

4. Asphalt Plant



4.1. Introduction

Asphalt plants heat and dry the aggregate and mix it with the appropriate amount of asphalt cement, in accordance with the project mix design. There are two main types of asphalt plants: batch plants and dryer drum plants. These are briefly described below.

Standard Highway Specification 4.01-3.03 requires that the asphalt plant be calibrated as specified in AASHTO M-156. Airport Specification 401-4.2 requires the asphalt plant to conform to ASTM D 995.

The Asphalt Institute's Manuals MS-3 *Asphalt Plant Manual* and MS-22 *Principles of Construction of Hot-Mix Asphalt Pavements* contain much more information on asphalt plants.

Batch Plants

Batch plants make asphalt concrete one batch at a time. This is done by placing measured amounts of

different-sized aggregate and asphalt cement in a "pugnall," where they are mixed. The pugmill is then emptied and the process repeated. The aggregate and asphalt cement are heated before they are placed in the pugmill. The process is shown in the diagram on the page 4-4.

Aggregate at the plant starts at the *cold bins* (see Figure 4-1). There are usually three or four bins for different sizes of aggregate. The aggregate empties through the bottom of the bins through feeders (most operate with a small belt or a vibrator). The feeders are equipped with adjustable *cold feed gates*. Aggregate in different bins is released at different rates to form the proportional combination of material for the mix design. The correct proportions are obtained by calibrating the gates and adjusting the variable speed feeder belt. Aggregate from all the feeders is deposited on a main *cold feed conveyor*.

The *cold elevator* carries the proportioned aggregate from the conveyor to the *dryer*, which heats and

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