



**PRODUCTION OF CERTIFIED AGGREGATE
FROM RECLAIMED ROADWAYS**

GENERAL

This IM deals with requirements for furnishing certified aggregate produced from reclaimed materials.

The requirements of Office of Materials [IM 209](#) (Certified Aggregates Approved Producer Program) also apply to the production of aggregate from reclaimed roadway materials.

Processing Requirements for Aggregates Produced from Reclaimed Materials

Notification to District Materials personnel of new production, as well as testing frequency, sampling, documentation, and acceptance of recycled materials, are the same as for virgin materials as outlined in [IM 209](#). The District Materials Engineer shall be afforded the opportunity to witness the stockpiling of unprocessed recycled material.

Processing of reclaimed PCC, RAP, or CCP shall include a means of eliminating material other than PCC, RAP, or CCP in the finished product. This may be accomplished by pre-screening or other methods acceptable to the District Materials Engineer. Stockpiles contaminated with reinforcing steel, soil, or other matter not allowed by the Specifications can be rejected upon visual inspection. The producer or contractor shall be informed immediately that the stockpile has been rejected. Recycled yards must have controlled access and delivered material shall be inspected prior to incorporation into unprocessed stockpiles.

Some aggregate products allow the blending of RAP with virgin aggregate or crushed PCC. The virgin aggregate or crushed PCC shall meet the gradation and quality requirements of the intended product before blending with RAP. RAP shall be processed to meet the applicable nominal maximum size for the intended product before blending with other aggregate. Blending shall be accomplished by the use of belt feeders and bins equipped with adjustable gates or drive systems that can be calibrated and controlled. For modified subbase the amount of recycled HMA from composite pavement and RAP shall not exceed 50%. Crushed recycled materials may total no more than 30% of the shoulder aggregate for new construction and no more than 50% of the total for existing granular shoulders. The intended proportions shall be provided to the District Materials Engineer at least 24 hours before the start of production. The District Materials Engineer shall be afforded the opportunity to witness the calibration of the blending equipment.

Granular Subbase & Modified Subbase from Reclaimed Roadways

These products require that the reclaimed material be identifiable and the following shall apply:

- A. Recycled crushed PCC pavement, crushed composite pavement (CCP), and salvaged HMA (RAP) can be reclaimed from an Interstate or Primary roadway pavement under the jurisdiction of the contracting authority and shall be certified based on gradation testing.

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- B. Recycled PCC roadway pavement or recycled composite roadway pavement obtained from secondary roads or municipal streets may be used if the source of the aggregate is known and the PCC coarse aggregate durability is Class 2 or better and shall be certified based on gradation testing. The producer shall be responsible for documentation of the pavement source.
- C. When the source or quality of the material from the secondary or municipal pavement is unknown, the material shall be certified based on quality requirements identified in the Standard Specifications for crushed stone for the aggregate being produced and gradation requirements for the aggregate product.
1. If the concrete originated from multiple locations, the crushed material must be stockpiled in separate but homogeneous stockpiles.
 2. Prior to certification and furnishing to projects, each stockpile must be readily identifiable, and have compliant results on applicable tests on samples taken from each of these stockpiles.