

ANNUAL BATCH PLANT CONCRETE PROCESS CONTROL PLAN PART 1 OF 2

DATE: _____

READY MIX CONCRETE COMPANY: _____

READY MIX COMPANY LOCATION: _____

<i>All qualified TDOT Level 2 or higher qualified Concrete Technicians shall be listed in this section or on attached sheets. Include every technician that will be working on this project and update as needed.</i>	NAME:	CERT.#
	NAME:	CERT.#
	NAME:	CERT.#
	NAME:	CERT.#

We hereby propose to utilize the below listed process controls to insure that the concrete delivered to the above referenced project meets Tennessee Department of Transportation Specifications. If approved, this plan will be posted at the concrete plant along with approved mix designs for each particular project.

The following Sampling, Testing, and Inspections will be performed by T.D.O.T. Certified Plant Technicians.

- 1.) Tests to determine aggregate gradations (AASHTO T-27 with T-11 when required) will be performed prior to any batching and then a minimum of once per week or every 500 C.Y. for each source of aggregate utilized for this project. *Perform fineness modulus test on fine aggregate per AASHTO M-6 with each gradation.*
- 2.) Stockpiles will be checked daily to insure that they are being maintained in an uncontaminated and unsegregated manner. Current aggregate quality reports shall be kept on file at the plant.
- 3.) Calibration of weighing systems for aggregates, cement, fly ash, water meters, and admixture dispensing systems will be performed at the beginning of the project, then every month or as conditions warrant. Scale checks may be performed by a Certified Scale Company at a minimum interval of six (6) months.
- 4.) Assurance of accurate weighing, proper metering, and mixing of all materials and the quality of water will be verified daily.
- 5.) Mixing trucks and/or equipment, counters, concrete build - up in drums, blade wear, water gauges, etc. will be checked at the beginning of each project and randomly thereafter. Transport trucks shall be checked and approved by Tennessee Department of Transportation before use. The Producer shall update the concrete truck checklist every six (6) months and distribute to Regional Materials and Tests.

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- 6.) Adjustment of mix proportions due to the moisture content of both fine and course aggregates will be performed prior to initial daily mixing and again in the afternoon if operations are continuous through AM and PM hours of the day. Moisture determination will be in accordance with AASHTO-T255. Moisture Probes may be utilized but must be correlated and verified with a dry moisture check weekly.
- 7.) Slump (AASHTO T119), air entrainment (AASHTO T-152 - AASHTO T-196 for concrete containing light weight aggregates) and ambient air and mix temperatures shall be checked for specifications compliance on the initial load and randomly thereafter for each day's run. Air loss during transport shall be determined on initial loads and randomly verified thereafter. **When Self-Consolidating Concrete (SCC) is being batched; the slump flow, visual stability index (VSI), T50 (ASTM C1611), and passing ability (ASTM C1621) shall be within the specifications.**
- 8.) If Class "D" Concrete is included in the plans, SOP 4-1 is applicable. The Producer/Contractor shall check slump and air at the plant initially and randomly throughout pour to assure that the requirements are met.
- 9.) An approved report will be furnished daily to the project supervisor showing all pertinent information. Records of tests and inspections that are project specific and not included on the daily reports are to be maintained and submitted to the project supervisor upon project completion. Documents that are plant and lab specific shall be maintained at the plant systematically.
- 10.) *An approved delivery ticket will accompany each load sent to the project. All information including actual batch weights of each component identified as well as other information in the Standard Specification shall be identified on the delivery ticket.*

The above scheduled frequencies of testing are a minimum. Should problems become evident, they will be increased as the conditions require.

Sign Name: _____
Representative Concrete Supplier

Print Name: _____
Representative Concrete Supplier