Washington State Department of Transportation

Asphalt Plant Inspection

Inspection and approval of asphalt mixing plant and facilities is required on all asphalt paving projects according to the schedule below. Upon completion of the required inspection, copies of the inspection report are to be distributed as follows:

Project Field Laboratory, Project Engineer, Regional Materials Engineer.

Inspection forms are layed out in three sections: (1) Plant Information; (2) Plant Component; and (3) Plant Operation Inspection Checklist.

Schedule of Required Inspections:

All Projects		(1)
Permanent Plants -	Annual Inspection	(1), (2), (3)
	Large Project (over 10,000 tons total)	(1), (3)
Portable Plants -	Initial at Each Set-Up	(1), (2), (3)
	Subsequent	(1), (3)

Summary of Plant Inspection

Defective Elements Noted (Plant Repair Required)			
Contractor Notified of Results ☐ Yes ☐ No	Contractor Signature	Date	Reinspection Date
Defective Elements Corrected			
Plant Accepted for Contract ☐ Yes ☐ No	Signature		Date

Contract Information

Contract No.	SR No.	Section	Plan Quantity (Class/Mix/Tons)
Prime Contractor	Paving Subcontractor	Project Engineer	
Inspection Date	By	InspectionType ☐ (1) ☐ (2) ☐ (3)	

Inspection (1)

Plant Information

Plant (Make/Model)	Plant Capacity-Batch (kg)	Plant Capacity-Drum (Tons/Hr.)
Plant Location (Pit Site/Street or Road Address)	Plant Designation	
Plant Type (Portable/Permanent)	Plant Type (Batch/Cont./Drum)	
Preceding State Contract at this Location (Cont. No./Proj. Engr.)	Preceding State Contract At Prev. Location (Cont. No./Proj. Engr.)	

Mix Information

Aggregate (Size)	Aggregate Source	Approved ( )	Size	Source	Approved ( )	Size	Source	Approved ( )

Blend Sand: Source	Approved ( )	Paving Asphalt: Source	Approved ( )	Anti-Strip: Source	Approved ( )

Inspection (1) - Continued

Stockpile Date for Mix Design From: _____

State Inspection	Contr. Data	Stockpile Samples	By	Stockpile Meets Specs. for Class

Screened	Screenless
Mix Design: Date Submitted	Mix Design: Date Received

Asphalt Content:	Class	Percent	Anti-Strip Required:	Yes	No	Percent
				☐	☐	
				☐	☐	
				☐	☐	

Inspection (2)

Plant Component Information

1. Cold Feed:

No. of Bins _____ Type of Feeders

Bin 1 _____ Bin 2 _____ Bin 3 _____ Bin 4 _____

Automatic Sampler Location _____

2. Drier:

Size _____ Dia X _____ Length _____ tph Capacity

Fuel _____ Make _____

Drum Plant Only: Mix Sampling Capability: _____

3. Dust Control

Type ☐ Baghouse ☐ Cyclone ☐ Scrubber

Emmision Level Checked: Date _____ By _____

4. Screens

Size of Screen Deck _____ **X** _____ , _____ tph Capacity

Screen Sizes: Bin 4 _____ Bin 3 _____ Bin 2 _____ Bin 1 _____

5. Aggregate Proportioning

Batch Plant: Scales Capacity _____ Make _____

Last Inspection Date _____

Automatic Controls: (Required: Over 5,000 Tons)

Type _____ Make _____

Drum Plant: Belt Scale: Make _____ Model _____

Moisture Compensation _____

6. Asphalt Proportioning

Batch Plant: Scales Capacity _____ Make _____

Last Inspection Date _____

Drum/Cont. Asphalt Meter: Make _____ Model _____

Last Calibration Date _____

Temperature/Density Compensation

Last Calibration Date _____

Plant Component Information - Continued

7. *Mixing Unit*

Make _____ Rated Capacity _____

8. *Asphalt Storage*

Size of StorageTank _____ (gal.) HeatingMethod _____

Volume Depth Charts on Hand _____

9. *Quantity Control*

STORAGE SILO: Location of Low Bin Cutoff _____

WEIGH HOPPER: Capacity _____ Type _____ (Manual/Auto)

TRUCK SCALES: Size _____ Capacity _____

Check One: ☐ Cert. W/M _____
☐ State Scale Oper. _____

Plant Operation Inspection Check List

Standard Spec.		Accept	Deficient
	1. Aggregate and Cold Feed		
	a. Source approved for this contract	☐	☐
5-04.3(7)A	b. Mix design approved for this contract	☐	☐
	c. Stockpiles identified for project	☐	☐
5-04.3(7)	d. Adequate separation of stockpiles	☐	☐
5-04.3(1)A 7	e. Adequate separation of cold feed bins	☐	☐
5-04.3(1)A 5	f. Blend sand bin equipped to prevent bridging	☐	☐
5-04.3(1)D	g. DRUM ONLY: Feed belt and belt scales correctly installed	☐	☐
5-04.3(1)C 3	h. DRUM ONLY: Interlock - feed to controls	☐	☐
	2. Temperature Measurement		
5-04.3(1)A 9	a. Recording pyrometer	☐	☐
5-04.3(1)A 9	b. Thermometer only (when approved)	☐	☐
5-04.3(1)C 2	c. Calibration checked	☐	☐
	3. Dust Collection		
5-04.3(1)A 10	a. Waste/dust disposal	☐	☐
5-04.3(1)A 10	b. Baghouse only: surge bin capacity adequate or operable provisions to waste fines	☐	☐
5-04.3(1)A 10	c. Baghouse only: interlock return feed	☐	☐
	4. Screens and Bins		
5-04.3(1)7	a. Overflow chutes checked for obstructions	☐	☐
5-04.3(1)7	b. Low-bin tell-tales	☐	☐
	5. Aggregate Proportioning		
	a. Batch plant:		
5-04.3(1)B 2	(1) Weigh hopper free from binding	☐	☐
5-04.3(1)B 6	(2) Scale dial visible to operator	☐	☐
5-04.3(1)C 2	(3) Test weights present for checks	☐	☐
5-04.3(1)B 6	(4) Controls capable of being set and locked	☐	☐

Plant Operation Inspection Check List - Continued

Standard Spec.		Accept	Deficient
	5. Aggregate Proportioning - Continued		
	b. Continuous mix:		
5-04.3(1)C 3	(1) Low-bin tell-tales operational	☐	☐
5-04.3(1)C 3	(2) Synchronized and interlocked asphalt and aggregate feed	☐	☐
	c. Drum mixer:		
5-04.3(1)D 1	(1) Synchronized and interlocked asphalt and aggregate feed	☐	☐
	(2) Aggregate moisture compensation	☐	☐
	6. Asphalt Proportioning		
	a. All plants:		
5-04.3(1)A 9	(1) Thermometer near discharge valve	☐	☐
5-04.3(1)A 9	(2) Thermometer checked for accuracy	☐	☐
	b. Batch plant:		
1-09.2	(1) Scales accurate to $^1/_2$ percent	☐	☐
	c. Continuous mix:		
5-04.3(1)C 3	(1) Asphalt flow meter operational	☐	☐
	(2) Asphalt pump speed adjustable	☐	☐
	d. Drum plants		
5-04.3(1)D 1	(1) Asphalt feed interlocked	☐	☐
	(2) Asphalt temperature/density compensation	☐	☐
	(3) Asphalt totalizer flow meter operational	☐	☐
	7. Mixing Unit		
	a. Batch plant:		
5-04.3(1)B 4	(1) Paddle tips checked	☐	☐
5-04.3(1)B 4	(2) Paddle to liner clearance 1 inch or less	☐	☐
	Paddle to liner clearance 1 to 1-$^1/_2$ inches	☐	☐
	Paddle to liner clearance over 1-$^1/_2$ inches	☐	☐
5-04.3(1)B 2	(3) Outlet gates: free from dry aggregate leakage	☐	☐
	(4) Outlet gates: free from asphalt leakage	☐	☐
	b. Continuous mix:		
5-04.3(1)C 4	(1) Paddle tips checked	☐	☐
5-04.3(1)C 4	(2) Paddle to liner clearance 1 inch or less	☐	☐
5-04.3(1)C 4	Paddle to liner clearance 1 to 1-$^1/_2$ inches	☐	☐
5-04.3(1)C 4	Paddle to liner clearance over 1-$^1/_2$ inches	☐	☐
	8. Asphalt Storage		
5-04.3(1)A 4	a. Full circulating system	☐	☐
5-04.3(1)A 4	b. Return pipe below stored asphalt level	☐	☐
5-04.3(1)A 4	c. Asphalt temperature thermometer	☐	☐
5-04.3(1)A 4	d. Asphalt sampling valve or provision to dip from tank	☐	☐
	9. Quantity Control		
1-09.2	a. Scale calibration up to date	☐	☐
5-04.3(8)	b. Storage silo low level cutoff	☐	☐
	c. Trucks are tared daily (truck scales only)	☐	☐