

# Concrete Process Control

CONCRETE PRODUCER: \_\_\_\_\_ LOCATION: \_\_\_\_\_

## PLANT PROCEDURES

1. **Delivery tickets** shall accompany every load and daily concrete inspection reports are to be supplied to field inspector daily. Retain copies of all QC tests in plant files.
2. The **calibration of weighing systems** (cement, aggregate and water scales, water meters and admixture dispensing systems) shall be checked prior to starting the project and monthly thereafter. This is the responsibility of the plant personnel and QC technicians. Retain copies of the plant checks in plant files and post in a conspicuous location for inspection purposes.
3. **Stockpiles** shall be inspected weekly to insure that they are uncontaminated and unsegregated. **Gradation testing** on coarse and fine aggregate shall be in accordance with the latest versions of AASHTO T-27 and AASHTO T-11 when required. This will be performed prior to mixing of concrete. Run one (1) test at the beginning of the project with a minimum of one (1) per week or 500 C.Y. thereafter for Section 604 items and 1500 C.Y. for Section 501 items and document. Run **Fineness Modulus (FM)** on fine aggregate according to the latest version of AASHTO M-6 with each gradation check and document. The fineness modulus shall not vary more than 0.20 from the base fineness modulus established on the approved concrete design.
4. Tests and adjustments of mix proportions for **moisture content** of both fine and coarse aggregates shall be performed as required in accordance with the latest version of AASHTO T-255. A minimum of one a.m. and one p.m. Additional tests and adjustments may be required based on weather conditions. Retain the test results in the plant files.
5. **Mix proportions** of the aggregate, cement, water and admixtures shall be observed and recorded during batching operations to ensure accuracy of the batching with respect to the approved mix design during every pour.
6. Check all **ready mix trucks** for: (a) excessive blade wear, (b) concrete build-up in the drum, (c) manufacturer's capacity plate, (d) operable revolution counter and (e) working water gauge as required by the specifications. 501 and 604. Post a list of all approved trucks in a conspicuous location.
7. Ensure that **excessive water** is not left in the concrete truck drum before loading the truck. Document any water added to each batch of concrete including that in any form.
8. Tests for **slump** (AASHTO T-119), **air content** (AASHTO T-152), **concrete temperature, and ambient air temperature** shall be performed daily for the first truck.
9. Furnish the project supervisor all **files** accumulated throughout the life of the project in the form of stockpile reports, moisture reports and recorded batch information on cement, water, admixtures and other pertinent information for inclusion into the project final records at the end of the project. Also furnish the project supervisor a certification by the contractor that the concrete incorporated into the work meets the requirements of the specifications at the completion of the project as indicated in Sub-Sections 501 and 604 of the standard specifications.

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(Company Rep Signature)

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(Title)