



Oklahoma Department of Transportation

Asphalt Plant Inspection

Form: 411-IF (Revised: 3/9/2020)

Reset Form

Print Form

P/S Name: P/S Code:

Location: Plant ID:

Manufacturer: Make/Model:

Capacity: Plant Type: Portable Permanent

If Portable, Last Known Location:

1. Scales (All Plants)

Yes **No**

a. Scales have been currently certified (within the last six months or after moving plant).

Certification Date:

2. Bituminous Equipment (All Plants)

Yes **No**

a. Tanks are equipped for constant controlled heating of bituminous material.

b. Circulation system is of adequate capacity to provide continuous circulation between storage tank and proportioning units, during entire plant operating period.

c. Storage tank capacity is adequate to ensure continuous plant operation and uniform temperature of bituminous material, when it is being introduced into the aggregate.

d. Adequate and readily available means exist, for measuring and sampling storage tanks.

e. Sampling tap and valve is readily accessible and free from obstructions.

3. Cold Feed Bins (All Plants)

Yes **No**

a. Plant is equipped with a shut-off to operate when any aggregate bin becomes empty, or flow from any bin gate becomes restricted.

b. Adequate and convenient facilities are provided for obtaining representative samples of the full flow of aggregate from each cold feed bin and the total cold feed. Facility meets AASHTO T2 section 5.3.1 requirements.

c. Adequate and convenient facilities are provided for diverting aggregate flow into trucks or other suitable containers to check accuracy of aggregate delivery system.

4. Cold Aggregate Feed (All Plants)

Yes **No**

a. Plant is equipped with adequate and accurate cold feed controls, such as variable speed belts and/or adjustable gates.

5. Maximum Aggregate Size (All Plants)

Yes **No**

a. Suitable methods or devices exist to reject oversized aggregate before it enters the cold feed.

6. Dryer (All Plants)

Yes **No**

a. Dryer is capable of drying and heating aggregate uniformly and in accordance with mixture specification requirements, without burning or overheating any portion.

b. Dryer leaves no visible unburned oil or carbon residue on aggregate, when discharging aggregate.

7. Bituminous Control Unit (All Plants)

Yes **No**

a. Satisfactory means, such as weighing or metering, are provided to obtain proper amount of bituminous material.

Asphalt Plant Inspection - Continued

- b. Suitable means, such as steam, oil jacketing, or other insulation, are provided for maintaining specified temperature of bituminous material in pipe, lines, meters, weigh buckets, spray bars, and other containers.

8. Thermometric Equipment (All Plants)	<u>Yes</u>	<u>No</u>	
a. Armored recording thermometer of suitable range is fixed in the bituminous material feed line, at a suitable location near the discharge at the mixer unit.	<input type="radio"/>	<input type="radio"/>	
b. Approved recording thermometers, pyrometers, or other recording thermometric instruments are fixed at the discharge chute of the dryer and, when applicable, in the hot fines bin for automatic registering and recording of aggregate and mixture temperature.	<input type="radio"/>	<input type="radio"/>	
9. Mineral Filler Storage and Supply (If Equipped)	<u>Yes</u>	<u>No</u>	<u>N/A</u>
a. Plant is equipped with adequate dry storage unit for storing mineral filler and means for accurately proportioning mineral filler.	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>
10. Fiber Storage and Supply (If Equipped)	<u>Yes</u>	<u>No</u>	<u>N/A</u>
a. Plant is equipped with adequate fiber storage system.	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>
b. Fiber storage system includes low level indicator.	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>
c. Fiber supply includes no-flow indicator.	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>
d. File or printout is available, for tracking feed rate of fiber.	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>
e. Plant is equipped with a transparent pipe in the fiber supply line.	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>
11. Warm Mix Technology (If Equipped)	<u>Yes</u>	<u>No</u>	<u>N/A</u>
a. Plant is adequately equipped to use chemical additive.	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>
Approved Product Name: <input style="width: 250px; height: 20px;" type="text"/>			
b. Plant is adequately equipped to use foaming process.	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>
Approved Product Name: <input style="width: 250px; height: 20px;" type="text"/>			
12. Emission Controls (All Plants)	<u>Yes</u>	<u>No</u>	
a. Plant is equipped with dust collection system capable of properly wasting material or returning all or any part uniformly into the mixture.	<input type="radio"/>	<input type="radio"/>	
Dust Collector Type: <input type="radio"/> Baghouse <input type="radio"/> Cyclone <input type="radio"/> Scrubber			
b. Except for water, other emissions are controlled to be in compliance with applicable limits.	<input type="radio"/>	<input type="radio"/>	
13. Safety Requirements (All Plants)	<u>Yes</u>	<u>No</u>	
a. Adequate, safe, and unobstructed stairways to all sampling points and guarded ladders to other plant units, where necessary, are provided.	<input type="radio"/>	<input type="radio"/>	
b. All gears, pulleys, chains, sprockets, and other dangerous moving parts are thoroughly protected.	<input type="radio"/>	<input type="radio"/>	
c. Adequate, safe, and unobstructed platform for sampling from trucks is provided.	<input type="radio"/>	<input type="radio"/>	
14. Screens (Batch Only)	<u>Yes</u>	<u>No</u>	<u>N/A</u>
a. Plant is equipped with screens of adequate capacity to separate heated aggregate into required sizes.	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>
b. Screens are unclogged and not ripped or torn.	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>
15. Hot Bins (Batch Only)	<u>Yes</u>	<u>No</u>	<u>N/A</u>
a. Hot bin storage capacity is sufficient to ensure uniform and continuous plant operation.	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>

Asphalt Plant Inspection - Continued

b. Bins are separated into specified number of compartments and arranged to ensure separate and adequate storage of appropriate aggregate fractions.			<input type="radio"/>
c. Compartments are provided with adequate overflow chutes to prevent backing up of material into other compartments.	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>
d. Bin gates close tightly, to avoid leakage.	<input type="radio"/>	<input type="radio"/>	
e. Bins are equipped with "tell-tale" devices to indicate position of aggregate in bins at the lower quarter points.	<input type="radio"/>	<input type="radio"/>	
f. Plant is equipped with a shut-off to operate when any aggregate bin becomes empty.	<input type="radio"/>	<input type="radio"/>	
g. Adequate and convenient facilities are provided for obtaining aggregate samples from each bin.			
16. <u>Weigh Box or Hopper (Batch Only)</u>	<u>Yes</u>	<u>No</u>	<u>N/A</u>
a. Weigh box or hopper is suspended on scales and is adequate for weighing aggregate from each bin and holding a full batch.		<input type="radio"/>	<input type="radio"/>
b. Weigh box or hopper is supported on fulcrums and knife edges that will not be easily thrown out of alignment or adjustment		<input type="radio"/>	<input type="radio"/>
c. Hopper gate does not leak.			
17. <u>Aggregate Scales (Batch Only)</u>	<u>Yes</u>	<u>No</u>	<u>N/A</u>
a. Scales are equipped with adjustable pointers for marking weight of each material to be weighed into a batch.	<input type="radio"/>		<input type="radio"/>
b. Scales are accurate, in good working condition, and free from excess vibration.	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>
c. Scales accurately return to zero.	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>
18. <u>Bituminous Material Bucket (Batch Only)</u>	<u>Yes</u>	<u>No</u>	<u>N/A</u>
a. Bucket capacity is adequate for handling a batch in a single weighing.	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>
b. Filling system and bucket are of adequate design, size, and shape to prevent bituminous material from overflowing, splashing, or spilling outside the bucket.			
c. Bucket is arranged to deliver bituminous material in a thin uniform sheet or multiple sprays over the full length of the mixer.		<input type="radio"/>	<input type="radio"/>
19. <u>Mixing Unit (Batch Only)</u>	<u>Yes</u>	<u>No</u>	<u>N/A</u>
a. Mixer is designed to provide means of adjusting clearance between blades and liner plates, to ensure proper and efficient mixing.		<input type="radio"/>	
b. If not enclosed, mixer box is equipped with dust hood to prevent loss of dust.	<input type="radio"/>	<input type="radio"/>	
c. Mixer is constructed to prevent leakage of contents.	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>
d. Mixer discharge is constructed to not cause appreciable segregation.	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>
e. Mixer is equipped with means of controlling mixing time and an accurate time lock to control operation of a complete mixing cycle.			
20. <u>Aggregate Delivery Sym (Drum Only)</u>	<u>Yes</u>	<u>No</u>	<u>N/A</u>
a. Plant is equipped with an approved belt scale for continuously weighing the total cold aggregate feed.	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>
b. All belts, motors, and gauges are in good working condition and free from moving to help prevent erratic results.	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>
c. Means for introducing moisture content of total cold feed into the belt weighing signal and correcting wet aggregate weight to dry aggregate weight are provided.	<input type="radio"/>		<input type="radio"/>
d. Automatic digital record of dry weight of aggregate flow is displayed, recorded, and totaled in appropriate units of volume or weight and time at least every 5 minutes of plant operation and is also available on demand at least every minute of plant operation for a period of at least 5 minutes.			

	<u>Yes</u>	<u>No</u>	<u>N/A</u>
21. Bituminous Material System (Drum Only)			
a. Interlock between dry weight of aggregate flow and flow of bituminous material through an approved meter, capable of adjusting the flow of bituminous material to compensate for variation in dry weight of aggregate flow, is provided.			<input type="radio"/>
b. Automatic digital record of the flow of bituminous material is displayed, recorded, and totaled in appropriate units of volume or weight and time at least every 5 minutes of plant operation and is also available on demand at least every minute of plant operation for a period of at least 5 minutes.		<input type="radio"/>	<input type="radio"/>
22. Drum Mixer (Drum Only)			
a. Means of diverting mixes at startup and shutdowns or when mixing is not complete or uniform is provided.			<input type="radio"/>
23. Mixture Storage (Drum Only)			
a. Holding bin has quick opening and closing gates.		<input type="radio"/>	<input type="radio"/>
b. Holding bin is designed to minimize segregation and heat loss.	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>
24. Surge and Storage Bins or Silos (If Equipped)			
a. Bins and silos are capable of discharging mixture, that meets specification requirements, into delivery units.			<input type="radio"/>
b. Bins or silos are emptied at the end of the mixing and delivery period.		<input type="radio"/>	<input type="radio"/>

CERTIFICATION OF INSPECTOR

I have inspected the above listed asphalt plant and found it to meet the applicable specification requirements except as noted the the remarks below.

Name of Inspector

Signature of Inspector

Residency

Date

Remarks (A remark should be listed for each "NO" marked):

This form conforms to the requirements of AASHTO M 156 and meets the Department's certification requirements in Section 411.03 of the current Standard Specifications. Plants and scales shall be inspected and certified not less than once every six months and when moved.