed at least 10 minutes at $25 \pm 1^{\circ}\text{C}$ ( $77 \pm 1.8^{\circ}\text{F}$ )?	_____	_____
b. Sample rapidly dried with damp towel?	_____	_____
c. Specimen mass determined to 0.1 g?	_____	_____
d. Any water that seeps from specimen included in mass?	_____	_____
3. Mass of volumeter filled with distilled water at $25 \pm 1^{\circ}\text{C}$ ( $77 \pm 1.8^{\circ}\text{F}$ ) determined?	_____	_____
4. SSD specimen placed into volumeter and let stand for 1 minute?	_____	_____
5. Temperature of water brought to $25 \pm 1^{\circ}\text{C}$ ( $77 \pm 1.8^{\circ}\text{F}$ ) and volumeter covered, allowing some water to escape through the capillary bore of the tapered lid?	_____	_____
6. Volumeter wiped dry, and mass of volumeter and contents determined?	_____	_____
7. $G_{mb}$ calculated to the nearest 0.001?	_____	_____
8. Absorption calculated to the nearest 0.01 percent?	_____	_____
<b>Method C/A:</b>		
1. Immersed weight determined.		
a. Water at $25 \pm 1^{\circ}\text{C}$ ( $77 \pm 1.8^{\circ}\text{F}$ )?	_____	_____
b. Immersed, shaken, on side, for $4 \pm 1$ 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 $105^{\circ}\text{C}$ ( $221^{\circ}\text{F}$ )?	_____	_____
b. Breaking down to 6.3 mm ( $\frac{1}{4}$ 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 $25 \pm 5^{\circ}\text{C}$ ( $77 \pm 9^{\circ}\text{F}$ ) and mass determined to 0.1 g?	_____	_____
5. $G_{mb}$ calculated to the nearest 0.001?	_____	_____
6. Absorption calculated to the nearest 0.01?	_____	_____

**OVER**

**Procedure Element**

**Trial 1   Trial 2**

**Method C/B:**

- |  |       |       |
|--|-------|-------|
| 1. Saturated surface-dry (SSD) mass determined to 0.1g.  |       |       |
| a. Immersed at least 10 minutes at $25 \pm 1^{\circ}\text{C}$ ( $77 \pm 1.8^{\circ}\text{F}$ )?  | _____ | _____ |
| b. Sample rapidly dried with damp towel (within 5 seconds)?  | _____ | _____ |
| c. Specimen mass determined to 0.1g?   | _____ | _____ |
| d. Any water that seeps from specimen included in mass?  | _____ | _____ |
| 2. Mass of volumeter filled with distilled water at $25 \pm 1^{\circ}\text{C}$ ( $77 \pm 1.8^{\circ}\text{F}$ ) determined to 0.1 g?   | _____ | _____ |
| 3. SSD specimen placed into volumeter and let stand for 1 minute?  | _____ | _____ |
| 4. Temperature of water brought to $25 \pm 1^{\circ}\text{C}$ ( $77 \pm 1.8^{\circ}\text{F}$ ) 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?  | _____ | _____ |
| 6. Dry mass determined by:   |       |       |
| a. Warming in oven at a minimum of $105^{\circ}\text{C}$ ( $221^{\circ}\text{F}$ )?  | _____ | _____ |
| b. Breaking down to 6.3 mm ( $\frac{1}{4}$ 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 $25 \pm 5^{\circ}\text{C}$ ( $77 \pm 9^{\circ}\text{F}$ ) and mass determined to 0.1 g?  | _____ | _____ |
| 7. $G_{mb}$ calculated to the nearest 0.001?   | _____ | _____ |
| 8. Absorption calculated to the nearest 0.01 percent?  | _____ | _____ |

**Comments:**      First attempt:   Pass \_\_\_\_\_ Fail \_\_\_\_\_      Second attempt:   Pass \_\_\_\_\_ Fail \_\_\_\_\_

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Examiner Signature \_\_\_\_\_ WAQTC #: \_\_\_\_\_



## **FOP for AASHTO T 166**

Bulk Specific Gravity ( $G_{mb}$ ) of compacted Hot Mix Asphalt using Saturated Surface-Dry Specimens

### Scope

**Delete** AASHTO T 275

### Test Specimens

**Add** the following after the second paragraph

Two specimens are required for testing when produced using the [FOP for AASHTO T 312](#). These gyratory produced 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.

The final test result will be determined from an average of the results from two specimens. The allowable  $G_{mb}$  variance between these specimens is 0.012. When the variance is greater than 0.012, review test procedures, check test equipment and make adjustments needed before performing the next random sample testing. Record in the "Remarks" section the reason for the variation. If the two specimens from the next sample have a variance greater than 0.012 no further testing can be performed until the Independent Assurance Inspector evaluates the tester, equipment, and test procedure to determine the reason for the variation.

The IA will document the findings of the investigation. Make adjustments to correct deficiencies before performing the next random sample testing.

### Report.

**Add** the following:

- Average result of two gyratory specimens to 0.001

## Scope

**Delete** AASHTO T 275

## 4. TEST SPECIMENS

**Add** subsection 4.7.

4.7. Two specimens are required for testing when produced using the [FOP for AASHTO T 312](#). These gyratory produced 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.

**Add** subsection 4.7.1.

The final test result will be determined from an average of the results from two specimens. The allowable  $G_{mb}$  variance between these specimens is 0.012. When the variance is greater than 0.012, review test procedures, check test equipment and make adjustments needed before performing the next random sample testing. Record in the “Remarks” section the reason for the variation. If the two specimens from the next sample have a variance greater than 0.012 no further testing can be performed until the Independent Assurance Inspector evaluates the tester, equipment, and test procedure to determine the reason for the variation.

The IA will document the findings of the investigation. Make adjustments to correct deficiencies before performing the next random sample testing.

## 13. REPORT.

**Add** subsection 13.1.4.

- Average result of two gyratory specimens reported to the nearest thousandth.

## **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.

### **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 subplot 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.

**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 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 before dilution.

**Report**

- On forms approved by the agency
- Sample ID
- Date
- Time
- Location
- Quantity represented



## **ASPHALT MIXTURE SPECIMENS BY MEANS OF THE SUPERPAVE GYRATORY COMPACTOR FOP FOR AASHTO T 312**

### **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 312-19.

### **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  $\pm 3^{\circ}\text{C}$  ( $\pm 5^{\circ}\text{F}$ )
- Thermometers accurate to  $\pm 1^{\circ}\text{C}$  ( $\pm 2^{\circ}\text{F}$ ) between 10 and  $232^{\circ}\text{C}$  (50 -  $450^{\circ}\text{F}$ )

*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:  $1.16 \pm 0.02^{\circ}$
  - Ram Pressure:  $600 \text{ kPa} \pm 18 \text{ kPa}$
  - 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 and AASHTO R 35.

### 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 R 97.
- 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 ( $600 \pm 18$  kPa).
  - b. Check the angle ( $1.16 \pm 0.02^\circ$ ).
8. Upon completion of the compaction process, record the number of gyrations and specimen height.

**Note 6:** If the specimen is not  $115 \pm 5$  mm 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 to the nearest 0.1 mm



## 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.**

Procedure Element	Trial 1	Trial 2
1. Angle, pressure and number of gyrations set?	_____	_____
2. Bearing surfaces, rotating base surface, and rollers lubricated?	_____	_____
3. Representative sample obtained according to the FOP for AASHTO R 97?	_____	_____
4. Sample reduced according to FOP AASHTO R 47?	_____	_____
5. Sample placed in a container and spread to 1 or 2 inches thick for even heating?	_____	_____
6. Asphalt mixture heated to compaction temperature range?	_____	_____
7. Mold, base plate, and upper plate heated to compaction temperature range?	_____	_____
8. Mold, base plate, and upper plate (if required) removed from oven and paper disk placed on bottom of mold?	_____	_____
9. Mix placed into mold in one lift without segregation?	_____	_____
10. Paper disk placed on top of the asphalt mixture?	_____	_____
11. Mold placed into compactor and upper plate clamped into place?	_____	_____
12. Pressure applied at 600 kPa $\pm$ 18 kPa?	_____	_____
13. Specified number of gyrations applied?	_____	_____
14. Proper angle confirmed from display?	_____	_____
15. Compacted specimen removed from mold, paper disc(s) removed, and allowed to cool to room temperature?	_____	_____
16. Asphalt mixture sample measured to a height of 115 $\pm$ 5 mm at required gyrations?	_____	_____

Comments: First attempt: Pass\_\_\_\_\_Fail\_\_\_\_\_ Second attempt: Pass\_\_\_\_\_Fail\_\_\_\_\_

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Examiner Signature \_\_\_\_\_ WAQTC #: \_\_\_\_\_



[FOP for AASHTO T 312](#)

## Asphalt Mixture Specimens by Means of the Superpave Gyratory Compactor

**Sample Preparation****Laboratory Produced Asphalt Mixtures**

**Add** the following:

The compacted mix design specimen shall have dimensions of 150 mm in diameter and  $115 \pm 2$  mm in height at the desired number of gyrations.

The final test result will be determined from an average of two specimens.

Report the mass necessary to produce a trial specimen to achieve this height requirement in the Mix Design submittal.

When testing laboratory produced asphalt mixtures, the initial dry mass of these specimens shall not vary more than 30.0 grams from the mass determined in the Mix Design to achieve the height requirement.

**Plant Produced Asphalt Mixtures**

**Delete** the 4<sup>th</sup> bullet and substitute the following:

- The final test result will be determined from an average of two specimens.
- The initial dry mass of these specimens shall not vary more than 30.0 grams from the mass determined in the Mix Design to achieve the height requirement.

[AASHTO T 312](#)**8. HMA Mixture Preparation****8.1. Laboratory Prepared:**

**8.1.1 Delete** last sentence and **Substitute** the following:

The compacted mix design specimen shall have dimensions of 150 mm in diameter and  $115 \pm 2$  mm in height at the desired number of gyrations.

The final test result will be determined from an average of two specimens.

Report the mass necessary to produce a trial specimen to achieve this height requirement in the Mix Design submittal.

When testing laboratory produced asphalt mixtures, the initial dry mass of these specimens shall not vary more than 30.0 grams from the mass determined in the Mix Design to achieve the height requirement.

**8.2. Plant Produced:**

**Add** the following:

**8.2.6.** The final test result will be determined from an average of two specimens.

**8.2.7.** The initial dry mass of these specimens shall not vary more than 30.0 grams from the mass determined in the Mix Design (tolerance).





## VOLUMETRIC PROPERTIES OF ASPHALT MIXTURES

### WAQTC TM 13

#### 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 (VMA), voids filled with asphalt binder (VFA), 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<sub>mix max</sub>)
- $G_{mb}$  = measured bulk specific gravity (Gravity<sub>mix bulk</sub>)
- $G_{sb}$  = oven-dry bulk specific gravity of aggregate (Gravity<sub>stone bulk</sub>)
- $G_{sa}$  = apparent specific gravity of aggregate (Gravity<sub>stone apparent</sub>)
- $G_{se}$  = effective specific gravity of aggregate (Gravity<sub>stone effective</sub>)
- $G_b$  = specific gravity of the binder (Gravity<sub>binder</sub>)
- $V_a$  = air Voids (Voids<sub>air</sub>)
- VMA = Voids in Mineral Aggregate
- VFA = Voids Filled with Asphalt (binder)
- $V_{ba}$  = absorbed binder volume (Voids<sub>binder absorbed</sub>)
- $V_{be}$  = effective binder volume (Voids<sub>binder effective</sub>)
- $P_b$  = percent binder content (Percent<sub>binder</sub>)
- $P_{ba}$  = percent absorbed binder (Percent<sub>binder absorbed</sub>)
- $P_{be}$  = percent effective binder content (Percent<sub>binder effective</sub>)
- $P_s$  = percent of aggregate (Percent<sub>stone</sub>)
- DP = Dust proportion to effective binder ratio  
( $P_{\#200}/P_{be}$ )

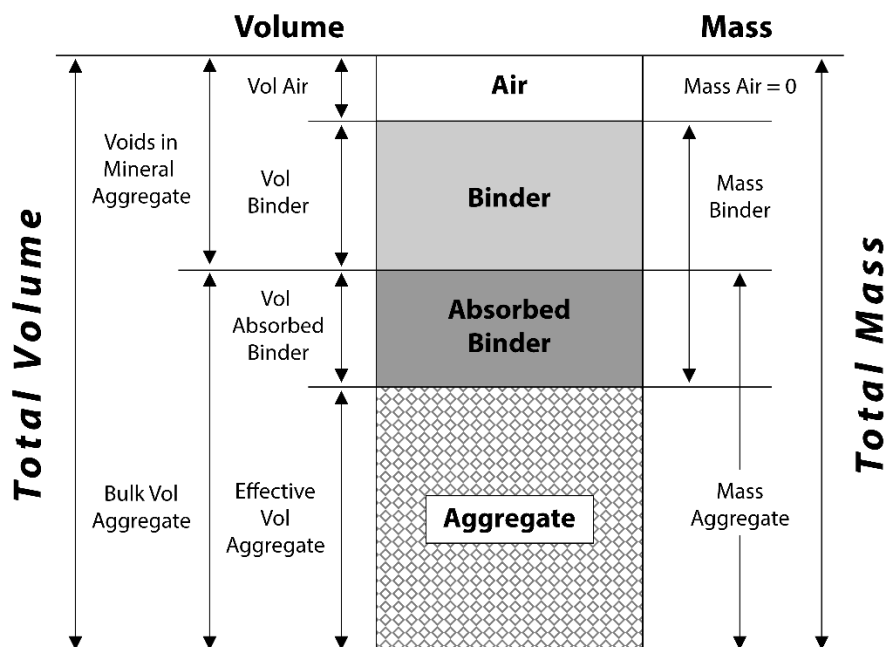
## Background

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. Asphalt mixture 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 asphalt mixture must be designed to meet these criteria. In production the asphalt mixture is evaluated to determine if the mix still meets the specifications and is consistent with the original mix design (JMF). The production asphalt mixture 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 asphalt mixture mix is obtained in accordance with FOP for AASHTO R 97. The sample is then compacted in a gyratory compactor to simulate the in-place asphalt mixture pavement after it has been placed, compacted, and the volumetric properties of the compacted sample are determined.

**Asphalt mixture phase diagram**

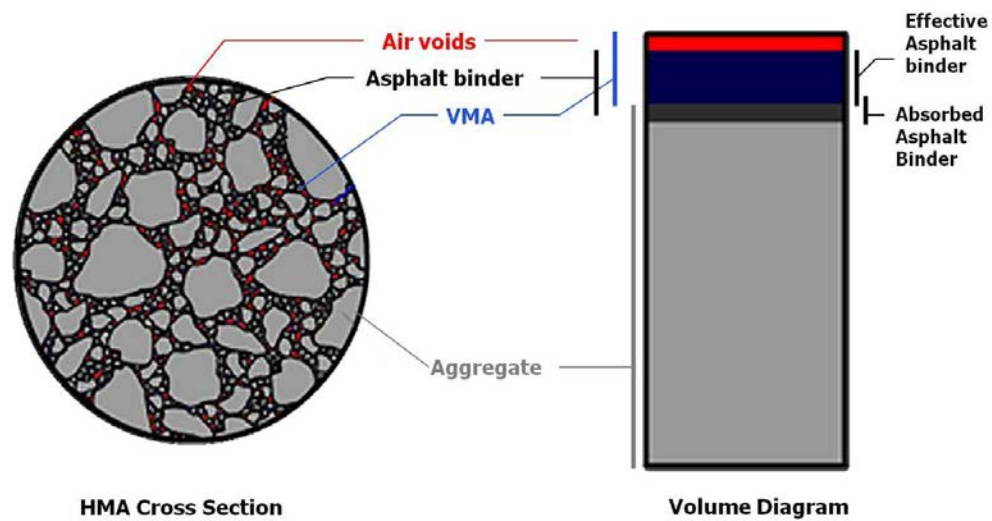


Each of the properties in the asphalt mixture phase diagram can be measured or calculated. For example: The mass of the aggregate is measured; the voids in mineral aggregate (VMA) is calculated; total asphalt binder can be measured but the amount available to act as a binder in the mix must be calculated 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 asphalt mixture: air voids ( $V_a$ ), voids in mineral aggregate (VMA), voids filled with asphalt binder (VFA), and effective asphalt binder content ( $P_{be}$ ) provide some indication of the mixture's probable performance.

## Volumetric Properties

Volumetric Relationship of Asphalt Mixture Constituents



## Required Values

The specific gravities listed in Table 1 and the percent by mass of each of the components in the asphalt mixture 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 asphalt mixture sample.

**Table 1**

<b>Data</b>	<b>Test Method</b>	<b>Obtained</b>
G <sub>sb</sub> - combined aggregate bulk specific gravity	AASHTO T 84 / T 85 or agency approved test method	JMF or performed at the beginning of placement
G <sub>b</sub> – measured specific gravity of the asphalt binder	AASHTO T 228	JMF or from the supplier
G <sub>mm</sub> – measured maximum specific gravity of the loose mix	FOP for AASHTO T 209	Performed on the field test sample
G <sub>mb</sub> – measured bulk specific gravity of the compacted paving mix	FOP for AASHTO T 166	Performed on the field compacted specimen
P <sub>b</sub> – percent asphalt binder	FOP for AASHTO T 308	Performed on the field test sample
P <sub>-#200</sub> – aggregate passing the #200 (75 µm) sieve	FOP for AASHTO T 30	Performed on the field test sample

## Air Voids (V<sub>a</sub>)

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 asphalt mixture 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<sub>mb</sub>) when compared to the maximum specific gravity (G<sub>mm</sub>).

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

Where:

- V<sub>a</sub> = air voids in compacted mixture, percent of total volume (report to 0.1)
- G<sub>mm</sub> = maximum specific gravity of paving mixture (AASHTO T 209)
- G<sub>mb</sub> = 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.

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

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  $\mu$ m) 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 asphalt mixture is in production based on field test data.

**Table 2**

<b>JMF Data</b>	
Asphalt binder grade	PG 64-28
N <sub>values</sub>	N <sub>ini</sub> = 7 N <sub>des</sub> = <b>75</b> N <sub>max</sub> = 115
G <sub>sb</sub> (combined specific gravity of the aggregate)	2.678
Target P <sub>b</sub>	4.75%
Initial sample mass for gyratory specimens	4840 grams
Mixing temperature range	306 – 312 °F
Laboratory compaction temperature range	286 – 294 °F
G <sub>b</sub> (specific gravity of the asphalt binder)	1.020
<b>Target gradation</b>	
<b>Sieve Size mm (in.)</b>	<b>Percent Passing</b>
19.0 (3/4)	100
12.5 (1/2)	85
9.5 (3/8)	80
4.75 (No. 4)	50
2.36 (No. 8)	30
01.18 (No. 16)	25
0.600 (No. 30)	15
0.300 (No. 50)	10
0.150 (No. 100)	7
75 µm (No. 200)	5.0



## Sample Test Result

Tables 3 and 4 include data from test results performed on a field sample of asphalt mixture used in the example calculations.

**Table 3**

Field Data		
	Test method	Example values
P <sub>b</sub>	FOP for AASHTO T 308	4.60%
G <sub>mb</sub>	FOP for AASHTO T 166	2.415
G <sub>mm</sub>	FOP for AASHTO T 209	2.516

**Table 4**

Sieve Analysis FOP for AASHTO T 30	
Sieve Size mm (in.)	Percent Passing
19.0 (3/4)	100
12.5 (1/2)	86
9.5 (3/8)	77
4.75 (No. 4)	51
2.36 (No. 8)	34
01.18 (No. 16)	23
0.600 (No. 30)	16
0.300 (No. 50)	12
0.150 (No. 100)	8
75 μm (No. 200)	4.9

## Sample Calculations

### Air Voids (V<sub>a</sub>)

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

$$V_a = 100 \left[ \frac{(2.516 - 2.415)}{2.516} \right] = 4.01431\% \text{ report } 4.0\%$$

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) ( $G_{se}$ )

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

$$G_{se} = \frac{(100 - 4.60\%)}{\left[ \left( \frac{100}{2.516} \right) - \left( \frac{4.60\%}{1.020} \right) \right]} =$$

$$G_{se} = \frac{95.40\%}{39.74563 - 4.50980} = 2.70747 \text{ report } 2.707$$

Given:

$$G_b = 1.020$$

### Percent of Absorbed (asphalt) Binder ( $P_{ba}$ )

$$P_{ba} = 100 \left[ \frac{(G_{se} - G_{sb})}{(G_{sb} \times G_{se})} \right] G_b$$

$$P_{ba} = 100 \left[ \frac{(2.707 - 2.678)}{(2.678 \times 2.707)} \right] 1.020 =$$

$$P_{ba} = 100 \left[ \frac{0.0290}{7.24935} \right] 1.020 = 0.40804\% \text{ report } 0.41\%$$

### 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 the nearest 0.1 percent
- Voids in the Mineral Aggregate, VMA to the nearest 0.1 percent
- Voids Filled with Asphalt, VFA to the nearest whole value
- Effective Specific Gravity of Aggregate (stone),  $G_{se}$  to the nearest 0.001
- Percent of Absorbed (asphalt) Binder,  $P_{ba}$  to the nearest 0.01
- Percent Effective (asphalt) Binder,  $P_{be}$  to the nearest 0.01
- Dust Proportion, DP to the nearest 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) ( $G_{se}$ )

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

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  $\mu$ m) sieve, percent by mass of aggregate (AASHTO T 30)

$P_{be}$  = effective asphalt binder content, percent by total weight

[FOP for WAQTC TM 13](#)

## Definition of Terms

$V_a$  = air Voids ( $Voids_{air}$ )

$P_a$  = Air Voids: Asphalt Institute 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.

## Table 1

Test Method for  $G_{sb}$ : Delete AASHTO T 84 and substitute Idaho IT-144.

Air Voids ( $V_a$ )

Asphalt Institute MS-2, 7th Edition now uses the following equation to calculate Air Voids. They are mathematically equivalent and the use of either is acceptable.

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





## **SAMPLING FRESHLY MIXED CONCRETE FOP FOR WAQTC TM 2**

### **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), meeting the requirements of FOP for AASHTO T 27/T 11, minimum of 2 ft<sup>2</sup> (0.19 m<sup>2</sup>) 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 m<sup>3</sup> (1 ft<sup>3</sup>).
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  $1/2 \text{ m}^3$  ( $1/2 \text{ yd}^3$ ) 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  $1/2 \text{ m}^3$  ( $1/2 \text{ yd}^3$ ) 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  $1/2 \text{ m}^3$  ( $1/2 \text{ yd}^3$ ) 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 T 121.

### **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.

Procedure Element	Trial 1	Trial 2
1. Receptacle dampened and excess water removed?	_____	_____
2. Obtain a representative sample from drum mixer:		
a. Concrete sampled after 1/2 m <sup>3</sup> (1/2 yd <sup>3</sup> ) discharged?	_____	_____
b. Receptacle passed through entire discharge stream or discharge stream completely diverted into sampling container?	_____	_____
3. Obtain a representative sample from a paving mixer:		
a. Concrete sampled after all the concrete has been discharged?	_____	_____
b. Material obtained from at least 5 different locations in the pile?	_____	_____
c. Avoid contaminating the sample with sub-grade materials.	_____	_____
4. Obtain a representative sample from a pump:		
a. Concrete sampled after 1/2 m <sup>3</sup> (1/2 yd <sup>3</sup> ) has been discharged?	_____	_____
b. All the pump slurry is out of the lines?	_____	_____
c. Receptacle passed through entire discharge stream or discharge stream completely diverted into sampling container?	_____	_____
d. Do not lower the pump arm from the placement position.	_____	_____
5. Samples transported to place of testing?	_____	_____
6. Sample(s) combined, or remixed, or both?	_____	_____
7. Sample protected?	_____	_____
8. Minimum size of sample used for strength tests 0.03 m <sup>3</sup> (1ft <sup>3</sup> )?	_____	_____
9. Completed temperature test within 5 minutes of obtaining sample?	_____	_____
10. Start tests for slump and air within 5 minutes of obtaining sample?	_____	_____
11. Start molding cylinders within 15 minutes of obtaining sample?	_____	_____
12. Protect sample against rapid evaporation and contamination?	_____	_____

**OVER**

**Procedure Element****Trial 1   Trial 2**

## 13. Wet Sieving:

- |  |       |       |
|--|-------|-------|
| a. Required sieve size determined for test method to be performed? | _____ | _____ |
| b. Concrete placed on sieve and doesn't overload the sieve.        | _____ | _____ |
| c. Sieve shaken until no more material passes the sieve.           | _____ | _____ |
| d. Sieving continued until required testing size obtained.         | _____ | _____ |
| e. Oversized aggregate discarded.                                  | _____ | _____ |
| f. Sample remixed.   | _____ | _____ |

Comments:      First attempt:   Pass\_\_\_\_\_Fail\_\_\_\_\_      Second attempt: Pass\_\_\_\_\_Fail\_\_\_\_\_

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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.

Procedure Element	Trial 1	Trial 2
1. What is the minimum sample size?		
a. 0.03 m <sup>3</sup> or 1 ft <sup>3</sup>	_____	_____
2. Describe the surface of the receptacle before the sample is introduced into it?		
a. It must be dampened.	_____	_____
3. Describe how to obtain a representative sample from a drum mixer.		
a. Sample the concrete after 1/2 m <sup>3</sup> (1/2 yd <sup>3</sup> ) has been discharged.	_____	_____
b. Pass receptacle through entire discharge stream or completely divert discharge stream into sampling container.	_____	_____
4. Describe how to obtain a representative sample from a paving mixer.		
a. Sample the concrete after all the concrete has been discharged.	_____	_____
b. Obtain the material from at least 5 different locations in the pile.	_____	_____
c. Avoid contaminating the sample with sub-grade materials.	_____	_____
5. Describe how to obtain a representative sample from a pump:		
a. Sample the concrete after 1/2 m <sup>3</sup> (1/2 yd <sup>3</sup> ) has been discharged.	_____	_____
b. Make sure all the pump slurry is out of the lines.	_____	_____
c. Pass receptacle through entire discharge stream or completely divert discharge stream into sampling container.	_____	_____
d. Do not lower the pump arm from the placement position.	_____	_____
6. After obtaining the sample or samples what must you do?		
a. Transport samples to place of testing.	_____	_____
7. What must be done with the sample or samples once you have transported them to the place of testing?		
a. Combine and remix the sample.	_____	_____
b. Protect sample against rapid evaporation and contamination.	_____	_____

**OVER**

Procedure Element	Trial 1	Trial 2
8. What are the two time parameters associated with sampling?		
a. Complete temperature test and start tests for slump and air within 5 minutes of sample being obtained?	_____	_____
b. Start molding cylinders within 15 minutes of sample being obtained?	_____	_____
9. What test methods may require wet sieving?		
a. Slump, air content, and strength specimens?	_____	_____
10. The sieve size used for wet sieving is based on?		
a. The test method to be performed.	_____	_____
11. How long must you continue wet sieving?		
a. Until a sample of sufficient size for the test being performed is obtained.	_____	_____
12. What is done with the oversized aggregate?		
a. Discard it.	_____	_____
13. What must be done to the sieved sample before testing?		
a. Remix.	_____	_____

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

### 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 at 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  $\pm 0.5^{\circ}\text{C}$  ( $\pm 1^{\circ}\text{F}$ ) 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  $0.2^{\circ}\text{C}$  ( $0.5^{\circ}\text{F}$ ) 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  $15^{\circ}\text{C}$  or  $27^{\circ}\text{F}$  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.

Procedure Element	Trial 1	Trial 2
1. Obtain sample of concrete large enough to provide a minimum of 75 mm (3 in.) of concrete cover around sensor in all directions?	_____	_____
2. Place temperature measuring device in sample with a minimum of 75 mm (3 in.) cover around sensor?	_____	_____
3. Gently press concrete around thermometer?	_____	_____
4. Read temperature after a minimum of 2 minutes or when temperature reading stabilizes?	_____	_____
5. Complete temperature measurement within 5 minutes of obtaining sample?	_____	_____
6. Record temperature to nearest 0.5°C (1°F)?	_____	_____

Comments: First attempt: Pass\_\_\_\_Fail\_\_\_\_ Second attempt: Pass\_\_\_\_Fail\_\_\_\_

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Examiner Signature \_\_\_\_\_ WAQTC #: \_\_\_\_\_

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## SLUMP OF HYDRAULIC CEMENT CONCRETE FOP FOR AASHTO T 119

### Scope

This procedure provides instructions for determining the slump of hydraulic cement concrete in accordance with AASHTO T 119-18. It is not applicable to non-plastic and non-cohesive concrete.

**Warning**—Fresh Hydraulic cementitious mixtures are caustic and may cause chemical burns to skin and tissue upon prolonged exposure.

### Apparatus

- Mold: conforming to AASHTO T 119
  - Metal: 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.
  - Non-metal: see AASHTO T 119, Section 5.1.2.
- Tamping rod: 16 mm (5/8 in.) diameter and 400 mm (16 in.) to 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 the concrete mixture contains aggregate retained on the 37.5mm (1½ in.) sieve, the aggregate must be removed in accordance with the Wet Sieving portion of the FOP for WAQTC TM 2.

Begin testing 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  $\frac{2}{3}$  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  $5 \pm 2$  seconds by a steady upward lift with no lateral or torsional (twisting) motion being imparted to the concrete.  
Complete the entire operation from the start of the filling through removal of the mold without interruption 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 1:** 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.

Procedure Element	Trial 1	Trial 2
<b>First layer</b>		
1. Mold and floor or base plate dampened?	_____	_____
2. Mold held firmly against the base by standing on the two foot pieces? Mold not allowed to move in any way during filling?	_____	_____
3. Representative sample scooped into the mold, moving a scoop around the perimeter of the mold to evenly distribute the concrete as discharged?	_____	_____
4. Mold approximately one third (by volume), 67 mm (2 5/8 in.) deep?	_____	_____
5. Layer rodded throughout its depth 25 times with hemispherical end of rod, uniformly distributing strokes?	_____	_____
<b>Second layer</b>		
6. Representative samples scooped into the mold, moving a scoop around the perimeter of the mold to evenly distribute the concrete as discharged?	_____	_____
7. Mold filled approximately two thirds (by volume), 155 mm (6 1/8 in.), deep?	_____	_____
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?	_____	_____
<b>Third layer</b>		
9. Representative sample scooped into the mold, moving a scoop around the perimeter of the mold to evenly distribute the concrete as discharged??	_____	_____
10. Mold filled to just over the top of the mold?	_____	_____
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?	_____	_____
12. Excess concrete kept above the mold at all times while rodding?	_____	_____
13. Concrete struck off level with top of mold using tamping rod?	_____	_____

**OVER**

Procedure Element	Trial 1	Trial 2
14. Concrete removed from around the outside bottom of the mold?	_____	_____
15. Mold lifted upward 300 mm (12 in.) in one smooth motion, without a lateral or twisting motion of the mold, in $5 \pm 2$ seconds?	_____	_____
16. Test performed from start of filling through removal of the mold within 2 1/2 minutes?	_____	_____
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?	_____	_____

Comments: First attempt: Pass\_\_\_\_\_Fail\_\_\_\_\_ Second attempt: Pass\_\_\_\_\_Fail\_\_\_\_\_

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Examiner Signature \_\_\_\_\_ WAQTC #: \_\_\_\_\_

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## DENSITY (UNIT WEIGHT), YIELD, AND AIR CONTENT (GRAVIMETRIC) OF CONCRETE FOP FOR AASHTO T 121

### Scope

This procedure covers the determination of density, or unit weight, of freshly mixed concrete in accordance with AASHTO T 121-19. 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 400 mm (16 in.) to 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: frequency at least 9000 vibrations per minute (150 Hz), at least 19 to 38 mm (3/4 to 1 1/2 in.) in diameter but not greater than 38 mm (1 1/2 in.), and the length of the shaft shall be at least 75 mm (3 in.) than the depth of the section being vibrated.
- 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  $0.57 \pm 0.23$  kg ( $1.25 \pm 0.5$  lb) for use with measures of  $0.014 \text{ m}^3$  ( $1/2 \text{ ft}^3$ ) or less, or having a mass of  $1.02 \pm 0.23$  kg ( $2.25 \pm 0.5$  lb) for use with measures of  $0.028 \text{ m}^3$  ( $1 \text{ ft}^3$ ).

**Table 1**  
**Dimensions of Measures\***

Capacity m <sup>3</sup> (ft <sup>3</sup> )	Inside Diameter mm (in.)	Inside Height mm (in.)	Minimum Thicknesses mm (in.)		Nominal Maximum Size of Coarse Aggregate*** mm (in.)
			Bottom	Wall	
0.0071	203 ±2.54	213 ±2.54	5.1	3.0	25
(1/4)**	(8.0 ±0.1)	(8.4 ±0.1)	(0.20)	(0.12)	(1)
0.0142	254 ±2.54	279 ±2.54	5.1	3.0	50
(1/2)	(10.0 ±0.1)	(11.0 ±0.1)	(0.20)	(0.12)	(2)
0.0283	356 ±2.54	284 ±2.54	5.1	3.0	76
(1)	(14.0 ±0.1)	(11.2 ±0.1)	(0.20)	(0.12)	(3)

\* **Note 1:** 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.

## 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 concrete with slump 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 m<sup>3</sup> (1/2 ft<sup>3</sup>) 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 before the FOP for AASHTO T 152.

**Note 2:** If the two tests are being performed using the same sample, this test shall begin within five minutes of obtaining the sample.

2. Determine and record the mass of the empty measure.
3. Dampen the inside of the measure and empty excess water.

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.
13. After consolidation, 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.
14. 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.
15. Clean off all excess concrete from the exterior of the measure including the rim.
16. Determine and record the mass of the measure and the concrete.
17. 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. 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. Tap around the perimeter of the measure smartly 10 to 15 times with the mallet.
5. Slightly overfill the measure. Evenly distribute the concrete in a circular motion around the inner perimeter of the measure.
6. Insert the vibrator at three different points, penetrating the first layer approximately 25 mm (1 in.). Do not let the vibrator touch the side of the measure.
7. Tap around the perimeter of the measure smartly 10 to 15 times with the mallet.
8. Return to Step 13 of the rodding procedure.

**Procedure – Self-Consolidating Concrete**

1. Perform Steps 1 through 3 of the rodding procedure.
2. Use the scoop to slightly overfill the measure. Evenly distribute the concrete in a circular motion around the inner perimeter of the measure.
3. Return to Step 13 of the rodding procedure.

**Calculations****Mass of concrete in the measure**

$$\text{concrete mass} = M_c - M_m$$

Where:

Concrete mass = mass of concrete in measure

$M_c$  = mass of measure and concrete

$M_m$  = mass of measure

**Density**

$$D = \frac{\text{concrete mass}}{V_m}$$

Where:

D = density of the concrete mix

$V_m$  = volume of measure (Annex A)

**Yield  $m^3$** 

$$Y_{m^3} = \frac{W}{D}$$

Where:

$Y_{m^3}$  = yield ( $m^3$  of the batch of concrete)

W = total mass of the batch of concrete

**Yield yd<sup>3</sup>**

$$Y_{ft^3} = \frac{W}{D} \qquad Y_{yd^3} = \frac{Y_{ft^3}}{27ft^3/yd^3}$$

Where:

$Y_{ft^3}$	=	yield (ft <sup>3</sup> of the batch of concrete)
$Y_{yd^3}$	=	yield (yd <sup>3</sup> of the batch of concrete)
W	=	total mass of the batch of concrete
D	=	density of the concrete mix

**Note 5:** The total mass, W, includes the masses of the cement, water, and aggregates in the concrete.

**Cement Content**

$$N = \frac{N_t}{Y}$$

Where:

N	=	actual cementitious material content per $Y_m^3$ or $Y_{yd}^3$
$N_t$	=	mass of cementitious material in the batch
Y	=	$Y_m^3$ or $Y_{yd}^3$

**Note 6:** Specifications may require Portland Cement content and supplementary cementitious materials content.

**Water Content**

The mass of water in a batch of concrete is the sum of:

- 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 required by the agency)

\*Mass of free water on aggregate

This information is obtained from concrete batch tickets collected from the driver. Use the Table 2 to convert liquid measures.

**Table 2**  
**Liquid Conversion Factors**

To Convert From	To	Multiply By
Liters, L	Kilograms, kg	1.0
Gallons, gal	Kilograms, kg	3.785
Gallons, gal	Pounds, lb	8.34
Milliliters, mL	Kilograms, kg	0.001
Ounces, oz	Milliliters, mL	28.4
Ounces, oz	Kilograms, kg	0.0284
Ounces, oz	Pounds, lb	0.0625
Pounds, lb	Kilograms, kg	0.4536

**Mass of free water on aggregate**

$$\text{Free Water Mass} = \text{CA or FC Aggregate} - \frac{\text{CA or FC Aggregate}}{1 + (\text{Free Water Percentage}/100)}$$

Where:

Free Water Mass           = on coarse or fine aggregate  
 FC or CA Aggregate       = mass of coarse or fine aggregate  
 Free Water Percentage   = percent of moisture of coarse or fine aggregate

**Water/Cement Ratio**

$$\frac{\text{Water Content}}{C}$$

Where:

Water Content   = total mass of water in the batch  
 C               = total mass of cementitious materials

**Example**

Mass of concrete in measure ( $M_m$ )	16.290 kg (36.06 lb)
Volume of measure ( $V_m$ )	0.007079 m <sup>3</sup> (0.2494 ft <sup>3</sup> )

From batch ticket:

Yards batched	4 yd <sup>3</sup>
Cement	950 kg (2094 lb)
Fly ash	180 kg (397 lb)
Coarse aggregate	3313 kg (7305 lb)
Fine aggregate	2339 kg (5156 lb)
Water added at plant	295 L (78 gal)

Other

Water added in transit	0
Water added at jobsite	38 L (10 gal)
Total mass of the batch of concrete (W)	7115 kg (15,686 lb)
Moisture content of coarse aggregate	1.7%
Moisture content of coarse aggregate	5.9%



**Density**

$$D = \frac{M_m}{V_m}$$

$$D = \frac{16.920 \text{ kg}}{0.007079 \text{ m}^3} = 2390 \text{ kg/m}^3 \quad D = \frac{36.06 \text{ lb}}{0.2494 \text{ ft}^3} = 144.6 \text{ lb/ft}^3$$

Given:

$$M_m = 16.920 \text{ kg (36.06 lb)}$$

$$V_m = 0.007079 \text{ m}^3 (0.2494 \text{ ft}^3) \text{ (Annex A)}$$

**Yield m<sup>3</sup>**

$$Y_{m^3} = \frac{W}{D}$$

$$Y_{m^3} = \frac{7115 \text{ kg}}{2390 \text{ kg/m}^3} = 2.98 \text{ m}^3$$

Given:

$$\text{Total mass of the batch of concrete (W), kg} = 7115 \text{ kg}$$

**Yield  $yd^3$** 

$$Y_{ft^3} = \frac{W}{D}$$

$$Y_{yd^3} = \frac{Y_{ft^3}}{27 ft^3 / yd^3}$$

$$Y_{ft^3} = \frac{15,686 \text{ lb}}{144.6 \text{ lb}/ft^3} = 108.48 \text{ ft}^3 \quad Y_{yd^3} = \frac{108.48 \text{ ft}^3}{27 \text{ ft}^3 / yd^3} = 4.02 \text{ yd}^3$$

Given:

Total mass of the batch of concrete (W), lb = 15,686 lb

**Cement Content**

$$N = \frac{N_t}{Y}$$

$$N = \frac{950 \text{ kg} + 180 \text{ kg}}{2.98 \text{ m}^3} = 379 \text{ kg}/\text{m}^3 \quad N = \frac{2094 \text{ lb} + 397 \text{ lb}}{4.02 \text{ yd}^3} = 620 \text{ lb}/\text{yd}^3$$

Given:

$N_t$  (cement) = 950 kg (2094 lb)

$N_t$  (flyash) = 180 kg (397 lb)

$Y$  =  $Y_m^3$  or  $Y_{yd}^3$

**Note 6:** Specifications may require Portland Cement content and supplementary cementitious materials content.

**Free water**

$$\text{Free Water Mass} = \text{CA or FC Aggregate} - \frac{\text{CA or FC Aggregate}}{1 + (\text{Free Water Percentage}/100)}$$

$$\text{CA Free Water} = 3313 \text{ kg} - \frac{3313 \text{ kg}}{1 + (1.7/100)} = 55 \text{ kg}$$

$$\text{CA Free Water} = 7305 \text{ lb} - \frac{7305 \text{ lb}}{1 + (1.7/100)} = 122 \text{ lb}$$

$$\text{FA Free Water} = 2339 \text{ kg} - \frac{2339 \text{ kg}}{1 + (5.9/100)} = 130 \text{ kg}$$

$$\text{FA Free Water} = 5156 \text{ lb} - \frac{5156 \text{ lb}}{1 + (5.9/100)} = 287 \text{ lb}$$

Given:

CA aggregate = 3313 kg (7305 lb)

FC aggregate = 2339 kg (5156 lb)

CA moisture content = 1.7%

FC moisture content = 5.9%

**Water Content**

Total of all water in the mix.

$$\text{Water Content} = [(78 \text{ gal} + 10 \text{ gal}) * 3.785 \text{ kg/gal}] + 55 \text{ kg} + 130 \text{ kg} = 518 \text{ kg}$$

$$\text{Water Content} = [(78 \text{ gal} + 10 \text{ gal}) * 8.34 \text{ lb/gal}] + 122 \text{ lb} + 287 \text{ lb} = 1143 \text{ lb}$$

Given:

$$\text{Water added at plant} = 295 \text{ L (78 gal)}$$

$$\text{Water added at the jobsite} = 38 \text{ L (10 gal)}$$

**Water/ Cement Ratio**

$$W/C = \frac{518 \text{ kg}}{950 \text{ kg} + 180 \text{ kg}} = 0.458 \quad W/C = \frac{1143 \text{ lb}}{2094 \text{ lb} + 397 \text{ lb}} = 0.459$$

**Report 0.46**

**Report**

- Results on forms approved by the agency
- Sample ID
- Density (unit weight) to the nearest 1 kg/m<sup>3</sup> (0.1 lb/ft<sup>3</sup>)
- Yield to the nearest 0.01 m<sup>3</sup> (0.01 yd<sup>3</sup>)
- Cement content to the nearest 1 kg/m<sup>3</sup> (1 lb/yd<sup>3</sup>)
- Cementitious material content to the nearest 1 kg/m<sup>3</sup> (1 lb/yd<sup>3</sup>)
- Water/Cement ratio to the nearest 0.01

## ANNEX A

### 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.

#### Apparatus

- Listed in the FOP for AASHTO T 121
  - Measure
  - Balance or scale
  - Strike-off plate
- Thermometer: Standardized liquid-in-glass, or electronic digital total immersion type, accurate to 0.5°C (1°F)

#### Procedure

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 A1, 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.

**Calculations**

$$V_m = \frac{M}{D}$$

Where:

$V_m$  = volume of the mold

$M$  = mass of water in the mold

$D$  = density of water at the measured temperature

**Example**

Mass of water in Measure = 7.062 kg (15.53 lb)

Density of water at 23°C (73.4°F) = 997.54 kg/m<sup>3</sup> (62.274 lb/ft<sup>3</sup>)

$$V_m = \frac{7.062 \text{ kg}}{997.54 \text{ kg/m}^3} = 0.007079 \text{ m}^3 \quad V_m = \frac{15.53 \text{ lb}}{62.274 \text{ lb/ft}^3} = 0.2494 \text{ ft}^3$$

**Table A1**  
**Unit Mass of Water**  
**15°C to 30°C**

°C	(°F)	kg/m <sup>3</sup>	(lb/ft <sup>3</sup> )	°C	(°F)	kg/m <sup>3</sup>	(lb/ft <sup>3</sup> )
15	(59.0)	999.10	(62.372)	23	(73.4)	997.54	(62.274)
15.6	(60.0)	999.01	(62.366)	23.9	(75.0)	997.32	(62.261)
16	(60.8)	998.94	(62.361)	24	(75.2)	997.29	(62.259)
17	(62.6)	998.77	(62.350)	25	(77.0)	997.03	(62.243)
18	(64.4)	998.60	(62.340)	26	(78.8)	996.77	(62.227)
18.3	(65.0)	998.54	(62.336)	26.7	(80.0)	996.59	(62.216)
19	(66.2)	998.40	(62.328)	27	(80.6)	996.50	(62.209)
20	(68.0)	998.20	(62.315)	28	(82.4)	996.23	(62.192)
21	(69.8)	997.99	(62.302)	29	(84.2)	995.95	(62.175)
21.1	(70.0)	997.97	(62.301)	29.4	(85.0)	995.83	(62.166)
22	(71.6)	997.77	(62.288)	30	(86.0)	995.65	(62.156)

## Report

- Measure ID
- Date Standardized
- Temperature of the water
- Volume,  $V_m$ , of the measure





**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.**

<b>Procedure Element</b>	<b>Trial 1</b>	<b>Trial 2</b>
1. Mass and volume of empty measure determined?	_____	_____
<b>First Layer</b>		
2. Dampened measure filled approximately one third full, moving a scoop around the perimeter of the measure to evenly distribute the concrete as discharged?	_____	_____
3. Layer rodded throughout its depth 25 times, without forcibly striking the bottom of the measure, with hemispherical end of rod, uniformly distributing strokes?	_____	_____
4. Perimeter of the measure tapped 10 to 15 times with the mallet after rodding?	_____	_____
<b>Second layer</b>		
5. Measure filled approximately two thirds full, moving a scoop around the perimeter of the measure to evenly distribute the concrete as discharged?	_____	_____
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?	_____	_____
7. Perimeter of the measure tapped 10 to 15 times with the mallet after rodding?	_____	_____
<b>Third layer</b>		
8. Measure slightly overfilled, moving a scoop around the perimeter of the measure to evenly distribute the concrete as discharged?	_____	_____
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?	_____	_____
10. Perimeter of the measure tapped 10 to 15 times with the mallet after rodding each layer?	_____	_____
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?	_____	_____

**OVER**

Procedure Element	Trial 1	Trial 2
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. Concrete mass calculated?	_____	_____
17. Density calculated correctly?	_____	_____

Comments: First attempt: Pass\_\_\_\_\_Fail\_\_\_\_\_ Second attempt: Pass\_\_\_\_\_Fail\_\_\_\_\_

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Examiner Signature \_\_\_\_\_ WAQTC #: \_\_\_\_\_

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## AIR CONTENT OF FRESHLY MIXED CONCRETE BY THE PRESSURE METHOD FOP for AASHTO T 152

### Scope

This procedure covers determination of the air content in freshly mixed Portland Cement Concrete containing dense aggregates in accordance with AASHTO T 152-19, 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, Annex A.

**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 400 mm (16 in.) to 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: frequency at least 9000 vibrations per minute (150 Hz), at least 19 to 38 mm (3/4 to 1 1/2 in.) in diameter but not greater than 38 mm (1 1/2 in.), and the length of the shaft shall be at least 75 mm (3 in.) than the depth of the section being vibrated.
  - 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  $0.57 \pm 0.23$  kg ( $1.25 \pm 0.5$  lb)

## 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 concrete with 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 the concrete mixture contains aggregate retained on the 37.5mm (1½ in.) sieve, the aggregate must be removed in accordance with the Wet Sieving portion of the FOP for WAQTC TM 2.  
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.
12. After consolidation, 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.
13. 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.
14. Clean the top flange of the measure to ensure a proper seal.

15. Moisten the inside of the cover and check to see that both petcocks are open and the main air valve is closed.
16. Clamp the cover on the measure.
17. Inject water through a petcock on the cover until water emerges from the petcock on the other side.
18. 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.
19. 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.
20. 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.
21. Close both petcocks.
22. Open the main air valve.
23. Tap the side of the measure smartly with the mallet.
24. 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.
25. Release or close the main air valve.
26. Open both petcocks to release pressure, remove the concrete, and thoroughly clean the cover and measure with clean water.
27. 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. Tap around the perimeter of the measure smartly 10 to 15 times with the mallet.

6. 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.
7. Insert the vibrator at three different points, penetrating the first layer approximately 25 mm (1 in.). Do not let the vibrator touch the 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.
8. Tap around the perimeter of the measure smartly 10 to 15 times with the mallet.
9. Return to Step 12 of the rodding procedure.

### **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 slightly overfill the measure. Evenly distribute the concrete in a circular motion around the inner perimeter of the measure.
4. Return to Step 12 of the rodding procedure.

### **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.)

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**ANNEX A—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 logbook 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.
2. Determine and record the mass of the dry, empty air meter measure and cover assembly (mass method only).
3. Fill the measure nearly full with water.
4. Clamp the cover on the measure with the tube extending down into the water. Mark the petcock with the tube attached for future reference.
5. 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.
6. Wipe off the air meter measure and cover assembly; determine and record the mass of the filled unit (mass method only).
7. 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.
8. 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.
9. Determine which petcock has the straight tube attached to it. Attach the curved tube to external portion of the same petcock.
10. 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 2 from the mass found in Step 6. 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 A1:** 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.

11. 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.
12. 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  $5.0 \pm 0.1$  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  $5.0 \pm 0.1$  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.
13. 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.
14. If an internal standardization vessel is used, follow Steps 1 through 8 to set initial reading.
15. 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.)
16. Place the cover back on the measure and add water through the petcock until all the air has been expelled.
17. 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.
18. 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.
19. Remove the extension tubing from threaded petcock hole in the underside of the cover before starting the test procedure.

## Report

- Air meter ID
- Date standardized
- Initial pressure (IP)



**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.**

<b>Procedure Element</b>	<b>Trial 1</b>	<b>Trial 2</b>
1. Representative sample selected?	_____	_____
<b>First Layer</b>		
2. Dampened measure filled approximately one third full, moving a scoop around the perimeter of the measure to evenly distribute the concrete as discharged?	_____	_____
3. Layer rodded throughout its depth 25 times, without forcibly striking the bottom of the measure, with hemispherical end of rod, uniformly distributing strokes?	_____	_____
4. Perimeter of the measure tapped 10 to 15 times with the mallet after rodding?	_____	_____
<b>Second layer</b>		
5. Measure filled approximately two thirds full, moving a scoop around the perimeter of the measure to evenly distribute the concrete as discharged?	_____	_____
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?	_____	_____
7. Perimeter of the measure tapped 10 to 15 times with the mallet after rodding?	_____	_____
<b>Third layer</b>		
8. Measure slightly overfilled, moving a scoop around the perimeter of the measure to evenly distribute the concrete as discharged?	_____	_____
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?	_____	_____
10. Perimeter of the measure tapped 10 to 15 times with the mallet after rodding each layer?	_____	_____
11. Concrete struck off level with top of the measure using the bar or strike-off plate and rim cleaned off?	_____	_____
12. Top flange of base cleaned?	_____	_____

**OVER**

**Procedure Element****Trial 1   Trial 2****Using a Type B Meter:**

13. Both petcocks open?	_____	_____
14. Air valve closed between air chamber and the measure?	_____	_____
15. Inside of cover cleaned and moistened before clamping to base?	_____	_____
16. Water injected through petcock until it flows out the other petcock?	_____	_____
17. Water injection into the petcock continued while jarring and or rocking the meter to insure all air is expelled?	_____	_____
18. Air pumped up to just past initial pressure line?	_____	_____
19. A few seconds allowed for the compressed air to stabilize?	_____	_____
20. Gauge adjusted to the initial pressure?	_____	_____
21. Both petcocks closed?	_____	_____
22. Air valve opened between chamber and measure?	_____	_____
23. The outside of measure tapped smartly with the mallet?	_____	_____
24. With the main air valve open, gauge lightly tapped and air percentage read to the nearest 0.1 percent?	_____	_____
25. Air valve released or closed and then petcocks opened to release pressure before removing the cover?	_____	_____
26. Aggregate correction factor applied if required?	_____	_____
27. Air content recorded to 0.1 percent?	_____	_____

**Comments:**      First attempt: Pass\_\_\_\_\_Fail\_\_\_\_\_      Second attempt: Pass\_\_\_\_\_Fail\_\_\_\_\_

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Examiner Signature \_\_\_\_\_ WAQTC #: \_\_\_\_\_

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## METHOD OF MAKING AND CURING CONCRETE TEST SPECIMENS IN THE FIELD FOP FOR AASHTO T 23

### Scope

This procedure covers the method for making, initially curing, and transporting concrete test specimens in the field in accordance with AASHTO T 23-18.

**Warning**—Fresh Hydraulic cementitious mixtures are caustic and may cause chemical burns to skin and tissue upon prolonged exposure.

### Apparatus

- 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 400 mm (16 in.) to 600 mm (24 in.) long, having a hemispherical tip of the same diameter as the rod for preparing 150 mm (6 in.) x 300 mm (12 in.) cylinders.
- Small tamping rod: 10 mm (3/8 in.) diameter and 305 mm (12 in.) to 600 mm (24 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 9000 vibrations per minute, with a diameter no more than 1/4 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  $0.57 \pm 0.23$  kg ( $1.25 \pm 0.5$  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 before 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 –Self-Consolidating Concrete**

1. Use the scoop to slightly overfill the mold. Evenly distribute the concrete in a circular motion around the inner perimeter of the mold.
2. Strike off the surface of the molds with tamping rod, straightedge, float, or trowel.
3. Immediately begin initial curing.

**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. Immediately 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. Immediately 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 mm<sup>2</sup> (2 in<sup>2</sup>) 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. Immediately 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. Immediately 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:
  - 16 to 27°C (60 to 80°F) for concrete with design strength up to 40 Mpa (6000 psi).
  - 20 to 26°C (68 to 78°F) for concrete with design 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. 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  $23^{\circ} \pm 2^{\circ}\text{C}$  ( $73 \pm 3^{\circ}\text{F}$ ). 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 before 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 before 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.

<b>Procedure Element</b>	<b>Trial 1</b>	<b>Trial 2</b>
1. Molds placed on a level, rigid, horizontal surface free of vibration?	_____	_____
2. Representative sample selected?	_____	_____
3. Making of specimens begun within 15 minutes of sampling?	_____	_____
<b>First layer</b>		
4. Concrete placed in the mold, moving a scoop or trowel around the perimeter of the mold to evenly distribute the concrete as discharged?	_____	_____
5. Mold filled approximately half full?	_____	_____
6. Layer rodded throughout its depth 25 times with hemispherical end of rod, uniformly distributing strokes?	_____	_____
7. Sides of the mold tapped 10-15 times after rodding?		
a. With mallet for reusable steel molds	_____	_____
b. With the open hand for flexible light-gauge molds	_____	_____
<b>Second layer</b>		
8. Concrete placed in the mold, moving a scoop or trowel around the perimeter of the mold to evenly distribute the concrete as discharged?	_____	_____
9. Mold slightly overfilled on the last layer?	_____	_____
10. Layer rodded 25 times with hemispherical end of rod, uniformly distributing strokes and penetrating 25 mm (1 in.) into the underlying layer?	_____	_____
11. Sides of the mold tapped 10-15 times after rodding each layer?		
a. With mallet for reusable steel molds	_____	_____
b. With the open hand for flexible light-gauge molds	_____	_____
12. Concrete struck off with tamping rod, float or trowel?	_____	_____
13. Specimens covered with non-absorptive, non-reactive cap or plate?	_____	_____
14. Initial curing addressed?	_____	_____

**OVER**

Comments: First attempt: Pass\_\_\_\_Fail\_\_\_\_ Second attempt: Pass\_\_\_\_Fail\_\_\_\_

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Examiner Signature \_\_\_\_\_ WAQTC #: \_\_\_\_\_

This checklist is derived, in part, from copyrighted material printed in ACI CP-1, published by the American Concrete Institute.

**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.**

<b>Procedure Element</b>	<b>Trial 1</b>	<b>Trial 2</b>
1. Molds placed on a level, rigid, horizontal surface free of vibration?	_____	_____
2. Representative sample selected?	_____	_____
3. Making of specimens begun within 15 minutes of sampling?	_____	_____
<b>First layer</b>		
4. Concrete placed in the mold, moving a scoop or trowel around the perimeter of the mold to evenly distribute the concrete as discharged?	_____	_____
5. Mold filled approximately one third full?	_____	_____
6. Layer rodded throughout its depth 25 times with hemispherical end of rod, uniformly distributing strokes?	_____	_____
7. Sides of the mold tapped 10-15 times after rodding each layer?		
a. With mallet for reusable steel molds	_____	_____
b. With the open hand for flexible light-gauge molds	_____	_____
<b>Second layer</b>		
8. Concrete placed in the mold, moving a scoop or trowel around the perimeter of the mold to evenly distribute the concrete as discharged?	_____	_____
9. Mold filled approximately two thirds full?	_____	_____
10. Layer rodded 25 times with hemispherical end of rod, uniformly distributing strokes and penetrating 25 mm (1 in.) into the underlying layer?	_____	_____
11. Sides of the mold tapped 10-15 times after rodding?		
a. With mallet for reusable steel molds	_____	_____
b. With the open hand for flexible light-gauge molds	_____	_____
<b>Third layer</b>		
12. Concrete placed in the mold, moving a scoop or trowel around the perimeter of the mold to evenly distribute the concrete as discharged?	_____	_____

**OVER**

Procedure Element	Trial 1	Trial 2
13. Mold slightly overfilled on the last layer?	_____	_____
14. Layer rodded 25 times with hemispherical end of rod, uniformly distributing strokes and penetrating 25 mm (1 in.) into the underlying layer?	_____	_____
15. Sides of the mold tapped 10-15 times after rodding?		
a. With mallet for reusable steel molds	_____	_____
b. With the open hand for flexible light-gauge molds	_____	_____
16. Concrete struck off with tamping rod, straightedge, float, or trowel?	_____	_____
17. Specimens covered with non-absorptive, non-reactive cap or plate?	_____	_____
18. Initial curing addressed?	_____	_____

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.

**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**

**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 R 90 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**

<b>Nominal Maximum Size* mm (in.)</b>	<b>Minimum Sample Mass g (lb)</b>
4.75 (No. 4)	500 (1.1)
9.5 (3/8)	1500 (3.3)
12.5 (1/2)	2000 (4)
19.0 (3/4)	3000 (7)
25.0 (1)	4000 (9)
37.5 (1 1/2)	6000 (13)
50 (2)	8000 (18)
63 (2 1/2)	10,000 (22)
75 (3)	13,000 (29)
90 (3 1/2)	16,000 (35)
100 (4)	25,000 (55)
150 (6)	50,000 (110)

\* 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**

<b>Maximum Particle Size mm (in.)</b>	<b>Minimum Sample Mass g</b>
0.425 (No. 40)	10
4.75 (No. 4)	100
12.5 (1/2)	300
25.0 (1)	500
50 (2)	1000

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  $110 \pm 5^{\circ}\text{C}$  ( $230 \pm 9^{\circ}\text{F}$ ).
    - ii. Uncontrolled heat source (Hot plate, infrared heater, etc.): Stir frequently to avoid localized overheating.
  - b. For soil – controlled heat source (oven): at  $110 \pm 5^{\circ}\text{C}$  ( $230 \pm 9^{\circ}\text{F}$ ).

**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 (w) 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**

<b>Aggregate</b>		
<b>Heat Source</b>	<b>Specific Instructions</b>	<b>Drying intervals to achieve constant mass (minutes)</b>
<b>Controlled:</b> Forced draft (preferred), ventilated, or convection oven	110 ±5°C (230 ±9°F)	30
<b>Uncontrolled:</b>		
Hot plate, infrared heater, etc.	Stir frequently	10
Microwave	Heap sample and cover with ventilated lid	2
<b>Soil</b>		
<b>Heat Source</b>	<b>Specific Instructions</b>	<b>Drying increments (minutes)</b>
<b>Controlled:</b> Forced draft (preferred), ventilated, or convection oven	110 ±5°C (230 ±9°F)	1 hour

## Calculation

### 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

$M_n$  = 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

$$\% \text{ Change} = \frac{1405.1 \text{ g} - 1402.0 \text{ g}}{1405.1 \text{ g}} \times 100 = 0.22\%$$

*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

$$\% \text{ Change} = \frac{1402.0 \text{ g} - 1400.9 \text{ g}}{1402.0 \text{ g}} \times 100 = 0.08\%$$

*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<sub>W</sub> = wet mass

M<sub>D</sub> = dry mass

Example:

Mass of container: 1232.1 g

Mass of container and wet sample: 2764.7 g

Mass, M<sub>W</sub>, of wet sample: 2764.7 g - 1232.1 g = 1532.6 g

Mass of container and dry sample (COOLED): 2633.5 g

Mass, M<sub>D</sub>, 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<sub>W</sub>, wet mass
- M<sub>D</sub>, dry mass
- w, moisture content to the 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.

Procedure Element	Trial 1	Trial 2
1. Representative sample of appropriate mass obtained?	_____	_____
2. Mass of container determined to 0.1 g?	_____	_____
3. Sample placed in container and mass determined to 0.1 g?	_____	_____
4. Test sample mass conforms to the required mass?	_____	_____
5. Wet sample mass determined to 0.1 g?	_____	_____
6. Loss of moisture avoided prior to mass determination?	_____	_____
7. Sample dried by a suitable heat source?	_____	_____
a. Describe suitable heat sources for aggregate?	_____	_____
b. Describe suitable heat sources for soils?	_____	_____
8. If aggregate heated by means other than a controlled oven, is sample stirred to avoid localized overheating?	_____	_____
9. For microwave, aggregate heaped and covered with a ventilated lid?	_____	_____
10. For aggregate, heated for the additional, specified time?	_____	_____
a. Forced draft, ventilated, convection ovens – 30 minutes;		
b. Microwave – 2 minutes		
c. Other – 10 minutes		
11. For soil:		
a. Heated for at least 1 hour additional drying time using a controlled heat source?	_____	_____
12. Mass determined and compared to previous mass - showing less than 0.10 percent loss?	_____	_____
13. Sample cooled, dry mass determined and recorded to the nearest 0.1 percent?	_____	_____
14. Moisture content calculated correctly and recorded to the nearest 0.1 percent?	_____	_____

OVER

EMBANKMENT AND BASE  
IN-PLACE DENSITY

WAQTC / IDAHO

FOP AASHTO T 255/T 265 (18)

Comments:      First attempt:    Pass\_\_\_\_Fail\_\_\_\_      Second attempt:    Pass\_\_\_\_Fail\_\_\_\_

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Examiner Signature \_\_\_\_\_ WAQTC #: \_\_\_\_\_

**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  
USING A 4.54 kg (10 lb) RAMMER AND A 457 mm (18 in.) DROP  
FOP FOR AASHTO T 180**

**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 99-19: Methods A, B, C, and D
- AASHTO T 180-19: 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 (¾ 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 A, Correction of Maximum Dry Density and Optimum Moisture for Oversized Particles*. 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 wet 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 mold 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 *Annex B, Standardization of the Mold*.
- 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  $110 \pm 5^{\circ}\text{C}$  ( $230 \pm 9^{\circ}\text{F}$ ) 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.), meeting the requirements of FOP for AASHTO T 27/T 11.
- 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**

	<b>T 99</b>	<b>T 180</b>
Mold Volume, m <sup>3</sup>	Methods A, C: 0.000943 ±0.000014 Methods B, D: 0.002124 ±0.000025	Methods A, C: 0.000943 ±0.000014 Methods B, D: 0.002124 ±0.000025
Mold Diameter, mm	Methods A, C: 101.60 ±0.40 Methods B, D: 152.40 ±0.70	Methods A, C: 101.60 ±0.4 Methods B, D: 152.40 ±0.70
Mold Height, mm	116.40 ±0.50	116.40 ±0.50
Detachable Collar Height, mm	50.80 ±0.64	50.80 ±0.64
Rammer Diameter, mm	50.80 ±0.25	50.80 ±0.25
Rammer Mass, kg	2.495 ±0.009	4.536 ±0.009
Rammer Drop, mm	305	457
Layers	3	5
Blows per Layer	Methods A, C: 25 Methods B, D: 56	Methods A, C: 25 Methods B, D: 56
Material Size, mm	Methods A, B: 4.75 minus Methods C, D: 19.0 minus	Methods A, B: 4.75 minus Methods C, D: 19.0 minus
Test Sample Size, kg	Method A: 3 Method C: 5 (1)	Method B: 7 Method D: 11(1)
Energy, kN-m/m <sup>3</sup>	592	2,693

(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**

	<b>T 99</b>	<b>T 180</b>
Mold Volume, ft <sup>3</sup>	Methods A, C: 0.0333 ±0.0005 Methods B, D: 0.07500 ±0.0009	Methods A, C: 0.0333 ±0.0005 Methods B, D: 0.07500 ±0.0009
Mold Diameter, in.	Methods A, C: 4.000 ±0.016 Methods B, D: 6.000 ±0.026	Methods A, C: 4.000 ±0.016 Methods B, D: 6.000 ±0.026
Mold Height, in.	4.584 ±0.018	4.584 ±0.018
Detachable Collar Height, in.	2.000 ±0.025	2.000 ±0.025
Rammer Diameter, in.	2.000 ±0.025	2.000 ±0.025
Rammer Mass, lb	5.5 ±0.02	10 ±0.02
Rammer Drop, in.	12	18
Layers	3	5
Blows per Layer	Methods A, C: 25 Methods B, D: 56	Methods A, C: 25 Methods B, D: 56
Material Size, in.	Methods A, B: No. 4 minus Methods C, D: 3/4 minus	Methods A, B: No.4 minus Methods C, D: 3/4 minus
Test Sample Size, lb	Method A: 7 Method C: 12 <sub>(1)</sub>	Method B: 16 Method D: 25 <sub>(1)</sub>
Energy, lb-ft/ft <sup>3</sup>	12,375	56,250

(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.

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.

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.

**Note 1:** Both T 99 and T 180 have four methods (A, B, C, D) that require different masses and employ different sieves.

## Procedure

During compaction, rest the mold 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. For many materials, this condition can be identified by forming a cast by hand.
  - a. Prepare individual samples of plastic or degradable material, increasing moisture contents 1 to 2 percent for each point.
  - b. Allow samples of plastic soil to stand for 12 hrs.
3. Form a specimen by compacting the prepared soil in the mold assembly in approximately equal layers. For each layer:
  - a. Spread the loose material uniformly in the mold.

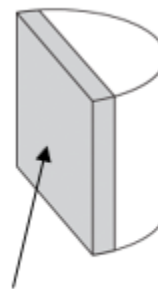
**Note 2:** It is recommended to cover the remaining material with a non-absorbent sheet or damp cloth to minimize loss of moisture.

- 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 ( $\frac{1}{4}$  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. Clean soil from exterior of the mold and base plate.
7. Determine and record the mass of the mold, base plate, and wet soil to the nearest 1 g (0.005 lb) or better.
8. Determine and record the wet mass ( $M_w$ ) of the sample by subtracting the mass in Step 1 from the mass in Step 7.
9. Calculate the wet density, in  $\text{kg/m}^3$  ( $\text{lb/ft}^3$ ), by dividing the wet mass by the measured volume ( $V_m$ ).
10. 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.



**Extruded material**



**Representative moisture  
content sample**

**Note 3:** 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.

11. Determine and record the moisture content of the sample in accordance with the FOP for AASHTO T 255 / T 265.
12. If the material is degradable or plastic, return to Step 3 using a prepared individual sample. If not, continue with Steps 13 through 15.
13. 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.
14. Add sufficient water to increase the moisture content of the remaining soil by 1 to 2 percentage points and repeat steps 3 through 11.
15. Continue determinations until there is either a decrease or no change in the wet mass. There will be a minimum of three points on the dry side of the curve and two points on the wet side. For non-cohesive, drainable soils, one point on the wet side is sufficient.

## Calculations

### Wet Density

$$D_w = \frac{M_w}{V_m}$$

Where:

$D_w$  = wet density, kg/m<sup>3</sup> (lb/ft<sup>3</sup>)

$M_w$  = wet mass

$V_m$  = volume of the mold, Annex B

### Dry Density

$$D_d = \left( \frac{D_w}{w + 100} \right) \times 100 \quad \text{or} \quad D_d = \frac{D_w}{\left( \frac{w}{100} \right) + 1}$$

Where:

$D_d$  = dry density,  $\text{kg/m}^3$  ( $\text{lb/ft}^3$ )

$w$  = moisture content, as a percentage

### Example for 4-inch mold, Methods A or C

Wet mass,  $M_w$  = 1.928 kg (4.25 lb)

Moisture content,  $w$  = 11.3%

Measured volume of the mold,  $V_m$  = 0.000946  $\text{m}^3$  (0.0334  $\text{ft}^3$ )

### Wet Density

$$D_w = \frac{1.928 \text{ kg}}{0.000946 \text{ m}^3} = 2038 \text{ kg/m}^3 \quad D_w = \frac{4.25 \text{ lb}}{0.0334 \text{ ft}^3} = 127.2 \text{ lb/ft}^3$$

### Dry Density

$$D_d = \left( \frac{2038 \text{ kg/m}^3}{11.3 + 100} \right) \times 100 = 1831 \text{ kg/m}^3 \quad D_d = \left( \frac{127.2 \text{ lb/ft}^3}{11.3 + 100} \right) \times 100 = 114.3 \text{ lb/ft}^3$$

Or

$$D_d = \left( \frac{2038 \text{ kg/m}^3}{\frac{11.3}{100} + 1} \right) = 1831 \text{ kg/m}^3 \quad D_d = \left( \frac{127.2 \text{ lb/ft}^3}{\frac{11.3}{100} + 1} \right) = 114.3 \text{ lb/ft}^3$$

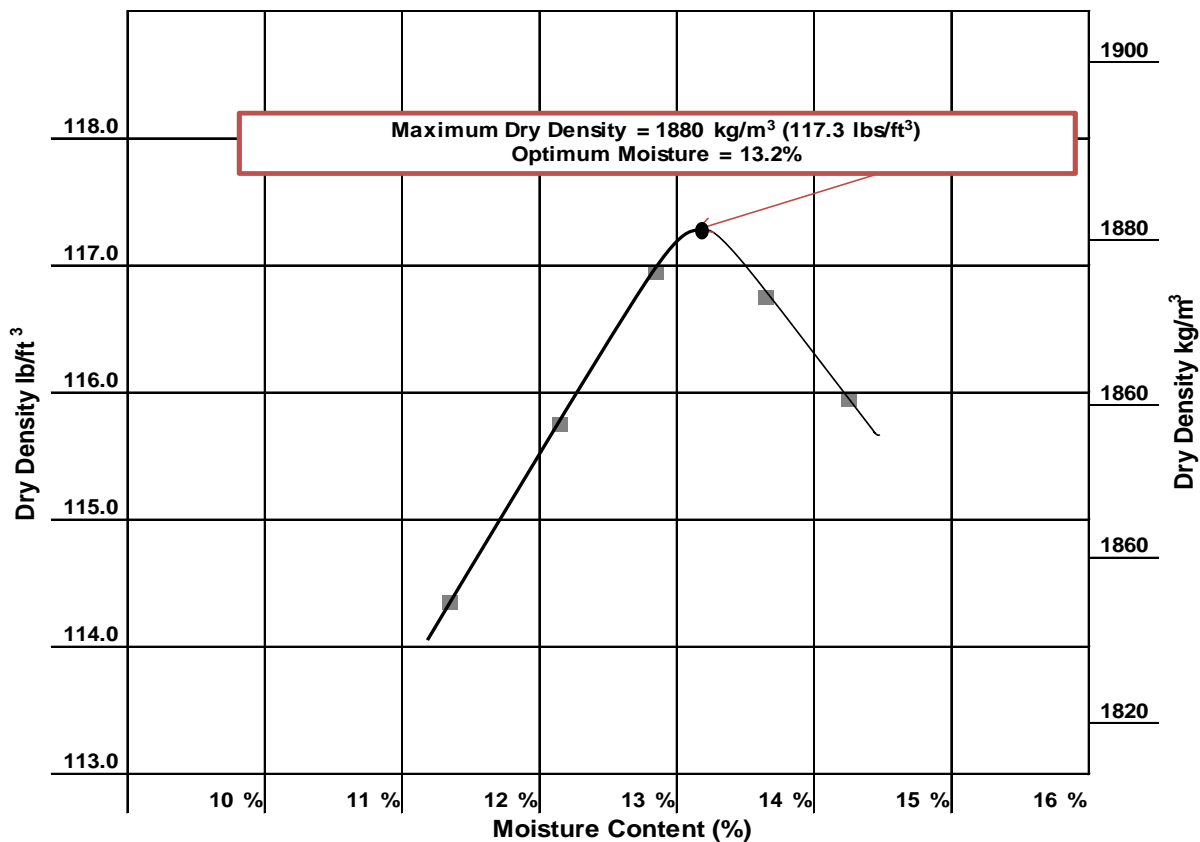
## Moisture-Density Curve Development

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.

Dry Density		Moisture Content, %
kg/m <sup>3</sup>	lb/ft <sup>3</sup>	
1831	114.3	11.3
1853	115.7	12.1
1873	116.9	12.8
1869	116.7	13.6
1857	115.9	14.2



In this case, the curve has its peak at:

$$\text{Maximum dry density} = 1880 \text{ kg/m}^3 (117.3 \text{ lb/ft}^3)$$

$$\text{Optimum moisture content} = 13.2\%$$

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 nearest 1 kg/m<sup>3</sup> (0.1 lb/ft<sup>3</sup>)
- Optimum moisture content to the nearest 0.1 percent

## ANNEX A

### 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:

$M_D$  = 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.

$$P_f = \frac{100 \times M_{DF}}{M_{DF} + M_{DC}} \quad \frac{100 \times 15.4 \text{ lb}}{15.4 \text{ lbs} + 5.7 \text{ lb}} = 73\% \quad \frac{100 \times 6.985 \text{ kg}}{6.985 \text{ kg} + 2.585 \text{ kg}} = 73\%$$

And

$$P_c = \frac{100 \times M_{DC}}{M_{DF} + M_{DC}} \quad \frac{100 \times 5.7 \text{ lb}}{15.4 \text{ lbs} + 5.7 \text{ lb}} = 27\% \quad \frac{100 \times 2.585 \text{ kg}}{6.985 \text{ kg} + 2.585 \text{ kg}} = 27\%$$

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 dry fine particles

$M_{DC}$  = mass of dry oversize particles

## Optimum Moisture Correction Equation

1. Calculate the corrected moisture content as follows:

$$MC_T = \frac{(MC_F \times P_f) + (MC_c \times P_c)}{100} = \frac{(13.2\% \times 73.0\%) + (2.1\% \times 27.0\%)}{100} = 10.2\%$$

$MC_T$  = 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:

$$D_d = \frac{100\%}{\left[\left(\frac{P_f}{D_f}\right) + \left(\frac{P_c}{k}\right)\right]}$$

Where:

$D_d$  = corrected total dry density (combined fine and oversized particles)  
 $\text{kg/m}^3$  ( $\text{lb/ft}^3$ )

$D_f$  = dry density of the fine particles  $\text{kg/m}^3$  ( $\text{lb/ft}^3$ ), determined in the lab

$P_c$  = percent of dry oversize particles, of sieve used, by weight.

$P_f$  = percent of dry fine particles, of sieve used, by weight.

$k$  = Metric:  $1,000 \times$  Bulk Specific Gravity ( $G_{sb}$ ) (oven dry basis)  
of coarse particles ( $\text{kg/m}^3$ ).

$k$  = English:  $62.4 \times$  Bulk Specific Gravity ( $G_{sb}$ ) (oven dry basis)  
of coarse particles ( $\text{lb/ft}^3$ )

**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

### Example

- Metric:

Maximum laboratory dry density ( $D_f$ ):	1880 kg/m <sup>3</sup>
Percent coarse particles ( $P_c$ ):	27%
Percent fine particles ( $P_f$ ):	73%
Mass per volume coarse particles (k):	(2.697) (1000) = 2697 kg/m <sup>3</sup>

$$D_d = \frac{100\%}{\left[\left(\frac{P_f}{D_f}\right) + \left(\frac{P_c}{k}\right)\right]}$$

$$D_d = \frac{100\%}{\left[\left(\frac{73\%}{1880 \text{ kg/m}^3}\right) + \left(\frac{27\%}{2697 \text{ kg/m}^3}\right)\right]}$$

$$D_d = \frac{100\%}{[0.03883 \text{ kg/m}^3 + 0.01001 \text{ kg/m}^3]}$$

$$D_d = 2047.5 \text{ kg/m}^3 \text{ report } 2048 \text{ kg/m}^3$$

English:

Maximum laboratory dry density ( $D_f$ ): 117.3 lb/ft<sup>3</sup>

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<sup>3</sup>

$$D_d = \frac{100\%}{\left[\left(\frac{P_f}{D_f}\right) + \left(\frac{P_c}{k}\right)\right]}$$

$$D_d = \frac{100\%}{\left[\left(\frac{73\%}{117.3 \text{ lb/ft}^3}\right) + \left(\frac{27\%}{168.3 \text{ lb/ft}^3}\right)\right]}$$

$$D_d = \frac{100\%}{[0.6223 \text{ lb/ft}^3 + 0.1604 \text{ lb/ft}^3]}$$

$$D_d = \frac{100\%}{0.7827 \text{ lb/ft}^3}$$

$$D_d = 127.76 \text{ lb/ft}^3 \quad \text{Report } 127.8 \text{ lb/ft}^3$$

## Report

- Results on forms approved by the agency
- Sample ID
- Corrected maximum dry density to the nearest 1 kg/m<sup>3</sup> (0.1 lb/ft<sup>3</sup>)
- Corrected optimum moisture to the nearest 0.1 percent

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## **ANNEX B**

### **STANDARDIZATION OF THE MOLD**

Standardization is a critical step to ensure accurate test results when using this apparatus. Failure to perform the standardization procedure as described herein will produce inaccurate or unreliable test results.

#### **Apparatus**

Mold and base plate

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.

- Cover plate – A piece of plate glass, at least 6 mm (1/4 in.) thick and at least 25 mm (1 in.) larger than the diameter of the mold.
- Thermometers – Standardized liquid-in-glass, or electronic digital total immersion type, accurate to 0.5°C (1°F)

#### **Procedure**

1. Create a watertight seal between the mold and base plate.
2. Determine and record the mass of the dry sealed mold, base plate, and cover plate.
3. Fill the mold with water at a temperature between 16°C and 29°C (60°F and 85°F) and cover with the cover plate in such a way as to eliminate bubbles and excess water.
4. Wipe the outside of the mold, base plate, and cover plate dry, being careful not to lose any water from the mold.
5. Determine and record the mass of the filled mold, base plate, cover plate, and water.
6. Determine and record the mass of the water in the mold by subtracting the mass in Step 2 from the mass in Step 5.
7. Measure the temperature of the water and determine its density from Table B1, interpolating as necessary.
8. Calculate the volume of the mold,  $V_m$ , by dividing the mass of the water in the mold by the density of the water at the measured temperature.

## Calculations

$$V_m = \frac{M}{D}$$

Where:

$V_m$  = volume of the mold

$M$  = mass of water in the mold

$D$  = density of water at the measured temperature

## Example

Mass of water in mold= 0.94367 kg (2.0800 lb)

Density of water at 23°C (73.4°F) = 997.54 kg/m<sup>3</sup> (62.274 lb/ft<sup>3</sup>)

$$V_m = \frac{0.94367 \text{ kg}}{997.54 \text{ kg/m}^3} = 0.000946 \text{ m}^3 \quad V_m = \frac{2.0800 \text{ lb}}{62.274 \text{ lb/ft}^3} = 0.0334 \text{ ft}^3$$

**Table B1**  
**Unit Mass of Water**  
**15°C to 30°C**

°C	(°F)	kg/m <sup>3</sup>	(lb/ft <sup>3</sup> )	°C	(°F)	kg/m <sup>3</sup>	(lb/ft <sup>3</sup> )
15	(59.0)	999.10	(62.372)	23	(73.4)	997.54	(62.274)
15.6	(60.0)	999.01	(62.366)	23.9	(75.0)	997.32	(62.261)
16	(60.8)	998.94	(62.361)	24	(75.2)	997.29	(62.259)
17	(62.6)	998.77	(62.350)	25	(77.0)	997.03	(62.243)
18	(64.4)	998.60	(62.340)	26	(78.8)	996.77	(62.227)
18.3	(65.0)	998.54	(62.336)	26.7	(80.0)	996.59	(62.216)
19	(66.2)	998.40	(62.328)	27	(80.6)	996.50	(62.209)
20	(68.0)	998.20	(62.315)	28	(82.4)	996.23	(62.192)
21	(69.8)	997.99	(62.302)	29	(84.2)	995.95	(62.175)
21.1	(70.0)	997.97	(62.301)	29.4	(85.0)	995.83	(62.166)
22	(71.6)	997.77	(62.288)	30	(86.0)	995.65	(62.156)

## Report

- Mold ID
- Date Standardized
- Temperature of the water
- Volume,  $V_m$ , of the mold to the nearest 0.000001 m<sup>3</sup> (0.0001 ft<sup>3</sup>)





## 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.

Procedure Element	Trial 1	Trial 2
1. If damp, sample dried in air or drying apparatus, not exceeding 60°C (140°F)?	_____	_____
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?	_____	_____
3. Sample passing the sieve has appropriate mass?	_____	_____
4. If material is degradable:		
a. Multiple samples mixed with water varying moisture content by 1 to 2 percent, bracketing the optimum moisture content?	_____	_____
5. If soil is plastic (clay types):		
a. Multiple samples mixed with water varying moisture content by 1 to 2 percent, bracketing the optimum moisture content?	_____	_____
b. Samples placed in covered containers and allowed to stand for at least 12 hours?	_____	_____
6. Sample determined to be 4 to 8 percent below expected optimum moisture content?	_____	_____
7. Determine mass of clean, dry mold without collar to nearest 1 g?	_____	_____
8. Mold placed on rigid and stable foundation?	_____	_____
9. Layer of soil (approximately one third compacted depth) placed in mold with collar attached, loose material lightly tamped?	_____	_____
10. Soil compacted with appropriate number of blows (25 or 56)?	_____	_____
11. Material adhering to the inside of the mold trimmed?	_____	_____
12. Layer of soil (approximately two thirds compacted depth) placed in mold with collar attached, loose material lightly tamped?	_____	_____
13. Soil compacted with appropriate number of blows (25 or 56)?	_____	_____
14. Material adhering to the inside of the mold trimmed?	_____	_____
15. Mold filled with soil such that compacted soil will be above the mold, loose material lightly tamped?	_____	_____

OVER

<b>Procedure Element</b>	<b>Trial 1</b>	<b>Trial 2</b>
16. Soil compacted with appropriate number of blows (25 or 56)?	_____	_____
17. Collar removed without shearing off sample?	_____	_____
18. Approximately 6 mm (1/4 in.) of compacted material above the top of the mold (without the collar)?	_____	_____
19. Soil trimmed to top of mold with the beveled side of the straightedge?	_____	_____
20. Remove all soil from exterior surface of mold and base plate?	_____	_____
21. Mass of mold and contents determined to appropriate precision (1 g)?	_____	_____
22. Wet density calculated from the wet mass?	_____	_____
23. Soil removed from mold using a sample extruder if needed?	_____	_____
24. Soil sliced vertically through center (non-granular material)?	_____	_____
25. Moisture sample removed ensuring all layers are represented?	_____	_____
26. Moist mass determined immediately to 0.1 g?	_____	_____
27. Moisture sample mass of correct size?	_____	_____
28. Sample dried, and water content determined according to the FOP for T 255/T 265?	_____	_____
a. 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?	_____	_____
b. Water added to increase moisture content of the remaining sample in approximately 1 to 2 percent increments?	_____	_____
c. Steps 7 through 29 repeated for each increment of water added?	_____	_____
29. Process continued until wet density either decreases or stabilizes?	_____	_____
30. Moisture content and dry density calculated for each sample?	_____	_____
31. Dry density plotted on vertical axis, moisture content plotted on horizontal axis, and points connected with a smooth curve?	_____	_____
32. Moisture content at peak of curve recorded as optimum water content and recorded to nearest 0.1 percent?	_____	_____
33. Dry density at optimum moisture content reported as maximum density to nearest 1 kg/m <sup>3</sup> (0.1 lb/ft <sup>3</sup> )?	_____	_____
34. Corrected for coarse particles if applicable?	_____	_____

**Comments:**      First attempt:    Pass\_\_\_\_\_Fail\_\_\_\_\_      Second attempt:    Pass\_\_\_\_\_Fail\_\_\_\_\_

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Examiner Signature \_\_\_\_\_ WAQTC #: \_\_\_\_\_

## 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.

Procedure Element	Trial 1	Trial 2
1. If damp, sample dried in air or drying apparatus, not exceeding 60°C (140°F)?	_____	_____
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?	_____	_____
3. Sample passing the sieve has appropriate mass?	_____	_____
4. If material is degradable:		
a. Multiple samples mixed with water varying moisture content by 1 to 2 percent, bracketing the optimum moisture content?	_____	_____
5. If soil is plastic (clay types):		
a. Multiple samples mixed with water varying moisture content by 1 to 2 percent, bracketing the optimum moisture content?	_____	_____
b. Samples placed in covered containers and allowed to stand for at least 12 hours?	_____	_____
6. Sample determined to be 4 to 8 percent below expected optimum moisture content?	_____	_____
7. Determine mass of clean, dry mold without collar to nearest 1 g?	_____	_____
8. Mold placed on rigid and stable foundation?	_____	_____
9. Layer of soil (approximately one fifth compacted depth) placed in mold with collar attached, loose material lightly tamped?	_____	_____
10. Soil compacted with appropriate number of blows (25 or 56)?	_____	_____
11. Material adhering to the inside of the mold trimmed?	_____	_____
12. Layer of soil (approximately two fifths compacted depth) placed in mold with collar attached, loose material lightly tamped?	_____	_____
13. Soil compacted with appropriate number of blows (25 or 56)?	_____	_____
14. Material adhering to the inside of the mold trimmed?	_____	_____
15. Layer of soil (approximately three fifths compacted depth) placed in mold with collar attached, loose material lightly tamped?	_____	_____
16. Soil compacted with appropriate number of blows (25 or 56)?	_____	_____

**OVER**

Procedure Element	Trial 1	Trial 2
17. Material adhering to the inside of the mold trimmed?	_____	_____
18. Layer of soil (approximately four fifths compacted depth) placed in mold with collar attached, loose material lightly tamped?	_____	_____
19. Soil compacted with appropriate number of blows (25 or 56)?	_____	_____
20. Material adhering to the inside of the mold trimmed?	_____	_____
21. Mold filled with soil such that compacted soil will be above the mold, loose material lightly tamped?	_____	_____
22. Soil compacted with appropriate number of blows (25 or 56)?	_____	_____
23. Collar removed without shearing off sample?	_____	_____
24. Approximately 6 mm (1/4 in.) of compacted material above the top of the mold (without the collar)?	_____	_____
25. Soil trimmed to top of mold with the beveled side of the straightedge?	_____	_____
26. Remove all soil from exterior surface of mold and base plate?	_____	_____
27. Mass of mold and contents determined to appropriate precision (1 g)?	_____	_____
28. Wet density calculated from the wet mass?	_____	_____
29. Soil removed from mold using a sample extruder if needed?	_____	_____
30. Soil sliced vertically through center (non-granular material)?	_____	_____
31. Moisture sample removed ensuring all layers are represented?	_____	_____
32. Moist mass determined immediately to 0.1 g?	_____	_____
33. Moisture sample mass of correct size?	_____	_____
34. Sample dried, and water content determined according to the FOP for T 255/T 265?	_____	_____
35. 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?	_____	_____
36. Water added to increase moisture content of the remaining sample in approximately 1 to 2 percent increments?	_____	_____
37. Steps 2 through 20 repeated for each increment of water added?	_____	_____
38. Process continued until wet density either decreases or stabilizes?	_____	_____
39. Moisture content and dry density calculated for each sample?	_____	_____
40. Dry density plotted on vertical axis, moisture content plotted on horizontal axis, and points connected with a smooth curve?	_____	_____
41. Moisture content at peak of curve recorded as optimum water content and recorded to nearest 0.1 percent?	_____	_____
42. Dry density at optimum moisture content reported as maximum density to nearest 1 kg/m <sup>3</sup> (0.1 lb/ft <sup>3</sup> )?	_____	_____

**OVER**

**Procedure Element**

**Trial 1   Trial 2**

43. Corrected for coarse particles if applicable?

\_\_\_\_\_

Comments:      First attempt:   Pass\_\_\_\_\_Fail\_\_\_\_\_

Second attempt: Pass\_\_\_\_\_Fail\_\_\_\_\_

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Examiner Signature \_\_\_\_\_WAQTC #:\_\_\_\_\_



[FOP for AASHTO T 99 & T 180](#)**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)****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.





## DEVELOPING A FAMILY OF CURVES FOP FOR AASHTO R 75

### 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 to develop a 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/ft<sup>3</sup> apart. Template curves are indicated by a dashed line.

7. Plot the 80 percent of optimum moisture range when desired:
  - a. 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.
  - b. Draw a smooth, “best fit,” curved line connecting the 80 percent of optimum moisture points plotted on the curves that parallel the spine.

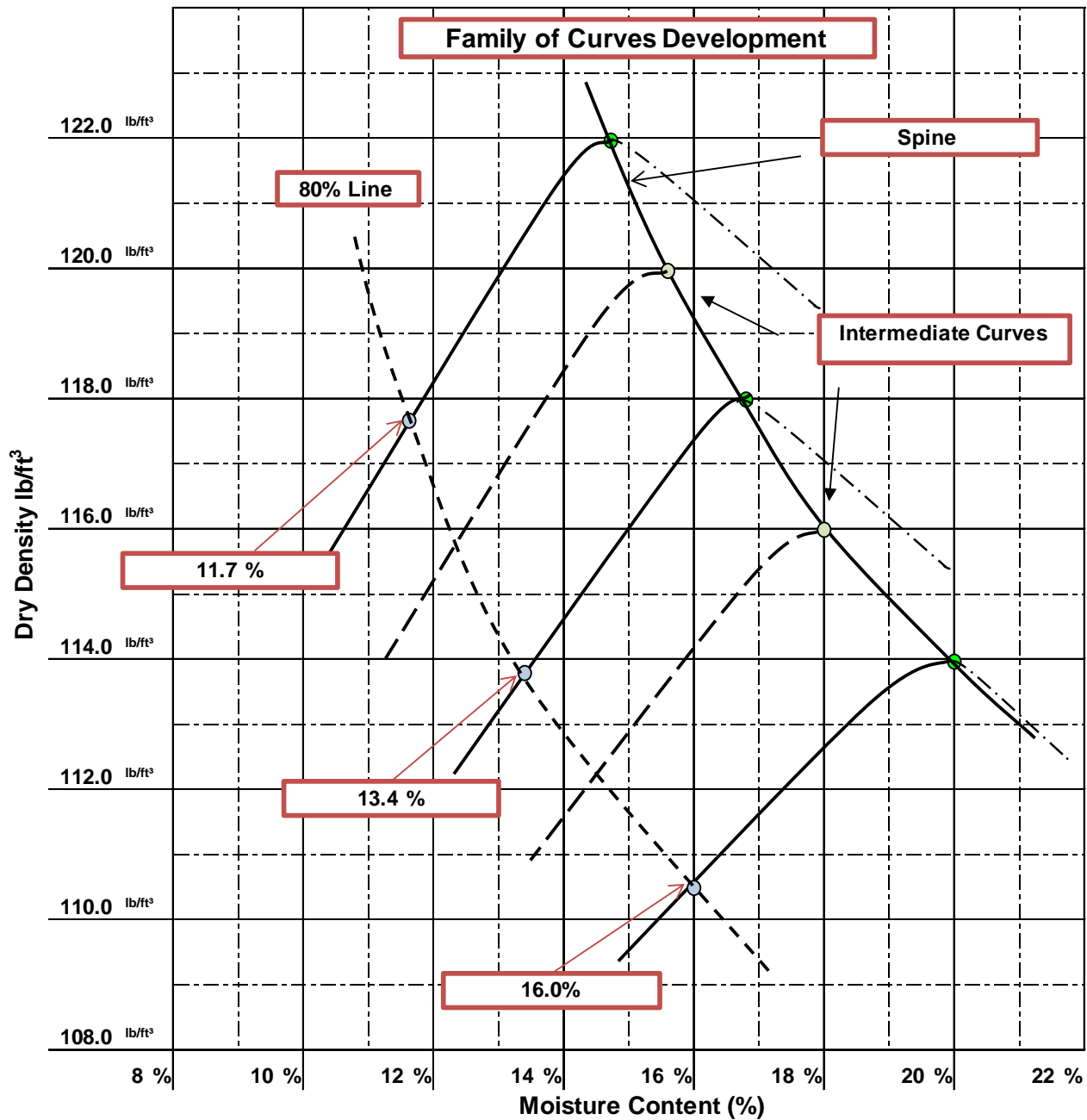
## Calculations

Calculate 80 percent of optimum moisture of each curve:

Example:

Optimum moisture of the highest density curve = 14.6%

$$80\% \text{ point} = \frac{80}{100} \times 14.6\% = 11.7\%$$







## **SPECIFIC GRAVITY AND ABSORPTION OF COARSE AGGREGATE FOP FOR AASHTO T 85**

### **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  $110 \pm 5^{\circ}\text{C}$  ( $230 \pm 9^{\circ}\text{F}$ ) 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, meeting the requirements of FOP for AASHTO T 27/T 11.
- Large absorbent towel

### Sample Preparation

1. Obtain the sample in accordance with the FOP for AASHTO R 90 (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  $110 \pm 5^{\circ}\text{C}$  ( $230 \pm 9^{\circ}\text{F}$ ) 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**

Nominal Maximum Size* mm (in.)	Minimum Mass of Test Sample, g (lb)
12.5 (1/2) or less	2000 (4.4)
19.0 (3/4)	3000 (6.6)
25.0 (1)	4000 (8.8)
37.5 (1 1/2)	5000 (11)
50 (2)	8000 (18)
63 (2 1/2)	12,000 (26)
75 (3)	18,000 (40)

\* 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  $23.0 \pm 1.7^{\circ}\text{C}$  ( $73.4 \pm 3^{\circ}\text{F}$ ). 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)

$$G_{sb}SSD = \frac{B}{B - C}$$

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

Sample	A	B	C	B - C	A - C	B - A
1	2030.9	2044.9	1304.3	740.6	726.6	14.0
2	1820.0	1832.5	1168.1	664.4	651.9	12.5
3	2035.2	2049.4	1303.9	745.5	731.3	14.2

Sample	G <sub>sb</sub>	G <sub>sb</sub> SSD	G <sub>sa</sub>	Absorption
1	2.742	2.761	2.795	0.7
2	2.739	2.758	2.792	0.7
3	2.730	2.749	2.783	0.7

These calculations demonstrate the relationship between G<sub>sb</sub>, G<sub>sb</sub> SSD, and G<sub>sa</sub>. G<sub>sb</sub> is always lowest, since the volume includes voids permeable to water. G<sub>sb</sub> SSD is always intermediate. G<sub>sa</sub> 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 the nearest 0.001
- Absorption to the nearest 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.**

<b>Procedure Element</b>	<b>Trial 1</b>	<b>Trial 2</b>
1. Sample obtained by FOP for AASHTO R 90 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 $110 \pm 5^{\circ}\text{C}$ ( $230 \pm 9^{\circ}\text{F}$ ) and cooled to room temperature?	_____	_____
6. Re-screen over appropriate sieve?	_____	_____
7. Covered with water for 15 to 19 hours?	_____	_____
8. Wire basket completely submerged in immersion tank and attached to balance?	_____	_____
9. Immersion tank inspected for proper water height?	_____	_____
10. Balance tared with basket in tank and temperature checked $23.0 \pm 1.7^{\circ}\text{C}$ ( $73.4 \pm 3^{\circ}\text{F}$ )?	_____	_____
11. Sample removed from water and rolled in cloth to remove visible films of water?	_____	_____
12. Larger particles wiped individually?	_____	_____
13. Evaporation avoided?	_____	_____
14. Sample mass determined to 0.1 g?	_____	_____
15. Sample immediately placed in basket, in immersion tank?	_____	_____
16. Entrapped air removed before weighing by shaking basket while immersed?	_____	_____
17. Immersion tank inspected for proper water height?	_____	_____
18. Immersed sample weight determined to 0.1 g?	_____	_____
19. All the sample removed from basket?	_____	_____
20. Sample dried to constant mass and cooled to room temperature?	_____	_____

**OVER**

**Procedure Element**

**Trial 1 Trial 2**

21. Sample mass determined to 0.1 g?

\_\_\_\_\_

22. Proper formulas used in calculations?

\_\_\_\_\_

Comments: First attempt: Pass\_\_\_\_\_Fail\_\_\_\_\_ Second attempt: Pass\_\_\_\_\_Fail\_\_\_\_\_

\_\_\_\_\_  
 \_\_\_\_\_  
 \_\_\_\_\_  
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 \_\_\_\_\_  
 \_\_\_\_\_

Examiner Signature \_\_\_\_\_ WAQTC #: \_\_\_\_\_

## **IN-PLACE DENSITY OF ASPHALT MIXTURES BY NUCLEAR METHOD FOP FOR AASHTO T 355**

### **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 355-18. 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 before 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) before 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.

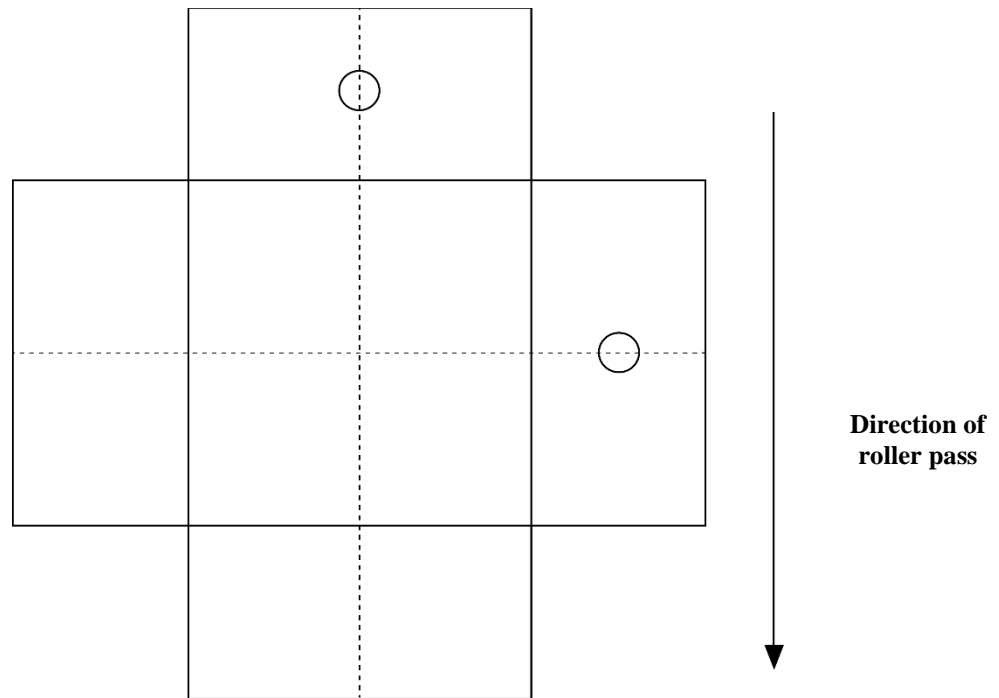
## Procedure

1. Maintain maximum contact between the base of the gauge and the surface of the material under test.
2. Use filler material to fill surface voids.
3. 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.
4. If using thin-layer mode, enter the anticipated overlay thickness into the gauge.

**Note 2:** If core correlation is required, entered thickness, anticipated thickness, and nominal core thickness may be required to match.

**Method A – Average of two one-minute tests**

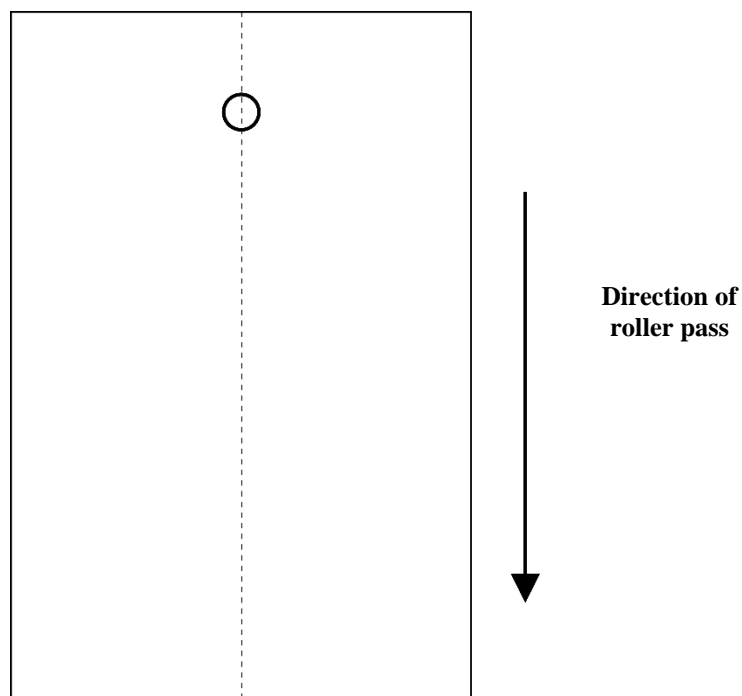
1. Place the gauge on the test site, perpendicular to the roller passes.
2. Using a crayon (not spray paint), mark the outline or footprint of the gauge.
3. Extend the probe to the backscatter position.
4. Take a one-minute test and record the wet density reading.
5. Rotate the gauge 90 degrees centered over the original footprint. Mark the outline or footprint of the gauge.
6. Take another one-minute test and record the wet density reading.
7. If the difference between the two one-minute tests is greater than  $40 \text{ kg/m}^3$  ( $2.5 \text{ lb/ft}^3$ ), retest in both directions. If the difference of the retests is still greater than  $40 \text{ kg/m}^3$  ( $2.5 \text{ lb/ft}^3$ ) test at 180 and 270 degrees.
8. The density reported for each test site shall be the average of the two individual one-minute wet density readings.



**Method A**  
**Footprint of the gauge test site**

**Method B – One four-minute test**

1. Place the gauge on the test site, parallel to the roller passes.
2. Using a crayon (not spray paint), mark the outline or footprint of the gauge.
3. Extend the probe to the backscatter position.
4. Take one 4-minute test and record the wet density reading.



**Method B**  
**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.

$$\text{Percent compaction} = \frac{\text{Corrected Reading}}{\text{Maximum Density}} \times 100$$

**Method A Example:**

Reading #1: 141.5 lb/ft<sup>3</sup>

Reading #2: 140.1 lb/ft<sup>3</sup> Are the two readings within the tolerance? (YES)

Reading average: 140.8 lb/ft<sup>3</sup>

Core correction: +2.1 lb/ft<sup>3</sup>

Corrected reading: 142.9 lb/ft<sup>3</sup>

**Method B Example:**

Reading: 140.8 lb/ft<sup>3</sup>

Core correction: +2.1 lb/ft<sup>3</sup>

Corrected reading 142.9 lb/ft<sup>3</sup>

**Example percent compaction:**

From the FOP for AASHTO T 209:

$$G_{mm} = 2.466$$

$$\text{Theoretical Maximum Density} = 2.466 \times 62.245 \text{ lb/ft}^3 = 153.5 \text{ lb/ft}^3$$

$$\text{Percent compaction} = \frac{142.9 \text{ lb/ft}^3}{153.5 \text{ lb/ft}^3} \times 100 = 93.1\%$$

**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 to the nearest 0.1 percent
- Name and signature of operator

## APPENDIX – CORRELATION WITH CORES

(Nonmandatory Information)

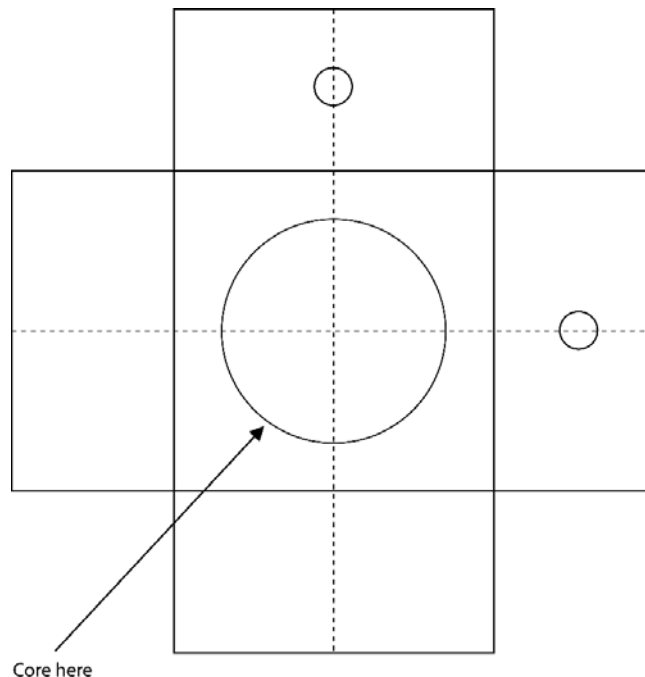
The bulk specific gravity ( $G_{mb}$ ) of the core is a physical measurement of the in-place asphalt mixture and can be compared with the nuclear density gauge readings. Comparing the core value to the corresponding gauge values, a correlation can be established.

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 before removal of the core.

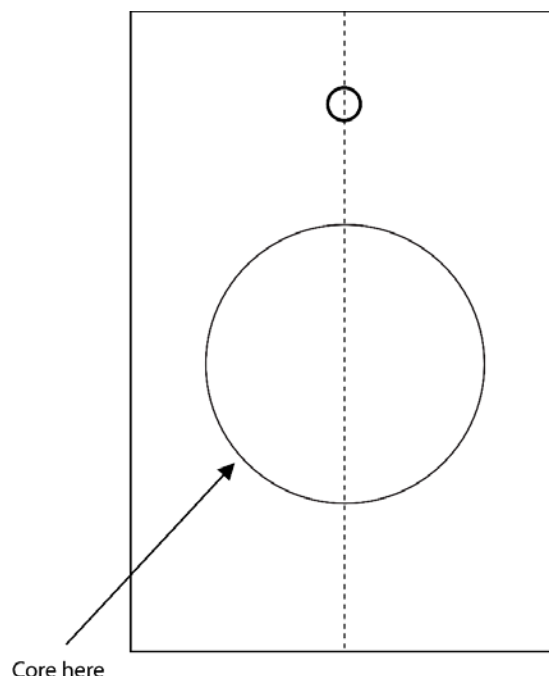
When density correlation with the FOP for AASHTO T 166 is required, correlation of the nuclear gauge with pavement cores shall be made on the first day's paving (within 24 hours) or from a test strip constructed before the start of paving. Cores must be taken before traffic is allowed on the pavement.

### 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.



**Method A – Footprint of the gauge test site. Core location in the center of the footprint.**



**Method B - Footprint of the gauge test site.**

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  $1 \text{ kg/m}^3$  ( $0.1 \text{ lb/ft}^3$ ). Calculate the average difference and standard deviation of the differences for the entire data set to the nearest  $1 \text{ kg/m}^3$  ( $0.1 \text{ lb/ft}^3$ ).
  - b. If the standard deviation of the differences is equal to or less than  $40 \text{ kg/m}^3$  ( $2.5 \text{ lb/ft}^3$ ), 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  $40 \text{ kg/m}^3$  ( $2.5 \text{ lb/ft}^3$ ), 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 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.

## Calculations

### Correlation Factor

$$\sqrt{\frac{\sum x^2}{n-1}}$$

Where:

$\sum$  = Sum

x = Difference from the average Difference

n-1 = number of data sets minus 1

### Example

Core #	Core results from T 166:	Average Gauge reading	Difference:	x	x <sup>2</sup>
1	144.9 lb/ft <sup>3</sup>	142.1 lb/ft <sup>3</sup>	2.8 lb/ft <sup>3</sup>	-0.7	0.49
2	142.8 lb/ft <sup>3</sup>	140.9 lb/ft <sup>3</sup>	1.9 lb/ft <sup>3</sup>	0.2	0.04
3	143.1 lb/ft <sup>3</sup>	140.7 lb/ft <sup>3</sup>	2.4 lb/ft <sup>3</sup>	-0.3	0.09
4	140.7 lb/ft <sup>3</sup>	138.9 lb/ft <sup>3</sup>	1.8 lb/ft <sup>3</sup>	0.3	0.09
5	145.1 lb/ft <sup>3</sup>	143.6 lb/ft <sup>3</sup>	1.5 lb/ft <sup>3</sup>	0.6	0.36
6	144.2 lb/ft <sup>3</sup>	142.4 lb/ft <sup>3</sup>	1.8 lb/ft <sup>3</sup>	0.3	0.09
7	143.8 lb/ft <sup>3</sup>	141.3 lb/ft <sup>3</sup>	2.5 lb/ft <sup>3</sup>	-0.4	0.16
8	142.8 lb/ft <sup>3</sup>	139.8 lb/ft <sup>3</sup>	3.0 lb/ft <sup>3</sup>	0.9	0.81
9	144.8 lb/ft <sup>3</sup>	143.3 lb/ft <sup>3</sup>	1.5 lb/ft <sup>3</sup>	-0.6	0.36
10	143.0 lb/ft <sup>3</sup>	141.0 lb/ft <sup>3</sup>	2.0 lb/ft <sup>3</sup>	-0.1	<u>0.01</u>
Average Difference:			+2.1 lb/ft <sup>3</sup>	$\sum x^2 = 2.5$	

**Number of data sets**

$$n - 1 = 10 - 1 = 9$$

**Standard deviation**

$$\text{standard deviation} = \sqrt{\frac{2.5}{9}} = 0.53$$

Where:

$$\text{Sum of } x^2 = 2.5$$

$$\text{Number of data sets} = 9$$

The standard deviation of 0.53 is less than 2.5 therefore no cores are eliminated. The average difference from all ten cores is used.

**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.

Procedure Element	Trial 1	Trial 2
1. Gauge turned on approximately 10 to 20 minutes before use?	_____	_____
2. Gauge calibrated, and standard count recorded?	_____	_____
3. Test location selected appropriately [600 mm (24 in.) from vertical projections or 10 m (30 ft.) from any other radioactive sources]?	_____	_____
4. Filler spread evenly over test site?	_____	_____
5. Excess filler material removed by striking off the surface?	_____	_____
6. Gauge placed on pavement surface and footprint of gauge marked?	_____	_____
7. Probe extended to backscatter position?	_____	_____
8. Method A:		
a. One-minute count taken; gauge rotated 90°, reseated, and another one-minute count taken?	_____	_____
b. Densities averaged?	_____	_____
c. If difference of the wet densities is greater than 40 kg/m <sup>3</sup> (2.5 lb/ft <sup>3</sup> ), retest conducted in both directions?	_____	_____
9. Method B:		
a. One four-minute count taken?	_____	_____
10. Core correlation applied if required?	_____	_____
11. Percent compaction calculated correctly?	_____	_____

Comments:      First attempt:    Pass\_\_\_\_\_Fail\_\_\_\_\_      Second attempt: Pass\_\_\_\_\_Fail\_\_\_\_\_

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Examiner Signature \_\_\_\_\_ WAQTC #: \_\_\_\_\_





**FOP for AASHTO T 355**

## In-Place Density of Asphalt Mixtures by Nuclear Method

**Scope**

**Add** the following:

Asphalt mixtures when no acceptance test strip is required See [Section 270.00](#), Minimum Testing Requirements for [405 SUPERPAVE Hot Mix Asphalt](#).

**Procedure**

**Add** the following:

5. Method A is Specified.



## **IN-PLACE DENSITY AND MOISTURE CONTENT OF SOIL AND SOIL-AGGREGATE BY NUCLEAR METHODS (SHALLOW DEPTH) FOP FOR AASHTO T 310**

### **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 310-19. 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/scrapper 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  $32 \text{ kg/m}^3$  ( $2.0 \text{ lb/ft}^3$ ) 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 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  $50 \text{ kg/m}^3$  ( $3.0 \text{ lb/ft}^3$ ). 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  $\pm 1$  percent, the nuclear gauge readings can be accepted. Moisture content verification is gauge and material specific. 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  $\pm 1$  percent requirement. 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 ( $\text{kg/m}^3$  or  $\text{lb/ft}^3$ ) from the wet density ( $\text{kg/m}^3$  or  $\text{lb/ft}^3$ ) or compute using the percent moisture by dividing wet density from the nuclear gauge by 1 plus the 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 plus the 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 T 99/T 180. 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

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/m<sup>3</sup> (lb/ft<sup>3</sup>)

$\rho_w$  = Wet density, kg/m<sup>3</sup> (lb/ft<sup>3</sup>)

w = Moisture content from the FOP's for AASHTO T 255 / T 265, as a percentage

Calculate percent compaction as follows:

$$\% \text{ Compaction} = \frac{\rho_d}{\text{Agency density standard}} \times 100$$

where:

$\rho_d$  = Dry density, kg/m<sup>3</sup> (lb/ft<sup>3</sup>)

Agency density standard = Corrected maximum dry density  
from the FOP from T 99/T 180 Annex

## Example:

Wet density readings from gauge: 1948 kg/m<sup>3</sup> (121.6 lb/ft<sup>3</sup>)

1977 kg/m<sup>3</sup> (123.4 lb/ft<sup>3</sup>)

Avg: 1963 kg/m<sup>3</sup> (122.5 lb/ft<sup>3</sup>)

**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:**

$$\rho_d = \left( \frac{1963 \text{ kg/m}^3 \text{ or } 122.5 \text{ lb/ft}^3}{15.9 + 100} \right) \times 100 \text{ or } \rho_d = \left( \frac{1963 \text{ kg/m}^3 \text{ or } 122.5 \text{ lb/ft}^3}{\frac{15.9}{100} + 1} \right)$$
$$= 1694 \text{ kg/m}^3 \text{ or } 105.7 \text{ lb/ft}^3$$

where:

$$\rho_w = 1963 \text{ kg/m}^3 \text{ or } 122.5 \text{ lb/ft}^3$$

$$w = 15.9\%$$

**Calculate percent compaction as follows:**

$$\% \text{ Compaction} = \frac{105.7 \text{ lb/ft}^3}{111.3 \text{ lb/ft}^3} \times 100 = 95\%$$

where:

$$\text{Agency density standard} = 111.3 \text{ lb/ft}^3$$

## 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 the nearest 0.1 lb/ft<sup>3</sup>
- Moisture content as a percent, by mass, of dry soil mass to the nearest 0.1 percent
- Dry density to the nearest 0.1 lb/ft<sup>3</sup>
- Density standard to the nearest 0.1 lb/ft<sup>3</sup>
- Percent compaction the nearest 1 percent
- 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.

<b>Procedure Element</b>	<b>Trial 1</b>	<b>Trial 2</b>
1. Gauge turned on 10 to 20 minutes before use?	_____	_____
2. Calibration verified?	_____	_____
3. Standard count taken and recorded in accordance with manufacturer's instructions?	_____	_____
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?	_____	_____
5. Loose, disturbed material removed?	_____	_____
6. Flat, smooth area prepared?	_____	_____
7. Surface voids filled with native fines (-No. 4) to 3 mm (1/8 in.) maximum thickness?	_____	_____
8. Hole driven 50 mm (2 in.) deeper than probe depth?	_____	_____
9. Gauge placed, probe placed, and source rod lowered without disturbing loose material?	_____	_____
10. Method A:		
a. Gauge firmly seated, and gently pulled back so that the source rod is against the side of the hole toward the scaler / detectors?	_____	_____
b. Two, one-minute reading taken; wet density within 32 kg/m <sup>3</sup> (2.0 lb/ft <sup>3</sup> )?	_____	_____
c. Density and moisture data averaged?	_____	_____
11. Method B:		
a. Gauge firmly seated, and gently pulled back so that the source rod is against the side of the hole toward the scaler / detectors?	_____	_____
b. A minimum of a one-minute reading taken; density and moisture data recorded?	_____	_____
c. Gauge turned 90° or 180° (180° in trench)?	_____	_____

**OVER**

Procedure Element	Trial 1	Trial 2
d. Gauge firmly seated, and gently pulled back so that the source rod is against the side of the hole toward the scaler / detectors?	_____	_____
e. A minimum of a one-minute reading taken; density and moisture data recorded?	_____	_____
f. Wet densities within 50 kg/m <sup>3</sup> (3.0 lb/ft <sup>3</sup> )?	_____	_____
g. Density and moisture data averaged?	_____	_____
12. Representative sample (4 kg or 9 lb) obtained from test location?	_____	_____
13. Sample sealed immediately to prevent moisture loss?	_____	_____
14. Moisture content correctly determined using other means than the nuclear density gauge reading?	_____	_____
15. Dry Density calculated using proper moisture content?	_____	_____
16. Percent compaction calculated correctly?	_____	_____

Comments: First attempt: Pass\_\_\_\_\_Fail\_\_\_\_\_ Second attempt: Pass\_\_\_\_\_Fail\_\_\_\_\_

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Examiner Signature \_\_\_\_\_ WAQTC #: \_\_\_\_\_

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**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.
- When the maximum density standard is from AASHTO T 99 or AASHTO T 180, a one-point determination per AASHTO T 272 is performed for every AASHTO T 310 compaction test to select the proper individual moisture-density curve or family of curves, including correction for coarse aggregate when necessary.
- A family of curves developed per AASHTO R 75 may be used to determine the maximum density standard only if the moisture density curves were developed with material from the same geologic source area with concurrence from the District Materials Engineer.
- For coarse granular materials, the maximum density standard may be density-gradation curve developed using a vibratory method such as AKDOT&PF's ATM 212, ITD's IT 74, WSDOT's TM 606, or WFLHD's Humphres.

**Granular Materials and Processed Aggregates above Subgrade**

- For Idaho 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.
  - When large aggregate is present, use a 1 inch buffer sieve.
  - Do not overload the No. 4 sieve.
- Use the Idaho IT 74 laboratory curve to find the maximum dry density at the percent passing No. 4 sieve. Divide the in place dry density by the maximum dry density to determine the compaction percent.
- A new Idaho 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 in place dry density reading is equal to or greater than 95% (94.6 rounded) at the peak point of the Idaho 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.

**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**

**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 R 90 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**

<b>Nominal Maximum Size* mm (in.)</b>	<b>Minimum Sample Mass g (lb)</b>
4.75 (No. 4)	500 (1.1)
9.5 (3/8)	1500 (3.3)
12.5 (1/2)	2000 (4)
19.0 (3/4)	3000 (7)
25.0 (1)	4000 (9)
37.5 (1 1/2)	6000 (13)
50 (2)	8000 (18)
63 (2 1/2)	10,000 (22)
75 (3)	13,000 (29)
90 (3 1/2)	16,000 (35)
100 (4)	25,000 (55)
150 (6)	50,000 (110)

\* 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**

<b>Maximum Particle Size mm (in.)</b>	<b>Minimum Sample Mass g</b>
0.425 (No. 40)	10
4.75 (No. 4)	100
12.5 (1/2)	300
25.0 (1)	500
50 (2)	1000

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  $110 \pm 5^{\circ}\text{C}$  ( $230 \pm 9^{\circ}\text{F}$ ).
    - ii. Uncontrolled heat source (Hot plate, infrared heater, etc.): Stir frequently to avoid localized overheating.
  - b. For soil – controlled heat source (oven): at  $110 \pm 5^{\circ}\text{C}$  ( $230 \pm 9^{\circ}\text{F}$ ).

**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 (w) 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**

<b>Aggregate</b>		
<b>Heat Source</b>	<b>Specific Instructions</b>	<b>Drying intervals to achieve constant mass (minutes)</b>
<b>Controlled:</b> Forced draft (preferred), ventilated, or convection oven	110 ±5°C (230 ±9°F)	30
<b>Uncontrolled:</b>		
Hot plate, infrared heater, etc.	Stir frequently	10
Microwave	Heap sample and cover with ventilated lid	2
<b>Soil</b>		
<b>Heat Source</b>	<b>Specific Instructions</b>	<b>Drying increments (minutes)</b>
<b>Controlled:</b> Forced draft (preferred), ventilated, or convection oven	110 ±5°C (230 ±9°F)	1 hour

## Calculation

### 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

$M_n$  = 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

$$\% \text{ Change} = \frac{1405.1 \text{ g} - 1402.0 \text{ g}}{1405.1 \text{ g}} \times 100 = 0.22\%$$

*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

$$\% \text{ Change} = \frac{1402.0 \text{ g} - 1400.9 \text{ g}}{1402.0 \text{ g}} \times 100 = 0.08\%$$

*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<sub>W</sub> = wet mass

M<sub>D</sub> = dry mass

Example:

Mass of container: 1232.1 g

Mass of container and wet sample: 2764.7 g

Mass, M<sub>W</sub>, of wet sample: 2764.7 g - 1232.1 g = 1532.6 g

Mass of container and dry sample (COOLED): 2633.5 g

Mass, M<sub>D</sub>, 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<sub>W</sub>, wet mass
- M<sub>D</sub>, dry mass
- w, moisture content to the 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.

Procedure Element	Trial 1	Trial 2
1. Representative sample of appropriate mass obtained?	_____	_____
2. Mass of container determined to 0.1 g?	_____	_____
3. Sample placed in container and mass determined to 0.1 g?	_____	_____
4. Test sample mass conforms to the required mass?	_____	_____
5. Wet sample mass determined to 0.1 g?	_____	_____
6. Loss of moisture avoided prior to mass determination?	_____	_____
7. Sample dried by a suitable heat source?	_____	_____
a. Describe suitable heat sources for aggregate?	_____	_____
b. Describe suitable heat sources for soils?	_____	_____
8. If aggregate heated by means other than a controlled oven, is sample stirred to avoid localized overheating?	_____	_____
9. For microwave, aggregate heaped and covered with a ventilated lid?	_____	_____
10. For aggregate, heated for the additional, specified time?	_____	_____
a. Forced draft, ventilated, convection ovens – 30 minutes;		
b. Microwave – 2 minutes		
c. Other – 10 minutes		
11. For soil:		
a. Heated for at least 1 hour additional drying time using a controlled heat source?	_____	_____
12. Mass determined and compared to previous mass - showing less than 0.10 percent loss?	_____	_____
13. Sample cooled, dry mass determined and recorded to the nearest 0.1 percent?	_____	_____
14. Moisture content calculated correctly and recorded to the nearest 0.1 percent?	_____	_____

OVER

EMBANKMENT AND BASE  
IN-PLACE DENSITY

WAQTC / IDAHO

FOP AASHTO T 255/T 265 (18)

Comments:      First attempt:    Pass\_\_\_\_Fail\_\_\_\_      Second attempt:    Pass\_\_\_\_Fail\_\_\_\_

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Examiner Signature \_\_\_\_\_ WAQTC #: \_\_\_\_\_

## **ONE-POINT METHOD FOR DETERMINING MAXIMUM DRY DENSITY AND OPTIMUM MOISTURE FOP FOR AASHTO T 272**

### **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 272-18. 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**

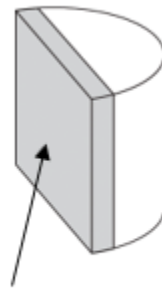
1. Determine the mass of the clean, dry mold. Include the base plate but exclude the extension collar. Record the mass to the nearest 1 g (0.005 lb).
2. Thoroughly mix the sample with sufficient water to adjust moisture content to 80 to 100 percent of the anticipated optimum moisture.
3. Form a specimen 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. Clean soil from exterior of the mold and base plate.
7. Determine the mass of the mold and wet soil to the nearest 1 g (0.005 lb) or better.
8. Determine the wet mass of the sample by subtracting the mass in Step 1 from the mass in Step 7.
9. Calculate the wet density as indicated below under “Calculations.”
10. 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.



**Extruded material**



**Representative moisture  
content sample**

11. 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/m<sup>3</sup> (lb/ft<sup>3</sup>), 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 m<sup>3</sup> (0.03344 ft<sup>3</sup>)

$$\text{Wet Density} = \frac{2.0055 \text{ kg}}{0.0009469 \text{ m}^3} = 2118 \text{ kg/m}^3$$

$$\text{Wet Density} = \frac{4.42 \text{ lb}}{0.03344 \text{ ft}^3} = 132.2 \text{ lb/ft}^3$$

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/m<sup>3</sup> (lb/ft<sup>3</sup>)

$\rho_w$  = Wet density, kg/m<sup>3</sup> (lb/ft<sup>3</sup>)

w = Moisture content, as a percentage

Example:

$$\rho_w = 2118 \text{ kg/m}^3 (132.2 \text{ lb/ft}^3)$$

$$w = 13.5\%$$

$$\rho_d = \left( \frac{2118 \text{ kg/m}^3}{13.5 + 100} \right) \times 100 = 1866 \text{ kg/m}^3 \quad \rho_d = \left( \frac{132.2 \text{ lb/ft}^3}{13.5 + 100} \right) \times 100 = 116.5 \text{ lb/ft}^3$$

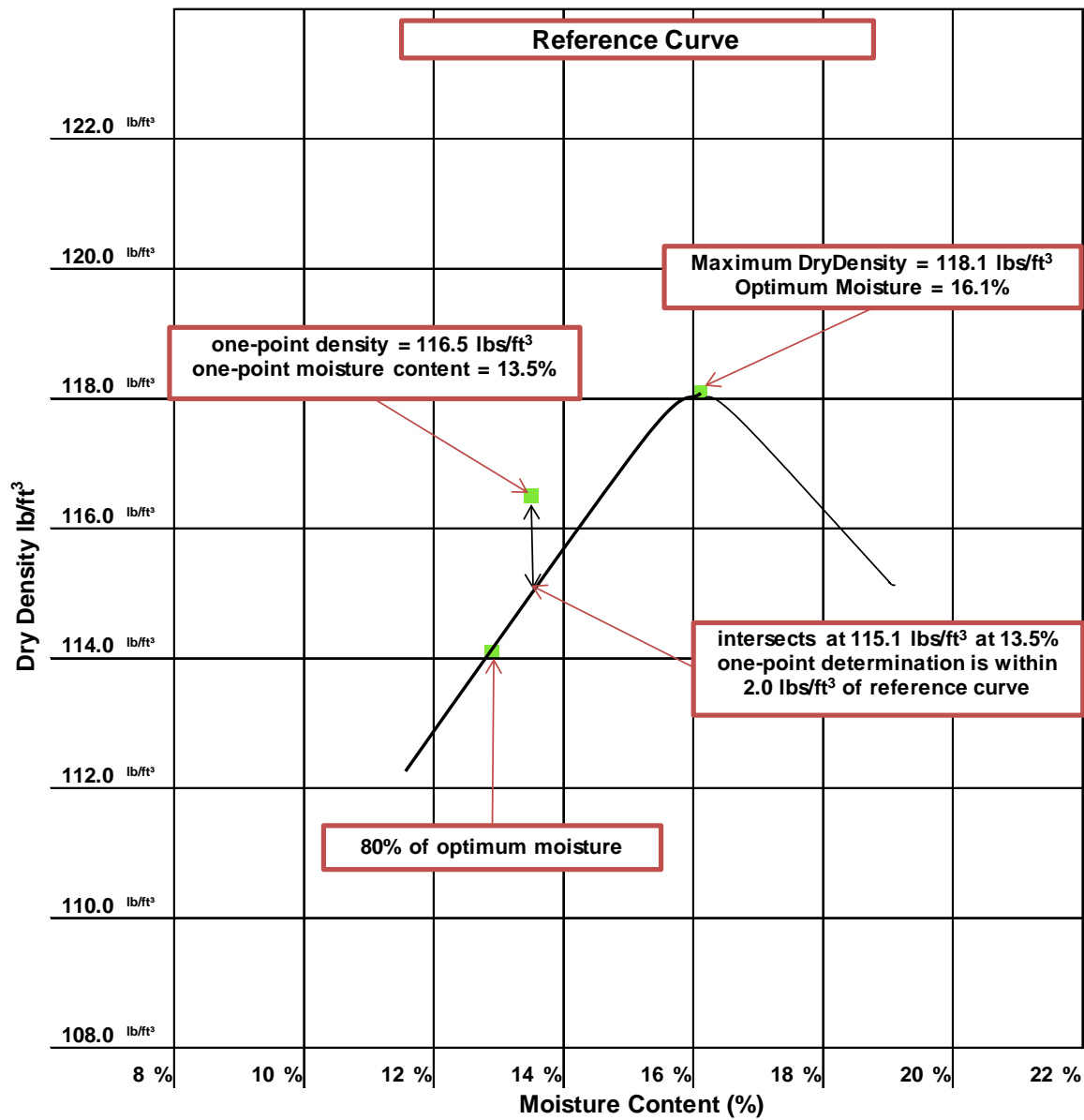
or

$$\rho_d = \left( \frac{2118 \text{ kg/m}^3}{\frac{13.5}{100} + 1} \right) = 1866 \text{ kg/m}^3 \quad \rho_d = \left( \frac{132.2 \text{ lb/ft}^3}{\frac{13.5}{100} + 1} \right) = 116.5 \text{ lb/ft}^3$$

### **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. Plot the one-point, dry density on the vertical axis and moisture content on the horizontal axis, on the reference curve graph.
3. If the one-point falls on the reference curve or within  $\pm 2.0 \text{ lbs/ft}^3$ , use the maximum dry density and optimum moisture content determined by the curve.
4. Use the FOP for AASHTO T 99/T 180 Annex A to determine corrected maximum dry density and optimum moisture content if oversize particles have been removed.
5. Perform a full moisture-density relationship if the one-point does not fall on or within  $\pm 2.0 \text{ lbs/ft}^3$  of the reference curve at 80 to 100 percent optimum moisture.

### Example



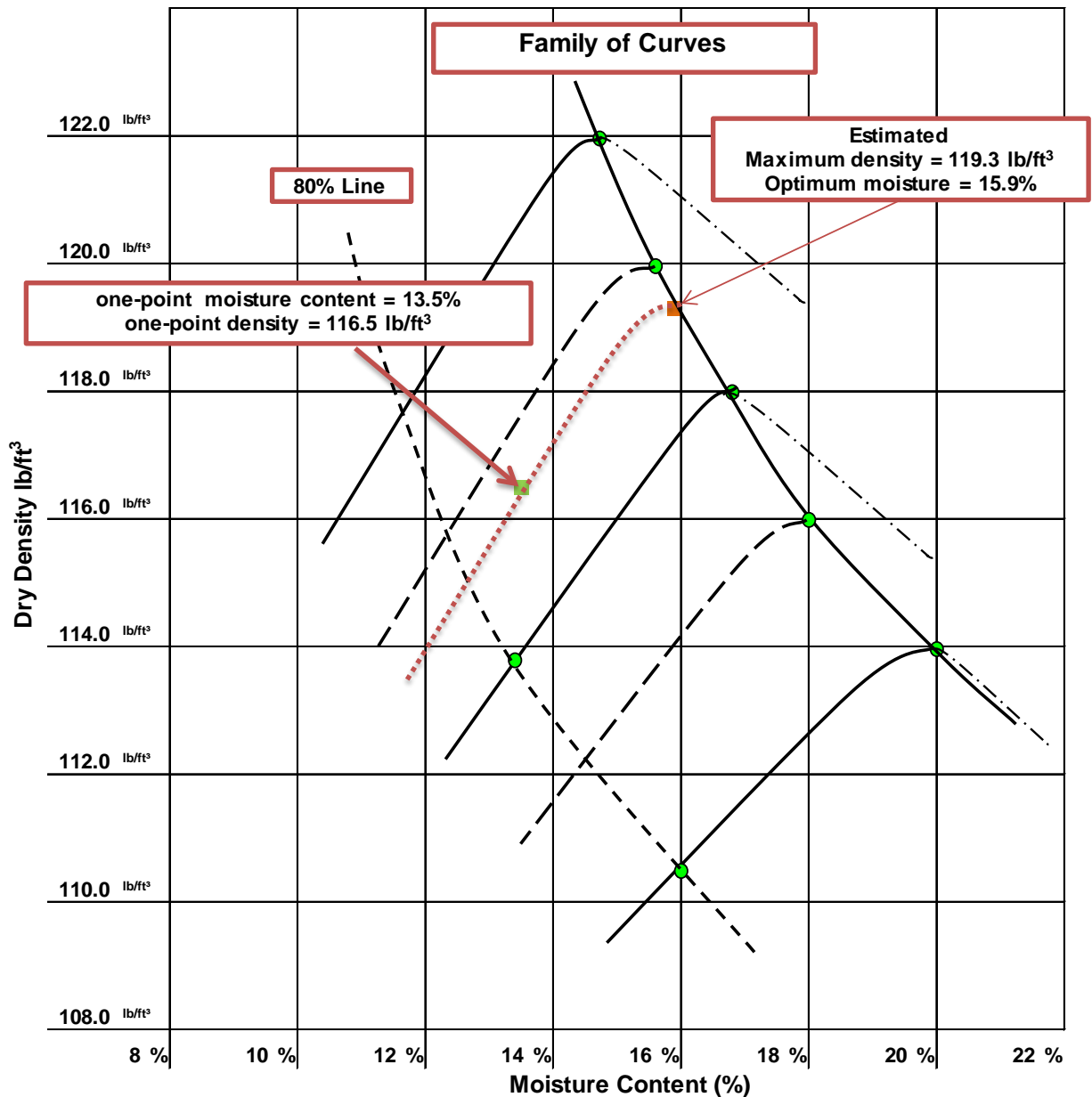
The results of a one-point determination were 116.5 lb/ft³ at 13.5 percent moisture. The point was plotted on the reference curve graph. The one-point determination is within 2.0 lb/ft³ of the point on the curve that corresponds with the moisture content.

### **Maximum Dry Density and Optimum Moisture Content Determination Using a Family of Curves**

1. Plot the one-point, dry density on the vertical axis and moisture content on the horizontal axis, on the reference family of curves graph.
2. If the moisture-density one-point falls on one of the curves in the family of curves, use the maximum dry density and optimum moisture content defined by that curve.
3. 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.
  - a. 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.
  - b. 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.
4. Use the FOP for AASHTO T 99/T 180 Annex A to determine corrected maximum dry density and optimum moisture content if oversize particles have been removed.
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/ft<sup>3</sup> 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/ft<sup>3</sup> 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 nearest  $1 \text{ kg/m}^3$  ( $0.1 \text{ lb/ft}^3$ )
- Corrected maximum dry density (if applicable)
- Optimum moisture content to the nearest 0.1 percent
- Corrected optimum moisture content (if applicable)
- 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.

Procedure Element	Trial 1	Trial 2
1. One-point determination of dry density and corresponding moisture content made in accordance with the FOP for AASHTO T 99?	_____	_____
a. Correct size (4.75 mm / No. 4 or 19.0 mm / 3/4 in.) material used?	_____	_____
2. If necessary, sample dried until friable in air or drying apparatus, not exceeding 60°C (140°F)?	_____	_____
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?	_____	_____
4. Sample passing the sieve has appropriate mass?	_____	_____
5. Moisture content adjusted if needed?	_____	_____
6. Determine mass of clean, dry mold without collar to nearest 1 g?	_____	_____
7. Mold placed on rigid and stable foundation?	_____	_____
8. Layer of soil (approximately one third compacted depth) placed in mold with collar attached, loose material lightly tamped?	_____	_____
9. Soil compacted with appropriate number of blows (25 or 56)?	_____	_____
10. Material adhering to the inside of the mold trimmed?	_____	_____
11. Layer of soil (approximately two thirds compacted depth) placed in mold with collar attached, loose material lightly tamped?	_____	_____
12. Soil compacted with appropriate number of blows (25 or 56)?	_____	_____
13. Material adhering to the inside of the mold trimmed?	_____	_____
14. Mold filled with soil such that compacted soil will be above the mold, loose material lightly tamped?	_____	_____
15. Soil compacted with appropriate number of blows (25 or 56)?	_____	_____
16. Collar removed without shearing off sample?	_____	_____
17. Approximately 6 mm (1/4 in.) of compacted material above the top of the mold (without the collar)?	_____	_____
18. Soil trimmed to top of mold with the beveled side of the straightedge?	_____	_____
19. Remove soil from exterior surface of mold and base plate?	_____	_____
20. Mass of mold and contents determined to appropriate precision?	_____	_____

OVER

Procedure Element	Trial 1	Trial 2
21. Wet density calculated from the wet mass?	_____	_____
22. Soil removed from mold using a sample extruder if needed?	_____	_____
23. Soil sliced vertically through center (non-granular material)?	_____	_____
24. Moisture sample removed ensuring all layers are represented?	_____	_____
25. Moist mass determined immediately to 0.1 g?	_____	_____
26. Moisture sample mass of correct size?	_____	_____
27. Sample dried and water content determined according to the FOP for T 255/T 265?	_____	_____
28. One-point plotted on family of curves supplied?	_____	_____
a. One-point falls within 80 to 100 percent of optimum moisture content in order to be valid?	_____	_____
b. 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?	_____	_____
c. Maximum dry density and corresponding optimum moisture content correctly estimated?	_____	_____
29. One-point plotted on a single reference curve?	_____	_____
a. Does one-point plot within 2 lb/ft <sup>3</sup> in order to be valid?	_____	_____
b. Does one-point fall within 80 to 100 percent of optimum moisture content in order to be valid?	_____	_____
c. Maximum dry density and corresponding optimum moisture content determined from single reference curve?	_____	_____

Comments:      First attempt:    Pass\_\_\_\_Fail\_\_\_\_      Second attempt: Pass\_\_\_\_Fail\_\_\_\_

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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.

Procedure Element	Trial 1	Trial 2
1. One-point determination of dry density and corresponding moisture content made in accordance with the FOP for AASHTO T 180?	_____	_____
a. Correct size (4.75 mm / No. 4 or 19.0 mm / 3/4 in.) material used?	_____	_____
2. If necessary, sample dried until friable in air or drying apparatus, not exceeding 60°C (140°F)?	_____	_____
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?	_____	_____
4. Sample passing the sieve has appropriate mass?	_____	_____
5. Moisture content adjusted if needed?	_____	_____
6. Determine mass of clean, dry mold without collar to nearest 1 g?	_____	_____
7. Mold placed on rigid and stable foundation?	_____	_____
8. Layer of soil (approximately one fifth compacted depth) placed in mold with collar attached, loose material lightly tamped?	_____	_____
9. Soil compacted with appropriate number of blows (25 or 56)?	_____	_____
10. Material adhering to the inside of the mold trimmed?	_____	_____
11. Layer of soil (approximately two fifths compacted depth) placed in mold with collar attached, loose material lightly tamped?	_____	_____
12. Soil compacted with appropriate number of blows (25 or 56)?	_____	_____
13. Material adhering to the inside of the mold trimmed?	_____	_____
14. Layer of soil (approximately three fifths compacted depth) placed in mold with collar attached, loose material lightly tamped?	_____	_____
15. Soil compacted with appropriate number of blows (25 or 56)?	_____	_____
16. Material adhering to the inside of the mold trimmed?	_____	_____
17. Layer of soil (approximately four fifths compacted depth) placed in mold with collar attached, loose material lightly tamped?	_____	_____
18. Soil compacted with appropriate number of blows (25 or 56)?	_____	_____
19. Material adhering to the inside of the mold trimmed?	_____	_____

OVER

Procedure Element	Trial 1	Trial 2
20. Mold filled with soil such that compacted soil will be above the mold, loose material lightly tamped?	_____	_____
21. Soil compacted with appropriate number of blows (25 or 56)?	_____	_____
22. Collar removed without shearing off sample?	_____	_____
23. Approximately 6 mm (1/4 in.) of compacted material above the top of the mold (without the collar)?	_____	_____
24. Soil trimmed to top of mold with the beveled side of the straightedge?	_____	_____
25. Remove soil from exterior surface of mold and base plate?	_____	_____
26. Mass of mold and contents determined to appropriate precision?	_____	_____
27. Wet density calculated from the wet mass?	_____	_____
28. Soil removed from mold using a sample extruder if needed?	_____	_____
29. Soil sliced vertically through center (non-granular material)?	_____	_____
30. Moisture sample removed ensuring all layers are represented?	_____	_____
31. Moist mass determined immediately to 0.1 g?	_____	_____
32. Moisture sample mass of correct size?	_____	_____
33. Sample dried and water content determined according to the FOP for T 255/T 265?	_____	_____
34. One-point plotted on family of curves supplied?	_____	_____
a. One-point falls within 80 to 100 percent of optimum moisture content in order to be valid?	_____	_____
b. 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?	_____	_____
c. Maximum dry density and corresponding optimum moisture content correctly estimated?	_____	_____
35. One-point plotted on a single reference curve?	_____	_____
a. Does one-point plot within 2 lb/ft <sup>3</sup> in order to be valid?	_____	_____
b. Does one-point fall within 80 to 100 percent of optimum moisture content in order to be valid?	_____	_____
c. Maximum dry density and corresponding optimum moisture content determined from single reference curve?	_____	_____

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 moisture / density relationship, 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.

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.

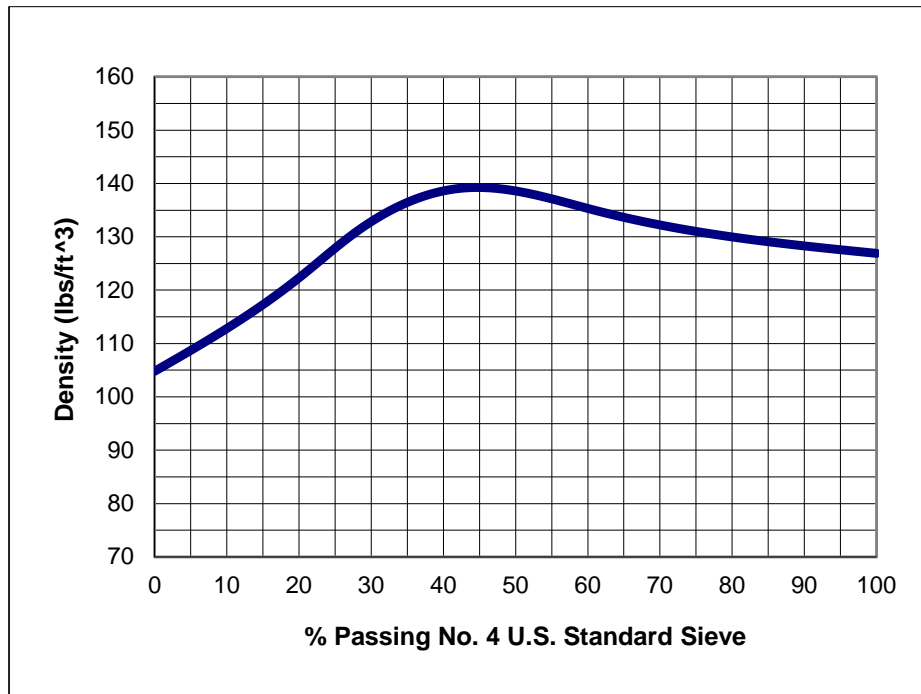
### Maximum Density Chart

Density Curves			
Pass #4	Maximum	Pass #4	Maximum
0.0	104.8	31.0	133.7
1.0	105.6	32.0	134.5
2.0	106.4	33.0	135.2
3.0	107.1	34.0	135.8
4.0	107.9	35.0	136.4
5.0	108.7	36.0	137.0
6.0	109.5	37.0	137.5
7.0	110.3	38.0	137.9
8.0	111.1	39.0	138.3
9.0	112.0	40.0	138.6
10.0	112.8	41.0	138.9
11.0	113.7	42.0	139.0
12.0	114.5	43.0	139.2
13.0	115.4	44.0	139.2
14.0	116.4	45.0	139.2
15.0	117.3	46.0	139.2
16.0	118.2	47.0	139.1
17.0	119.2	48.0	139.0
18.0	120.2	49.0	138.8
19.0	121.3	50.0	138.6
20.0	122.3	51.0	138.3
21.0	123.4	52.0	138.1
22.0	124.5	53.0	137.8
23.0	125.6	54.0	137.5
24.0	126.8	55.0	137.1
25.0	127.9	56.0	136.8
26.0	129.0	57.0	136.4
27.0	130.0	58.0	136.0
28.0	131.0	59.0	135.7
29.0	132.0	60.0	135.3
30.0	132.8	61.0	135.0

Density Curves			
Pass #4	Maximum	Pass #4	Maximum
62.0	134.6	82.0	129.6
63.0	134.3	83.0	129.4
64.0	134.0	84.0	129.3
65.0	133.6	85.0	129.1
66.0	133.3	86.0	128.9
67.0	133.1	87.0	128.8
68.0	132.8	88.0	128.6
69.0	132.5	89.0	128.4
70.0	132.2	90.0	128.3
71.0	132.0	91.0	128.1
72.0	131.7	92.0	128.0
73.0	131.5	93.0	127.9
74.0	131.2	94.0	127.7
75.0	131.0	95.0	127.6
76.0	130.8	96.0	127.4
77.0	130.6	97.0	127.3
78.0	130.4	98.0	127.2
79.0	130.2	99.0	127.0
80.0	130.0	100.0	126.9
81.0	129.8		

Control Points for Density Curves		
Pass #4	Maximum	Loose
0.0	104.8	87.6
20.5	122.8	99.6
27.4	130.4	103.8
42.5	139.1	105.4
61.1	134.9	96.7
100.0	126.9	81.9

**Maximum Density Curve**



**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/ft³

Percent passing 4.75 mm (No. 4) sieve = 49%

Maximum density = 138.8 lb/ft³

$$\text{Percent compaction} = \frac{136.0 \text{ lb/ft}^3}{138.8 \text{ lb/ft}^3} \times 100 = 98\%$$

EMBANKMENT AND BASE  
IN-PLACE DENSITY

WAQTC / IDAHO

FOP CURVES (16)

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**Idaho Field Operating Procedure for****FLAT AND ELONGATED PARTICLES IN COARSE  
AGGREGATE  
FOP FOR ASTM D4791**

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**1. SCOPE**

- 1.1. This Idaho Field Operating Procedure (FOP) covers the determination of the percentage, by mass, of flat and elongated particles in coarse aggregates for comparison with specification limits.
- 1.2. This FOP can be performed in conjunction with AASHTO T 27/T 11.

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**2. SUMMARY AND SIGNIFICANCE OF METHOD**

- 2.1. 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.

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**3. REFERENCE DOCUMENTS**

- 3.1. *AASHTO Standards*
- M 231, Weighing Devices Used in the Testing of Materials
  - R 76, Standard Practice for Reducing Samples of Aggregate to Testing Size
  - R 90, Sampling Aggregate Products
  - T 27, Sieve Analysis of Coarse and Fine Aggregates
  - T 11, Materials Finer Than 75- $\mu$ m (No. 200) Sieve in Material Aggregates by Washing
- 3.2. *ASTM Standards*
- D4791, Standard Test Method for Flat Particles, Elongated Particles, or Flat and Elongated Particles in Coarse Aggregate
  - E11, Standard Specification for Woven Wire Test Sieve Cloth and Test Sieves
- 3.3. *OTHER Standards*
- Standard Specifications for Highway Construction, Subsection 703.

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**4. APPARATUS**

- 4.1. *Balance or Scale:* Meets the requirements of AASHTO M 231 Class G 2. Capacity sufficient for the principal sample mass, accurate to 0.1 percent of the sample mass or readable to 0.1 g.
- 4.2. *Sieves:* Meeting requirements of ASTM E11.
- 4.3. *Proportional Caliper Device:* Meeting the requirements of ASTM D 4791.

- 4.3.1. 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.
- 4.3.2. 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.

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## 5. TERMINOLOGY

- 5.1. 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.

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## 6. SAMPLE AND SAMPLE PREPARATION

- 6.1. Sample the aggregate in accordance with the FOP for AASHTO R 90.
- 6.2. Mix the sample and reduce to sample size in accordance with the FOP for AASHTO R 76. See Table 1 for minimum required sample mass.

Table 1 Sample Size

Nominal Maximum Size	Sample Mass, min.	
	kg	lb
3/8"	1	2
1/2"	2	4
3/4"	5	11
1"	10	22
1 1/2"	15	33

- 6.3. Dry the sample to constant mass.
- 6.4. Sieve the aggregate according to the FOP for AASHTO T 27/11.
- 6.4.1. 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.
- 6.4.2. 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.
- 6.5. Reduce each individual sieve size fraction through and including the 3/8" sieve to approximately 100 particles per R 76 (Reduction to an exact amount is not permitted).

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## 7. PROCEDURE

- 7.1. From Step 6.5, perform the following for each sieve size fraction:
- 7.1.1. Determine the total dry mass of each fraction to the nearest 0.1 g. This mass is designated as **T** in the calculation.
- 7.1.2. Set the proportional caliper device to the ratio required in the contract specifications: (2:1, 3:1, or 5:1).



- 7.1.3. Expedite testing through preliminary visual separation of all material which obviously is not flat and elongated.
- 7.1.4. 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.
- 7.1.5. 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.

## 8. CALCULATIONS

- 8.1. 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:

$P_i$  = percent flat & elongated of individual size fraction

F = mass of flat and elongated particles in fraction

T = total mass of particles in fraction

*Example –*

Individual Percent Flat & Elongated for 3/4" Sieve Size Fraction:

$$P_i = \frac{196.4}{1178.0} \times 100 = 16.7, \text{Report } 17\%$$

## 9. REPORT

- 9.1. Sample Report

Sieve Size	Total Mass in Size Fraction (Mass)	Mass of Flat & Elongated Particles (Mass)	Flat & Elongated (Percent) *
1"	1640.9	589.2	36
3/4"	1178.0	196.4	17
1/2"	825.7	70.1	8
3/8"	277.0	23.3	8

\* Report to the nearest 1 percent.



## PERFORMANCE EXAM CHECKLIST

### FLAT PARTICLES, ELONGATED PARTICLES, OR FLAT AND ELONGATED PARTICLES IN COARSE AGGREGATE FOP FOR IDAHO 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.

Procedure Element:	Trial 1	Trial 2
<b>Sample Preparation</b>		
1. Sample obtained, mixed and reduced in accordance with AASHTO R 90 and AASHTO R 76 to approximately the amount required for testing? For combined samples fine portion (- # 4) removed?	_____	_____
2. Minimum dry sample mass meets requirements of Table 1?	_____	_____
<b>Procedure</b>		
1. If determination by mass, sample oven-dried to constant mass at 230 ±9° F? <b>Note:</b> If determination is by particle count drying is not necessary.	_____	_____
2. Sample sieved according to AASHTO T 27?	_____	_____
3. Each coarse aggregate size fraction present in amount of 10% or more of original coarse sample reduced according to R 76 until approximately 100 particles obtained?	_____	_____
<b>Flat and Elongated Particle Test:</b>		
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?	_____	_____
5. Proportional caliper device positioned at proper ratio?	_____	_____
6. Larger opening set equal to particle <u>length</u> ?	_____	_____
7. Particle is <u>flat and elongated</u> if the <u>thickness</u> can be placed in the smaller opening?	_____	_____
8. Proportion of sample in each group determined by count or by mass, as required?	_____	_____
<b>Calculation</b>		
1. Percentage of flat and elongated particles calculated to nearest 1% for each sieve size greater than No. 4?	_____	_____
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?	_____	_____

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

Comments: \_\_\_\_\_

Testing Technician's Signature: \_\_\_\_\_ WAQTC #: \_\_\_\_\_ Date: \_\_\_\_\_

Examiner's Name: \_\_\_\_\_ Signature: \_\_\_\_\_ WAQTC #: \_\_\_\_\_

Quality Assurance

ITD STQP

590.00

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# Idaho Field Operating Procedure for SAMPLING AND FABRICATION OF 2-IN. (50-MM) CUBE SPECIMENS USING GROUT (NON- SHRINK) OR MORTAR FOP FOR AASHTO R 64

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## 1. SCOPE

- 1.1. This method covers field sampling and fabrication and initial curing of 2-in. (50-mm) 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 SI 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.

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## 2. REFERENCE DOCUMENTS

- 2.1 *AASHTO Standards*
- T 106, Test method for Compressive Strength of Hydraulic Cement Mortars (Using 2-in. or 50-mm Cube Specimens.)
- 2.2 *ASTM Standards*
- C 1107 Standard Specification for Packaged Dry, Hydraulic-Cement Grout (Non-shrink)
  - D 2240, Standard Test Method for Rubber Property—Durometer Hardness
- 2.3 *WAQTC Method*
- TM 2, Sampling Freshly Mixed Concrete

### 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 1—Permissible Variations of Specimen Molds

Parameter	2-in. Cube Mold		50-mm Cube Molds	
	New	In Use	New	In Use
Planeness of Sides	<0.001 in.	<0.002 in.	<0.025 mm	<0.05 mm
Distance Between Opposite Sides	2 in. + 0.005 in.	2 in. + 0.02 in.	50 mm + 0.13 mm	50 mm + 0.50 mm
Height of Each Compartment	2 in. + 0.001 in. to -0.005 in.	2 in. + 0.01 in. to -0.015 in.	50 mm + 0.25 mm to -0.013 mm	50 mm + 0.25 mm to -0.38 mm
Angle Between Adjacent Faces <sup>A</sup>	90 + 0.5°	90 + 0.5°	90 + 0.5°	90 + 0.5°

<sup>A</sup>

Measured at points slightly removed from the intersection. Measured separately for each compartment between all the interior faces and the adjacent face and between interior faces and top and bottom planes of the mold.

- 4.2. *Tamper*: A non-absorptive, nonabrasive, non-brittle material such as a hard rubber compound having a Shore A durometer hardness of  $80 \pm 10$ . 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, 4 in. to 6 in. (100 to 150 mm) 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 cy (1 m<sup>3</sup>). When the batch is less than 1 cy (1 m<sup>3</sup>) sample from the batch after discharge. If remixing is required, sample after remixing. Begin molding the specimen within an elapsed time of not more than 2 1/2 minutes from completion of mixing

Note 2—This test is to be used only for grouts with 100 percent passing the 3/8- in. (9.5-mm) sieve.

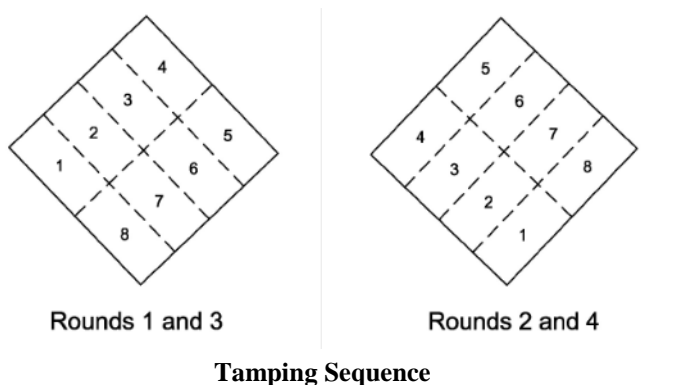
- 5.2. Obtain a representative sample of the mix. Samples shall be a minimum size of 4 lb. (2000 g) for each set of three (3) cubes to be fabricated.

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## 6. PROCEDURE

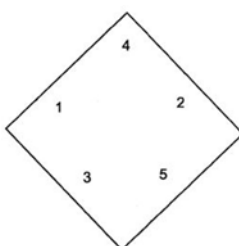
- 6.1. Assemble both portions of the mold and the bottom cover plate. All joints shall be water tight. If not water tight, seal the surfaces where the halves of the mold join by applying a coating of light cup grease (non water soluble). The amount should be sufficient to extrude slightly when the halves 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 1 in. (25 mm) (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.

**Figure #1**



- 6.2.2. For fluid mixes, puddle the lift 5 times with a gloved finger. See Figure 2 for tamping sequence.

**Figure #2**



- 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  $24 \pm 4$  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.



## PERFORMANCE EXAM CHECKLIST

### SAMPLING & FABRICATION OF 2" (50 – MM) CUBE SPECIMENS USING GROUT (NON-SHRINK) MORTAR IDAHO FOP FOR AASHTO R 64

Participant Name: \_\_\_\_\_ Exam Date: \_\_\_\_\_

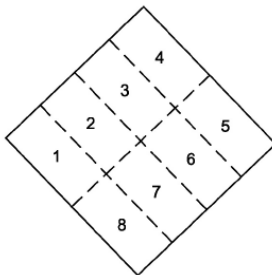
Record the symbols "P" for passing or "F" for failing on each step of the checklist.

#### Procedure Elements:

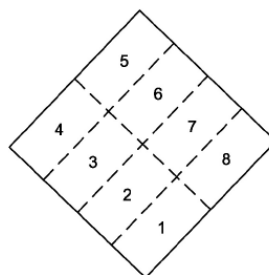
1. **Obtain Sample.** Use WAQTC TM 2 for 1 yd<sup>3</sup> or more or for less than 1 yd<sup>3</sup> sample from discharge after remixing takes place.
2. **Inspect and adjust test apparatus.** Apparatus includes mold assembly, tamper, trowel, watertight container.
3. **Mold portion attached to bottom plate and joints are water tight.** Use of a light coating of non water-soluble grease is allowed.
4. **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.
5. **Consolidate the mix.** The mix shall be consolidated depending on the consistency, either plastic or fluid.
6. **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.

Trial 1

Trial 2

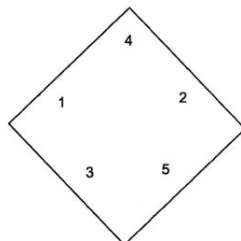


Rounds 1 and 3



Rounds 2 and 4

7. **Fluid Mixes:** puddle the lift 5 times with gloved finger.



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.
9. **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.
10. **Immediately secure the top plate to the molds.**
11. **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  $24 \pm 4$  hours.

First Attempt: Pass

☐

Fail

☐

Second Attempt: Pass

☐

Fail

☐

Comments:

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Testing Technician's Signature: \_\_\_\_\_ WAQTC #: \_\_\_\_\_ Date: \_\_\_\_\_

Examiner's Name: \_\_\_\_\_ Signature: \_\_\_\_\_ WAQTC #: \_\_\_\_\_

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# Idaho Field Operating Procedure for UNCOMPACTED VOID CONTENT OF FINE AGGREGATE FOP FOR AASHTO T 304



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## 1. SCOPE

- 1.1. This Idaho Field Operating Procedure (FOP) covers a method for determining the loose uncompacted void content of a sample of fine aggregate.
- 1.2. Three procedures are included for the measurement of void content:
  - 1.2.1. Standard Graded Sample (Method A)
  - 1.2.2. Individual Size Fractions (Method B)
  - 1.2.3. As-Received Grading (Method C)
- 1.3. For Method A or C, the percent void content is determined directly and the average value of two test runs is reported.
- 1.4. For Method B, the mean percent void content is calculated using the results from each of the three individual size fractions.

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## 2. REFERENCE DOCUMENTS

- 2.1. *IDAHO Test Methods*
  - IT-144, Specific Gravity and Absorption of Fine Aggregate Using Automatic Vacuum Sealing (CoreLok) Method
- 2.2. *AASHTO Standards*
  - M 231, Weighing Devices Used in the Testing of Materials
  - R 76, Reducing Samples of Aggregate to Testing Size
  - R 90, Sampling Aggregate Products
  - T 11, Materials Finer Than 75- $\mu$ m (No. 200) Sieve in Mineral Aggregate
  - T 27, Sieve Analysis of Fine and Coarse Aggregate
  - T 304, Uncompacted Void Content of Fine Aggregate.
  - T 308, Determining Asphalt Binder Content of Hot Mix Asphalt (HMA) by the Ignition Method

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## 3. SUMMARY AND SIGNIFICANCE OF METHOD

- 3.1. 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.

- 3.2. 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.
- 3.3. 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.
- 3.4. 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.
- 3.5. 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.
- 3.6. The bulk dry specific gravity of the fine aggregate ( $G_{sb}$ ) 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).
- 3.7. Void content information from Methods A, B, and C may be a useful indicator of properties such as:
  - 3.7.1. Mixing water demand of hydraulic cement concrete.
  - 3.7.2. Flowability, pumpability, or workability of grouts and mortars.
  - 3.7.3. The effect of fine aggregate on stability, strength and VMA in asphalt mixtures.
  - 3.7.4. Stability and strength of base course material.

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#### 4. APPARATUS

- 4.1. *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.
- 4.2. *Funnel:* A funnel such that the lateral surface of the right frustum of the cone is sloped  $60^{\circ} \pm 4^{\circ}$  from the horizontal with an opening  $0.5 \pm 0.02$  inches diameter. The funnel section shall be a piece of metal, 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.
- 4.3. *Funnel Stand:* A three or four-legged support capable of holding the funnel firmly in position with the axis of the funnel collinear (within  $4^{\circ}$  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.
- 4.4. *Glass Plate:* A square glass plate approximately 2.3 by 2.3 inches with a minimum 0.15-inch thickness.

- 4.5. *Pan:* A metal or plastic pan of sufficient size to contain the funnel stand and prevent loss of material.
- 4.6. *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.
- 4.7. *Balance:* Meets the requirements of AASHTO M 231 Class G 2. A balance with a capacity of 1000 g and sensitive to 0.1 g.

## 5. SAMPLE

- 5.1. The samples used for this test shall be obtained using AASHTO R 90 and AASHTO R 76, or from sieve analysis samples used for AASHTO T 27, or from an extracted asphalt mixture sample using AASHTO T 308
- 5.2. 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.
- 5.3. For Method C, dry a split of the as-received sample in accordance with the drying provisions of AASHTO T 27.

## 6. SAMPLE PREPARATION

### 6.1. *Method A – Standard Graded Sample*

- 6.1.1. Weigh out and combine the following quantities of fine aggregate that has been dried and sieved in accordance with AASHTO T 27.

<u>Individual Size Fraction</u>	<u>Mass, g</u>
Passing No. 8 to Retained on No. 16	44 ±0.2
Passing No. 16 to Retained on No. 30	57 ±0.2
Passing No. 30 to Retained on No. 50	72 ±0.2
Passing No. 50 to Retained on No. 100	17 ±0.2
	190 ±0.2

### 6.2. *Method B – Individual Size Fractions*

- 6.2.1. 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:

<u>Individual Size Fraction</u>	<u>Mass, g</u>
Passing No. 8 to Retained on No. 16	190 ±1
Passing No. 16 to Retained on No. 30	190 ±1
Passing No. 30 to Retained on No. 50	190 ±1

Do not mix fractions together. Each size is tested separately.

- 6.3. *Method C – As-received Grading*
- 6.3.1. Pass the sample (dried in accordance with AASHTO T 27) through a No. 4 sieve. Obtain a  $190 \pm 1$  g sample of this material for the test.
- 6.4. *Specific Gravity of Fine Aggregate*
- 6.4.1. If the bulk specific gravity ( $G_{sb}$ ) of the fine aggregate sample is unknown, determine it according to Idaho IT-144.

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## 7. PROCEDURE

- 7.1. Record all masses to the nearest 0.1 g.
- 7.2. Record the mass of the empty measure.
- 7.3. Mix each test sample with the spatula until it appears to be homogeneous.
- 7.4. 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.
- 7.5. Pour the test sample into the funnel. Level the material in the funnel with the spatula.
- 7.6. Remove the finger and allow the sample to freely flow into the cylindrical measure.
- 7.7. 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.
- 7.7.1. Until this operation is complete, avoid vibration or disturbance that could cause compaction of the fine aggregate in the measure (see note).
- Note:** After strike off, the cylindrical measure may be tapped lightly to compact the sample to make it easier to transfer the container to the scale or balance without spilling any of the sample.
- 7.8. 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.
- 7.9. Recombine the sample from the retaining pan and cylindrical measure, repeat the procedure, and average the results of the two test runs.

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## 8. CALCULATIONS

- 8.1. Calculate the uncompacted voids for each determination according to the following formula:

$$U = \frac{V - \left(\frac{F}{G}\right)}{V} \times 100$$

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

8.1.1. **For Methods A and C:** Calculate the average uncompacted voids for the two determinations.

8.2. **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 = Mean uncompacted void content, %

$U_1, U_2, U_3$  = Uncompacted void content of individual size fractions

8.3. *Calculation Examples*

$$U = \frac{99.8 - \left( \frac{146.2}{2.636} \right)}{V} \times 100 = 44.3, \text{ say } 44.4\%$$

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%

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## 9. REPORT

9.1. Results shall be reported on Form ITD-1046 to the nearest 0.1 percent.





## PERFORMANCE EXAM CHECKLIST

### UNCOMPACTED VOID CONTENT OF FINE AGGREGATE FOP 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)**

**Trial 1**

**Trial 2**

#### ***Sampling***

**1. Sample obtained by one of the following:**

(a) R 90 & R 76 (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?

\_\_\_\_\_

Individual Size Fractions	Mass, g	OK?
No. 8 to No. 16	44 ± 0.2	
No. 16 to No. 30	57 ± 0.2	
No. 30 to No. 50	72 ± 0.2	
No. 50 to No. 100	17 ± 0.2	
Total:	190 ± 0.2	

#### **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 ( $G_{sb}$ )First Attempt: Pass ☐ Fail ☐ Second Attempt: Pass ☐ Fail ☐

Comments

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Testing Technician's Signature: \_\_\_\_\_ WAQTC # \_\_\_\_\_ Date: \_\_\_\_\_

Examiner's Name: \_\_\_\_\_ Signature: \_\_\_\_\_ WAQTC # \_\_\_\_\_

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**Idaho Field Operating Procedure for****Pavement Thickness by Magnetic Pulse  
Induction****Fop for AASHTO T 359**

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**1. SCOPE**

- 1.1. This procedure covers the determination of the pavement thickness by using magnetic pulse induction in accordance with AASHTO T 359. This field operating procedure is derived from AASHTO T 359.
- 1.1.1. 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.*

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**2. REFERENCE DOCUMENTS**

- 2.1. *AASHTO Standards*
- T 359, Pavement Thickness by Magnetic Pulse Induction
  - T 148, Measuring Length of Drilled Concrete Cores
- 2.2. *ASTM Standards*
- A653, Standard Specification for Steel Sheet, Zinc-Coated (Galvanized) or Zinc-Iron Alloy-Coated (Galvannealed) by the Hot-Dip Process

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**3. SUMMARY OF TEST METHOD**

- 3.1.1. The method uses magnetic pulse induction technology to measure the thickness of one or several layers above a metal reflector. While scanning, the device generates a variant magnetic field that creates an eddy current in the reflector. The eddy current will generate an induced magnetic field inside the reflector, the intensity of which is detected by sensors from the device. For a given type of reflector, the intensity of the induced magnetic field is determined primarily by the distance from the device to the target. A calibration file, recording the relationship between the induced magnetic field intensity and the distance, is developed for each unique type of reflector produced by the manufacturer. Reflectors are usually either round or square galvanized sheet steel about 0.6 mm thick. They usually range in size depending on the anticipated thickness of the pavement to be measured. For pavements up to 350 mm thick, round 300-mm diameter reflectors are adequate. Square 355-mm reflectors are adequate for pavements up to 500 mm thick.

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**4. INTERFERENCES**

- 4.1. 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.

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**5. APPARATUS**

- 5.1. An electromagnetic pulse induction device that generates a variant magnetic field that creates an eddy current in a reflector capable of measuring pavement thickness.
- 5.2. 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.
- 5.2.1. 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.
- 5.2.2. For pavements less than 6 inches thick use 6 inch diameter reflector.
- 5.3. 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.

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**6. PROCEDURE**

- 6.1. Place targets at required locations prior to paving.
- 6.1.1. It is usually necessary to fasten the reflectors to the base or subbase to prevent movement during the paving operation.
- 6.1.2. Place the reflector at least 3 feet from any steel or dowel bars.
- 6.1.3. Record the approximate location reference for ease of locating after paving.
- 6.2. **Note** – 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.
- 6.3. Thickness measurements are normally made within 2 feet of each edge and across the driving lane.
- 6.3.1. When adjacent lanes are placed simultaneously, plates across the width of the pavement will represent both lanes.
- 6.3.2. When pavements include shoulders, measurements may be made in the shoulder area within 3 feet of the lane line, unless special circumstances dictate otherwise.
- 6.4. At a minimum, place reflectors at twice the number of stations required for each 0.1 mile section.
- 6.4.1. Reflectors are to be placed at random locations within the section.
- 6.4.2. The minimum number of measurements per 0.1 mile is as follows in Table 1:

**Table 1** Minimum Number of Reflectors per 0.1 Mile

Placement Type	Minimum No. of Measurements
1 lane no, no shoulders	3
1 lane, 1 shoulder	3
2 lanes, no shoulder	5
2 lanes, 2 shoulders	5

- 6.4.3. In cases where a tapered or an unusual pavement width is being placed, use engineering judgment to determine where thickness measurements are made.
- 6.5. Once the pavement is sufficiently cured to support foot traffic, use the gauge search mode to locate the reflector center.
- 6.5.1. 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.
- 6.5.2. When the gauge search function is showing the strongest signal, mark directly above the reflector on the pavement.
- 6.6. Remove all debris from the surface where the gauge wheels will pass.
- 6.7. With the gauge switched to the measurement mode, place the front wheel approximately 1-1/2 feet before the mark.
- 6.7.1. Press the measurement button and then slowly push the gauge over the reflector.
- 6.7.2. After the gauge has traveled approximately 6 feet, the gauge processor will calculate the thickness of the pavement above the reflector.
- 6.8. Repeat step 6.7 two more times and record the results.
- 6.8.1. No single result at a single location should be more than 0.125 inch different than the other 2 readings.
- 6.8.2. If an individual reading exceeds 0.125 inches, repeat the three readings.
- 6.8.3. 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.
- 6.9. Repeat 6.5 to 6.8 to obtain the required number of measurements.

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## **7. CALCULATION AND INTERPRETATION OF RESULTS**

- 7.1. Average the 3 readings for a location and record the average to the nearest 0.05 inch.
- 7.2. Average the readings for a section and record the average to the nearest 0.1 inch.

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## **8. REPORT**

- 8.1. Report the metal target type used, date, test locations, all thickness measurements and averages.



## 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 6 Western Alliance for Quality Transportation Construction (WAQTC) modules, 2 ITD STQP modules, and 16 individual test method qualifications.

Details on the 6 WAQTC and 2 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**

Test Method	Test Reference	Notes For Pre-Qualification
<b>Aggregates</b>		
Cleanness Value	<a href="#">Idaho IT 72</a>	AgTT Qualification is required.
Specific Gravity and Absorption of Fine Aggregate	<a href="#">Idaho IT 144</a>	AgTT Qualification is required. Performance exam administered by HQ Central Laboratory
Bulk Density ("Unit Weight") and Voids in Aggregate	<a href="#">AASHTO T 19</a>	AgTT Qualification is required.
Specific Gravity and Absorption of Fine Aggregate	<a href="#">AASHTO T 84</a>	AgTT Qualification is required.
Uncompacted Void Content Of Fine Aggregate	<a href="#">AASHTO T 304</a>	AgTT Qualification is required.
Flat and Elongated Particles in Coarse Aggregate	<a href="#">ASTM D4791</a>	AgTT Qualification is required
<b>Bituminous Materials</b>		
Saybolt Viscosity	<a href="#">Idaho IT 61</a>	AsTT or AsTT II Qualification is required.
Anti-strip Detection	<a href="#">Idaho IT 99</a>	
Hamburg Wheel Track Testing of Compacted Asphalt Mixtures	<a href="#">AASHTO T 324</a>	
Cracking Tolerance Index of Asphalt Mixtures Using the Indirect Tensile Cracking Test at Intermediate Temperatures	<a href="#">ASTM D8255</a>	
Bulk Specific Gravity and Density of Compacted Hot Mix Asphalt (HMA) using Automatic Vacuum Sealing Method (CoreLok)	<a href="#">AASHTO T 331</a>	AsTT or AsTT II Qualification is required.
Field Sampling Asphalt Mixtures after Compaction (Obtaining Cores)	<a href="#">AASHTO R 67</a>	
<b>Soils</b>		
Determining the Plastic Limit and Plasticity Index of Soils	<a href="#">AASHTO T 90</a>	EbTT Qualification is required.
Determining the Liquid Limit of Soils	<a href="#">AASHTO T 89</a>	EbTT Qualification is required.
Specific Gravity of Soils	<a href="#">AASHTO T 100</a>	EbTT Qualification is required.
<b>Concrete</b>		
Sampling & Fabrication of 2" Cube Specimens using Grout or Mortar	<a href="#">AASHTO R 64</a>	CTT Qualification is required.



**PERFORMANCE EXAM CHECKLIST****CLEANNES VALUE  
IDAHO IT-72**

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

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

Comments: \_\_\_\_\_

Testing Technician's Signature: \_\_\_\_\_ WAQTC # \_\_\_\_\_ Date: \_\_\_\_\_

Examiner's Name: \_\_\_\_\_ Signature: \_\_\_\_\_ WAQTC # \_\_\_\_\_

Quality Assurance

ITD STQP

590.00

## PERFORMANCE EXAM CHECKLIST

### SPECIFIC GRAVITY AND ABSORPTION OF FINE AGGREGATE USING AUTOMATIC VACUUM SEALING (CORELOK) METHOD IDAHO IT-144-19

Participant Name: \_\_\_\_\_ Exam Date: \_\_\_\_\_

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

Verification Element:	Trial 1	Trial 2
1. Pycnometer and lid placed inside a bucket of water at $25 \pm 1^\circ\text{C}$ ( $77 \pm 2^\circ\text{F}$ )?	_____	_____
2. Pycnometer and lid removed from water dried well and placed on clamping device until it makes contact with stops?	_____	_____
3. Pycnometer filled with $25 \pm 1^\circ\text{C}$ ( $77 \pm 2^\circ\text{F}$ ) water to 10mm (3/8”) of top, sprayed with Isopropyl alcohol to remove air?	_____	_____
4. Lid gently placed on Pycnometer and clamped?	_____	_____
5. A syringe filled with $25 \pm 1^\circ\text{C}$ ( $77 \pm 2^\circ\text{F}$ ) inserted in top of lid and gently added until water is expelled through the 3mm (1/8”) hole?	_____	_____
6. Water wiped from lid, device water and pycnometer weighed and recorded to 0.1 g?	_____	_____
7. Procedure repeated two additional times (no greater than 0.5 g difference) recorded to work sheet and averaged?	_____	_____
<b>Procedure Element</b>		
8. Representative samples obtained per FOP for AASHTO R 90?	_____	_____
9. Reduced per FOP for AASHTO R 76, modified?	_____	_____
10. Dried per FOP for AASHTO T 255?	_____	_____
11. Samples cooled to $25 \pm 1^\circ\text{C}$ ( $77 \pm 2^\circ\text{F}$ )?	_____	_____
12. Three samples obtained @ 500g $\pm 1\text{g}$ and one @ 1000g $\pm 1\text{g}$ ?	_____	_____
13. Pycnometer and lid removed from water, dried and pycnometer placed on clamping device until it makes contact with stops?	_____	_____
14. Water added to pycnometer (at $25 \pm 1^\circ\text{C}$ , $77 \pm 2^\circ\text{F}$ ) to approximately half full?	_____	_____
15. Sample at 500 g $\pm 1\text{g}$ slowly added to pycnometer?	_____	_____
16. Metal spatula inserted against side of pycnometer and slowly pushed to center removed, repeated in eight equal increments?	_____	_____
17. Water added at $25 \pm 1^\circ\text{C}$ ( $77 \pm 2^\circ\text{F}$ ) to within 10mm (3/8”) of rim?	_____	_____
18. Sprayed with isopropyl alcohol to remove air?	_____	_____
19. Lid gently placed on pycnometer with 3mm (1/8”) hole to the front and clamped?	_____	_____
20. Syringe filled with $25 \pm 1^\circ\text{C}$ ( $77 \pm 2^\circ\text{F}$ ) water inserted in top of lid and water slowly added until it is expelled through 3mm (1/8”) hole?	_____	_____

- |   |       |       |
|---|-------|-------|
| 21. Excess water wiped from lid?  | _____ | _____ |
| 22. Clamping device, pycnometer and sample mass recorded to 0.1 g?  | _____ | _____ |
| 23. Clamping device, pycnometer and sample mass determined no more than 2 minutes from time sample was submerged?               | _____ | _____ |
| 24. Second 500g $\pm$ 1 g sample tested and mass recorded?  | _____ | _____ |
| 25. If recorded mass of first and second sample greater than 1 g, was a third 500 g $\pm$ 1 g sample tested?                    | _____ | _____ |
| 26. Vacuum device set at manufacture's recommended setting?   | _____ | _____ |
| 27. Small plastic bag inspected and mass determined to 0.1 g and recorded?  | _____ | _____ |
| 28. 1000 g $\pm$ 1 g sample mass determined and recorded?   | _____ | _____ |
| 29. 1000 g $\pm$ 1 g sample placed in the bag, supported by a smooth surface to prevent punctures?                              | _____ | _____ |
| 30. Sample placed in vacuum device and spread flat by grasping both sides of bag and gently shaking?                            | _____ | _____ |
| 31. Open end of bag placed over seal bar and closed?  | _____ | _____ |
| 32. Sample removed from vacuum chamber when door opens and submerged in 25 $\pm$ 1C (77 $\pm$ 2F) water bath within 10 seconds? | _____ | _____ |
| 33. Bag maintained at a minimum depth of two inches?  | _____ | _____ |
| 34. A small cut made at corner of bag approximately 25 to 50mm (1" to 2")?  | _____ | _____ |
| 35. Submerged bag held open until water flows freely into bag (approximately 45 seconds)  | _____ | _____ |
| 36. A second cut approximately 25 to 50mm (1" to 2") made to opposite side of bag?  | _____ | _____ |
| 37. Residual air removed from bag by running fingers across top of submerged bag?   | _____ | _____ |
| 38. Bag placed in weighing basket and water allowed to flow freely into bag?  | _____ | _____ |
| 39. Sample mass determined and recorded after 15 minutes but not more than 20 minutes and recorded to 0.1g?                     | _____ | _____ |
| 40. Test data entered into manufacture's software to obtain test results?   | _____ | _____ |

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

Comments: \_\_\_\_\_

\_\_\_\_\_

\_\_\_\_\_

\_\_\_\_\_

Testing Technicians Signature: \_\_\_\_\_ WAQTC # \_\_\_\_\_ Date: \_\_\_\_\_

Examiner's Name: \_\_\_\_\_ Signature: \_\_\_\_\_ WAQTC # \_\_\_\_\_

## PERFORMANCE EXAM CHECKLIST

### 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.

Procedure Elements:	Trial 1	Trial 2
1. <b>Obtain Sample.</b> Use the FOP for AASHTO R 90.	_____	_____
2. <b>Aggregate dried to constant mass per the FOP for AASHTO T 255.</b>	_____	_____
3. <b>Reduce Sample to required size.</b> Use the FOP for AASHTO R 76. Sample shall be 125% to 200% of the quantity needed to fill the measure.	_____	_____
4. <b>Inspect measure and other apparatus.</b> Measure must be calibrated within the last 12 months; balance conforms to M 231, scoop/ shovel, & tamping rod in good working order.	_____	_____
5. <b>Rodding</b> aggregate NMS 1 1/2” (37.5 mm) or less		
a. <b>Measure filled 1/3 full, leveled by hand, and rodded 25 times evenly distributed.</b> The rod shall not strike the bottom of the measure forcibly.	_____	_____
b. <b>Measure filled 2/3 full, leveled by hand, and rodded 25 times evenly distributed.</b> The rod shall not penetrate into the first layer.	_____	_____
c. <b>Measure filled to overflowing, and rodded 25 times evenly distributed.</b> 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.	_____	_____
6. <b>Jigging:</b> aggregates NMS greater than 1 1/2” (37.5 mm) but not exceeding 5” (125mm)	_____	_____
a. <b>Measure filled 1/3 full.</b>	_____	_____
b. <b>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.</b>	_____	_____
c. <b>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</b>	_____	_____

- d. **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.

**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/ft<sup>3</sup> (10 kg/ m<sup>3</sup>).**

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

Comments: \_\_\_\_\_

\_\_\_\_\_

\_\_\_\_\_

Testing Technician's Signature: \_\_\_\_\_ WAQTC # \_\_\_\_\_ Date: \_\_\_\_\_

Examiner's Name: \_\_\_\_\_ Signature: \_\_\_\_\_ WAQTC # \_\_\_\_\_

**PERFORMANCE EXAM CHECKLIST****SPECIFIC GRAVITY AND ABSORPTION OF FINE AGGREGATE  
AASHTO T 84**

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*****Sample Preparation***

1. Sampled according to AASHTO R 90?  
\_\_\_\_\_
3. Sample reduced according to AASHTO R 76 to approximately  
2000 g?  
\_\_\_\_\_
4. Dried to a constant mass at  $230 \pm 9^\circ \text{F}$ , cooled to a comfortable handling  
temperature?  
\_\_\_\_\_
5. Addition of 6% moisture to sample?  
\_\_\_\_\_
6. Allowed to stand 15 – 19 hours?  
\_\_\_\_\_
7. Uniformly dried by a current of warm air, with frequent stirring?  
\_\_\_\_\_
8. Mold placed on flat, non-absorbent surface and filled to over-flowing?  
\_\_\_\_\_
9. Sample compacted with 25 light drops of tamper from 0.2” above top of  
sample?  
\_\_\_\_\_
10. Tamper allowed to fall freely under gravitational attraction?  
\_\_\_\_\_
11. Loose sand removed from around bases and mold lifted vertically?  
\_\_\_\_\_
12. Sample fails to slump on the first test?  
\_\_\_\_\_
13. If it does slump, is water added, sample covered and allowed to stand 30  
minutes?  
\_\_\_\_\_
14. 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?  
\_\_\_\_\_

**Testing Procedure**

1. Split out two 500 gram samples that weigh within 0.2 grams of each other.  
\_\_\_\_\_
2. 1000 ml Pycnometer partially filled with water and first sample added?  
\_\_\_\_\_
3. Second sample dried back to constant mass?  
\_\_\_\_\_
4. Pycnometer filled to 90 % of calibrated capacity and agitated to eliminate air  
bubbles?  
\_\_\_\_\_
5. Temperature adjusted to  $73.4 \pm 3^\circ \text{F}$ .?  
\_\_\_\_\_

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6. Water level brought to calibrated capacity and agitated to eliminate air bubbles?
7. Second sample cooled in air at room temperature for  $1.0 \pm 0.5$  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.

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

Comments:


Testing Technician's Signature: \_\_\_\_\_ WAQTC # \_\_\_\_\_ Date: \_\_\_\_\_

Examiner's Name: \_\_\_\_\_ Signature: \_\_\_\_\_ WAQTC # \_\_\_\_\_



## PERFORMANCE EXAM CHECKLIST

### UNCOMPACTED VOID CONTENT OF FINE AGGREGATE

### IDAHO FOP 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)**

**Trial 1**

**Trial 2**

#### **Sampling**

**1. Sample obtained by one of the following:**

(a) R 90 & R 76 (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?

\_\_\_\_\_

Individual Size Fractions	Mass, g	OK?
No. 8 to No. 16	44 ± 0.2	
No. 16 to No. 30	57 ± 0.2	
No. 30 to No. 50	72 ± 0.2	
No. 50 to No. 100	17 ± 0.2	
Total:	190 ± 0.2	

#### **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 ( $G_{sb}$ )First Attempt: Pass ☐ Fail ☐ Second Attempt: Pass ☐ Fail ☐

Comments

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Testing Technician's Signature: \_\_\_\_\_ WAQTC # \_\_\_\_\_ Date: \_\_\_\_\_

Examiner's Name: \_\_\_\_\_ Signature: \_\_\_\_\_ WAQTC # \_\_\_\_\_

## PERFORMANCE EXAM CHECKLIST

### FLAT PARTICLES, ELONGATED PARTICLES, OR FLAT AND ELONGATED PARTICLES IN COARSE AGGREGATE FOP FOR IDAHO 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.

Procedure Element:	Trial 1	Trial 2
<b>Sample Preparation</b>		
1. Sample obtained, mixed and reduced in accordance with AASHTO R 90 and AASHTO R 76 to approximately the amount required for testing? For combined samples fine portion (- # 4) removed?	_____	_____
2. Minimum dry sample mass meets requirements of Table 1?	_____	_____
<b>Procedure</b>		
1. If determination by mass, sample oven-dried to constant mass at $230 \pm 9^\circ \text{F}$ ? <b>Note:</b> If determination is by particle count drying is not necessary.	_____	_____
2. Sample sieved according to AASHTO T 27?	_____	_____
3. Each coarse aggregate size fraction present in amount of 10% or more of original coarse sample reduced according to R 76 until approximately 100 particles obtained?	_____	_____
<b>Flat and Elongated Particle Test:</b>		
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?	_____	_____
5. Proportional caliper device positioned at proper ratio?	_____	_____
6. Larger opening set equal to particle <u>length</u> ?	_____	_____
7. Particle is <u>flat and elongated</u> if the <u>thickness</u> can be placed in the smaller opening?	_____	_____
8. Proportion of sample in each group determined by count or by mass, as	_____	_____
<b>Calculation</b>		
1. Percentage of flat and elongated particles calculated to nearest 1% for each sieve size greater than No. 4?	_____	_____
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?	_____	_____

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

Comments: \_\_\_\_\_

Testing Technician's Signature: \_\_\_\_\_ WAQTC #: \_\_\_\_\_ Date: \_\_\_\_\_

Examiner's Name: \_\_\_\_\_ Signature: \_\_\_\_\_ WAQTC #: \_\_\_\_\_

Quality Assurance

ITD STQP

590.00

**PERFORMANCE EXAM CHECKLIST****FIELD VISCOSITY  
IDAHO IT 61**

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****Sampling**

1. Sample taken using a valve:

a. Minimum of 4 L (1gal) allowed to flow before sample taken?

b. Sample taken in clean 1 L (1 quart) wide mouth jar?

2. Sample taken with Thief device.

a. Sample can immersed approximately to middle of tanker?

b. Rubber stopper removed from can and sample taken from the middle of the tanker/tank?

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?

**Equipment**

4. Temperature of the viscometer bath at 50°C (122°F)?

5. Viscosity tube clean and dry and cork installed?

**Testing**

6. Sample cooled to 51.7 ±0.3°C (125 ±0.5°F)?

7. Sample poured through a #20 sieve prior to entering the brass viscosity tube?

8. Enough sample poured into the tube to allow overflow into gallery?

9. Thermometer placed into tube and sample stirred slowly until testing

10. Thermometer withdrawn and excess in the overflow gallery siphoned out using a pipette without touching overflow rim?

11. Emulsified asphalt sample in viscometer immediately covered?

12. Cork pulled allowing the sample roll down the inside lip of the receiving flask?

13. Timer immediately started when cork is pulled?

14. Timer stopped when bottom of sample meniscus reaches graduation mark?

15. Test results reported to nearest 1 second on ITD-1045 form?

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

Comments \_\_\_\_\_

Testing Technician's Signature: \_\_\_\_\_ WAQTC #: \_\_\_\_\_ Date: \_\_\_\_\_

Examiner's Name: \_\_\_\_\_ Signature: \_\_\_\_\_ WAQTC #: \_\_\_\_\_

Quality Assurance

ITD STQP

590.00

**PERFORMANCE EXAM CHECKLIST**  
**DETECTION OF ANTI-STRIP ADDITIVE IN ASPHALT**  
**IDAHO T 99**

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
<b>General</b>		
1. All containers and or stir sticks were clean and chemical solutions were fresh.	_____	_____
<b>Detection Test by Color Method Only</b>		
2. A control blank was performed.	_____	_____
3. 40 ml of Reagent Isopropyl Alcohol or equivalent was used.	_____	_____
4. The asphalt mixture was heated on a hot plate.	_____	_____
5. Heating of sample was stopped before mixture became too dark.	_____	_____
6. The same amount of Bromophenol Blue Indicator was added to both mixtures.	_____	_____
7. Test results were accurately interpreted and recorded on the proper ITD Form.	_____	_____

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

Comments \_\_\_\_\_

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Testing Technician's Signature: \_\_\_\_\_ WAQTC #: \_\_\_\_\_ Date: \_\_\_\_\_

Examiner's Name: \_\_\_\_\_ Signature: \_\_\_\_\_ WAQTC #: \_\_\_\_\_

Quality Assurance

ITD STQP

590.00



**PERFORMANCE EXAM CHECKLIST****HAMBURG WHEEL-TRACK TESTING OF COMPACTED ASPHALT MIXTURES  
AASHTO T 324**

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. The tester has a copy of the current procedure on hand?	_____	_____
2. All equipment is functioning according to the test procedure, and if required, has the current calibration/verification tags present?	_____	_____
3. Specimen height is $62 \pm 1.0$ mm ( $2.44 \pm 0.04$ in.) or 38.1 mm (1.5 inch) minimum for cores?	_____	_____
4. Specimen meets air void tolerance of $7.0 + 1.0$ %?	_____	_____
5. Specimens placed in molds and loaded into trays with a maximum gap of 7.5 mm between molds?	_____	_____
6. Tray mounted in machine and securely fastened?	_____	_____
7. Sample data and testing parameters entered into computer? (e.g., sample name, aggregate source, wheel speed, maximum rut depth, number of passes, and water temperature)	_____	_____
8. Wheels gently lowered and samples allowed to soak at testing temperature for 30 minutes?	_____	_____
9. Wheel tracking device shut off when test parameters are reached?	_____	_____
10. Test data obtained for charting and analysis?	_____	_____

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

Testing Technician's Signature: \_\_\_\_\_ WAQTC #: \_\_\_\_\_ Date: \_\_\_\_\_

Examiner's Name: \_\_\_\_\_ Signature: \_\_\_\_\_ WAQTC #: \_\_\_\_\_

Quality Assurance

ITD STQP

590.00

**PERFORMANCE EXAM CHECKLIST****CRACKING TOLERANCE INDEX OF ASPHALT MIXTURES  
USING THE INDIRECT TENSILE CRACKING TEST AT  
INTERMEDIATE TEMPERATURES  
ASTM D8255**

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****Test Specimen**

1.

1.

2.

**Procedure**

1.

2.

3.

4.

5.

6. .

7.

%

Where:

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

Comments:

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Testing Technician's Signature: \_\_\_\_\_ WAQTC #: \_\_\_\_\_ Date: \_\_\_\_\_

Examiner's Name: \_\_\_\_\_ Signature: \_\_\_\_\_ WAQTC #: \_\_\_\_\_

**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 1inch 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?

$$G_{mb} = \frac{A}{\left[ C + (B - A) - E - \left[ \frac{B - A}{F} \right] \right]}$$

Where:

$G_{mb}$  = 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 Manufacturer.

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

Comments:

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Testing Technician's Signature: \_\_\_\_\_ WAQTC #: \_\_\_\_\_ Date: \_\_\_\_\_

Examiner's Name: \_\_\_\_\_ Signature: \_\_\_\_\_ WAQTC #: \_\_\_\_\_

**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.**

Procedure Element:	Trial 1	Trial 2
1. Core location determined by Agency?	_____	_____
2. Asphalt mixture sufficiently cool or cooled with water, ice dry ice or liquid nitrogen?	_____	_____
3. Core machine correctly positioned over location?	_____	_____
4. Water or air used to remove cuttings and minimize friction?	_____	_____
5. Constant pressure applied to bit while keeping it perpendicular to HMA surface?	_____	_____
6. Coring stopped a desired depth?	_____	_____
7. Retrieval device used to obtain object?	_____	_____
8. Core labeled?	_____	_____
9. Core placed for transport in a manner that prevents damage from jarring, rolling, impact with any object, or extreme temperatures?	_____	_____
10. Core hole filled with agency suitable material and compacted when necessary?	_____	_____
11. Thickness determined to 1/8 in., 0.01 ft., or 3 mm?	_____	_____

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

Comments:

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Testing Technician's Signature: \_\_\_\_\_ WAQTC #: \_\_\_\_\_ Date: \_\_\_\_\_

Examiner's Name: \_\_\_\_\_ Signature: \_\_\_\_\_ WAQTC #: \_\_\_\_\_

Quality Assurance

ITD STQP

590.00



## PERFORMANCE EXAM CHECKLIST

### 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. <b>Inspect and clean apparatus.</b> 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. <b>Prepare sample.</b> 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. <b>Adjustment of moisture content.</b> 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. <b>Roll sample to 3.0 mm (approx. 1/8”).</b> Take approximately 8g of the 20g sample and separate into 1.5– 2.0 gram increments. Roll on a ground surface with just enough pressure to make a thread of uniform diameter for its 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. <b>Re-roll until thread breaks or crumbles.</b> 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. <b>Collect crumbled particles.</b> Using the spatula, gather all portions of the crumbled particles into a suitable container; <b>cover immediately</b> and determine the mass to the nearest 0.01g.	_____	_____
7. <b>Remove cover and place in oven at 110±5° C (230±9° F) and dry to constant mass.</b> When removing sample from the drying oven <b>cover immediately</b> .	_____	_____
8. <b>Determine moisture content.</b> 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.

\_\_\_\_\_

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

Comments:

\_\_\_\_\_

\_\_\_\_\_

\_\_\_\_\_

Testing Technician's Signature: \_\_\_\_\_ WAQTC #: \_\_\_\_\_ Date: \_\_\_\_\_

Examiner's Name: \_\_\_\_\_ Signature: \_\_\_\_\_ WAQTC #: \_\_\_\_\_

## PERFORMANCE EXAM CHECKLIST

### DETERMINING THE LIQUID LIMIT OF SOILS (METHOD “B” ONE POINT) AASHTO T-89

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. <b>Prepare sample.</b> Using AASHTO T 87 or AASHTO T 146. This test requires a minimum of 50g of minus # 40 (0.425 mm) material.	_____	_____
2. <b>Inspect and adjust test apparatus.</b> 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. <b>Adjust sample moisture and mix.</b> 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 <b>may not</b> be adjusted by adding dry soil to the moistened sample. Cover the sample and allow to season for 30 minutes.	_____	_____
4. <b>Spread sample into cup of device.</b> 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 its maximum depth. Use as few strokes as possible; do not entrap air into the sample. Return excess material to the mixing dish.	_____	_____
5. <b>Cut groove into the sample.</b> 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. <b>Turn the device on and count the taps.</b> 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. <b>Repeat steps 3 through 6 until the groove closes with a range of 22 and 28 taps.</b> 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.

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9. **Remove cover, place in oven at  $110 \pm 5^\circ \text{C}$  ( $230 \pm 9^\circ \text{F}$ ) and dry to a constant mass.** When removing the sample from the oven to determine constant mass **cover immediately.**

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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%

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11. **Calculate the Liquid Limit.** Using the formula:

$$LL = (W_N) \left( \frac{N}{25} \right)^{0.121}$$

Calculate the corrected Liquid Limit for 25 taps to the nearest 0.1%.

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12. **Report the Liquid Limit.** The Liquid Limit is the nearest whole number.

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

Comments: \_\_\_\_\_

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Testing Technician's Signature: \_\_\_\_\_ WAQTC #: \_\_\_\_\_ Date: \_\_\_\_\_

Examiner's Name: \_\_\_\_\_ Signature: \_\_\_\_\_ WAQTC #: \_\_\_\_\_

## PERFORMANCE EXAM CHECKLIST

### 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 Element:**

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?

**Trial 1**

**Trial 2**

_____	_____
_____	_____
_____	_____
_____	_____
_____	_____
_____	_____
_____	_____
_____	_____
_____	_____
_____	_____

$$\text{Specific Gravity}, \frac{T_x}{T_x} = \frac{W_0}{[W_0 + (W_a - W_b)]}$$

$$\text{Specific Gravity}, \frac{T_x}{20^\circ C} = \left( \text{Specific Gravity}, \frac{T_x}{T_x} \right) \times K$$

Where:

$T_x$  = temperature of the contents of the Pycnometer when mass  $W_b$  was determined, in degrees Celsius;

$W_0$  = 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 pycnometer 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  $20^\circ C$ )

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

Comments: \_\_\_\_\_

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\_\_\_\_\_

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Testing Technicians Signature: \_\_\_\_\_ WAQTC #: \_\_\_\_\_ Date: \_\_\_\_\_

Examiner Name: \_\_\_\_\_ Signature: \_\_\_\_\_ WAQTC #: \_\_\_\_\_

Quality Assurance

ITD STQP

590.00

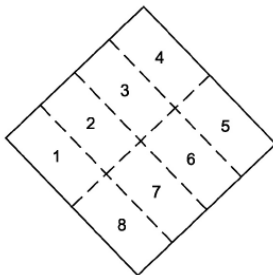
**PERFORMANCE EXAM CHECKLIST****SAMPLING & FABRICATION OF 2" (50 – MM) CUBE SPECIMENS USING GROUT (NON-SHRINK) MORTAR  
IDAHO FOP FOR AASHTO R 64**

Participant Name: \_\_\_\_\_ Exam Date: \_\_\_\_\_

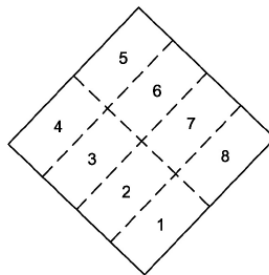
Record the symbols "P" for passing or "F" for failing on each step of the checklist.

**Procedure Elements:****Trial 1****Trial 2**

1. **Obtain Sample.** Use AASHTO T-141 for 1 yd<sup>3</sup> or more or for less than 1 yd<sup>3</sup> sample from discharge after remixing takes place.
2. **Inspect and adjust test apparatus.** Apparatus includes mold assembly, tamper, trowel, watertight container.
3. **Mold portion attached to bottom plate and joints are water tight.** Use of a light coating of non water-soluble grease is allowed.
4. **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.
5. **Consolidate the mix.** The mix shall be consolidated depending on the consistency, either plastic or fluid.
6. **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.

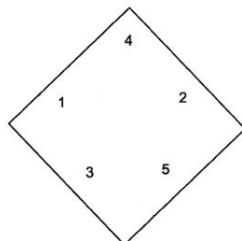


Rounds 1 and 3



Rounds 2 and 4

7. **Fluid Mixes:** puddle the lift 5 times with gloved finger.



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.
9. **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.
10. **Immediately secure the top plate to the molds.**
11. **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  $24 \pm 4$  hours.

First Attempt: Pass

☐

Fail

☐

Second Attempt: Pass

☐

Fail

☐

Comments:

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Testing Technician's Signature: \_\_\_\_\_ WAQTC #: \_\_\_\_\_ Date: \_\_\_\_\_

Examiner's Name: \_\_\_\_\_ Signature: \_\_\_\_\_ WAQTC #: \_\_\_\_\_