



Florida Department of Transportation

RICK SCOTT
GOVERNOR

605 Suwannee Street
Tallahassee, FL 32399-0450

ANANTH PRASAD, P.E.
SECRETARY

January 14, 2012

Monica Gourdine
Program Operations Engineer
Federal Highway Administration
545 John Knox Road, Suite 200
Tallahassee, Florida 32303

Re: Office of Design, Specifications
Section **320**
Proposed Specification: **3200201 Hot Mix Asphalt – Plant Methods and Equipment.**

Dear Ms. Gourdine:

We are submitting, for your approval, two copies of the above referenced Supplemental Specification.

These changes were proposed by Gregory Sholar, of the State Materials Office, to clarify the specification.

Please review and transmit your comments, if any, within two weeks. Comments should be sent via email to SP965TT or trey.tillander@dot.state.fl.us.

If you have any questions relating to this specification change, please call me at 414-4140.

Sincerely,

V. Y. "Trey" Tillander, III, P.E.
State Specifications Engineer

TT/cah

Attachment

cc: Florida Transportation Builders' Assoc.
State Construction Engineer

HOT MIX ASPHALT – PLANT METHODS AND EQUIPMENT.**(REV ~~11-1420-132~~)**

SUBARTICLE 320-2.1 (Page240 – 241) is deleted and the following substituted:

320-2.1 Minimum Producer QC Requirements: Perform as a minimum the following activities:

1. Stockpiles:
 - a. Assure materials are placed in the correct stockpile;
 - b. Assure good stockpiling techniques;
 - c. Inspect stockpiles for separation, contamination, segregation, and other similar items;
 - d. Properly identify and label each stockpile.
2. Incoming Aggregate:
 - a. Obtain gradations and bulk specific gravity (G_{sb}) values from aggregate supplier for reference;
 - b. Determine the gradation of all component materials and routinely compare gradations and G_{sb} values to mix design.
3. Cold Bins:
 - a. Calibrate the cold gate/feeder belt for each material;
 - b. Determine cold gate/feeder belt settings;
 - c. Observe operation of cold feeder for uniformity;
 - d. Verify accuracy of all settings;
 - e. Verify that the correct components are being used, and that all modifiers or additives or both are being incorporated into the mix.
4. Batch Plants:
 - a. Determine percent used and weight to be pulled from each bin to assure compliance with the mix design;
 - b. Check mixing time;
 - c. Check operations of weigh bucket and scales.
5. Drum Mixer Plants:
 - a. Determine aggregate moisture content;
 - b. Calibrate the weigh bridge on the charging conveyor.
6. Control Charts: Maintain QC data and charts (updated daily) for all QC Sampling and Testing and make available upon demand. Provide the following charts:
 - a. All components used to determine the composite pay factor (No. 8 sieve, No. 200 sieve, asphalt binder content, air voids, and density) ~~by LOT~~;
 - b. Gradation of incoming aggregate;
 - c. Gradation, asphalt binder content and maximum specific gravity (G_{mm}) of RAP;
 - d. Any other test result or material characteristic (as determined by the Contractor) necessary for process control.

The above listed minimum activities are to be considered normal activities necessary to control the production of hot mix asphalt at an acceptable quality level. Depending on the type of process or materials, some of the activities listed may not be necessary and in other cases, additional activities may be required. The frequency of

these activities will also vary with the process and the materials. When the process varies from the defined process average and variability targets, the frequency of these activities will be increased until the proper conditions have been restored.

ARTICLE 320-7 (Page 247) is deleted and the following substituted:

320-7 Transportation of the Mixture.

Transport the mix in trucks of tight construction, which prevents the loss of material and the excessive loss of heat and previously cleaned of all foreign material. After cleaning, thinly coat the inside surface of the truck bodies with soapy water or an asphalt release agent as needed to prevent the mixture from adhering to the beds. Do not allow excess liquid to pond in the truck body. Do not use a release agent that will contaminate, degrade, or alter the characteristics of the asphalt mix or is hazardous or detrimental to the environment. Petroleum derivatives (such as diesel fuel), solvents, and any product that dissolves asphalt are prohibited. Provide each truck with a tarpaulin or other waterproof cover mounted in such a manner that it can cover the entire load when required. When in place, overlap the waterproof cover on all sides so that it can be tied down. Cover each load during cool and cloudy weather and at any time it appears rain is likely during transit with a tarpaulin or waterproof cover. *Cover and tie down ~~strap~~ all loads of friction course mixtures.*

HOT MIX ASPHALT – PLANT METHODS AND EQUIPMENT.
(REV 1-14-13)

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 - b. Gradation of incoming aggregate;
 - c. Gradation, asphalt binder content and maximum specific gravity (G_{mm}) of RAP;
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The above listed minimum activities are to be considered normal activities necessary to control the production of hot mix asphalt at an acceptable quality level. Depending on the type of process or materials, some of the activities listed may not be necessary and in other cases, additional activities may be required. The frequency of

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