



Florida Department of
TRANSPORTATION

Control Chart Instructions

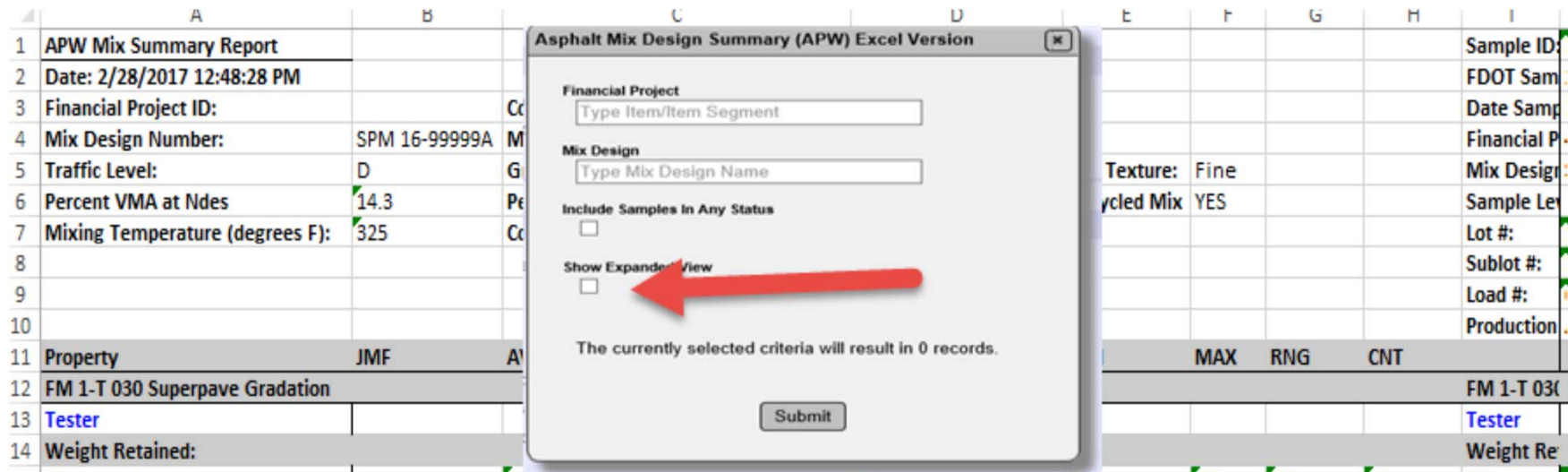
State Materials Office

Overview

- The Control Charts have been created to provide users the ability to plot the official results for Asphalt testing of a specific mix design.
- These Control Charts can be used to meet the requirement in Specification 320-2.1 No. 6.
- The Control Charts plot data for the following:
 - Sieves: 3/8", No. 4, No. 8, No.200
 - Percent Asphalt Content
 - Percent Air Voids
 - Gmb
 - Gmm
 - VMA
 - VFA
 - Dust/Asphalt Ratio
 - Gse
 - Core Percent Gmm

Mix Summary Report

- Prior to running the Control Charts, you will need to run a Mix Summary Report from MAC for a specific mix design and have it saved on your computer.
- When running the Mix Summary Report you will need to select the Show Expanded View box.



	A	B	C	D	E	F	G	H	I
1	APW Mix Summary Report								Sample ID:
2	Date: 2/28/2017 12:48:28 PM								FDOT Sam
3	Financial Project ID:								Date Samp
4	Mix Design Number:	SPM 16-99999A							Financial P
5	Traffic Level:	D							Mix Design:
6	Percent VMA at Ndes	14.3				Texture:	Fine		Sample Len
7	Mixing Temperature (degrees F):	325				Recycled Mix	YES		Lot #:
8									Sublot #:
9									Load #:
10									Production
11	Property	JMF							
12	FM 1-T 030 Superpave Gradation					MAX	RNG	CNT	FM 1-T 030
13	Tester								Tester
14	Weight Retained:								Weight Re

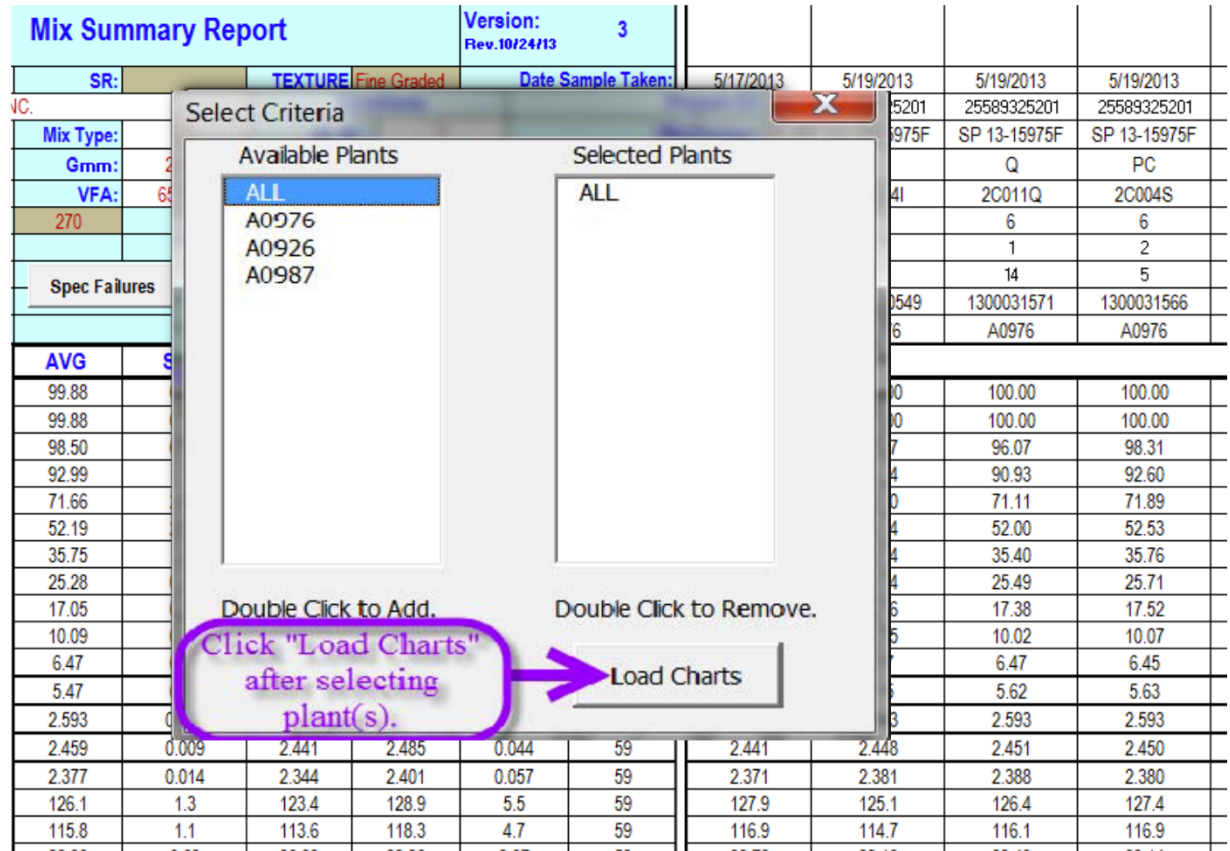
Control Charts – Selecting Report File

The screenshot shows an Excel spreadsheet with a control chart. The chart has a vertical axis labeled "3/8" and a horizontal axis labeled "No. 4". The chart area is divided into two sections: the top section (rows 3-14) has a vertical axis ranging from 83.9 to 93.9, and the bottom section (rows 21-27) has a vertical axis ranging from 70.1 to 74.1. A purple arrow points to the "Load Summary Data" button in the top-left corner of the chart area. A purple callout box with the text "Click 'Load Summary Data'" is positioned over this button. A "Select a File" dialog box is open over the chart, showing the "Desktop" folder. The file list includes folders like "APW", "Jenni", "MAC Flowcharts", and "Projects", and a file named "22872615201 SP 13-15975F.xlsm" (Microsoft Excel Macro-Enabled W... 234 KB). A purple callout box with the text "Select the Mix Summary Report file and click 'Open'." is positioned over the "Open" button in the dialog box. The spreadsheet header includes "Mix Number:", "Plants:", and "Report Date:".

Control Charts – Plant(s)

If the mix design was produced at multiple plants, this menu will appear for you to select the desire plant(s) for the control charts.

*** NOTE:** If the mix design was not produced at multiple plants, this menu will not appear and the worksheet will plot the charts.



Mix Summary Report

Version: 3
Rev. 10/24/13

SR: TEXTURE Fine Graded Date Sample Taken: 5/17/2013 5/19/2013 5/19/2013 5/19/2013

Mix Type: 270

Gmm: 270

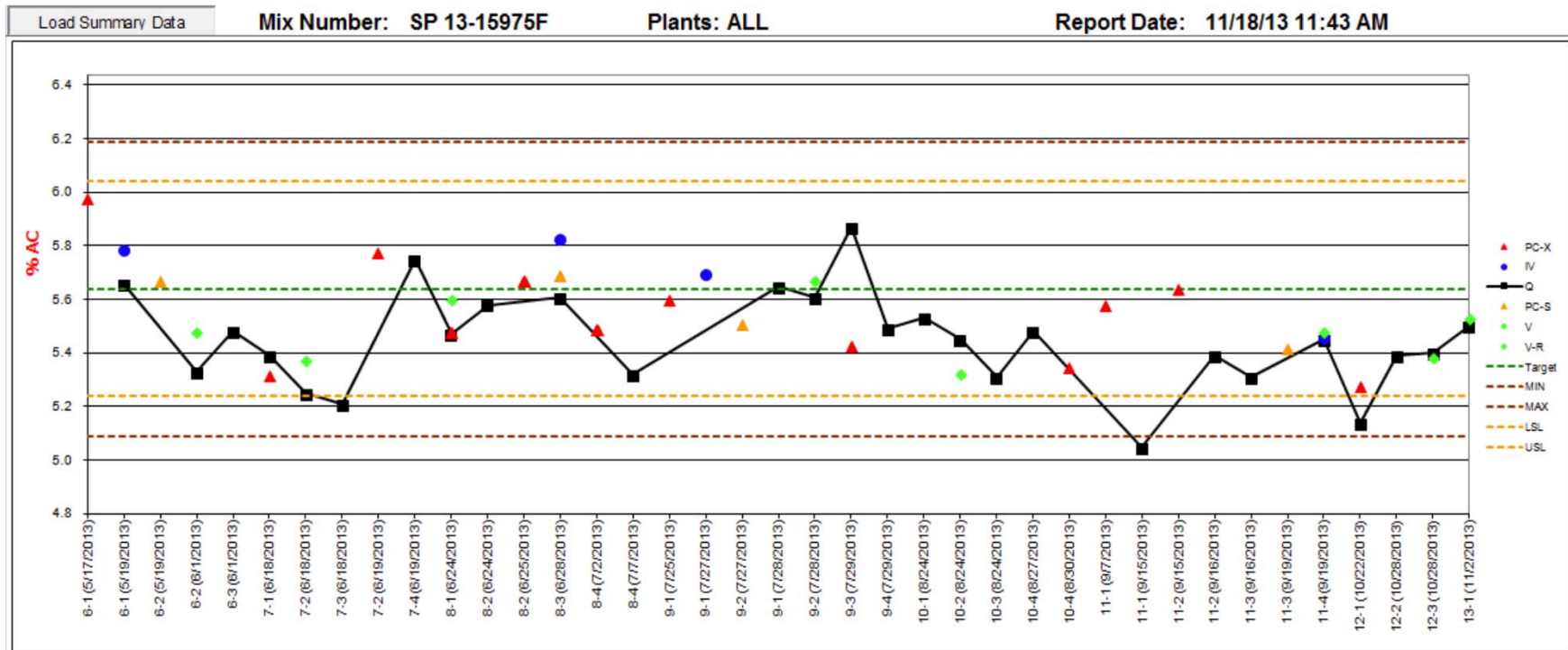
VFA: 68

Spec Failures

AVG












SR	TEST	TEST	TEST	TEST	TEST	TEST	TEST	TEST	TEST
5201	25589325201	25589325201							
975F	SP 13-15975F	SP 13-15975F							
	Q	PC							
41	2C011Q	2C004S							
	6	6							
	1	2							
	14	5							
549	1300031571	1300031566							
6	A0976	A0976							
0	100.00	100.00							
0	100.00	100.00							
7	96.07	98.31							
4	90.93	92.60							
0	71.11	71.89							
4	52.00	52.53							
4	35.40	35.76							
4	25.49	25.71							
6	17.38	17.52							
6	10.02	10.07							
7	6.47	6.45							
6	5.62	5.63							
8	2.593	2.593							
2.459	0.009	2.441	2.485	0.044	59	2.441	2.448	2.451	2.450
2.377	0.014	2.344	2.401	0.057	59	2.371	2.381	2.388	2.380
126.1	1.3	123.4	128.9	5.5	59	127.9	125.1	126.4	127.4
115.8	1.1	113.6	118.3	4.7	59	116.9	114.7	116.1	116.9

Control Charts



- The data is plotted in order by Date, Lot, then Sublot.

Control Charts – Legend

	PC-X
	IV
	Q
	PC-S
	V
	V-R
	Target
	MIN
	MAX
	LSL
	USL

- The legend is on the right side of each chart. There is a different symbol and color per sample level.
- Also included are the Master Production Limits, which are noted by “MIN” and “Max”, and upper and lower Spec Limits noted as “USL” and “LSL”.



Other Information

- You can download the Control Chart Workbook at the State Materials Office website:
 - <http://www.fdot.gov/materials/pavement/asphalt/fieldoperations/worksheets/worksheetshome.shtm>
 - The charts print landscape, two per page.
 - If you have any problems or questions, you can contact Curtis Curl at the State Materials Office.
 - E-mail: Curtis.Curl@dot.state.fl.us
 - Phone: (352) 955-6646
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