

Roads

Master Specification

RD-BP-S2 Supply of Asphalt

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RD-BP-S2 Supply of Asphalt

1 General

- 1.1 This Part specifies the requirements for the supply of Hot Mix Asphalt (HMA), with and without an Additive, and Warm Mix Asphalt (WMA) including the design and manufacture of the following:
 - a) Coarse Dense Mix Asphalt (AC10, AC14);
 - b) Fine Dense Mix Asphalt (FineAC7, FineAC10, & FineAC14);
 - c) Open Graded Asphalt (OG10 & OG14); and
 - d) Stone Mastic Asphalt (SMA7 & SMA10).
- 1.2 In the event of any inconsistency, ambiguity, or discrepancy between any of the Contract Documents, the following order of precedence will apply:
 - a) this Part;
 - b) Austroads: Guide to Pavement Technology Part 4B: Asphalt;
 - c) AS 2150 "Hot Mix Asphalt - A Guide to Good Practice"; and
 - d) industry documentation.
- 1.3 Documents referenced in this Part are listed below:
 - a) Austroads Guide to Pavement Technology Part 4B: Asphalt.
 - b) AS 2150 Hot Mix Asphalt - A Guide to Good Practice.

1.4 The following definitions apply to terms used in this Part:

Table RD-BP-S2 1-1 Definitions

Term	Definition
AfPA	Australian Flexible Pavement Association
AC	Coarse Asphalt Mix. Asphalt of a coarse nature suitable for Medium, Heavy and Very Heavy Duty applications unless used in Fine Asphalt Mix applications or expressly noted otherwise.
Additive	An organic, chemical, or emulsion product used to assist in the compaction of asphalt.
Asphalt Mix Design Assessment	A documented assessment of a submitted asphalt mix design with an Asphalt Mix Register Number provided by the Department.
Asphalt Mix Register Number	A mix approval number provided by the Department to an accepted nominated mix. All mixes are placed on the Department's Asphalt Mix Register and monitored by the Department.
FineAC	Fine Asphalt Mix. Asphalt of a fine nature suitable for Light to Medium Duty applications and suitable for Department patch maintenance, bikeways, footpaths, car parks and Local Government residential streets.
HMA	Hot Mix Asphalt. Asphalt Mix manufactured and compacted at standard temperatures. It may also mean Hot Mix Asphalt manufactured at standard temperatures but with the addition of an "Additive" to assist in meeting compaction requirements and required to be registered as a different mix.
Nominated Binder Content	The Contractor's target design binder content for the Nominated Mix.
Nominated Combined Aggregate Grading	The Contractor's target design gradings for the Nominated Mix.
Nominated Mix	An asphalt mix design proposed by the Contractor.
Process Control	A controlled documented system of practices and procedures used to monitor and control the product inputs, equipment, and manufacturing processes to ensure the product replicates the product design.
Production Mix	Manufactured product at an asphalt plant.
RAP	Reclaimed Asphalt Pavement.
RCG	Recycled Crushed Glass
SDS	Safety Data Sheets.
Special Process	The Contractor's documented and demonstrated techniques to achieve the requirements of this Part.
WMA	Warm Mix Asphalt. Hot Mix Asphalt manufactured and compacted at lower temperatures with the addition of an "Additive" or by using the foaming technique.

2 Quality Requirements

Process Control

2.1 The Contractor shall develop and implement a Process Control System. The following requirements shall be submitted to the Department for the asphalt plant to obtain approved process control:

- monthly RAP & Asphalt Production test results in electronic spreadsheet format;
- audit samples;
- monthly process control charts and invitation to process control meeting; and
- monthly asphalt plant computing data outputs to match with samples being taken.

Quality Plan, Procedures and Documentation

- 2.2 Further to the requirements of PC-QA1 "Quality System Requirements", the Contractor shall prepare and implement a Quality Plan that at a minimum, includes detailed procedures and documentation for:
- a) Mix Design.
 - b) Manufacture of Mixes.
 - c) The asphalt production plant, including company brand, mixing type, capacity, year of manufacturing, functionalities, special abilities, silos, computer control system and production history.
 - d) The laboratory NATA Accreditation certificate, approved tests, and calibration schedule.
 - e) Process control requirements, which include a description of the flow of materials and the processes carried out on them from input materials to the plant through to delivery of asphalt to the customer. It shall incorporate a flow diagram and identification of the key elements of the manufacturing process requiring monitoring, measurement, or verification.
 - f) Control of aggregates transferred from quarry stockpiles and delivered to an asphalt plant.
 - g) Control of glass aggregate.
 - h) Control of Reclaimed Asphalt Pavement (RAP) transferred from stockpiles and delivered to an asphalt plant.
 - i) Requirements for labelling of storage bays, silos, and bituminous tanks.
 - j) Requirements for heating, temperature control and insulation of tanks.
 - k) Requirements for controlling delivery of binders into the correct tanks.
 - l) Control requirements for binders, foam, additives, admixtures, fillers, and reclaimed asphalt.
 - m) Plant calibration and maintenance.
 - n) Description of the characteristics of any hot storage system and define its mode of operation.
 - o) Handling, storage, and delivery of asphalt mixture to ensure the minimum of segregation, degradation or binder drain down and that the asphalt remains within the specified temperature range.
 - p) An Inspection and Test Plan, vide Clause PC-QA1.6 "Inspection and Testing", which includes a schedule for monitoring and measuring the performance of the process (as identified in the key process element identification) and products. At a minimum, it shall meet the requirements of Clauses 6 "Production Sampling and Testing", Clause 7 "Property Variations of Production Asphalt" and Appendix 1: Asphalt Inspection Test and Verification.
 - q) Constant monitoring and statistical analysis of records to verify process capability and product characteristics.
 - r) A Calibration Schedule, which includes daily visual inspection of all equipment and calibration of weighting equipment, admixture dispensers, flow meters, batching or proportioning systems and temperature monitoring equipment (vide PC-QA1.6.4 "Inspection, Measuring and Test Equipment"). At a minimum, it shall meet the requirements of Appendix 1: Asphalt Inspection Test and Verification.
- 2.3 If not provided previously the procedures and documentation shall be submitted at least 10 days prior to the commencement of supply.
- 2.4 Provision of the procedures and documentation listed in this Clause shall constitute a **Hold Point**.
- 2.5 The Contractor shall use test procedures in accordance with Table RD-BP-S2 10-1 (refer https://www.dit.sa.gov.au/materials_technology_documents/test_procedures2) to verify conformance to this Part.

3 Materials

Quality of Materials

3.1 Materials shall comply with the following:

- | | |
|--|--|
| a) Binder, Flux and Cutter | RD-BP-S1 "Supply of Bituminous Materials" |
| b) Aggregate, Sand, Recycled Glass Aggregate, and Mineral Filler | RD-PV-S1 "Supply of Pavement Materials" |
| c) Tack Coat | AS 1160 Bitumen Emulsions for Construction and Maintenance of Pavements |
| d) AS 2157 Cutback Bitumen | |
| e) Hydrated Lime Filler | AS 1672.1 Limes for Building. |
| f) Rejuvenating Agent | Rejuvenating agent shall comply with recognised standards for such materials. Diesel is not considered a suitable rejuvenating agent. Rejuvenation agent shall be fully disclosed for mix assessment including submission of Safety Data Sheets. |

Reclaimed Asphalt Pavement Material

- 3.2 Reclaimed asphalt pavement material (RAP) shall be obtained from milling or excavation of existing asphalt pavements or asphalt plant waste.
- 3.3 For the use of RAP within asphalt mixes the Contractor's Quality Plan shall include a Reclaimed Asphalt Pavement Management Plan and Industry Code of Practice meeting the following minimum requirements:
- RAP shall be crushed and screened as necessary to ensure a maximum size no greater than the maximum size of asphalt being produced and to achieve a reasonably well graded, free flowing, and consistent product.
 - The processed RAP of each size shall be placed in separate stockpiles not exceeding 1,000 tonne and represent a lot. Each lot shall be tested for binder content, gradings, viscosity and moisture content at a minimum of one per lot. Test results shall be traceable to the asphalt mix containing the RAP. Alternatively, viscosity testing can be carried out on final mix on a regular basis sufficient to demonstrate viscosity is within the target range for binder type targeted (excluding polymer modified binders).
 - RAP that has been stockpiled for some time and has bound together in some way shall be reprocessed, to ensure that it is in a free flowing state at the time of use.

4 Mix Requirements

- 4.1 Mix requirements shall comply with the requirements of the latest edition of AUSTROADS 4B, except as varied below.

Nominated Mixes

- All submissions of nominated mixes shall be in accordance with Appendix 2: Assessment and Registration of Asphalt Mix Designs.
- The Contractor shall submit to the Department details of each approved asphalt mix proposed before commencing production / placement of asphalt.
- Submission of the details of nominated mixes and Certificate(s) shall constitute a **Hold Point**.

Compliance of Nominated Mixes

- 4.5 If the Contractor has a current Asphalt Mix Register Number and the mix has not been varied in accordance with Clause 4 "Variations to Nominated Mixes", the following shall be submitted:

- a) description of the Job Mix Formula (JMF); and
 - b) a copy of the latest Asphalt Mix Design Assessment.
- 4.6 Submission of the above information shall constitute a **Hold Point**.
- 4.7 The Contractor shall monitor the production results of all its registered mixes, and shall submit a summary of previous mix production data for the submitted mix and to include:
- a) plot of voids verses binder content, max density verses binder content;
 - b) summary sheet of JMF data in an electronic spreadsheet format;
 - c) process control plots of binder content, max density, production voids & in-situ voids; and
 - d) summary of associated non-conformances and dispositions.
- 4.8 Where the analysis of the production test data shows that the Design Air Voids Target requires a different binder content to the nominated binder content, an alternative mix design shall be submitted.

Variations to Nominated Mixes

- 4.9 The Contractor shall submit a new nominated mix in compliance with Clause 4 “Nominated Mixes” if:
- a) the Contractor proposes to vary the proportions of the constituents in a nominated mix;
 - b) the Contractor proposes to change the source of supply of any constituent; or
 - c) the Asphalt Mix Register Number is withdrawn by the Department.

Mobile Plants

- 4.10 The Contractor shall submit the asphalt mix history (including mix production data) and details of the nominated mobile plant in accordance Clause 2 “Quality Requirements”.
- 4.11 Plant settings and mix design parameters shall be met before proceeding with the permanent works and shall constitute a **Hold Point**.
- 4.12 A proposal to use plant fuel other than Liquefied Petroleum Gas (LPG), Liquefied Natural Gas (LNG), petrol or diesel shall constitute a **Hold Point**.

Asphalt Mix Applications

- 4.13 Standard mix for road pavements shall use AC10 coarse dense mix asphalt with either A15E to Medium Duty design or A5E to Light Duty design for wearing course. Generally, C320 shall be used (or C170 with aged binder from RAP) for all other layers unless a modified binder is required, using either AC10 or AC14 mixes.
- 4.14 Heavy duty mixes for road pavements shall use AC10 coarse dense mix asphalt with A5E modified binder at either Medium or Light Duty designs for wearing course and levelling courses. Generally, C320 shall be used (or C170 with aged binder from RAP) for all other layers unless a modified binder is required, using either AC10 or AC14 mixes as required.
- 4.15 Light Duty road pavements shall use Fine Dense mix asphalt to Light Duty design with C170 binder. Class C320 may also be used subject to approval.

Wearing Course

- 4.16 All wearing course layers shall contain at least 1% added hydrated lime. A levelling course that is trafficked more than 30 days is deemed to be a wearing course.
- 4.17 Design of asphalt mixes shall also meet the requirements of RD-BP-D4 “Surface Characteristics”.

Coarse Dense Mix Asphalt

- 4.18 Mix properties for the design and production control of coarse dense mix asphalt excluding RAP shall meet the requirements of Table RD-BP-S2 4-1. The grading envelopes shall meet the requirements

of Table RD-BP-S2 4-2 and production tolerances on grading and binder content shall comply with Table 11 in AS 2150.

Table RD-BP-S2 4-1 Mix Properties of Coarse Dense Mix Asphalt

Characteristic		Gyratory Cycle No.	AC10	AC14	AC14HB
Nominal Mix Sieve Size (mm)			9.5	13.2	13.2
Design & Production Air Voids Target (%)	Medium Duty ⁽¹⁾ (MD)	80	4.0	4.0	2.5
	Light Duty ⁽¹⁾ (LD)	50	4.0	4.0	-
Production Air Voids Tolerance (%)			Target ± 1.5	Target ± 1.5	Target ± 1.5
Binder Film Index (BFI) (µm) – Minimum	Medium Duty ⁽¹⁾ (MD)	80	8.5	8.5	10.0
	Light Duty (LD)	50	9.5	9.5	-

Notes:

(1) Medium and Light Duty refers to Austroads definitions for number of Gyratory Gyropac cycles, not extent of traffic loading.

Table RD-BP-S2 4-2 Coarse Dense Mix Grading Envelopes⁽¹⁾

Sieve	AC10		AC14 and AC14HB	
26.5				
19			100	100
13.2	100	100	92	80
9.5	92	80	83	67
6.7	82	66	70	54
4.75	70	52	60	43
2.36	48	34	42	28
1.18	34	21	30	19
0.6	24	14	21	12
0.3	17	8	16	7
0.15	11	5	10	6
0.075	7	4	6	3

Notes:

(1) Aggregate gradings with percentage passing sieve size (mm), in accordance with AS 1152.

Fine Dense Mix Asphalt

Mix properties for design and production control of fine dense mix asphalt excluding RAP shall meet the requirements of Table RD-BP-S2 4-3. The grading envelopes shall meet the requirements of

4.19 Table RD-BP-S2 4-4 and production tolerances on grading and binder content shall comply with Table 11 in AS 2150.

Table RD-BP-S2 4-3 Mix Properties of Fine Dense Mix Asphalt

Characteristic	Fine AC7	Fine AC10
Light Duty Design (Gyratory Cycles)	50 cycles	50 cycles
Nominal Mix Sieve Size (mm)	6.7	9.5
Minimum Binder Content (%)	6.0	5.7
Design & Production Air Voids Target (%)	4.0	4.0
Production Air Voids Tolerance (%)	Target ± 1.5	Target ± 1.5
Target In-situ Voids (%) (refer to Spec RD-BP-C3)	2.0 – 6.0	2.5 – 7.0
Binder film Index (µm) Minimum	8.0	8.0

Table RD-BP-S2 4-4 Mix Grading Envelopes of Fine Dense Mix Asphalt⁽¹⁾

Sieve	FineAC7		FineAC10	
13.2				100
9.5		100	100	90
6.7	100	90	90	75
4.75	90	75	77	63
2.36	65	51	56	43
1.18	47	35	41	30
0.6	33	23	29	20
0.3	22	15	20	13
0.15	14	9	13	8
0.075	8	5	8	5

Notes:

(1) Aggregate gradings with percentage passing sieve size (mm), in accordance with AS 1152.

Coarse / Fine Dense Mix Asphalt Including RAP

4.20 In addition to the requirements of this clause, Dense Mix Asphalt incorporating Reclaimed Asphalt Pavement shall meet the design requirements of Clause 4 "Coarse Dense Mix Asphalt" or Clause 4 "Fine Dense Mix Asphalt" and the following:

- a) for wearing course mixes, the proportion of RAP in the total mix shall not exceed 10% for "Coarse Dense Mix Asphalt" and 20% for "Fine Dense Mix Asphalt";
- b) for asphalt mixes with 10% RAP or less added, no added binder or rejuvenation is required;
- c) for all layers except wearing course, the proportion of RAP in the total mix shall not exceed 50%; excepted for asphalt mixes using polymer modified binders (PMB) shall not exceed 20%;
- d) for asphalt mixes with 10% or greater (5% increments) RAP content in the total mix, the actual percentage added shall be approved by the Department; and
- e) for asphalt mixes with higher than 10% RAP incorporation, use the following additional design components of binder rejuvenation:
 - i) extract RAP Binder to determine binder content and viscosity;
 - ii) the Resilient Modulus of RAP Mixes to be the same as equivalent Virgin Mixes in accordance with Table RD-BP-S2 14-2. Testing frequency is one test (a pair of production pat per sample) per 10 production samples per mix; and
 - iii) rejuvenating agent shall be a softer grade bitumen and low volatility oil (if required) capable of combining with bitumen to counteract hardening and produce a lower viscosity grade of binder.

4.21 Asphalt mixes with standard binder types reflects the design viscosity recommended. For mixes including added binder from RAP, softer binder class and or rejuvenator may be required to achieve the target viscosity.

Coarse / Fine Dense Mix Asphalt including Recycled Crushed Glass

4.22 In addition to the requirements of this clause, Dense Mix Asphalt incorporating Recycled Crushed Glass (RCG) shall meet the design requirements of Clause 4 "Coarse Dense Mix Asphalt" or Clause 4 "Fine Dense Mix Asphalt" and the following:

- a) RCG incorporated in asphalt shall be a 'Quarry Sand' substitute (or blend) and shall comply with RD-PV-S1 "Supply of Pavement Materials";
- b) for wearing course mixes, the proportion of RCG in the total mix shall not exceed 2.5%; and
- c) for all layers except wearing course, the proportion of RCG in the total mix shall not exceed 10%.

Open Graded Asphalt

4.23 The following applies to Open Graded Asphalt (OG):

a) mix properties for the design and production control shall comply with Table RD-BP-S2 4-5; the grading envelopes shall comply with

b) Table RD-BP-S2 4-6;

c) production tolerances on grading and binder content shall comply with Table 11 in AS 2150;

d) the design and production shall be to Medium Duty category (80 gyratory cycles);

e) binder type to be A15E;

f) cellulose fibres may be added to reduce binder drain down;

g) RAP content is not permitted; and

h) RCG content is not permitted.

Table RD-BP-S2 4-5 Mix Properties of Open Graded Asphalt

Characteristic	OG10	OG14
Nominal Mix Sieve Size (mm)	9.5	13.2
Hydrated Lime (%) – Minimum	1.0	1.0
Design Air Voids Target (%)	20	20
Production Air Voids Tolerance (%)	18 – 23	18 – 23
Binder Content Target (% by mass)	5.6	5.3

Table RD-BP-S2 4-6 Mix Grading Envelopes⁽¹⁾

Sieve	OG10		OG14	
19			100	100
13.2	100	100	100	85
9.5	100	85	70	45
6.7	65	35	45	25
4.75	45	20	25	10
2.36	20	10	15	7
1.18	14	6	12	6
0.6	10	5	10	5
0.3	8	4	8	4
0.15	7	3	7	3
0.075	5	2	5	2

Notes:

(1) Aggregate gradings with percentage passing sieve size (mm), in accordance with AS 1152.

Stone Mastic Asphalt

4.24 The following applies to Stone Mastic Asphalt (SMA):

a) mix properties for the design and production control shall meet the requirements of Table RD-BP-S2 4-7;

b) the grading envelopes shall meet the requirements of Table RD-BP-S2 4-8;

c) production tolerances on grading and binder content shall comply with Table 11 in AS 2150;

d) the design and production shall be to Medium Duty category (80 gyratory cycles);

e) binder type to be A5E, with A15E suitable for Light to Medium Duty traffic subject to approval;

f) minimum of 0.3% (by mass) cellulose fibre to reduce binder drain down shall be added and the nominated mix submission shall include details of the filler, fibre type and source;

- g) RAP content is not permitted; and
- h) RCG content is not permitted.

Table RD-BP-S2 4-7 Mix Properties of Stone Mastic Asphalt

Characteristic	SMA07	Fine SMA10
Nominal Mix Sieve Size (mm)	6.7	9.5
Hydrated Lime (%) – Minimum	1.0	1.0
Design Air Voids Target (%)	3.5	3.5
Production Air Voids Tolerance (%)	3.0 – 5.0	3.0 – 5.0
Binder Content Target (% by mass)	7.0	6.5
Binder Film Index (BFI) (µm) – Minimum	-	9.0

Table RD-BP-S2 4-8 Mix Grading Envelopes⁽¹⁾

Sieve	SMA7		SMA10	
13.2				100
9.5		100	100	90
6.7	100	85	55	30
4.75	62	30	40	20
2.36	35	20	28	15
1.18	28	16	24	13
0.6	24	14	21	12
0.3	20	12	18	10
0.15	16	10	14	9
0.075	12	8	12	8

Notes:

(1) Aggregate gradings with percentage passing sieve size (mm), in accordance with AS 1152.

Job Mix Formula

- 4.25 The nominated mix will be assessed by the Department for compliance with the requirements of this Part. An Asphalt Mix Design Assessment will be supplied to the Contractor and will incorporate:
- a) Mix Register Number.
 - b) Production grading tolerances.
 - c) A Job Mix Formula (JMF) comprising of Combined Grading, Binder Content, Max Density, Bulk Density, Design Target Air Voids, Binder Film Thickness, RAP Percentage, & Resilient Modulus.

5 Manufacture of Mixes

General

- 5.1 Mixes shall be manufactured to replicate the JMF in accordance with AS 2150, Clause 7 "Manufacturing and Storage of Mix".
- 5.2 Mixes shall not exhibit drainage of the binder and / or contain less than 95% of aggregate particles that are not fully coated with binder as determined by AS 2891.11.
- 5.3 Asphalt shall be manufactured so that its properties comply with the requirements specified in Clause 12 "Verification Requirements and Records".

Manufacturing Controls

- 5.4 Plant temperatures and mixing times shall be maintained in a range sufficient to ensure a homogenous mix without causing deleterious effects to the binder through overheating and within

the manufacturer's specifications as detailed in AAPA Advisory Note 7. The binder temperature used for storage / transport shall not exceed the values shown against the binder class indicated in Table RD-BP-S2 5-1.

Table RD-BP-S2 5-1 Maximum Binder Temperature

Binder Class	Max Temperature (°C)
170	180
320	185

- 5.5 The above maxima may be increased by up to 10°C when additives such as polymers or scrap rubber are incorporated in the binder.
- 5.6 Spray temperature of the binder into a pugmill type environment shall be such as to minimise oxidation or drainage of the binder.
- 5.7 The temperature of the mix delivered into each truck shall be recorded on the weigh note.

Manufacture of Mixes including RAP

- 5.8 In batch mixing plants, the RAP shall be either:
- metered into the asphalt plant after heating and drying of aggregates;
 - added directly to the weigh hopper with other aggregate materials, for each batch; or
 - weighed separately and added direct to the pugmill.
- 5.9 If necessary, batch mixing time shall be increased to ensure adequate heat transfer and dispersion of RAP. In drum mixing plants, RAP shall be protected from excessive temperatures by a combination of entry point to drum and shielding from direct flame contact.

Manufacture of Asphalt with Additive or Foaming Technique

- 5.10 Subject to prior approval, the Contractor may use an additive or foaming technique to manufacture:
- at standard temperatures but air and pavement placement temperatures are reduced in accordance with Clause 4.9 of RD-BP-C3 (HMA);
 - at standard temperatures but time until placement is extended and mix placement temperature reduced (HMA); or
 - asphalt at lower temperatures (WMA).
- 5.11 Where placement temperature is reduced, compaction requirements shall still be in accordance with RD-BP-C3 "Construction of Asphalt Pavements".
- 5.12 The Contractor shall provide the testing temperature of gyratory compaction when additives or foaming technique are used in accordance AS2891.2.2:2014.
- 5.13 The propriety product of the additive used shall be fully disclosed in accordance with Clause 4 "Nominated Mixes".

6 Production Sampling and Testing

General

- 6.1 The Contractor shall conduct sampling and testing of asphalt and binder for control and verification purposes during manufacture. Minimum sampling and testing frequency for each mix type in a 24 hour period shall be as shown in Table RD-BP-S2 6-1.

Table RD-BP-S2 6-1 Asphalt Sampling and Testing Frequency

Sampling & Testing Frequency	Fixed Asphalt Plant and Approved ⁽¹⁾ Process Control (tonne)	Fixed Asphalt Plant without Approved ⁽¹⁾ Process Control (tonne)	Mobile Asphalt Plant (tonne)
1	50 – 200	50 – 150	0 – 30
2	Additional sample / test each 300 tonne >200	151 – 300	31 – 100
3		301 – 500	101 – 250
4		Additional sample / test each 300 tonne >500	251 – 400
5			Additional sample / test each 300 tonne >400

Notes:

(1) As documented in Asphalt Mix Design Assessment.

- 6.2 For Fine Dense Mixes meeting the requirements in this Part, sample rate is one per lot (a lot defined as a day's production).
- 6.3 For Coarse Dense Mixes, Stone Mastic Asphalt & Open Graded Asphalt meeting the requirements of this Part, sample rate is in accordance Table RD-BP-S2 6-1.
- 6.4 The following tests & calculations shall be performed and reported on each production sample:
- Combined Grading;
 - Binder Content - various test methods allowed, with AS2891.3.3 to be used in any auditing or dispute resolution;
 - Maximum Density;
 - Bulk Density;
 - Air Voids;
 - Binder Film Index (BFI).
- 6.5 Test results and calculations of production mix shall be supplied to the Principal within 24 hours.

Audit Samples

- 6.6 The Contractor shall provide audit samples using the Department's random selection template for product auditing purposes in accordance MAT-PC063 "Random Sample Template" for the following:

Asphalt

- From each production mix sample, the Contractor shall provide a single sample (6L tin) of a minimum 11 kg asphalt for retention by the Department. These samples may be used for product auditing purposes. The Contractor shall submit asphalt audit samples using Random Sample Template (selection rate of 1 in 2 or otherwise as directed).

Asphalt for Performance Testing

- The Contractor shall combine all audit samples per mix type (from "Asphalt" above) that are not required for other auditing purposes, and prepare bulk samples for performance testing. All production reports for each audit shall remain with the bulk sample.

Residual Bitumen

- The Contractor shall provide one sample per type per delivery (minimum of 1 Litre) for product auditing purposes. Audit samples are not required where a Department arrangement exists.

Polymer Modified Binder

- d) The Contractor shall provide one sample per type per delivery (minimum of 1 Litre) for product auditing purposes.
- 6.7 All samples shall be delivered to the Department's Materials Laboratory at 19 Bridge Road, Walkley Heights at a minimum of monthly intervals, or as requested by the Principal. The Contractor may dispose remaining random asphalt samples after a minimum of 30 days.
- 6.8 All samples shall be a minimum of 11 kg and clearly labelled on the side of the container in clear indelible ink or paper sticker and shall include: materials, mix type, sample number, date of sampling and asphalt mix design register number and project.
- 6.9 The samples will be stored at the Department's expense. The Contractor shall provide documentation to confirm that the samples have been received at the Department's Laboratory, and submit this as part of the lot package. All samples shall be clearly marked and traceable to the relevant lot in accordance with PC-QA1 "Quality System Requirements".

7 Property Variations of Production Asphalt

- 7.1 In replicating the JMF properties, production mix variations shall not exceed the limits shown in Table 11 of AS 2150.
- 7.2 Variations of the Production Air Voids from the Design Air Voids Targets shall not exceed the Limits of Production Air Voids Tolerance in:
 - a) Table RD-BP-S2 4-1;
 - b) Table RD-BP-S2 4-3;
 - c) Table RD-BP-S2 4-5; and
 - d) Table RD-BP-S2 4-7.
- 7.3 The Contractor shall ensure that the moisture content of production asphalt is less than 0.2%.

8 Storage of Asphalt

- 8.1 Asphalt shall be stored in accordance with AS 2150, Section 7.5 "Storage of Mix".

9 Delivery of Mix

- 9.1 Mix shall be transported to site in a manner which does not result in a deterioration of the properties of the mix or contamination of the mix. The Contractor shall ensure that transport operations are arranged in a manner which ensures continuous placing of asphalt. If haulage distance is measured for the purpose of payment, the haulage distance shall be calculated from the Nominated Asphalt Plant which is closest to the work site, regardless of whether it is sourced from any other plant for any reason (including breakdown). The haulage distance includes the loaded trip only and excludes the return trip.

10 Test Procedures

10.1 The Contractor shall use the following test procedures (refer https://www.dit.sa.gov.au/contractor_documents) to verify conformance with the Specification:

Table RD-BP-S2 10-1 Test Procedures

Test	Test Procedure
Sampling of Raw Materials:	
- Aggregates & Processed RAP	TP 226
- Bitumen & Polymer Modified Binder	AS 2008
- Mineral Filler	TP 226
Sampling of Asphalt	TP 425
Compaction of Asphalt Test Specimens using a Gyratory Compactor	TP 428
Determination of the Maximum Density of Asphalt - Water Displacement Method (Duplicate sample testing not required)	AS 2891.7.1
Bulk Density of Compacted Asphalt Specimens:	
- Presaturation Method for Dense Graded and SMA	AS 2891.9.2 AS
- Bitumen & Polymer Modified Binder	2891.9.3
Measurement of Thickness or Height of Compacted Asphalt	ASTM D3549
Voids - Calculation	AS 2891.8
Binder Film Index - Calculation	AS 2891.8
Binder Content - Pressure Filtration Method	AS 2891.3.3
Binder Content - Reflux Method	AS 2891.3.1
Binder Content - Centrifugal Extraction	AS 2891.3.2
Binder Content - Ignition Oven	AGPT/T234
Stripping Potential of Asphalt – Tensile Strength Ratio (TSR)	AGPT/T232
Extractions of Bituminous Binder from Asphalt	AGPT/T191
Design of Bituminous Binder Blends to a Specified Viscosity Value	AGPT/T193
Characterisation of the Viscosity of RAP Binder using the Shear Rheometer (DSR) Asphalt Binder Viscosity	AGPT/T192 TP 664
Asphalt Particle Loss	AGPT/T236
Asphalt Binder Drain-Off	AGPT/T235
Particle Size Distribution by Dry Sieving	AS 1141.11
Voids in Dry Compacted Fillers	AS 1141.17
Moisture Content	AS 2891.10
Specific Surface	AS 2350.8
Loss on Ignition AS 3583.3 Water Soluble Fraction of Filler	AS 1141.8
Deformation Resistance of Asphalt Mixtures by the Wheel Tracking test	AGPT/T231
Fatigue Life of Compacted Bituminous Mixes Subject to Repeated Flexural Bending	TP477
Determination of the Resilient Modulus of Asphalt – Indirect Tensile Method	AS2891.13.1

11 Hold Points

11.1 The following is a summary of Hold Points referenced in this Part:

Table RD-BP-S2 11-1 Hold Points

Document Ref.	Hold Point	Response Time
2.4	Submission of Quality Plan (if not provided previously)	20 Working Days
4.4	Submission of the details of Nominated Mixes and Certificate(s)	20 Working Days
4.6	Submission of Job Mix Formula	15 Working Days
4.11	Submission of Trial mix data from a mobile plant	As required
4.12	Submission of proposal to use plant fuel	As required

12 Verification Requirements and Records

Test Records & Verification for Asphalt Mix Design Initial Assessment

12.1 The Contractor shall undertake the testing specified in this Part and Table RD-BP-S2 14-4, and shall supply written evidence of compliance.

Test Records & Verification for Plant Production

12.2 The Contractor shall undertake the testing specified in this Part and Table RD-BP-S2 13-1, and shall supply written evidence of compliance within the lot package.

Table RD-BP-S2 12-1 Plant Production Testing

Document Ref.	Subject	Property	Test Procedure	Test Frequency	Acceptance Limits
5.4 to 5.7	Manufacturing Controls	Temperature at manufacture	Thermometer reading or infrared gun	Each truckload	Refer Clause 5.4 to 5.7 "Manufacturing Controls"
6	Production Sampling & Testing	Binder Content & Combined Grading	AS 2891.3.3	Refer Clause 6 "General"	Refer Clause 4 "Mix Requirements" and Asphalt Mix Design Assessment
		Bulk Density	AS 2891.9.2 AS 2891.9.3	Refer Clause 6 "General"	Report Only
		Absorption of Compacted Specimens	AS 2891.9.2	Refer Clause 6 "General"	≤ 2.0% for AC20 ≤ 1.0% for SMA
		Maximum Density	AS 2891.7.1	Refer Clause 6 "General"	Report Only
		Voids on Compacted Specimens	AS 2891.8	Refer Clause 6 "General"	Refer Clause 4 "Mix Requirements" and Asphalt Mix Design Assessment
		Binder Film Index (BFI) ⁽¹⁾	AS 2891.8	Refer Clause 6 "General"	Refer Clause 4 "Mix Requirements"
		Resilient Modulus	AS2891.13.1	Refer Clause 6 "General"	Report only

Notes:

(1) Absorption for RAP component assumed to be zero.

13 Appendix 1: Asphalt Inspection Test and Verification

Table RD-BP-S2 13-1 Plant Inspection Schedule

Control Area	Inspection / Test	Purpose	Frequency
Cold feed bins	As set out in quality plan	To ensure correct feeding of plant	a) On installation. b) As set out in quality plan.
Dryer Drum	As set out in quality plan	To ensure correct heating and drying of aggregates	As set out in quality plan
Hot feed bins	As set out in quality plan	To ensure correct batching	As set out in quality plan
Binder	Tank temperature Penetration or softening point	To check storage temperature To check for binder hardening ⁽¹⁾	a) Daily b) In case of doubt
Additive Silos	As set out in quality plan	To ensure correct feed rates for additives	As set out in quality plan
Mixed asphalt	Temperature	To ensure temperature conforms	a) Every batch or continuously

Notes:

- (1) Binder can harden during storage, particularly when circulated. The Quality Plan should state the "safe" storage period for binder in its tank configuration and require testing if that period is exceeded without fresh deliveries. In the absence of other information, a period of two weeks should be adopted.

Table RD-BP-S2 13-2 Inspection and Test Frequencies for Additives⁽²⁾

Inspection / Test	Purpose	Frequency
Appropriate tests to determine intrinsic properties	To confirm characteristics of product or check compliance with specification	a) Source approval prior to initial use b) As stated in the quality plan
Inspection of delivery ticket	To check that consignment is as ordered and from the correct source	Each delivery
Organoleptic check of consignment	For comparison with normal appearance	Each delivery, if practicable; otherwise in accordance with quality plan

Notes:

- (2) This table may include the results of tests and inspections by the additive supplier as part of the Process Control System.

Table RD-BP-S2 13-3 Inspection / Test Frequencies for Asphalt to be Delivered

Product Inspection / Test	Purpose	Frequency
Organoleptic check on mixed asphalt	For comparison with normal appearance with respect to grading, evenness of mixing and adequacy of coating	Every load
Temperature	To ensure material conforms with Clause 5 or other requirements	a) As required under Process Control b) Whenever samples are taken
Grading, Binder Content, Voids, Maximum Density and Binder Film Index	To ensure material conforms to Clause 4	
Other design characteristics	To assess conformity	As detailed in quality plan
Suitability of delivery vehicles by visual assessment	To check adequacy of insulation	Prior to first use and in case of doubt
Cleanliness of delivery vehicles by visual assessment	To avoid contamination	Every load prior to loading

Table RD-BP-S2 13-4 Plant Calibration Requirements

Item of Plant	Inspection / Test	Purpose	Minimum Frequency
Weighing Equipment	Visual Inspection	To ascertain that weighing equipment is functioning properly	Daily
	Testing of weighing accuracy	To ensure accuracy within quality plan requirements	a) On installation ⁽³⁾ b) Annually c) In case of doubt
Admixture Dispensers	Organoleptic inspection	To ascertain that the dispenser is functioning correctly	First batch of the day containing admixture
	Test for accuracy	To ensure accuracy within quality plan requirements	a) On installation ⁽³⁾ b) Annually c) In case of doubt
Flow Meters	Comparison of the actual amount with the metered amount by reconciliation	To ensure accuracy within quality plan requirements	a) On installation ⁽³⁾ b) Annually c) In case of doubt
Batching Systems (on batch plants)	Comparison of actual mass of constituents in the batch with the intended mass using the method prescribed in the quality plan	To ascertain the batching accuracy in accordance with the quality plan	a) On installation ⁽³⁾ b) Annually c) In case of doubt
Batching Systems (on continuous plants)	Comparison of actual mass of constituents in the batch with the intended mass using the method prescribed in the quality plan	To ascertain the batching accuracy in accordance with the quality plan	a) On installation ⁽³⁾ b) Annually c) In case of doubt
Temperature Monitoring Equipment	Visual	To ascertain the equipment is function correctly	Daily
	Test of accuracy	To ensure correct temperatures are recorded	a) On installation ⁽³⁾ b) Annually c) In case of doubt

Notes:

(3) Or after comprehensive repair.

14 Appendix 2: Assessment and Registration of Asphalt Mix Designs

Submission

14.1 The Contractor shall submit the mix design together with supporting documentary evidence and laboratory and plant test results for mix and material properties to the Department.

14.2 The following details of Nominated Mix (NM) shall be submitted:

a) Constituent materials:

- i) Aggregates - source, geological type;
- ii) Added Mineral Filler - type, source;
- iii) Binder - source, class or grade;
- iv) Bitumen Adhesion Agent - name, type, source, SDS; and
- v) relevant test results verifying material properties for the above mentioned materials.

b) Mix Design:

- i) design mix maximum density;
- ii) nominated combined aggregate grading and binder content;
- iii) test results of the properties in tables of Clause 4 – “Mix Requirements” of each nominated mix;
- iv) details of mixing plant location, description capacity, history and any relevant information in accordance Clause 2 – “Quality Requirements”;
- v) test results of representative material of each nominated mix produced by the mixing plant from which the asphalt is to be supplied; and
- vi) manufacturer’s instructions of any additive including submission of SDS.

Table RD-BP-S2 14-1 Nominated Mixes - Testing Requirements

Characteristic ⁽¹⁾	FineAC7	FineAC10	AC10	SMA7	SMA10	AC14	OG10	OG14
Gyropac Gyrotory Compaction								
Raw Aggregate Grading – Individual Sizes (%)	YES	YES	YES	YES	YES	YES	YES	YES
Total Aggregates, Sand & Fillers Absorption (%)	YES	YES	YES	YES	YES	YES	YES	YES
Mix Design Proportions	YES	YES	YES	YES	YES	YES	YES	YES
Combined Gradings (%)	YES	YES	YES	YES	YES	YES	YES	YES
Maximum Density (t/m ³)	YES	YES	YES	YES	YES	YES	YES	YES
Voids (%)	YES	YES	YES	YES	YES	YES	YES	YES
Binder Content (%)	YES	YES	YES	YES	YES	YES	YES	YES
Binder Film Thickness (BFT) (µm)	YES	YES	YES	YES	YES	YES	NO	NO
Tensile Strength Ratio (TSR) ⁽³⁾ (%)	YES	YES	YES	NO	NO	YES	NO	NO
RAP (%) and Viscosity Treatments	YES	YES	YES	NO	NO	YES	NO	NO
Viscosity (pa.s) ⁽²⁾	YES	YES	YES	NO	NO	YES	NO	NO

Notes:

- (1) Including asphalt dense mixes containing RAP and WMA.
- (2) For asphalt dense mixes containing RAP in accordance Clause 4 "Coarse / Fine Dense Mix Asphalt Including RAP".
- (3) Tensile Strength Ratio testing shall be added to laboratory mix design for mobile plants and shall exceed 75%.

14.3 Testing shall be carried out on representative material of each NM progressively of:

- a) laboratory prepared mix; and
- b) plant prepared mix from which the asphalt is to be applied.

14.4 When requested, the Contractor shall submit a sample of 100 kg of loose asphalt of the nominated mix for verification of performance testing undertaken by the Department.

Nominated Mix Performance Test Requirements

14.5 The Contractor shall conduct testing on plant produced mix upon receipt of Asphalt Mix Design Assessment in accordance with Table RD-BP-S2 14-2 & Table RD-BP-S2 14-3.

Table RD-BP-S2 14-2 Nominated Mixes - Mix Performance Test Properties⁽¹⁾⁽²⁾

Asphalt Mix Characteristic		Wheel Tracking	Flexural Fatigue Department: TP477	Flexural Modulus Department: TP477	Resilient Modulus ⁽¹⁾
No.	Mix Type (including RAP & WMA)	AG:PT/T231 (mm)	Minimum MICRO-STRAIN @ 1 Million Cycles ⁽³⁾	@ 25°C & 10 Hz (Mpa)	AS2891.13.1 (MPa) ±1,000 MPa
1	AC10M320	3.0 ≤ WT ≤ 6.0	180 με	-	4,800 MPa
2	AC14M320	3.0 ≤ WT ≤ 6.0	170 με	-	4,600 MPa
3	AC14M320H	≥ 6.0	200 με	-	5,000 MPa
4	AC10L5E	≤ 3.0	265 με	-	4,300 MPa
5	AC10M15E	≤ 4.0	330 με	-	2,400 MPa
6	AC14M15E	≤ 4.0	310 με	-	2,500 MPa
7	AC10M5E	≤ 2.0	225 με	-	6,500 MPa
8	AC14M5E	≤ 2.0	200 με	-	6,600 MPa
9	SMA7M15E	-	-	-	-
10	SMA10M15E	≤ 3.0	350 με	-	2,000 MPa
11	SMA10M5E	≤ 3.0	250 με	-	5,000 MPa

Notes:

- (1) Minimum Testing Frequency (per Calendar Year). The Contractor shall carry out performance testing if the total asphalt amount is greater than 5,000 t per mix per calendar year and for special asphalt mixes including SMA10 or as requested by the Department's Asphalt Engineer. The Contractor shall also carry out additional performance testing for every 20,000 t per mix per calendar year.
- (2) Test results are for the Department's engineers only, are report only, and values given are provided as a guide.
- (3) Final strain value shall be reported as peak to neutral axis.

14.6 The Nominated Mixes shall be tested as required by Table RD-BP-S2 14-3 and to meet the requirements of Table RD-BP-S2 14-2.

Table RD-BP-S2 14-3 Nominated Mixes - Testing Requirements

Characteristic ⁽¹⁾	FineAC7	FineAC10	AC10	AC14	SMA7	SMA10	OG10	OG14
Gyratory Compaction								
Tensile Strength Ratio (TSR) (%)	NO	NO	YES	YES	NO	NO	NO	NO
Slab Compaction								
Resilient Modulus	NO	NO	YES	YES	YES	YES	NO	NO
Flexural Fatigue and Modulus	NO	NO	YES	YES	YES	YES	NO	NO
Wheel Tracking	NO	NO	YES	YES	YES	YES	NO	NO

Notes:

- (1) Including asphalt dense mixes containing RAP and WMA.

Asphalt Mix Design Assessment Progression

14.7 The following general stages apply to an asphalt mix design:

- a) laboratory assessment;
 - b) plant production assessment;
 - c) performance testing assessment; and
 - d) field inspection (for surface course mixes).
- 14.8 On an ongoing basis, the following applies to an asphalt mix design:
- a) plant production assessment including process control monitoring; and
 - b) performance testing on a minimum yearly basis.
- 14.9 If at any stage the Department deems a mix to be unsatisfactory, the registration may be withdrawn as indicated in Clause 4 "Variations to Nominated Mixes".

Laboratory Assessment

- 14.10 The laboratory mix design shall incorporate the requirements of Clause 4 including following minimum requirements:
- a) design grading curve based on raw aggregate gradings;
 - b) five point binder content verses voids laboratory analysis (washout binder content not required) using standard bitumen;
 - c) determination of design binder content at required target air voids;
 - d) provision of all Clause 4.25 requirements; and
 - e) plant trial of mix to verify aggregate gradings and design binder content,
- 14.11 The Contractor shall undertake the testing specified in this Part and Table RD-BP-S2 14-4, and submit the mix design together with supporting documentary evidence and laboratory and plant test results for mix and material properties to the Department.

Table RD-BP-S2 14-4 Initial Mix Design Testing

Ref.	Subject	Property	Test Procedure	Test Frequency	Acceptance Limits
3.1	Materials for Asphalt	Binder, Flux and Cutter	Refer Clause 3.1	Refer Clause 3.1	Refer Clause 3.1
		Aggregate, Sands & Mineral Filler	Refer Clause 3.1	Refer Clause 3.1	Refer Clause 3.1
		Hydrated Lime	Refer Clause 3.1	Refer Clause 3.1	Refer Clause 3.1
3.2	Reclaimed Asphalt Pavement Material (RAP)	Binder Content (wash out) & Grading	AS 2891.3.3	Refer Clause 3.3	Report Only
		Asphalt Binder Viscosity	TP 664	Refer Clause 3.3	Report Only
		Moisture Content	AS 1289.B1.3	Refer Clause 3.3	Report Only
4	Mix Requirements	Total Absorption by Combined Agg.	AS 2891.9.2	Refer Clause 14	Report Only
		Mix Design Proportions	Refer PC044	Refer Clause 14	Report Only
		Binder Content & Combined Grading	AS 2891.3.3	Refer Clause 14	Refer Clause 4.3, 4.4, 4.6 & 4.7 and Asphalt Mix Design Assessment
		Bulk Density	AS 2891.9.2 AS 2891.9.3	Refer Clause 14	Report Only
		Absorption of Compacted Specimens	AS 2891.9.2	Refer Table RD-BP-S2 10-1	≤ 2.0% for AC14 ≤ 1.0% for SMA
		Maximum Density	AS 2891.7.1	Refer Clause 14	Report Only
		Voids on Compacted Specimens	AS 2891.8	Refer Clause 14	Refer Clause 4.3, 4.4, 4.6 & 4.7 and Asphalt Mix Design Assessment
		Void in Mineral Aggregate (VMA)	AS 2891.8	Refer Clause 14	Refer Clause 4.3 & 4.4
		Tensile Strength Ratio (TSR)	AGPT/T232	Refer Clause 14	Refer Clause 4.3 & 4.4
		Binder Film Index (BFI)	AS 2891.8	Refer Clause 14	Refer Clause 4.3 & 4.4
		Resilient Modulus	AS 2891.13.1	Refer Clause 14	Refer Clause 4.3
		Viscosity of the Binder of the Combined Mix Containing RAP	AGPT/T192	Refer Clause 14	Refer Clause 4.5

14.12 The Department will compare the mix design and test results submitted with the requirements contained in:

- a) RD-PV-S1 "Supply of Pavement Materials";
- b) RD-BP-S2 "Supply of Asphalt";
- c) AS 2150, Sections 4, 5 and 6; and
- d) Austroads 4B.

Plant Production Assessment

14.13 The Contractor shall submit all production test data to the Department and the following analysis to demonstrate:

- a) sieve data is within the design grading curve envelope;
- b) binder content and air voids meet the nominated binder content; and
- c) constructed pavement air voids confirm mix design suitability.

14.14 When satisfied that the mix meets the specified requirements, the Department will note the summary of test results and give notice for performance testing via the Asphalt Mix Design Assessment.

Initial Performance Testing Assessment

14.15 The Contractor shall undertake performance testing on the NM and submit performance test results to the Department.

Regular Mix Design Assessment

14.16 The Contractor shall submit asphalt plant production test data and material test data to the Department to support the NM.

14.17 The Contractor shall demonstrate to the Department the following:

- a) The average air voids determined from production tests per mix are within $\pm 0.2\%$ from target for 25 consecutive discrete samples.
- b) The average binder content determined from production tests per mix shall not be lower than 0.05% from the nominated binder content for 25 consecutive discrete samples.

Regular Performance Testing Assessment

14.18 Performance testing shall be undertaken in accordance with Table RD-BP-S2 14-2 and Table RD-BP-S2 14-3 and submit them to the Department.

Registration

14.19 The Department shall maintain a register of assessed asphalt mixes. The Department will not issue additional mix register numbers if asphalt mixes are equal or less than 10% RAP incorporation, or Warm Mix Asphalt Additives or Foaming Technique are used. The "Mix Design Assessment" will consist of 5 pages, with a summary page that can be issued to the client. The "Registered Mix" number will be in this format: **AASSDBBBZ-CCC-TXXX**, where:

- a) AA = Mix Type
 - b) SS = Nominal Mix Size (mm)
 - c) D = Duty Type
 - d) B = Binder Type
 - e) Z = additional suffix, e.g. L for Hydrated Lime, G for Recycled Crushed Glass, R for Regular, H for High Binder, and for inclusion of RAP, each 5% is given a number (1 to 9 for 5% through 45%)
 - f) CCC = Contractor's name and plant
 - g) TXXX = sequential number for each mix combination, beginning at T001.
-