

# NOTICE

“EbTT Plus Certification” is comprised with the following listed FOP’s...

T-89                    TTQP / UDOT

T-90                    TTQP / UDOT

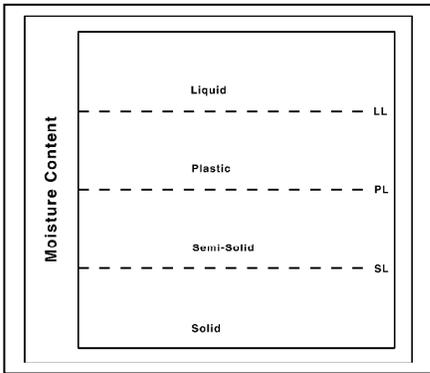
T-255 / T265        WAQTC

T-99 / T-180        WAQTC

T-272                    WAQTC

T-85                    WAQTC

**DETERMINING THE LIQUID LIMIT OF SOILS  
FOP FOR AASHTO T 89**



**Material phase and moisture content**

**Significance**

Fine-grained soils, particularly clays, exhibit different properties at different moisture contents. At very low moisture contents, the material acts like a solid. As the moisture content rises, the material moves from solid to semi-solid to plastic to liquid form.

The moisture content at the boundary between semi-solid and plastic states is known as the plastic limit (PL). The moisture content at the boundary between the plastic and liquid states is known as the liquid limit (LL). The difference between the plastic and liquid limits is called the plasticity index (PI), and indicates the size of the range over which the material acts as a plastic – capable of being deformed under stress, but maintaining its form when unstressed.

Fine-grained soils also exhibit shrinking and swelling as the moisture content changes. As water content increases from dry to wet, no change in volume occurs below a certain moisture content, known as the shrinkage limit (SL). Above the SL, volume increases as moisture content increases.

For these reasons, knowledge of the LL, PL, and PI, and sometimes the SL, are important to quality assurance in roadway construction.



**Liquid limit apparatus**

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## Scope

This procedure covers the determination of the liquid limit of a soil in accordance with AASHTO T 89. It is used in conjunction with the FOP for AASHTO T 90, Determining the Plastic Limit and Plasticity Index of Soils. The three values are used for soil classification and other purposes.

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## Apparatus

- Dish: preferably unglazed porcelain or similar mixing dish, of approximately 4.5 inch diameter.
- Spatula: having a blade 3 to 4 in. long and about 3/4 in. wide.
- Liquid Limit Device: manually or mechanically operated, consisting of a brass cup, carriage, and base plate.
- Grooving Tool: used to cut the soil in the liquid limit device cup.
- Gauge: part of the grooving tool or a separate metal bar,  $10.0 \pm 0.2$  mm ( $0.394 \pm 0.008$  in). thick and approximately 50 mm (2 in.) long.
- Containers: corrosion resistant, suitable for repeated heating and cooling, having close fitting lids to prevent the loss of moisture. One container is needed for each moisture content determination.
- Balance: conforming to AASHTO M 231, class G1, sensitive to 0.01 g with a 1200 g capacity.
- Oven: thermostatically controlled, capable of maintaining temperatures of  $230 \pm 9^\circ\text{F}$ .
- Graduated cylinders for measuring distilled or demineralized water.

- **Pulverizing Apparatus:** Either mortar and rubber-covered pestle or any device suitable for breaking up the aggregations of soil particles without reducing the size of the individual grains of soil.
- **Sieves:** A series of the following sizes: ¼ in., #4, #10, #40 and a pan.

### **Adjustment of Liquid Limit Device**

07 The liquid limit device shall be inspected to determine that the device is in good working order; that the pin connecting the cup is not worn to permit side play; that the screws connecting the cup to the hanger are tight; that the points of contact on the cup and base are not excessively worn; that the lip of the cup is not excessively worn; and that a groove has not been worn in the cup. The grooving tool shall be inspected to determine that the critical dimensions are correct.

*Note 1:* Wear is considered excessive when the point of contact on the cup or base exceeds approximately 0.5 in. in diameter, or when any point on the rim of the cup is worn to approximately 1/2 the original thickness. A slight groove in the center of the cup is not objectionable. If the groove becomes pronounced, the cup shall be replaced. A base that is excessively worn may be refinished as long as it is maintained within the tolerances specified.

Adjust the height of drop of the cup so that the point on the cup that comes in contact with the base rises to a height of  $10.0 \pm 0.2$  mm ( $0.394 \pm 0.008$  in).

*Note 2:* Check the height of the drop of the cup prior to each day's testing, by turning the crank at two revolutions per second while holding the gauge in position against the cup. If a ringing or clicking sound is heard without the cup rising from the gauge, the adjustment is correct. If no ringing is heard or if the cup rises from gauge, readjust the height of the drop. If the cup rocks on the gauge during this checking operation, the cam follower pivot is excessively worn and should be replaced.



Sample Preparation

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**Sample**

Samples must be prepared per AASHTO T 87 or T 146. Obtain a sample with a mass of about 100 g taken from the portion of the material passing the No. 40 sieve.

The mass required depends upon the method chosen. Method A (multi-point method) requires approximately 100 g. Method B (single point method) requires approximately 50 g.

**Procedure – Method A (Multi-Point)**

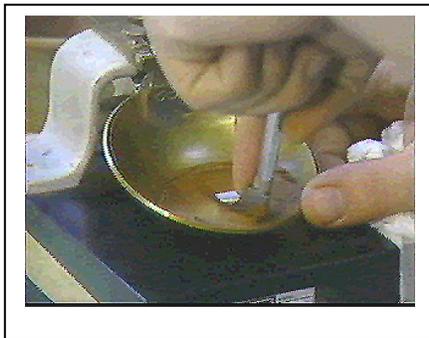


Spreading soil

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1. Place the sample in the dish and thoroughly mix with 15 to 20 mL of distilled or demineralized water by alternately and repeatedly stirring, kneading, and chopping with a spatula. Further additions of water shall be in increments of 1 to 3 mL. Each increment shall be thoroughly mixed with the soil before another increment is added. Once testing has begun, no additional dry soil should be added to the moistened soil. The cup of the Liquid Limit device shall not be used for mixing soil and water. If too much water is added, the sample shall either be discarded or mixed and kneaded until natural evaporation lowers the moisture content.

*Note 3:* Some soils are slow to absorb water. It is possible to add water so fast that a false LL value is obtained. This can be avoided by allowing more mixing and/or time. Also, tap water may be used for routine testing if comparative tests indicate no differences in results between using tap water and distilled or demineralized water.



Liquid limit procedure

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2. Add sufficient water to form a uniform mass of a stiff consistency.
3. Place enough material in the cup so that, when squeezed and spread with the spatula, the soil will rest in the cup above the spot where the cup rests on the base and will be 10 mm thick at the point of maximum thickness. Use as few strokes of the spatula as possible, taking care to prevent the entrapment of air bubbles in the sample.
4. Divide the soil in the cup with a firm stroke of the grooving tool. Avoid tearing of the sides of

the groove or slipping of the soil cake on the cup. Up to six strokes are permitted. The depth of the groove should be increased with each stroke, and only the last stroke should scrape the bottom of the cup.

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5. Lift and drop the cup by turning the crank at a rate of approximately two revolutions per second until the two halves of the soil pat come together along a distance of about 0.5 in. Do not hold the base while the crank is turned. Record the number of shocks required to close the groove.

*Note 4:* Some soils tend to slide on the cup instead of flowing. If this occurs, water should be added, the sample remixed, and the procedure repeated. If the soil continues to slide on the cup, the test is not applicable and a note should be made that the liquid limit could not be determined.

- 14
6. Obtain a moisture content sample by slicing through the soil pat perpendicularly with the spatula and through the center of the groove. Place it into a suitable container for subsequent moisture determination.

- 15
7. Determine the moisture content of the moisture content sample in accordance with the FOP for AASHTO T 255/T 265 (Soil).

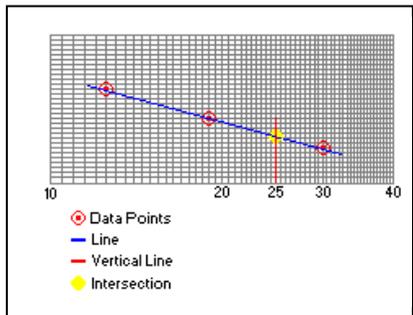
- 16
8. Place the soil remaining in the cup back in the mixing dish and add 1 to 3 mL of water, or use previously prepared portions to which sufficient water has been added to result in a more fluid condition.

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9. Repeat Steps 3 through 8, a minimum of two times. The object is to have a determination in all three shock ranges 25-35, 20-30, & 15-25.

**Note:** The range of the three determinations shall be at least 10 shocks.



Sampling for moisture



**Liquid limit flow curve**

### Flow Curve – Method A

Prepare a flow curve on a semi-logarithmic graph with moisture content on the arithmetic vertical axis and the number of shocks on the logarithmic horizontal axis. The flow curve is a straight line drawn as closely as possible through three or more plotted points.

### Liquid Limit – Method A

Determine the liquid limit. The moisture content at the intersection of the flow curve and the 25 shock line is the liquid limit.

### Procedure – Method B (Single-Point)

1. Place the sample in the dish and thoroughly mix with 8 to 10 mL of distilled or demineralized water, and following the mixing procedure in Method A, Step 1.
2. Follow the procedure in Method A except that the soil pat should be prepared with water to produce a consistency that will close the two halves of the soil pat at least 0.5 in. within 22 to 28 shocks of the cup.

*Note 5:* Groove closures occurring between 15 and 40 blows may be accepted if variations of  $\pm 5$  percent of the true liquid limit are tolerable.

3. Return the soil remaining in the cup to the mixing dish and, without adding any additional water, repeat Step 2. If the closure again occurs within the acceptable range, obtain a moisture content specimen.
4. Determine the moisture content of the moisture content sample in accordance with the FOP for AASHTO T 255/T 265 (Soil).

**Liquid Limit – Method B**

Calculate the moisture as follows:

The water content shall be expressed as the moisture content in percentage of the mass of the oven-dried soil.

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$$\text{Percent of Moisture} = \frac{\text{mass of water}}{\text{mass of oven-dried soil}} \times 100$$

$$\text{Mass of water} = \text{wet soil} - \text{oven-dried soil}$$

Calculate the liquid limit as follows:

$$LL = KW_N$$

Number of Blows N	Factor for Liquid Limit, K
22	0.985
23	0.990
24	0.995
25	1.000
26	1.005
27	1.009
28	1.014

Where:

LL = liquid limit

$W_N$  = moisture content of sample at N blows

N = number of blows

K= factor given in table

Example:

$$w_N = 16.0 \% \text{ and } N = 23$$

$$LL = (16.0)(0.990) = 15.8, \text{ say } 16\%$$

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**Report**

- Results shall be reported on standard forms approved by the agency.
- Report percentage of moisture to the 0.1 percent.
- Report LL to the nearest whole percent.

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**Tips!**

- Do not mix dry soil with moist soil in order to reduce moisture content.
- Be careful with grooving tool. Use up to six strokes to carefully separate the sample, rather than forcing the sample apart with just one or two strokes.



## REVIEW QUESTIONS

1. Describe how to mix the soil with water.
2. Describe how to obtain the moisture content sample.
3. What does the liquid limit represent?
4. How is the liquid limit used with the plastic limit?
5. Describe how to adjust the liquid limit apparatus.



**PERFORMANCE EXAM CHECKLIST**

**DETERMINING THE LIQUID LIMIT OF SOILS  
FOP FOR AASHTO T 89**

Participant Name \_\_\_\_\_ Exam Date \_\_\_\_\_

Record the symbols "P" for passing or "F" for failing on each step of the checklist.

<b>Procedure Element</b>	<b>Trial 1</b>	<b>Trial 2</b>
1. Describe the inspection for wear of the liquid limit device:	_____	_____
a. Wear at contact between cup and base 1/2" or less?	_____	_____
b. Edge of cup no less than 1/2 original thickness?	_____	_____
2. Describe how the height of the cup drop is adjusted:	_____	_____
a. Checked before each use?	_____	_____
b. Turn crank while holding gauge in position under cup?	_____	_____
c. Check for ringing or clicking without rising of cup?	_____	_____
d. Cup does not rock?	_____	_____
3. Describe initial sample preparation:	_____	_____
a. Material separated on appropriate sieves?	_____	_____
b. Soil sufficiently pulverized for separation of grains?	_____	_____
c. Material passing the # 40 recombined and mixed?	_____	_____
4. Describe the preparation of the liquid limit sample for Method A:	_____	_____
a. Sample mass approximately 100 g. of minus #40?	_____	_____
b. Mixed in dish with 15 to 20ml of distilled or demineralized water?	_____	_____
c. Mix by stirring, chopping, kneading with spatula until stiff consistency?	_____	_____
d. No dry soil added to lower moisture content?	_____	_____
5. Material placed in cup, centered, 10 mm thick?	_____	_____
6. Soil divided by using up to 6 strokes, preventing tearing or slipping of soil pat?	_____	_____
7. Cup lifted and dropped at a rate of 2 per second?	_____	_____
8. Pat halves come together over length of 1/2"?	_____	_____
9. Moisture container tare mass determined?	_____	_____
10. Moisture sample properly taken and wet mass determined?	_____	_____
11. Moisture content determined by AASHTO T 265?	_____	_____
12. Multiple tries conducted to achieve sample in shock ranges of 25-35,		

20-30, and 15-25?

\_\_\_\_\_

13. Flow curve plotted with shocks on logarithmic scale and the moisture on arithmetic scale?

\_\_\_\_\_

14. Liquid Limit correctly calculated and rounded to nearest whole number?

\_\_\_\_\_

15. Reported on standard agency form?

\_\_\_\_\_

Comments: First attempt: Pass  Fail  Second attempt: Pass  Fail

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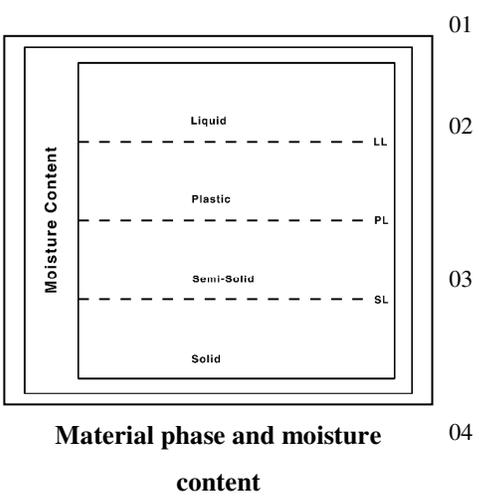


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Signature of Examiner \_\_\_\_\_



**DETERMINING THE PLASTIC LIMIT AND PLASTICITY INDEX OF SOILS  
FOP FOR AASHTO T 90**



**Significance**

Fine-grained soils, particularly clays, exhibit different properties at different moisture contents. At very low moisture contents, the material acts like a solid. As the moisture content rises, the material moves from solid to semi-solid to plastic to liquid form.

The moisture content at the boundary between semi-solid and plastic states is known as the plastic limit (PL). The moisture content between the plastic and liquid states is known as the liquid limit (LL). The difference between the plastic and liquid limits is called the plasticity index (PI), and indicates the size of the range over which the material acts as a plastic – capable of being deformed under stress, but maintaining its form when unstressed.

Fine-grained soils also exhibit shrinking and swelling as the moisture content changes. As water content increases from dry to wet, no change in volume occurs below a certain moisture content, known as the shrinkage limit (SL). Above the SL, volume increases as moisture content increases.

For these reasons, knowledge of the LL, PL, and PI, and sometimes the SL, are important to quality assurance in roadway construction.

## Scope

This procedure covers the determination of the plastic limit and plasticity index of soil in accordance with AASHTO T 90. It is used in conjunction with the FOP for AASHTO T 89, Determining the Liquid Limit of Soils. The three values are used for soil classification and other purposes. This FOP will cover the hand rolling method only. If the plastic limit device method is approved by the agency, see the FOP for AASHTO T 90 for that procedure.

## Apparatus

- Dish: preferably unglazed porcelain or similar mixing dish, of approximately 4.5 inch diameter.
- Spatula: having a blade 3 to 4 in. long and about 3/4 in. wide.
- Rolling Surface: a ground glass plate or piece of smooth, unglazed paper.
- Containers: corrosion resistant, suitable for repeated heating and cooling, having close fitting lids to prevent the loss of moisture. One container is needed for each moisture content determination.
- Balance: conforming to AASHTO M 231, class G1, sensitive to 0.01 g with a 1200 g capacity.
- Oven: thermostatically controlled, capable of maintaining temperatures of  $230 \pm 9^{\circ}\text{F}$ .

## Sample

The plastic limit procedure is often run in conjunction with the liquid limit procedure. If this is the case, the plastic limit sample should be obtained from the soil prepared for the liquid limit test at any point in the process at which the soil is plastic enough to be easily shaped into a ball without sticking to the fingers excessively when squeezed. Obtain approximately 8 g of soil to run the plastic limit test.

05

If only the plastic limit is to be determined, the sample must be prepared per AASHTO T 87 or T 146. Obtain about 20 g of material passing the No. 40 sieve. Mix the soil with distilled or demineralized water until the mass becomes plastic enough to be easily shaped into a ball. Obtain approximately 8 g of soil to run the plastic limit test.

*Note 1:* Tap water may be used for routine testing if comparative tests indicate no differences in results between using tap water and distilled or demineralized water.



**Rolling the thread**

06

### Procedure (Hand Rolling Method)

1. From the sample pull a 1.5 to 2 g mass.
2. Squeeze and form the test sample into an ellipsoidal-shape mass.
3. Roll this mass between the fingers or palm and the rolling surface with just sufficient pressure to roll the mass into a thread of uniform diameter along its length. Roll out between 80 and 90 strokes per minute, counting a stroke as one back and forth motion. The sample must be rolled into the 1/8 in. thread in no longer than 2 minutes.
4. Break the thread into six or eight pieces when the diameter of the thread reaches 1/8 in.
5. Squeeze the pieces together between the thumbs and fingers of both hands into an ellipsoidal-shape mass and reroll.
6. Continue this process of alternately rolling to a thread of 1/8 in. diameter, cutting into pieces, gathering together, kneading and rerolling until the thread crumbles under the pressure required for rolling and the soil can no longer be rolled into a thread.

07



**Breaking the thread**

08



Drying sample

**Note 2:** Crumbling may occur when the thread has a diameter greater than 1/8 in. This shall be considered a satisfactory end point, provided the soil has been previously rolled into a thread of 1/8 in. diameter. The crumbling will manifest itself differently with various types of soil. Some soils fall apart in many pieces; others form an outside tubular layer that splits at both ends; splitting progresses toward the middle, and the thread falls apart in small platy particles. Heavy clay requires much pressure to deform the thread, particularly as it approaches the plastic limit, and the thread breaks into a series of barrel-shaped segments each 1/4 to 3/8 in. long. At no time shall the tester attempt to produce failure at exactly 1/8 in. diameter. It is permissible, however, to reduce the total amount of deformation for feebly plastic soils by making the initial diameter of the ellipsoidal-shaped mass nearer to the required 1/8 in. final diameter.

7. Gather the portions of the crumbled soil together and place in a suitable, tared container and cover.
8. Repeat steps one through seven until 8 g of sample have been tested and placed in the covered container.
9. Calculate the moisture as follows:

The water content shall be expressed as the moisture content in percentage of the mass of the oven-dried soil.

$$\text{Percent of Moisture} = \frac{\text{mass of water}}{\text{mass of oven-dried soil}} \times 100$$

Mass of water = wet soil - oven-dried soil

09

**Plastic Limit**

The moisture content, as determined in Step 9 above, is the Plastic Limit. It is advisable to run several trials on the same material to ensure a proper determination of the Plastic Limit of the soil.

**Plasticity Index**

The Plasticity Index (PI) of the soil is equal to the difference between the Liquid Limit (LL) and the Plastic Limit (PL).

$PI = LL - PL$

Examples: #1

LL = 34 and PL = 17  
 PI = 34 - 17 = 17

#2

LL = 16 and PL = 10  
 PI = 16 - 10 = 6

**Example Calculation**

Container	Container Mass, g	Container and Wet Soil Mass, g	Wet Soil Mass, g	Container and Dry Soil Mass, g	Dry Soil Mass, g
1	14.44	22.65	8.21	21.45	7.01
2	14.18	23.69	9.51	22.81	8.63

Water Mass, g	Moisture Content	Plastic Limit
1.20	17.1	17
0.88	10.2	10

10

**Tips!**

- Some soils, such as sandy silts, require very light pressure when rolling.
- If the sample flattens rather than rolling into a thread, it may be too wet.

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**Report**

- Results shall be reported on standard forms approved by the agency.
- Report percent moisture to the 0.1 percent
- Report the PL and PI to the nearest whole number.



**REVIEW QUESTIONS**

1. Describe how to obtain the plastic limit sample if done in conjunction with the liquid limit procedure.
  
2. Describe the process for determining the plastic limit.
  
3. What does the plastic limit represent?
  
4. How is the plastic limit used with the liquid limit?
  
5. What does the plasticity index represent?
  
6. Approximately how much soil should be prepared to run the plastic limit test?
  
7. What is the approximate mass of the ellipsoidal sample?
  
8. What change in the procedure is permissible for feeble plastic soils?



**PERFORMANCE EXAM CHECKLIST**

**DETERMINING THE PLASTIC LIMIT AND PLASTICITY INDEX OF SOILS  
FOP FOR AASHTO T 90**

Participant Name \_\_\_\_\_ Exam Date \_\_\_\_\_

Record the symbols "P" for passing or "F" for failing on each step of the checklist.

Procedure Element	Trial 1	Trial 2
1. Describe the preparation of the plastic limit sample:	_____	_____
a. Sample may be obtained from preparations for liquid limit test sample?	_____	_____
b. Sample mass approximately 20 g of minus #40?	_____	_____
c. Mix in dish with enough distilled or demineralized water until easily shaped into ball?	_____	_____
d. Approximately 8 g sample obtained?	_____	_____
2. 1.5 to 2.0 mass obtained from ball?	_____	_____
3. Sample squeezed into ellipsoidal mass?	_____	_____
4. Mass rolled into 1/8" thread at rate of 80-90/min?	_____	_____
5. Thread broken into six or eight pieces, recombined, and rolling repeated?	_____	_____
6. Moisture sample obtained when thread just begins to crumble?	_____	_____
7. Tare mass of moisture container determined?	_____	_____
8. Moisture sample properly taken and wet mass determined?	_____	_____
9. Moisture content determined by the FOP for AASHTO T 265?	_____	_____
10. Multiple tries conducted until 8 g of original sample used?	_____	_____
11. Plastic limit correctly calculated and rounded to nearest whole number?	_____	_____
12. Plasticity index determined by subtracting plastic limit from liquid limit?	_____	_____
13. Plasticity index reported to the whole number?	_____	_____
14. Reported on standard agency form?	_____	_____

Comments: First attempt: Pass  Fail  Second attempt: Pass  Fail

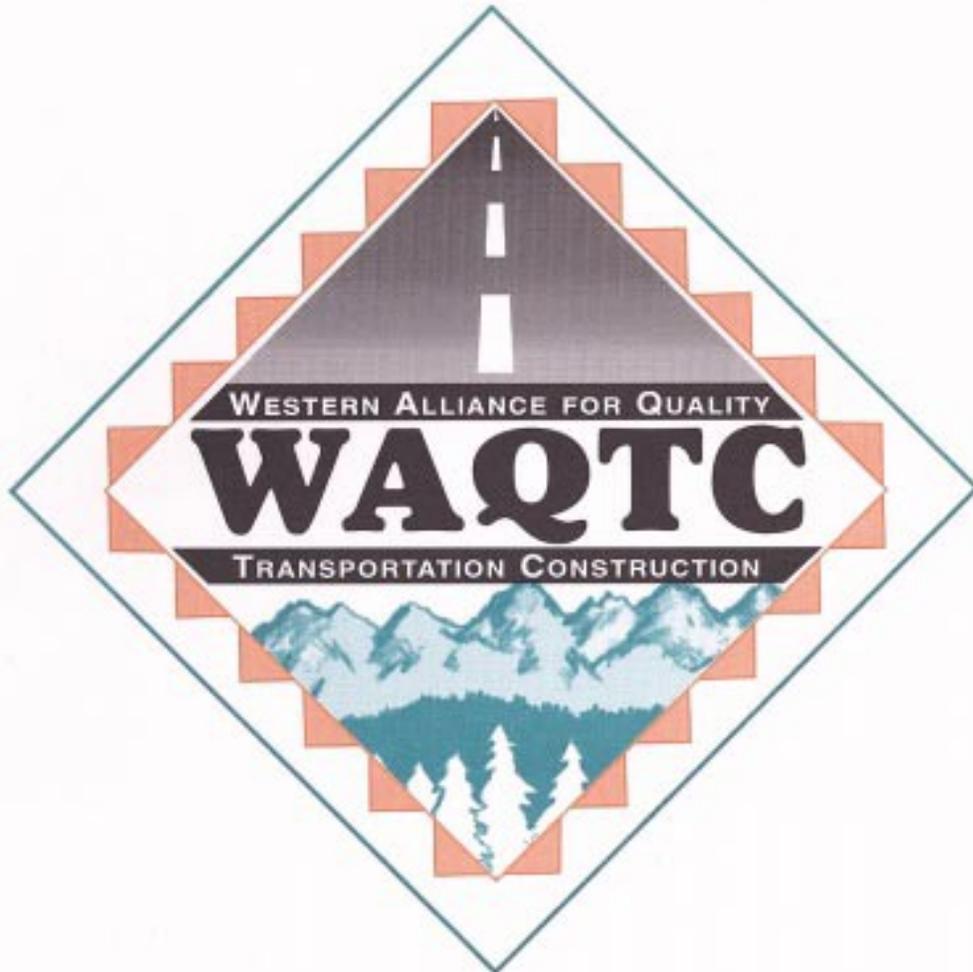
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Signature of Examiner \_\_\_\_\_



**Transportation Technician  
Qualification Program**

***EMBANKMENT & BASE  
IN-PLACE DENSITY  
Participant Workbook***





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## PREFACE

This module is one of a set developed for the Western Alliance for Quality Transportation Construction (WAQTC). WAQTC is an alliance supported by the western state Transportation Departments, along with the Federal Highway Administration (FHWA) and the Western Federal Lands Highway Division (WFLHD) of FHWA. WAQTC's charter includes the following mission.

### MISSION

Provide continuously improving quality in transportation construction.

Through our partnership, we will:

- Promote an atmosphere of trust, cooperation, and communication between government agencies and with the private sector.
- Assure personnel are qualified.
- Respond to the requirements of identified needs and new technologies that impact the products that we provide.

### BACKGROUND

There are two significant driving forces behind the development of the WAQTC qualification program. One, there is a trend to the use of quality control/quality assurance (QC/QA) specifications. QC/QA specifications include qualification requirements for a contractor's QC personnel and will be requiring WAQTC qualified technicians. Two, Federal regulation on materials sampling and testing (23 CFR 637, *Quality Assurance Procedures for Construction*, published in June 1995) mandates that by June 29, 2000 all testing technicians whose results are used as part of the acceptance decision shall be qualified. In addition, the regulation allows the use of contractor test results to be used as part of the acceptance decision.

### OBJECTIVES

WAQTC's objectives for its Transportation Technician Qualification Program include the following:

- To provide highly skilled, knowledgeable materials sampling and testing technicians.
- To promote uniformity and consistency in testing.
- To provide reciprocity for qualified testing technicians between states.
- To create a harmonious working atmosphere between public and private employees based upon trust, open communication, and equality of qualifications.

Training and qualification of transportation technicians is required for several reasons. It will increase the knowledge of laboratory, production, and field technicians — both industry and agency personnel — and increase the number of available, qualified testers. It will reduce problems associated with test result differences. Regional qualification eliminates the issue of reciprocity between states and allows qualified QC technicians to cross state lines without having the concern or need to be re-qualified by a different program.

The WAQTC Executive Board

## FOREWORD

This module is one of six developed to satisfy the training requirements prescribed by Western Alliance for Quality Transportation Construction (WAQTC) for technicians involved in transportation projects. The six modules cover:

- Aggregate
- Concrete
- Asphalt I
- Asphalt II
- Embankment and Base
- In-place Density

The modules are based upon AASHTO test methods along with procedures developed by WAQTC. They are narrative in style, illustrated, and include step-by-step instruction. There are review questions at the end of each test procedure, which are intended to reinforce the participants' understanding and help participants prepare for the final written and performance exams. Performance exam check lists are also included. The appendices include the corresponding AASHTO and WAQTC test methods.

It is the technician's responsibility to stay current as changes are made to this living document.

The comments and suggestions of every participant are essential to the continued success and high standards of the Transportation Technician Qualification Program. Please take the time to fill out the Course Evaluation Form as the course progresses and hand it in on the last day of class. If you need additional room to fully convey your thoughts, please use the back of the form.

The WAQTC Executive Board



## **GUIDANCE FOR COURSE EVALUATION FORM**

The Course Evaluation Form on the following page is very important to the continuing improvement and success of this course. The form is included in each Participant Workbook. During the course introduction, the Instructor will call the participants' attention to the form, its content, and the importance of its thoughtful completion at the end of the course. Participants will be encouraged to keep notes, or write down comments as the class progresses, in order to provide the best possible evaluation. The Instructor will direct participants to write down comments at the end of each day and to make use of the back of the form if more room is needed for comments.

On the last day of the course, just before the written examination, the Instructor will again refer to the form and instruct participants that completion of the form after their last examination is a requirement before leaving. Should the course have more than one Instructor, participants should be directed to list them as A, B, etc., with the Instructor's name beside the letter, and direct their answers in the Instructor Evaluation portion of the form accordingly.

EMBANKMENT AND BASE  
IN-PLACE DENSITY

WAQTC

FEEDBACK INSTRUCTIONS

**WESTERN ALLIANCE FOR QUALITY TRANSPORTATION CONSTRUCTION  
COURSE EVALUATION FORM**

The WAQTC Transportation Technician Qualification Program would appreciate your thoughtful completion of all items on this evaluation form. Your comments and constructive suggestions will be an asset in our continuing efforts to improve our course content and presentations.

Course Title: \_\_\_\_\_

Location: \_\_\_\_\_

Dates: \_\_\_\_\_

Your Name (Optional): \_\_\_\_\_

Employer: \_\_\_\_\_

Instructor(s) \_\_\_\_\_

**COURSE CONTENT**

Will the course help you perform your job better and with more understanding? Yes      Maybe      No

Explain: \_\_\_\_\_

\_\_\_\_\_

Was there an adequate balance between theory, instruction, and hands-on application? Yes      Maybe      No

Explain: \_\_\_\_\_

\_\_\_\_\_

Did the course prepare you to confidently complete both examinations? Yes      Maybe      No

Explain: \_\_\_\_\_

\_\_\_\_\_

What was the most beneficial aspect of the course? \_\_\_\_\_

\_\_\_\_\_

What was the least beneficial aspect of the course? \_\_\_\_\_

\_\_\_\_\_

**GENERAL COMMENTS**

General comments on the course, content, materials, presentation method, facility, registration process, etc. Include suggestions for additional Tips!

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**INSTRUCTOR EVALUATION**

Were the objectives of the course, and the instructional and exam approach, clearly explained? Yes      Maybe      No

Explain: \_\_\_\_\_

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Was the information presented in a clear, understandable manner? Yes      Maybe      No

Explain: \_\_\_\_\_

---

Did the instructors demonstrate a good knowledge of the subject? Yes      Maybe      No

Explain: \_\_\_\_\_

---

Did the instructors create an atmosphere in which to ask questions and hold open discussion? Yes      Maybe      No

Explain: \_\_\_\_\_

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## EMBANKMENT AND BASE

### Learning Objectives

Instructional objectives for this course include:

- Being familiar with Quality Assurance (QA) concepts
- Developing a background in measurements and calculations
- Being knowledgeable in highway materials terminology
- Respecting safety issues
- Acquiring knowledge of random sampling techniques
- Understanding the basics of compaction and density control
- Becoming proficient in the following quality control test procedures:

FOP for AASHTO T 255

Total Moisture Evaporable Content of Aggregate by Drying;

AASHTO T 265

Laboratory Determination of Moisture Content of Soils

FOP for AASHTO T 99

Moisture-Density Relations of Soils Using a 2.5-kg (5.5-lb) Rammer  
and 305-mm (12-in.) Drop;

AASHTO T 180

Moisture-Density Relations of Soils Using a 4.54-kg (10-lb) Rammer  
and 457-mm (18-in.) Drop

FOP for AASHTO R 75

Developing a Family of Curves

FOP for FOP for AASHTO T 85

Specific Gravity and Absorption of Coarse Aggregate

The overall goals of this embankment and base course are to understand compaction and density control and to be competent with specific quality control test procedures identified for the Transportation Technician Qualification Program of the Western Alliance for Quality Transportation Construction (WAQTC). Additional studies beyond this course will be required for those desiring greater in-depth knowledge of the theory behind the test procedures included herein.

**Course Outline and Suggested Schedule (Embankment and Base)****Day One**

- 0800 Welcome  
Introduction of Instructors  
Introduction and Expectations of Participants
- 0815 WAQTC Mission and TTQP Objectives  
Instructional Objectives for the Course  
Overview of the Course  
Course Evaluation Form
- 0830 Review of Quality Assurance Concepts
- 0845 Background in Measurements and Calculations
- 0945 Break
- 1000 Random Sampling
- 1030 Basics of Compaction and Density Control
- 1045 Total Evaporable Moisture Content of Aggregate by Drying  
FOP for AASHTO T 255  
Laboratory Determination of Moisture Content of Soils  
FOP for AASHTO T 265
- 1115 Moisture-Density Relations of Soils:  
Using a 2.5-kg (5.5-lb) Rammer and 305-mm (12-in.) Drop  
FOP for AASHTO T 99  
Using a 4.54-kg (10-lb) Rammer and 457-mm (18-in.) Drop  
FOP for AASHTO T 180
- 1130 Review Questions  
Questions and Answers
- 1200 Lunch
- 1315 Correction for Coarse Particles in the Soil Compaction Test  
Annex to FOP for T 99 / T 180
- 1400 Laboratory Practice  
Moisture Content and Moisture-Density Relations
- 1645 Evaluation  
End of Day

**Day Two**

- 0800 Questions from the Previous Day
- 0815 Developing a Family of Curves  
FOP for AASHTO R 75
- 0830 Laboratory Practice  
Moisture Content and Moisture-Density Relations (continued)
- 0945 Break
- 1200 Lunch
- 1315 Laboratory Practice  
Moisture Content and Moisture-Density Relations (continued)
- 1645 Evaluation  
End of Day

**Day Three**

- 0800 Questions from Previous Day
- 0815 Specific Gravity and Absorption of Coarse Aggregate  
FOP for AASHTO T 85
- 0845 Laboratory Practice  
Specific Gravity and Absorption
- 0945 Break
- 1000 Laboratory Practice
- 1130 Review Questions  
Questions and Answers
- 1200 Lunch
- 1315 Laboratory Practice  
Completion of any Moisture Content Determinations
- 1645 Evaluation  
End of day

**Day Four**

0800 Questions from Previous Day

0815 Instruction on Use of AKDOT&PF ATM 12, ITD IT 74, WSDOT  
T 606, or WFLHD Humphres Curves

0845 Laboratory Practice  
Open Lab to Practice Any Procedure

1200 Lunch

1315 Start of Exams

Participants will break into groups so that written and practical exams may be given concurrently.

Evaluation

**IN-PLACE DENSITY****Learning Objectives**

Instructional objectives for this course include:

- Being familiar with Quality Assurance (QA) concepts
- Developing a background in measurements and calculations
- Being knowledgeable in highway materials terminology
- Respecting safety issues
- Acquiring knowledge of random sampling techniques
- Understanding the basics of compaction and density control
- Becoming proficient in the following quality control test procedures:

FOP for AASHTO T 255

Total Moisture Evaporable Content of Aggregate by Drying;

AASHTO T 265

Laboratory Determination of Moisture Content of Soils

FOP for AASHTO T 99

Moisture-Density Relations of Soils Using a 2.5-kg (5.5-lb) Rammer and  
305-mm (12-in.) Drop;

AASHTO T 180

Moisture-Density Relations of Soils Using a 4.54-kg (10-lb) Rammer and  
457-mm (18-in.) Drop

FOP for AASHTO R 75

Developing a Family of Curves

FOP for AASHTO T 272

One-Point Method for Determining Maximum Dry Density and Optimum  
Moisture

FOP for AASHTO T 85

Specific Gravity and Absorption of Coarse Aggregate

FOP for AASHTO T 310

In-Place Density and Moisture Content of Soil and Soil-Aggregate by Nuclear  
Methods (Shallow Depth)

FOP for AASHTO T 209

Theoretical Maximum Specific Gravity ( $G_{mm}$ ) and Density of Hot Mix  
Asphalt (HMA) Paving Mixtures

## FOP for AASHTO T 166

Bulk Specific Gravity ( $G_{mb}$ ) of Compacted Hot Mix Asphalt (HMA) Mixtures  
Using Saturated Surface-Dry Specimens

## FOP for AASHTO T 355

In-Place Density of Asphalt Mixtures Using by Nuclear Method

The overall goals of this embankment and base course are to understand compaction and density control and to be competent with specific quality control test procedures identified for the Transportation Technician Qualification Program of the Western Alliance for Quality Transportation Construction (WAQTC). Additional studies beyond this course will be required for those desiring greater in-depth knowledge of the theory behind the test procedures included herein.

## Course Outline and Suggested Schedule (In-Place Density)

**Day One**

- 0800 Welcome
  - Introduction of Instructors
  - Introduction and Expectations of Participants
  
- 0815 WAQTC Mission and TTQP Objectives
  - Instructional Objectives for the Course
  - Overview of the Course
  - Course Evaluation Form
  
- 0830 Review of Quality Assurance Concepts
  
- 0845 Background in Measurements and Calculations
  
- 0945 Break
  
- 1000 Random Sampling
  
- 1030 Basics of Compaction and Density Control
- 1045 Total Moisture Content of Aggregate by Drying

FOP for AASHTO T 255  
Laboratory Determination of Moisture Content of Soils  
FOP for AASHTO T 265

1115 Review Questions  
Questions and Answers

1200 Lunch

1315 Moisture-Density Relations of Soils:  
Using a 2.5-kg (5.5-lb) Rammer and 305-mm (12-in.) Drop  
FOP for AASHTO T 99  
Using a 4.54-kg (10-lb) Rammer and 457-mm (18-in.) Drop  
FOP for AASHTO T 180

1345 Correction for Coarse Particles in the Soil Compaction Test  
Annex to FOP for AASHTO T 99/T 180

1400 Laboratory Practice

1645 Evaluation  
End of Day

## **Day Two**

0800 Questions from the Previous Day

0815 Specific Gravity and Absorption of Coarse Aggregate  
FOP for AASHTO T 85

0845 Developing a Family of Curves  
FOP for AASHTO R 75  
One-Point Method for Determining Maximum Dry Density and Optimum Moisture  
FOP for AASHTO T 272

0945 Break

- 1000 Review Questions  
Questions and Answers
- 1015 Instruction on Use of AKDOT&PF ATM 12, ITD IT 74, WSDOT  
T 606, or WFLHD Humphres Curves
- 1045 In-Place Density and Moisture Content of Soil and Soil-Aggregate by Nuclear  
Methods (Shallow Depth)  
FOP for AASHTO T 310
- 1130 Review Questions  
Questions and Answers
- 1200 Lunch
- 1315 Laboratory Practice  
In-Place Density of Embankment and Base
- 1645 Evaluation  
End of day

### Day Three

- 0800 Questions from the Previous Day
- 0815 Theoretical Maximum Specific Gravity ( $G_{mm}$ ) and Density of Hot Mix Asphalt  
(HMA) Paving Mixtures  
FOP for AASHTO T 209
- 0900 Bulk Specific Gravity ( $G_{mb}$ ) of Compacted Hot Mix Asphalt (HMA) Mixtures Using  
Saturated Surface-Dry Specimens  
FOP for AASHTO T 166
- 0945 Break
- 1000 Review Questions

## Questions and Answers

1030 In-Place Density of Asphalt Mixtures by Nuclear  
Method  
FOP for AASHTO T 355

1130 Review Questions  
Questions and Answers

1200 Lunch

1315 Laboratory Practice  
In-Place Density of Bituminous Mixes

1645 Evaluation  
End of Day

**Day Four**

0800 Start of Exams

Participants will break into groups so that written and practical exams may be given concurrently.

Evaluation

IN-PLACE DENSITY

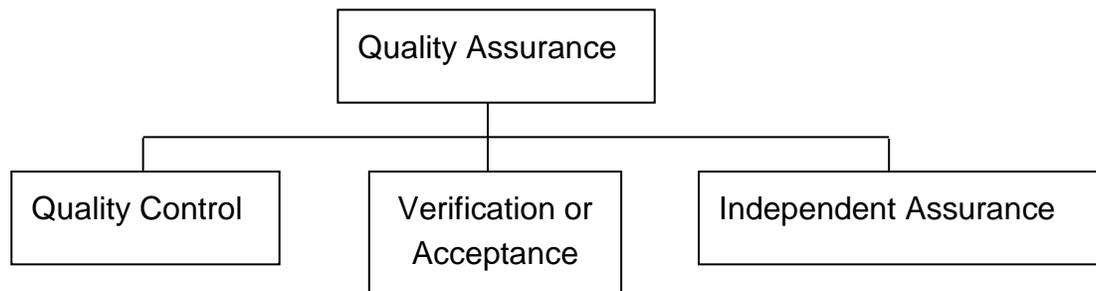
WAQTC

OBJECTIVES AND SCHEDULE

## QUALITY ASSURANCE CONCEPTS

The Federal Highway Administration (FHWA) has established requirements that each State Transportation Department (STD) must develop a Quality Assurance (QA) Program that is approved by the FHWA for projects on the National Highway System (NHS). In addition to complying with this requirement, implementing QA specifications in a construction program includes the benefit of improvement of overall quality of highway and bridge construction.

A QA Program may include three separate and distinct parts as illustrated below.



**Quality Assurance (QA)** are those planned and systematic actions necessary to provide confidence that a product or service will satisfy given requirements for quality.

**Quality Control (QC)** are those operational, process control techniques or activities that are performed or conducted to fulfill contract requirements for material and equipment quality. In some states, the constructor is responsible for providing QC sampling and testing, while in other states the STD handles QC. Where the constructor is responsible for QC tests, the results may be used for acceptance only if verified or accepted by additional tests performed by an independent group.

**Verification/Acceptance** consists of the sampling and testing performed to validate QC sampling and testing and, thus, the quality of the product. Verification/Acceptance samples are obtained and tests are performed independently from those involved with QC. Samples taken for QC tests may not be used for Verification/Acceptance testing.

**Independent Assurance (IA)** are those activities that are an unbiased and independent evaluation of all the sampling and testing procedures used in QC and Verification/Acceptance. IA may use a combination of laboratory certification, technician qualification or certification, proficiency samples, or split samples to assure that QC and Verification/Acceptance activities are valid. Agencies may qualify or certify laboratories and technicians, depending on the state in which the work is done.

EMBANKMENT AND BASE  
IN-PLACE DENSITY

WAQTC

QUALITY ASSURANCE

**BACKGROUND ON MEASUREMENTS AND CALCULATIONS**

01

**Introduction**

This section provides a background in the mathematical rules and procedures used in making measurements and performing calculations. Topics include:

- Units: Metric vs. English
- Mass vs. Weight
- Balances and Scales
- Rounding
- Significant Figures
- Accuracy and Precision
- Tolerance

Also included is discussion of real-world applications in which the mathematical rules and procedures may not be followed.

02

**Units: Metric vs. English**

The bulk of this document uses dual units. Metric units are followed by Imperial, more commonly known as English, units in parentheses. For example: 25 mm (1 in.). Exams are presented in metric or English.

03

Depending on the situation, some conversions are exact, and some are approximate. One inch is exactly 25.4 mm. If a procedure calls for measuring to the closest 1/4 in., however, 5 mm is close enough. We do not have to say 6.35 mm. That is because 1/4 in. is half way between 1/8 in. and 3/8 in. – or half way between 3.2 and 9.5 mm. Additionally, the tape measure or rule used may have 5 mm marks, but may not have 1 mm marks and certainly will not be graduated in 6 mm increments.

04

In SI (Le Systeme International d’Unites), the basic unit of mass is the kilogram (kg) and the basic unit of force, which includes weight, is the Newton (N). Mass in this document is given in grams (g) or kg.

Basic units in SI include:

Length: meter, m  
Mass: kilogram, kg  
Time: second, s

Derived units in SI include:

Force: Newton, N

**SI units**

<u>Metric</u>	<u>English</u>
25 mm	1 in.
1 kg	2.2 lb
1000 kg/m <sup>3</sup>	62.4 lb/ft <sup>3</sup>
25 MPa	3600 lb/in. <sup>2</sup>

**Some approximate conversions**

See the section below on “Mass vs. Weight” for further discussion of this topic.

**Mass vs. Weight**

05

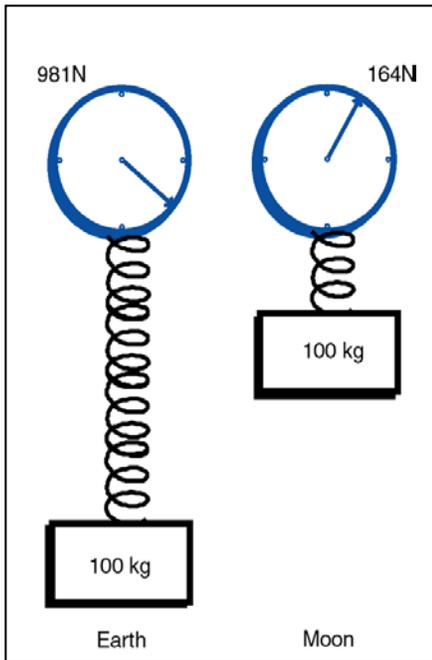
The terms mass, force, and weight are often confused. Mass, m, is a measure of an object’s material makeup, and has no direction. Force, F, is a measure of a push or pull, and has the direction of the push or pull. Force is equal to mass times acceleration, a.

06

$$F = ma$$

Weight, W, is a special kind of force, caused by gravitational acceleration. It is the force required to suspend or lift a mass against gravity. Weight is equal to mass times the acceleration due to gravity, g, and is directed toward the center of the earth.

$$W = mg$$



**Comparison of mass and weight**

07

In SI, the basic unit of mass is the kilogram (kg), the units of acceleration are meters per square second ( $m/s^2$ ), and the unit of force is the Newton (N). Thus a person having a mass of 84 kg subject to the standard acceleration due to gravity, on earth, of  $9.81 m/s^2$  would have a weight of:

08

$$W = (84.0 \text{ kg})(9.81 \text{ m/s}^2) = 824 \text{ kg}\cdot\text{m/s}^2 = 824 \text{ N}$$

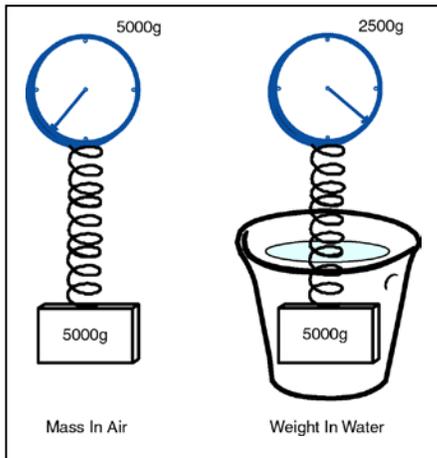
In the English system, mass can be measured in pounds-mass ( $lb_m$ ), while acceleration is in feet per square second ( $ft/s^2$ ), and force is in pounds-force ( $lb_f$ ). A person weighing  $185 lb_f$  on a scale has a mass of  $185 lb_m$  when subjected to the earth’s standard gravitational pull. If this person were to go to the moon, where the acceleration due to gravity is about one-sixth of what it is on earth, the person’s weight would be about  $31 lb_f$ , while his or her mass would remain  $185 lb_m$ . Mass does not depend on location, but weight does.

While the acceleration due to gravity does vary with position on the earth (latitude and elevation), the variation is not significant except for extremely

precise work – the manufacture of electronic memory chips, for example.

As discussed above, there are two kinds of pounds,  $lb_m$  and  $lb_f$ . In laboratory measurements of mass, the gram or kilogram is the unit of choice. But, is this mass or force? Technically, it depends on the instrument used, but practically speaking, mass is the result of the measurement. When using a scale, force is being measured – either electronically by the stretching of strain gauges or mechanically by the stretching of a spring or other device. When using a balance, mass is being measured, because the mass of the object is being compared to a known mass built into the balance.

09



**Submerged weight**

10

11

12

In this document, mass, not weight, is used in test procedures except when determining “weight” in water. When an object is submerged in water (as is done in specific gravity tests), the term weight is used. Technically, what is being measured is the force the object exerts on the balance or scale while the object is submerged in water (or the submerged weight). This force is actually the weight of the object less the weight of the volume of water displaced.

In summary, whenever the common terms “weight” and “weighing” are used, the more appropriate terms “mass” and “determining mass” are usually implied, except in the case of weighing an object submerged in water.

### Balances and Scales

Balances, technically used for mass determinations, and scales, used to weigh items, were discussed briefly above in the section on “Mass vs. Weight.” In field operating procedures, we usually do not differentiate between the two types of instruments. When using either one for a material or object in air, we are determining mass. For those procedures in which the material or object is suspended in water, we are determining weight in water.

13

14

AASHTO recognizes two general categories of instruments. Standard analytical balances are used

in laboratories. For most field operations, general purpose balances and scales are specified. Specifications for both categories are shown in Tables 1 and 2.

**Table 1**  
**Standard Analytical Balances**

<b>Class</b>	<b>Capacity</b>	<b>Readability and Sensitivity</b>	<b>Accuracy</b>
A	200 g	0.0001 g	0.0002 g
B	200 g	0.001 g	0.002 g
C	1200 g	0.01 g	0.02 g

**Table 2**  
**General Purpose Balances and Scales**

<b>Class</b>	<b>Principal Sample Mass</b>	<b>Readability and Sensitivity</b>	<b>Accuracy</b>
G2	2 kg or less	0.1 g	0.1 g or 0.1 percent
G5	2 kg to 5 kg	1 g	1 g or 0.1 percent
G20	5 kg to 20 kg	5 g	5 g or 0.1 percent
G100	Over 20 kg	20 g	20 g or 0.1 percent

15

**Rounding**

Numbers are commonly rounded up or down after measurement or calculation. For example, 53.67 would be rounded to 53.7 and 53.43 would be rounded to 53.4, if rounding were required. The first number was rounded up because 53.67 is closer to 53.7 than to 53.6. Likewise, the second number was rounded down because 53.43 is closer to 53.4 than to 53.5. The reasons for rounding are covered in the next section on “Significant Figures.”

If the number being rounded ends with a 5, two possibilities exist. In the more mathematically sound approach, numbers are rounded up or down depending on whether the number to the left of the 5 is odd or even. Thus, 102.25 would be rounded down to 102.2, while 102.35 would be rounded up to 102.4. This procedure avoids the bias that would exist if all numbers ending in 5 were rounded up or all numbers were rounded down. In some calculators, however, all rounding is up. This does result in some bias, or skewing of data, but the significance of the bias may or may not be significant to the calculations at hand.

### Significant Figures

- General

16

A general purpose balance or scale, classified as G20 in AASHTO M 231, has a capacity of 20,000 g and an accuracy requirement of  $\pm 5$  g. A mass of 18,285 g determined with such an instrument could actually range from 18,280 g to 18,290 g. Only four places in the measurement are significant. The fifth (last) place is not significant since it may change.

17

Mathematical rules exist for handling significant figures in different situations.

An example in Metric(**m**) or English(**ft**), when performing addition and subtraction, the number of significant figures in the sum or difference is determined by the least precise input. Consider the three situations shown below:

<u>Situation 1</u>	<u>Situation 2</u>	<u>Situation 3</u>
35.67	143.903	162
<u>+ 423.938</u>	<u>- 23.6</u>	+33.546
		<u>- .022</u>
= 459.61	= 120.3	= 196
not 459.608	not 120.303	not 195.524

Rules also exist for multiplication and division. These rules, and the rules for mixed operations involving addition, subtraction, multiplication,

and/or division, are beyond the scope of these materials. AASHTO covers this topic to a certain extent in the section called “Precision” or “Precision and Bias” included in many test methods, and the reader is directed to those sections if more detail is desired.

18

- Real World Limitations

While the mathematical rules of significant digits have been established, they are not always followed. For example, AASHTO Method of Test T 176, *Plastic Fines in Graded Aggregates and Soils by the Use of the Sand Equivalent Test*, prescribes a method for rounding and significant digits in conflict with the mathematical rules.

In this procedure, readings and calculated values are always rounded up. A clay reading of 7.94 would be rounded to 8.0 and a sand reading of 3.21 would be rounded to 3.3. The rounded numbers are then used to calculate the Sand Equivalent, which is the ratio of the two numbers multiplied by 100. In this case:

$$\frac{3.3}{8.0} \times 100 = 41.250 \dots$$

rounded to 41.3 and reported as 42

*Not:*  $\frac{3.21}{7.94} \times 100 = 40.428 \dots$

rounded to 40.0 and reported as 40)

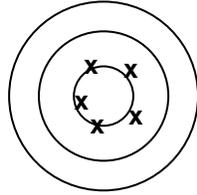
It is extremely important that engineers and technicians understand the rules of rounding and significant digits just as well as they know procedures called for in standard test methods.

### Accuracy and Precision

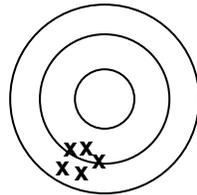
19

Although often used interchangeably, the terms accuracy and precision do not mean the same thing. In an engineering sense, accuracy denotes nearness

20



ACCURATE BUT NOT PRECISE,  
SCATTERED



PRECISE BUT NOT ACCURATE,  
BIASED

to the truth or some value accepted as the truth, while precision relates to the degree of refinement or repeatability of a measurement.

Two bulls-eye targets are shown to the left. The upper one indicates hits that are scattered and, yet, are very close to the center. The lower one has a tight pattern, but all the shots are biased from the center. The upper one is more accurate, while the lower one is more precise. A biased, but precise, instrument can often be adjusted physically or mathematically to provide reliable single measurements. A scattered, but accurate, instrument can be used if enough measurements are made to provide a valid average.

Consider the measurement of the temperature of boiling water at standard atmospheric pressure by two thermometers. Five readings were taken with each, and the values were averaged.

Thermometer No. 1	Thermometer No. 2
101.2° 214.2°	100.6° 213.1°
101.1° 214.0°	99.2° 210.6°
101.2° 214.2°	98.9° 210.0°
101.1° 214.0°	101.0° 213.8°
101.2° 214.2°	100.3° 212.5°
AVG = 101.2° 214.2°	AVG = 100.0° 212°

No. 1 shows very little fluctuation, but is off the known boiling point (100°C or 212°F) by 1.2°C or 2.2°F. No. 2 has an average value equal to the known boiling point, but shows quite a bit of fluctuation. While it might be preferable to use neither thermometer, thermometer No. 1 could be employed if 1.2°C or 2.2°F were subtracted from each measurement. Thermometer No. 2 could be used if enough measurements were made to provide a valid average.

Engineering and scientific instruments should be calibrated and compared against reference standards periodically to assure that measurements are accurate. If such checks are not performed, the accuracy is uncertain, no matter what the precision. Calibration of an instrument removes fixed error, leaving only random error for concern.

### Tolerance

26 Dimensions of constructed or manufactured objects,  
including laboratory test equipment, cannot be  
specified exactly. Some tolerance must be allowed.  
Thus, procedures for including tolerance in  
27 addition/subtraction and multiplication/division  
operations must be understood.

- Addition and Subtraction

When adding or subtracting two numbers that individually have a tolerance, the tolerance of the sum or difference is equal to the sum of the individual tolerances.

An example in Metric(**m**) or English(**ft**), if the distance between two points is made up of two parts, one being  $113.361 \pm 0.006$  and the other being  $87.242 \pm 0.005$  then the tolerance of the sum (or the difference) is:

$$(0.006) + (0.005) = 0.011$$

and the sum would be  $200.603 \pm 0.011$ .

- Multiplication and Division

28 To demonstrate the determination of tolerance again in either Metric(**m**) or English(**ft**) for the product of two numbers, consider determining the area of a rectangle having sides of  $76.254 \pm 0.009$  and  $34.972 \pm 0.007$ . The percentage variations of the two dimensions are:

$$\frac{0.009}{76.254} \times 100 = 0.01\% \quad \frac{0.007}{34.972} \times 100 = 0.02\%$$

The sum of the percentage variations is 0.03 percent – the variation that is employed in the area of the rectangle:

$$\begin{aligned} \text{Area} = \\ 2666.8 \text{ (m}^2 \text{ or ft}^2) \pm 0.03 \text{ percent} = \\ 2666.8 \pm 0.8 \text{ (m}^2 \text{ or ft}^2). \end{aligned}$$

- Real World Applications

Tolerances are used whenever a product is manufactured. For example, the mold used for determining soil density in AASHTO T 99 has a diameter of  $101.60 \pm 0.41$  mm ( $4.000 \pm 0.016$  in) and a height of  $116.43 \pm 0.13$  mm ( $4.584 \pm 0.005$  in).

Using the smaller of each dimension results in a volume of:

$$(\pi/4) (101.19 \text{ mm})^2 (116.30 \text{ mm}) = 935,287 \text{ mm}^3 \text{ or } 0.000935 \text{ m}^3$$

$$(\pi/4) (3.984 \text{ in})^2 (4.579 \text{ in}) = 57.082 \text{ in}^3 \text{ or } 0.0330 \text{ ft}^3$$

Using the larger of each dimension results in a volume of:

$$(\pi/4) (102.01 \text{ mm})^2 (116.56 \text{ mm}) = 952,631 \text{ mm}^3 \text{ or } 0.000953 \text{ m}^3$$

$$(\pi/4) (4.016 \text{ in})^2 (4.589 \text{ in}) = 58.130 \text{ in}^3 \text{ or } 0.0336 \text{ ft}^3$$

The average value is  $0.000944 \text{ m}^3$  (0.0333), and AASHTO T 99 specifies a volume of:

$$0.000943 \pm 0.000008 \text{ m}^3$$

or a range of

$$0.000935 \text{ to } 0.000951 \text{ m}^3$$

$$0.0333 \pm 0.0003 \text{ ft}^3$$

or a range of

$$0.0330 \text{ to } 0.0336 \text{ ft}^3$$

Because of the variation that can occur, some agencies periodically standardize molds, and make adjustments to calculated density based on those calculations.

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### **Summary**

Mathematics has certain rules and procedures for making measurements and performing calculations that are well established. So are standardized test procedures. Sometimes these agree, but occasionally, they do not. Engineers and technicians must be familiar with both, but must follow test procedures in order to obtain valid, comparable results.

## TERMINOLOGY

Many of the terms listed below are defined differently by various agencies or organizations. The definitions of the American Association of State Highway and Transportation Officials (AASHTO) are the ones most commonly used in this document.

**Absorbed water** – Water drawn into a solid by absorption, and having physical properties similar to ordinary water.

**Absorption** – The increase in the mass of aggregate due to water being absorbed into the pores of the material, but not including water adhering to the outside surface of the particles, expressed as a percentage of the dry mass.

**Acceptance** – See verification.

**Acceptance program** – All factors that comprise the State Transportation Department's (STD) determination of the quality of the product as specified in the contract requirements. These factors include verification sampling, testing, and inspection and may include results of quality control sampling and testing.

**Admixture** – Material other than water, cement, and aggregates in Portland cement concrete (PCC).

**Adsorbed water** – Water attached to the surface of a solid by electrochemical forces, and having physical properties substantially different from ordinary water.

**Aggregate** – Hard granular material of mineral composition, including sand, gravel, slag or crushed stone, used in roadway base and in Portland cement concrete (PCC) and asphalt mixtures.

- **Coarse aggregate** – Aggregate retained on or above the No. 4 (4.75 mm) sieve.
- **Coarse-graded aggregate** – Aggregate having a predominance of coarse sizes.
- **Dense-graded aggregate** – Aggregate having a particle size distribution such that voids occupy a relatively small percentage of the total volume.
- **Fine aggregate** – Aggregate passing the No. 4 (4.75 mm) sieve.
- **Fine-graded aggregate** – Aggregate having a predominance of fine sizes.
- **Mineral filler** – A fine mineral product at least 70 percent of which passes a No. 200 (75  $\mu$ m) sieve.
- **Open-graded gap-graded aggregate** – Aggregate having a particle size distribution such that voids occupy a relatively large percentage of the total volume.
- **Well-Graded Aggregate** – Aggregate having an even distribution of particle sizes.

**Aggregate storage bins** – Bins that store aggregate for feeding material to the dryer in a hot mix asphalt (HMA) plant in substantially the same proportion as required in the finished mix.

**Agitation** – Provision of gentle motion in Portland cement concrete (PCC) sufficient to prevent segregation and loss of plasticity.

**Air voids ( $V_a$ )** – Total volume of the small air pockets between coated aggregate particles in asphalt mixtures; expressed as a percentage of the bulk volume of the compacted paving mixture.

**Ambient temperature** – Temperature of the surrounding air

**Angular aggregate** – Aggregate possessing well-defined edges at the intersection of roughly planar faces

**Apparent specific gravity ( $G_{sa}$ )** – The ratio of the mass, in air, of a volume of the impermeable portion of aggregate to the mass of an equal volume of water at a stated temperature.

**Asphalt** – A dark brown to black cementitious material in which the predominate constituents are bitumens occurring in nature or obtained through petroleum processing. Asphalt is a constituent of most crude petroleum.

**Asphalt emulsion** – A mixture of asphalt binder and water.

**Asphalt binder** – An asphalt specially prepared in quality and consistency for use in the manufacture of asphalt mixtures.

**Asphalt mixtures** – A controlled mix of aggregate and asphalt binder.

**Automatic cycling control** – A control system in which the opening and closing of the weigh hopper discharge gate, the bituminous discharge valve, and the pugmill discharge gate are actuated by means of automatic mechanical or electronic devices without manual control. The system includes preset timing of dry and wet mixing cycles.

**Automatic dryer control** – A control system that automatically maintains the temperature of aggregates discharged from the dryer.

**Automatic proportioning control** – A control system in which proportions of the aggregate and asphalt binder fractions are controlled by means of gates or valves that are opened and closed by means of automatic mechanical or electronic devices without manual control.

**Bag (of cement)** – 94 lb of Portland cement (Approximately 1 ft<sup>3</sup> of bulk cement)

**Base** – A layer of selected material constructed on top of subgrade or subbase and below the paving on a roadway.

**Bias** – The offset or skewing of data or information away from its true or accurate position as the result of systematic error.

**Binder** – Asphalt binder or modified asphalt binder that binds the aggregate particles into a dense mass.

**Boulders** – Rock fragment, often rounded, with an average dimension larger than 300 mm (12 in.).

**Bulk specific gravity** – The ratio of the mass, in air, of a volume of aggregate ( $G_{sa}$ ) or compacted HMA mix ( $G_{mb}$ ) (including the permeable and impermeable voids in the particles, but not including the voids between particles) to the mass of an equal volume of water at a stated temperature.

**Bulk specific gravity (SSD)** – The ratio of the mass, in air, of a volume of aggregate ( $G_{sa SSD}$ ) or compacted asphalt mixtures ( $G_{mb SSD}$ ), including the mass of water within the voids (but not including the voids between particles), to the mass of an equal volume of water at a stated temperature. (See saturated surface dry.)

**Cementitious Materials** – cement and pozzolans used in concrete such as: Portland cement, fly ash, silica fume, and blast-furnace slag.

**Clay** – Fine-grained soil that exhibits plasticity over a range of water contents, and that exhibits considerable strength when dry, also, that portion of the soil finer than 2  $\mu$ m.

**Cobble** – Rock fragment, often rounded, with an average dimension between 75 and 300 mm (3 and 12 in.).

**Cohesionless soil** – Soil with little or no strength when dry and unconfined or when submerged, such as sand

**Cohesive soil** – Soil with considerable strength when dry and that has significant cohesion when unconfined or submerged.

**Compaction** – Densification of a soil or asphalt mixtures by mechanical means.

**Compaction curve (Proctor curve or moisture-density curve)** – The curve showing the relationship between the dry unit weight or density and the water content of a soil for a given compactive effort.

**Compaction test (moisture-density test)** – Laboratory compaction procedure in which a soil of known water content is placed in a specified manner into a mold of given dimensions, subjected to a compactive effort of controlled magnitude, and the resulting density determined.

**Compressibility** – Property of a soil or rock relating to susceptibility to decrease in volume when subject to load.

**Constant mass** – The state at which a mass does not change more than a given percent, after additional drying for a defined time interval, at a required temperature.

**Constructor** – The builder of a project. The individual or entity responsible for performing and completing the construction of a project required by the contract documents. Often called a contractor, since this individual or entity contracts with the owner.

**Cutback asphalt** – Asphalt binder that has been modified by blending with a chemical solvent.

**Crusher-run** – The total unscreened product of a stone crusher.

**Delivery tolerances** – Permissible variations from the desired proportions of aggregate and asphalt binder delivered to the pugmill.

**Density** – The ratio of mass to volume of a substance. Usually expressed in lb/ft<sup>3</sup> (kg/m<sup>3</sup>).

**Design professional** – The designer of a project. This individual or entity may provide services relating to the planning, design, and construction of a project, possibly including materials testing and construction inspection. Sometimes called a “contractor,” since this individual or entity contracts with the owner.

**Dryer** – An apparatus that dries aggregate and heats it to specified temperatures.

**Dry mix time** – The time interval between introduction of aggregate into the pugmill and the addition of asphalt binder.

**Durability** – The property of concrete that describes its ability to resist disintegration by weathering and traffic. Included under weathering are changes in the pavement and aggregate due to the action of water, including freezing and thawing.

**Dust Proportion – DP (Dust to Effective (asphalt) Binder Ratio)** – The percent passing the No. 200 sieve divided by the percent of effective asphalt binder.

**Effective specific gravity ( $G_{se}$ )** – The ratio of the mass in air of a unit volume of a permeable material (excluding voids permeable to asphalt binder) at a stated temperature to the mass in air (of equal density) of an equal volume of gas-free distilled water at a stated temperature.

**Effective diameter (effective size)** –  $D_{10}$ , particle diameter corresponding to 10 percent finer or passing.

**Embankment** – Controlled, compacted material between the subgrade and subbase or base in a roadway.

**End-result specifications** – Specifications that require the Constructor to take the entire responsibility for supplying a product or an item of construction. The Owner’s (the highway agency’s) responsibility is to either accept or reject the final product or to apply a price

adjustment that is commensurate with the degree of compliance with the specifications. Sometimes called performance specifications, although considered differently in highway work. (See performance specifications.)

**Family of curves** – a group of soil moisture-density relationships (curves) determined using AASHTO T 99 or T 180, which reveal certain similarities and trends characteristic of the soil type and source.

**Field operating procedure (FOP)** – Procedure used in field testing on a construction site or in a field laboratory. (Based on AASHTO or NAQTC test methods.)

**Fineness modulus** – A factor equal to the sum of the cumulative percentages of aggregate retained on certain sieves divided by 100; the sieves are 150, 75, 37.5, 19.0, 9.5, 4.75, 2.36, 1.18, 0.60, 0.30, and 0.15 mm. Used in the design of concrete mixes. The lower the fineness modulus, the more water/cement paste that is needed to coat the aggregate.

**Fines** – Portion of a soil or aggregate finer than a 75  $\mu\text{m}$  (No. 200) sieve. Also silts and clays.

**Fractured Face** – An angular, rough, or broken surface of an aggregate particle created by crushing or by other means. A face is considered a “fractured face” whenever one-half or more of the projected area, when viewed normal to that face, is fractured with sharp and well defined edges. This excludes small nicks.

**Fractured particle** – A particle of aggregate having at least the minimum number of fractured faces specified.

**Free water** – Water on aggregate available for reaction with hydraulic cement. Mathematically, the difference between total moisture content and absorbed moisture content.

**Glacial till** – Material deposited by glaciation, usually composed of a wide range of particle sizes, which has not been subjected to the sorting action of water.

**Gradation (grain-size distribution)** – The proportions by mass of a soil or fragmented rock distributed by particle size.

**Gradation analysis (grain size analysis or sieve analysis)** – The process of determining grain-size distribution by separation of sieves with different size openings.

**Hot aggregate storage bins** – Bins that store heated and separated aggregate before final proportioning into the mixer.

**Hot mix asphalt (HMA)** – High quality, thoroughly controlled hot mixture of asphalt binder and well-graded, high quality aggregate.

**Hot Mix Asphalt (HMA) batch plant** – A manufacturing facility for producing hot mix asphalt (HMA) that proportions aggregate by weight and asphalt by weight or volume.

**HMA continuous mix plant** – A manufacturing facility for producing HMA that proportions aggregate and asphalt binder by a continuous volumetric proportioning system without specific batch intervals.

**Hydraulic cement** – Cement that sets and hardens by chemical reaction with water.

**Independent assurance** – Unbiased and independent evaluation of all the sampling and testing procedures, equipment, and technicians involved with Quality Control (QC) and Verification/Acceptance.

**In situ** – Rock or soil in its natural formation or deposit.

**Liquid limit** – Moisture content corresponding to the boundary between the liquid and plastic states.

**Loam** – A mixture of sand, silt or clay, or a combination thereof, with organic matter.

**Lot** – A quantity of material to be controlled. It may represent a specified mass, a specified number of truckloads, or a specified time period during production.

**Manual proportioning control** – A control system in which proportions of the aggregate and asphalt binder fractions are controlled by means of gates or valves that are opened and closed by manual means. The system may or may not include power assisted devices in the actuation of gate and valve opening and closing.

**Materials and methods specifications** – Also called prescriptive specifications. Specifications that direct the Constructor to use specified materials in definite proportions and specific types of equipment and methods to place the material.

**Maximum size** – One sieve larger than nominal maximum size.

**Mesh** – The square opening of a sieve.

**Moisture content** – The ratio, expressed as a percentage, of the mass of water in a material to the dry mass of the material.

**Nominal maximum size** – One sieve larger than the first sieve to retain more than 10 percent of the material using an agency specified set of sieves based on cumulative percent retained. Where large gaps in specification sieves exist, intermediate sieve(s) may be inserted to determine nominal maximum size.

*Note:* The first sieve to normally retain more than 10 percent of the material usually is the second sieve in the stack but may be the third sieve.

**Nuclear gauge** – Instruments used to measure in-place density, moisture content, or asphalt binder content through the measurement of nuclear emissions.

**Optimum moisture content (optimum water content)** – The water content at which a soil can be compacted to a maximum dry density by a given compactive effort.

**Organic soil** – Soil with a high organic content.

**Owner** – The organization that conceives of and eventually operates and maintains a project. A State Transportation Departments (STD) is an Owner.

**Paste** – Mix of water and hydraulic cement that binds aggregate in Portland cement concrete (PCC).

**Penetration** – The consistency of a bituminous material, expressed as the distance in tenths of a millimeter (0.1 mm) that a standard needle vertically penetrates a sample of the material under specified conditions of loading, time, and temperature.

**Percent of Absorbed (asphalt) Binder ( $P_{ba}$ )** – The total percent of the asphalt binder that is absorbed into the aggregate, expressed as a percentage of the mass of aggregate rather than as a percentage of the total mass of the mixture. This portion of the asphalt binder content does not contribute to the performance of the mix.

**Percent aggregate (stone) ( $P_s$ )** – The percent aggregate (stone) content, expressed as a percentage of the total mass of the sample.

**Percent of Effective (asphalt) Binder ( $P_{be}$ )** – The total asphalt binder content of a paving mixture minus the portion of asphalt binder that is lost by absorption into the aggregate particles, expressed as a percentage of the mass of aggregate. It is the portion of the asphalt binder content that remains as a coating on the outside of the aggregate particles.

**Percent compaction** – The ratio of density of a soil, aggregate, or asphalt mixtures in the field to a maximum density determined by a standard compaction test, expressed as a percentage.

**Performance specifications** – Specifications that describe how the finished product should perform. For highways, performance is typically described in terms of changes over time in physical condition of the surface and its response to load, or in terms of the cumulative traffic required to bring the pavement to a condition defined as “failure.” Specifications containing warranty/guarantee clauses are a form of performance specifications.

**Plant screens** – Screens located between the dryer and hot aggregate storage bins that separate the heated aggregates by size.

**Plastic limit** – Moisture content corresponding to the boundary between the plastic and the semisolid states.

**Plasticity** – Property of a material to continue to deform indefinitely while sustaining a constant stress.

**Plasticity index** – Numerical difference between the liquid limit and the plastic limit and, thus, the range of water content over which the soil is plastic.

**Portland cement** – Hydraulic cement produced by pulverizing Portland cement clinker.

**Portland cement concrete (PCC)** – A controlled mix of aggregate, Portland cement, and water, and possibly other admixtures.

**PCC batch plant** – A manufacturing facility for producing Portland cement concrete.

**Prescriptive specifications** – See Materials and Methods specification.

**Proficiency samples** – Homogeneous samples that are distributed and tested by two or more laboratories. The test results are compared to assure that the laboratories are obtaining the same results.

**Pugmill** – A shaft mixer designed to mix aggregate and cement.

**Quality assurance** – Planned and systematic actions necessary to provide confidence that a product or service will satisfy given requirements for quality. The overall system for providing quality in a constructed project, including Quality Control (QC), Verification/Acceptance, and Independent Assurance (IA).

**Quality assurance specifications** – Also called QC/QA specifications. A combination of end-result (performance) specifications and materials and methods (prescriptive) specifications. The Constructor is responsible for quality control, and the Owner (highway agency) is responsible for acceptance of the product.

**Quality control (QC)** – Operational, process control techniques or activities that are performed or conducted to fulfill contract requirements for material or equipment quality.

**Random sampling** – Procedure for obtaining non-biased, representative samples.

**Sand** – Particles of rock passing the No. 4 (4.75 mm) sieve and retained on the No. 200 (75  $\mu$ m) sieve.

**Saturated surface dry (SSD)** – Condition of an aggregate particle, asphalt mixtures or Portland cement concrete (PCC) core, or other porous solid when the permeable voids are filled with water, but no water is present on exposed surfaces. (See bulk specific gravity.)

**Segregation** – The separation of aggregate by size resulting in a non-uniform material.

**SHRP** – The Strategic Highway Research Program (SHRP) established in 1987 as a five-year research program to improve the performance and durability of roads and to make those roads safe for both motorists and highway workers. SHRP research funds were partly used for the development of performance-based specifications to directly relate laboratory analysis with field performance.

**Sieve** – Laboratory apparatus consisting of wire mesh with square openings, usually in circular or rectangular frames.

**Silt** – Material passing the (75  $\mu\text{m}$ ) sieve that is non-plastic or very slightly plastic, and that exhibits little or no strength when dry and unconfined. Also, that portion of the soil finer than 75  $\mu\text{m}$  and coarser than 2  $\mu\text{m}$ .

**Slump** – Measurement related to the workability of concrete.

**Soil** – Sediments or unconsolidated accumulations of solid particles produced by the physical and chemical disintegration of rocks, and which may or may not contain organic matter.

**Specific gravity** – The ratio of the mass of a volume of a material to the mass of an equal volume of water at a stated temperature.

- **$G_{mm}$**  – theoretical maximum specific gravity (Gravity<sub>mix max</sub>)  
The ratio of the mass of a given volume of asphalt mixtures with no air voids to the mass of an equal volume of water, both at a stated temperature.
- **$G_{mb}$**  – measured bulk specific gravity (Gravity<sub>mix bulk</sub>)  
The ratio of the mass, in air, of a volume of compacted HMA mix (including the permeable and impermeable voids in the particles, but not including the voids between particles) to the mass of an equal volume of water at a stated temperature.
- **$G_{sb}$**  – oven-dry bulk specific gravity of aggregate (Gravity<sub>stone bulk</sub>)  
The ratio of the mass, in air, of a volume of aggregate (including the permeable and impermeable voids in the particles, but not including the voids between particles) to the mass of an equal volume of water at a stated temperature.
- **$G_{sa}$**  – apparent specific gravity of aggregate (Gravity<sub>stone apparent</sub>)  
The ratio of the mass, in air, of a volume of the impermeable portion of aggregate to the mass of an equal volume of water at a stated temperature.
- **$G_{se}$**  – effective specific gravity of aggregate (Gravity<sub>stone effective</sub>)  
The ratio of the mass in air of a unit volume of a permeable material (excluding voids permeable to asphalt binder) at a stated temperature to the mass in air (of equal density) of an equal volume of gas-free distilled water at a stated temperature.
- **$G_b$**  – specific gravity of the binder (Gravity<sub>binder</sub>)  
The ratio of the mass of a volume of asphalt binder to the mass of an equal volume of water at a stated temperature.

**Spine** – smooth line extending through the point of maximum density/optimum moisture content of a family of moisture-density curves.

**Stability** – The ability of an asphalt mixture to resist deformation from imposed loads. Stability is dependent upon internal friction, cohesion, temperature, and rate of loading.

**Stratified random sampling** – Procedure for obtaining non-biased, representative samples in which the established lot size is divided into equally-sized sublots.

**Subbase** – A layer of selected material constructed between the subgrade and the base course in a flexible HMA roadway, or between the subgrade and Portland cement concrete (PCC) pavement in a rigid PCC roadway.

**Subgrade** – Natural soil prepared and compacted to support a structure or roadway pavement.

**Sublot** – A segment of a lot chosen to represent the total lot.

**Superpave™** – Superpave™ (Superior Performing Asphalt Pavement) is a trademark of the Strategic Highway Research Program (SHRP). Superpave™ is a product of the SHRP asphalt research. The Superpave™ system incorporates performance-based asphalt materials characterization with design environmental conditions to improve performance by controlling rutting, low temperature cracking and fatigue cracking. The three major components of Superpave™ are the asphalt binder specification, the mix design and analysis system, and a computer software system.

**Theoretical maximum specific gravity ( $G_{mm}$ )** – The ratio of the mass of a given volume of asphalt mixtures with no air voids to the mass of an equal volume of water, both at a stated temperature.

**Topsoil** – Surface soil, usually containing organic matter.

**Uniformity coefficient** –  $C_u$ , a value employed to quantify how uniform or well-graded an aggregate is:  $C_u = D_{60}/D_{10}$ . 60 percent of the aggregate, by mass, has a diameter smaller than  $D_{60}$  and 10 percent of the aggregate, by mass, has a diameter smaller than  $D_{10}$ .

**Unit weight** – The ratio of weight to volume of a substance. The term “density” is more commonly used.

**µm** – Micro millimeter (micron) Used as measurement for sieve size.

**Vendor** – Supplier of project-produced material that is other than the constructor.

**Verification** – Process of sampling and testing performed to validate Quality Control (QC) sampling and testing and, thus, the quality of the product. Sometimes called Acceptance.

**Void in the mineral aggregate (VMA)** – The volume of inter-granular void space between aggregate particles of compacted asphalt mixtures that includes air and asphalt binder; expressed as a percentage of the bulk volume of the compacted paving mixture.

**Void filled with asphalt (VFA)** – The portion of the void in the mineral aggregate (VMA) that contains asphalt binder; expressed as a percentage of the bulk volume of mix or the VMA.

**Wet mixing period** – The time interval between the beginning of application of asphalt binder and the opening of the mixer gate.

**Zero air voids curve (saturation curve)** – Curve showing the zero air voids density as a function of water content.

EMBANKMENT AND BASE  
IN-PLACE DENSITY

WAQTC

TERMINOLOGY

**SAFETY**

The procedures included in this manual may involve hazardous materials, operations, and equipment. The procedures do not address all of the safety issues associated with their use. It is the responsibility of the employer to assess workplace hazards and to determine whether personal protective equipment (PPE) must be used. PPE must meet applicable American National Standards Institute (ANSI) standards, and be properly used and maintained. The employer must establish appropriate safety and health practices, in compliance with applicable state and federal laws, for these procedures and associated job site hazards. Hazardous materials must be addressed in a Hazard Communication program, and Material Safety Data Sheets (MSDS) must be obtained and available to workers. Supervisors and employees should be aware of job site hazards, and comply with their employer’s safety and health program. The following table identifies some areas that may affect individuals performing the procedures in this manual.

<b>Body Part Affected</b>	<b>Potential Hazards</b>	<b>PPE/Procedures That May Be Appropriate</b>
Head	Falling or fixed overhead objects; electrical shock	Hard hat or other protective helmet
Eyes and Face	Flying objects, radiation, molten metal, chemicals	Safety glasses, goggles, face shields; prescription or filter lenses
Ears	Noise	Ear plugs, ear muffs
Respiratory System	Inhalation of dusts, chemicals; O <sub>2</sub> deficiency	Properly fit and used respiratory protection consistent with the hazard
Skin	Chemicals including cement; heat	Appropriate chemical or heat resistant gloves, long-sleeve shirts, coveralls
Mouth, digestive system	Ingestion of toxic materials	Disposable or washable gloves, coveralls; personal hygiene
Hands	Physical injury (pinch, cut, puncture), chemicals	Appropriate gloves for physical hazards and compatible with chemicals present
Feet	Falling, sharp objects; slippery surfaces, chemicals	Safety shoes or boots (steel toed, steel shank); traction soles; rubber boots – chemicals, wet conditions
Joints, muscles, tendons	Lifting, bending, twisting, repetitive motions	Proper training and procedures; procedure modifications
Body/Torso	Falls; Burial	Fall protection; trench sloping or shoring
Miscellaneous	Traffic	Visibility, awareness, communication; driver training, safety awareness
Whole body	Radiation	Radiation safety training

EMBANKMENT AND BASE  
IN-PLACE DENSITY

WAQTC

SAFETY

## RANDOM SAMPLING OF CONSTRUCTION MATERIALS

01

### **Significance**

Sampling and testing are two of the most important functions in quality control (QC). Data from the tests are the tools with which the quality of product is controlled. For this reason, great care must be used in following standardized sampling and testing procedures.

In controlling operations, it is necessary to obtain numerous samples at various points along the production line. Unless precautions are taken, sampling can occur in patterns that can create a bias to the data gathered. Sampling at the same time, say noon, each day may jeopardize the effectiveness of any quality program. This might occur, for example, because a material producer does certain operations, such as cleaning screens at an aggregate plant, late in the morning each day. To obtain a representative sample, a reliable system of random sampling must be employed.

02

### **Scope**

The procedure presented here eliminates bias in sampling materials. Randomly selecting a set of numbers from a table or calculator will eliminate the possibility for bias. Random numbers are used to identify sampling times, locations, or points within a lot or subplot. This method does not cover how to sample, but rather how to determine sampling times, locations, or points.

### **Sampling Concepts**

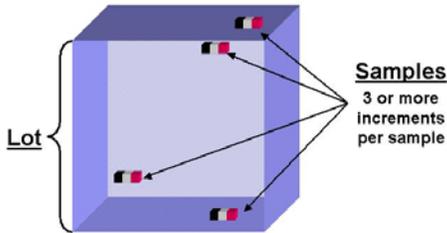
03

04

A lot is the quantity of material evaluated by QC procedures. A lot is a preselected quantity that may represent hours of production, a quantity or number of loads of material, or an interval of time. A lot may be comprised of several portions that are called sublots or units. The number of sublots comprising a lot will be determined by the agency's specifications.

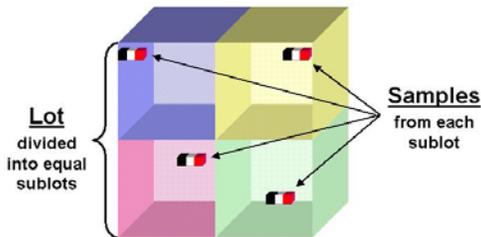
### Straight Random Sampling

One or more sample locations may be selected, using the entire lot as a single unit



### Stratified Random Sampling

The lot is divided into two or more equal sublots. Samples are taken from each subplot



05

### Straight Random Sampling vs. Stratified Random Sampling:

**Straight Random Sampling:** Straight random sampling considers an entire lot as a single unit and determines each sample location based on the entire lot size. **Stratified random sampling** divides the lot into a specified number of sublots or units and then determines each sample location within a distinct subplot. Both methods result in random distribution of samples to be tested for compliance with the agency's specification.

06

Agencies stipulate when to use straight random sampling or stratified random sampling. AASHTO T 2, Sampling of Aggregates, for example, specifies a straight random sampling procedure.

07

### Picking Random Numbers from a Table

Table 1 contains pairs of numbers. The first number is the "pick" number and the second is the Random Number, "RN." The table was generated with a spreadsheet and the cells (boxes at the intersection of rows and columns) containing the RNs actually contains the "random number function." Every time the spreadsheet is opened or changed, all the RNs change.

1. Select a Pick number in a random method. The first two or last two digits in the next automobile license plate you see would be one way to select. Another would be to start a digital stop watch and stop it several seconds later, using the decimal part of the seconds as your Pick number.
2. Find the RN matching the Pick number.

08

### Picking Random Numbers with a Calculator

09

Many calculators have a built-in random number function. To obtain a random number, key in the code or push the button(s) the calculator's instructions call for. The display will show a number between 0.000 and 1.000 and this will be your random number.

**TABLE 1**  
**Random Numbers**

Pick	RN								
01	0.998	21	0.758	41	0.398	61	0.895	81	0.222
02	0.656	22	0.552	42	0.603	62	0.442	82	0.390
03	0.539	23	0.702	43	0.150	63	0.821	83	0.468
04	0.458	24	0.217	44	0.001	64	0.187	84	0.335
05	0.407	25	0.000	45	0.521	65	0.260	85	0.727
06	0.062	26	0.781	46	0.462	66	0.815	86	0.708
07	0.370	27	0.317	47	0.553	67	0.154	87	0.161
08	0.410	28	0.896	48	0.591	68	0.007	88	0.893
09	0.923	29	0.848	49	0.797	69	0.759	89	0.255
10	0.499	30	0.045	50	0.638	70	0.925	90	0.604
11	0.392	31	0.692	51	0.006	71	0.131	91	0.880
12	0.271	32	0.530	52	0.526	72	0.702	92	0.656
13	0.816	33	0.796	53	0.147	73	0.146	93	0.711
14	0.969	34	0.100	54	0.042	74	0.355	94	0.377
15	0.188	35	0.902	55	0.609	75	0.292	95	0.287
16	0.185	36	0.674	56	0.579	76	0.854	96	0.461
17	0.809	37	0.509	57	0.887	77	0.240	97	0.703
18	0.105	38	0.013	58	0.495	78	0.851	98	0.866
19	0.715	39	0.497	59	0.039	79	0.678	99	0.616
20	0.380	40	0.587	60	0.812	80	0.122	00	0.759

**Examples of Straight Random Sampling Procedures Using Random Numbers**

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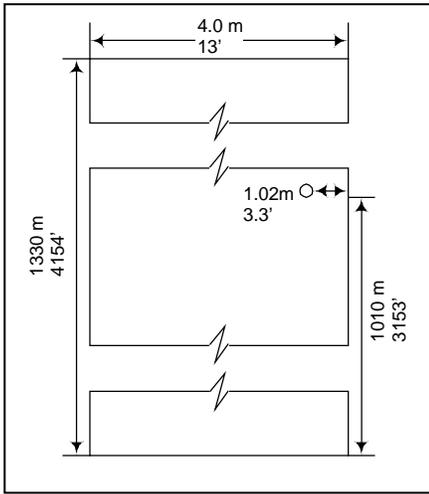
**Sampling from a Belt or Flowing Stream:**

Agencies specify the frequency of sampling in terms of time, volumes, or masses. The specification might call for one sample from every 1,000,000 kg(1000 t) or 1100 Tons(T) of aggregate. If the random number was 0.317, the sample would be taken at  $(0.317)(1,000,000 \text{ kg}) = 317,000 \text{ kg}$  (317 t). Or  $(.317) (1100 \text{ T}) = 349 \text{ T}$ .

One sample per day might also be specified. If the day were 9 hours long and the random number 0.199, the sample would be taken at  $(0.199)(9 \text{ hrs}) = 1.79 \text{ hr} = 1 \text{ hr}, 48 \text{ minutes}$  into the day. AASHTO T 2 permits this time to be rounded to the nearest 5 minutes.

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**Sampling from Haul Units:** Based on the agency's specifications – in terms of time, volume, or mass – determine the number of haul units that comprise a lot. Multiply the selected random



Sampling from a roadway

number(s) by the number of units to determine which unit(s) will be sampled.

For example, if 20 haul units comprise a lot and one sample is needed, pick one RN. If the RN were 0.773, then the sample would be taken from the  $(0.773)(20) = 15.46$ , or 16th haul unit.

**Sampling from a Roadway with Previously**

**Placed Material:** The agency’s specified frequency of sampling – in time, volume, or mass – can be translated into a location on a job. For example, if a sample is to be taken every 800 m<sup>3</sup> (1000yd<sup>3</sup>) and material is being placed 0.15 m (0.50 ft) thick and 4.0 m (13 ft) wide, then the lot is 1330 m (4154 ft) long. You would select two RNs in this case. To convert yd<sup>3</sup> to ft<sup>3</sup> multiply by 27.

The first RN would be multiplied by the length to determine where the sample would be taken along the project. The second would be multiplied by the width to determine where, widthwise, the sample would be taken. For example, a first RN of 0.759 would specify that the sample would be taken at  $(0.759)(1330 \text{ m})$  or  $(4154 \text{ ft}) = 1010 \text{ m}$  or 3153 ft from the beginning. A second RN of 0.255 would specify that the sample would be taken at  $(0.255)(4.0 \text{ m})$  or  $(13 \text{ ft}) = 1.02 \text{ m}$  or 3.3 ft from the right edge of the material. To avoid problems associated with taking samples too close to the edge, no sample is taken closer than 0.3 m (1 ft) to the edge. If the RN specifies a location closer than 0.3 m (1 ft), then 0.3 m (1 ft) is added to or subtracted from the distance calculated.

**Sampling from a Stockpile:** AASHTO T 2

recommends against sampling from stockpiles. However, some agencies use random procedures in determining sampling locations from a stockpile. Bear in mind that stockpiles are prone to segregation and that a sample obtained from a stockpile may not be representative. Refer to AASHTO T 2 for guidance on how to sample from a stockpile.

**In-Place Density Testing:** Agency specifications will indicate the frequency of tests. For example, one test per 500 m<sup>3</sup> (650 yd<sup>3</sup>) might be required. If the material is being placed 0.15 m (0.50 ft) thick and 10.0 m (33 ft) wide, then the lot is 333 m (1090 ft) long. You would select two RNs in this case.

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The first RN would be multiplied by the length to determine where the sample would be taken along the project. The second would be multiplied by the width to determine where, widthwise, the sample would be taken. For example, a first RN of 0.387 would specify that the sample would be taken at  $(0.387)(333 \text{ m})$  or  $(1090 \text{ ft}) = 129 \text{ m}$  or  $(422 \text{ ft})$  from the beginning. A second RN of 0.588 would specify that the sample would be taken at  $(0.588)(10.0 \text{ m})$  or  $(33 \text{ ft}) = 5.88 \text{ m}$  or  $(19 \text{ ft})$  from the right edge of the material. To avoid problems associated with taking samples too close to the edge, no sample is taken closer than 0.3 m (1 ft) to the edge. If the RN specifies a location closer than 0.3 m (1 ft), then 0.3 m (1 ft) is added to or subtracted from the distance calculated.

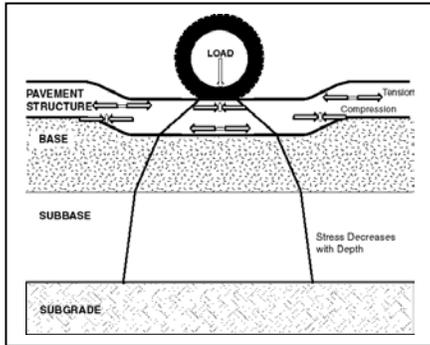
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EMBANKMENT AND BASE  
IN-PLACE DENSITY

WAQTC

RANDOM SAMPLING

**BASICS OF COMPACTION AND DENSITY CONTROL**



**Load distribution in roadway cross section**



**Grading**

**Introduction**

Roadways are constructed in layers. The first layer is the subgrade, or naturally present material. Next comes the subbase, material usually having better structural, drainage, and other properties than the subgrade. This material is sometimes a select material. Above the subbase is placed the base, material of even better quality than the subbase. Finally there is the pavement consisting of either hot mix asphalt (HMA) or portland cement concrete (PCC). In this layered system, structural or load bearing properties improve as we move up from subgrade to pavement. The result is a roadway structure that supports traffic without undergoing excessive surface deflection and/or long term settlement.

Variations to this layering can occur as in roadways constructed on high quality subgrade in which the subbase layer is eliminated. Also to be considered is “embankment,” material between the naturally occurring subgrade and the subbase or base that is added in “fill” sections of the roadway where the finished road is substantially above original grade.

Stability and durability of roadways is greatly dependent on the finished density of the various components. Low-density subgrade, subbase, base, or embankment will lead to excessive surface deflection under load and/or long term settlement in an amount higher than anticipated. However, compacting these elements to densities higher than necessary is expensive in both time and money.

Quality of roadways also depends greatly on the pavement. In HMA roadways, the density of the HMA plays a significant role in the overall ability to support load and provide long term service. HMA pavement specifications include detail on density as well as percent voids. Under-compaction results in low density and high void content. An under-compacted pavement will have low strength,

01  
02  
03  
04  
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06



**Cracking**



**Sheepsfoot roller**



**Proctor molds and hammer**

07

reduced durability, high deformation, and high permeability leading to problems such as rutting, ravelling, and freeze-thaw damage. Over-compaction results in high density and low void content. This pavement may bleed, rut, crack, or have premature failure.

08

For these reasons, a basic understanding of compaction theory and a thorough knowledge of testing methods is necessary for those involved with construction of embankments and bases, as well as HMA pavement. Compaction equipment and techniques depend on the type of material. Cohesive soils, such as clay, and cohesionless soils, such as gravel, require different compaction methods, and different equipment may be used on HMA than on soils.

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### **Fine-Grained Soils**

For fine-grained soils that contain a significant amount of cohesion and little or no internal friction, density depends on compactive effort and moisture content. With these soils, moisture-density relations are key, and two similar test methods are used to determine the relationship between soil moisture and density.

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- AASHTO T 99, the standard Proctor test
- AASHTO T 180, the modified Proctor test

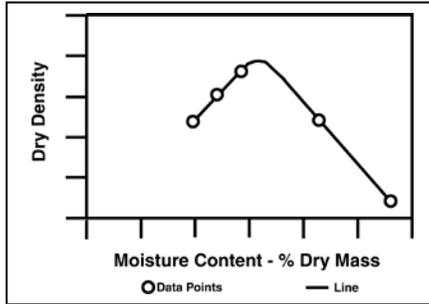
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In both methods, samples of soil are prepared at several moisture contents and compacted into molds of specified sizes using manual or mechanical rammers delivering a specified quantity of compactive energy. Knowing the moist masses of the compacted samples and the volume of the molds, moist densities can be determined. Moisture contents of the compacted samples are determined and used to obtain dry density values for the same samples. Maximum dry density and optimum moisture content for the soil are determined by plotting the relationship between dry density and moisture content.

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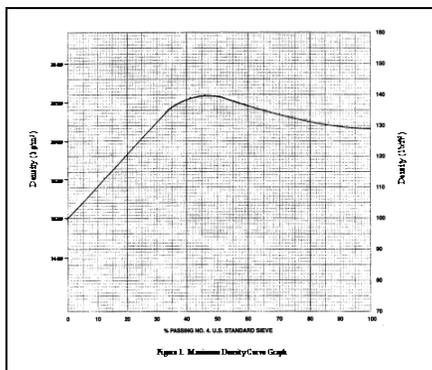
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Moisture-density curve



Nuclear moisture-density gauge



Maximum density curve

Construction specifications generally require that the soil be compacted to some percentage of maximum dry density while being maintained at a moisture content close to the optimum. These specified values will be based on AASHTO T 99 or AASHTO T 180, depending on the agency. In the field, dry density and moisture content of the material will be determined using a nuclear moisture-density gauge. The field values will be compared to the specifications to determine conformance with the project requirements.

### Coarse-Grained Soils

For coarse-grained granular soils having little or no cohesion, compactive effort is the primary concern, and moisture content is not as significant an issue because these soils are free-draining and do not retain water. These soils are tested using two general classifications of procedures. The first includes the moisture-density methods discussed above under "Fine-grained Soils." The second includes procedures that relate density to gradation.

Granular, free-draining materials can be tested by procedures that combine compaction and vibration, as in the Relative Density test. However, various transportation agencies have developed specialized tests that are a hybrid of moisture-density test procedures and relative density determinations, including the following:

- AKDOT&PF's ATM 212
- ITD's IT 74
- WSDOT's T 606
- WFLHD's Humphres

In these tests, material is compacted in a mold and in a manner similar to those used in a Proctor test, after which the material is further compacted through a combination of applied loads and vibration. A laboratory maximum dry density is determined, as is the percent of material passing a certain sieve such as the 4.75 mm (No. 4). A number of determinations are made for different

percentages passing the specified sieve. A graph is developed in which dry density is plotted versus the percentage of material passing that sieve. These tests are conducted in the agency's central lab, and the curve developed is a central lab function.

Construction specifications will call out a percent of maximum dry density required for the granular materials used on the job. These specified values will be based on ATM-12, T-74, TM 606, and Humphry's depending on the agency. In the field, the density of the granular material will be determined using a nuclear moisture-density gauge. The percent of material passing the specified sieve will also be determined. These values will be compared with the curve developed in the lab to determine conformance with the project specifications.

### Correction for Oversize Material

AASHTO T 99 and AASHTO T 180 discussed above are conducted on materials below a certain size, either 4.75 mm (No. 4) or 19.0 mm (3/4 in.) depending on the method. If the material to be tested includes particles in excess of that size, corrections will be required to the maximum dry densities determined. The method used is in the Annexes for AASHTO T 99 and T 180, Correction of Maximum Dry Density and Optimum Moisture for Oversized Particles.

The corrected density is actually a weighted average of the density of the smaller material passing the specified sieve and the larger material retained on the sieve. The density of the smaller material is determined using one of the methods covered above. The density of the larger material is based on knowledge of its bulk specific gravity.

### Hot Mix Asphalt Pavement

For HMA, density depends on compactive effort as well as the mix design. The gradation and particle shape of the aggregate, the grade of asphalt binder, and the interaction of these have major influences



Fine and coarse material

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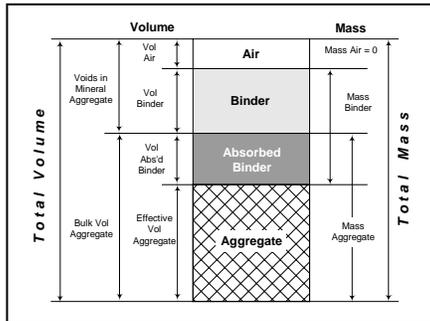
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on density and percent voids. The level of compactive effort and the equipment used depend on the mix design properties, environmental conditions and lift thickness.

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**HMA phase diagram**

Construction specifications will call for obtaining a certain percentage of maximum voidless density, as determined in the mix design process, while maintaining voids within a certain range. A specification of 92 to 96 percent of maximum density and a corresponding void content between 8 and 4 percent is typical. In the field, the density of the compacted HMA will be determined with cores and/or calibrated nuclear density gauges and, with this information, the percent voids will be calculated. These values will be compared to the specifications to determine conformance with the project requirements.

**Summary**

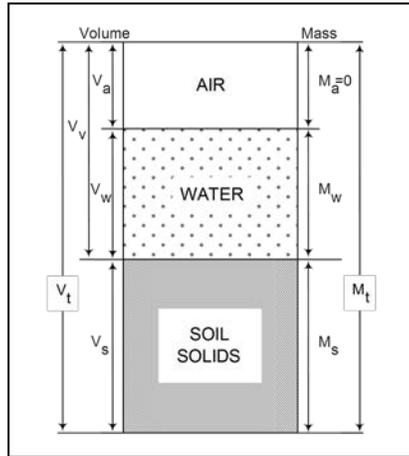
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Proper compaction of soil, aggregate, and hot mix asphalt is necessary for high-quality roadways. Understanding and proper performance of standardized density tests are paramount in obtaining that compaction. The Embankment and Base and/or In-Place Density technician must obtain samples and perform tests in the accepted manner in order to assure the quality of the finished roadway.



**TOTAL EVAPORABLE MOISTURE CONTENT OF AGGREGATE BY DRYING  
FOP FOR AASHTO T 255**

**LABORATORY DETERMINATION OF MOISTURE CONTENT OF SOILS  
FOP FOR AASHTO T 265**



**Phase diagram**



**Apparatus**



**Forced Air Oven**

**Significance**

The amount of water contained in many materials influences design and construction practices. Road bases are difficult to compact if they are too dry or too wet. If too dry, water must be added, and the amount to be added depends on how much is already present.

**Scope**

This procedure covers the determination of moisture content of aggregate and soil in accordance with AASHTO T 255-00 and AASHTO T 265-15. It may also be used for other construction materials.

**Overview**

Moisture content is determined by comparing the wet mass of a sample and the mass of the sample after drying to constant mass. The term constant mass is used to define when a sample is dry.

*Constant mass* – the state at which a mass does not change more than a given percent, after additional drying for a defined time interval, at a required temperature.

**Apparatus**

- Balance or scale: capacity sufficient for the principle sample mass, accurate to 0.1 percent of sample mass or readable to 0.1 g., and meeting the requirements of AASHTO M 231
- Containers, clean, dry and capable of being sealed
- Suitable drying containers
- Microwave safe container with ventilated lid
- Heat source, controlled:
  - Forced draft oven



**Infrared Oven**

09

- Ventilated oven
- Convection oven
- Heat source, uncontrolled:
  - Infrared heater/heat lamp, hot plate, fry pan, or any other device/method that will dry the sample without altering the material being dried
  - Microwave oven (900 watts minimum)
- Utensils such as spoons
- Hot pads or gloves

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**Sample Preparation**

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For aggregate, select the proper sample mass, in its existing condition based on Table 1 or other information that may be specified by the agency. Obtain the sample in accordance with the FOP for AASHTO T 2. Immediately seal or cover samples to prevent any change in moisture content.

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**TABLE 1**  
**Sample Sizes for Moisture Content of Aggregate**

Nominal Maximum Size* mm (in.)	Minimum Sample Mass g (lb)
4.75 (No. 4)	500 (1.1)
9.5 (3/8)	1500 (3.3)
12.5 (1/2)	2000 (4)
19.0 (3/4)	3000 (7)
25.0 (1)	4000 (9)
37.5 (1 1/2)	6000 (13)
50 (2)	8000 (18)
63 (2 1/2)	10,000 (22)
75 (3)	13,000 (29)
90 (3 1/2)	16,000 (35)
100 (4)	25,000 (55)
150 (6)	50,000 (110)

\* One sieve larger than the first sieve to retain more than 10 percent of the material using an agency specified set of sieves based on cumulative percent retained. Where large gaps in specification sieves exist, intermediate sieve(s) may be inserted to determine nominal maximum.

For soil, select the proper sample size based on Table 2 or other information that may be supplied by the agency.

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**TABLE 2**  
**Sample Sizes for Moisture Content of Soil**

<b>Maximum Particle Size mm (in)</b>	<b>Minimum Sample Mass g</b>
0.425 (No. 40)	10
4.75 (No. 4)	100
12.5 (1/2)	300
25.0 (1)	500
50 (2)	1000

Immediately seal or cover samples to prevent any change in moisture content or follow the steps in "Procedure."

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**Procedure**

Determine and record the sample mass as follows:

- For aggregate, determine and record all masses to the nearest 0.1 percent of the sample mass or to the nearest 0.1 g.
- For soil, determine and record all masses to the nearest 0.1 g.

When determining the mass of hot samples or containers or both, place and tare a buffer between the sample container and the balance. This will eliminate damage to or interference with the operation of the balance or scale.

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1. Determine and record the mass of the container (and lid for microwave drying).
2. Place the wet sample in the container.
  - a. For oven(s), hot plates, infrared heaters, etc.: Spread the sample in the container.
  - b. For microwave oven: Heap sample in the container; cover with ventilated lid.

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3. Determine and record the total mass of the container and wet sample.
4. Determine and record the wet mass of the sample by subtracting the container mass as determined in Step 1 from the mass of the container and sample in Step 3.
5. Place the sample in one of the following drying apparatus:
  - a. For aggregate –
    - i. Controlled heat source (oven): at  $110 \pm 5^{\circ}\text{C}$  ( $230 \pm 9^{\circ}\text{F}$ ).
    - ii. Uncontrolled heat source (Hot plate, infrared heater, etc.): Stir frequently to avoid localized overheating.
  - b. For soil - controlled heat source (oven): at  $110 \pm 5^{\circ}\text{C}$  ( $230 \pm 9^{\circ}\text{F}$ ).

**Note 1:** Soils containing gypsum or significant amounts of organic material require special drying. For reliable moisture contents, dry these soils at  $60^{\circ}\text{C}$  ( $140^{\circ}\text{F}$ ). For more information see AASHTO T 265, Note 2.

6. Dry until sample appears moisture free.
7. Determine mass of sample and container.
8. Determine and record the mass of the sample by subtracting the container mass determined in Step 1 from the mass of the container and sample determined in Step 7.
9. Return sample and container to the heat source for additional drying.

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Hotplate

- a. For aggregate –
  - i. Controlled heat source (oven): 30 minutes
  - ii. Uncontrolled heat source (Hot plate, infrared heater, etc.): 10 minutes
  - iii. Uncontrolled heat source (Microwave oven): 2 minutes

**Caution:** Some minerals in the sample may cause the aggregate to overheat, altering the aggregate gradation.

- b. For soil – controlled heat source (oven): 1 hour

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10. Determine mass of sample and container.
11. Determine and record the mass of the sample by subtracting the container mass determined in Step 1 from the mass of the container and sample determined in Step 10.
- 21
12. Determine percent change by subtracting the new mass determination ( $M_n$ ) from the previous mass determination ( $M_p$ ) divide by the previous mass determination ( $M_p$ ) multiply by 100.
13. Continue drying, performing steps 9 through 12, until there is less than a 0.10 percent change after additional drying time.
14. Constant mass has been achieved, sample is defined as dry.
15. Allow the sample to cool. Immediately determine and record the total mass of the container and dry sample.
- 22
16. Determine and record the dry mass of the sample by subtracting the mass of the container determined in Step 1 from the mass of the container and sample determined in Step 15.
17. Determine and record percent moisture by subtracting the final dry mass determination ( $M_D$ ) from the initial wet mass determination ( $M_W$ ) divide by the final dry mass determination ( $M_D$ ) multiply by 100.

**Table 3  
Methods of Drying**

<b>Aggregate</b>		
<b>Heat Source</b>	<b>Specific Instructions</b>	<b>Drying intervals to achieve constant mass (minutes)</b>
<b>Controlled:</b> Forced draft (preferred), ventilated, or convection oven	110 ±5°C (230 ±9°F)	30
<b>Uncontrolled:</b>		
Hot plate, infrared heater, etc.	Stir frequently	10
Microwave	Heap sample and cover with ventilated lid	2
<b>Soil</b>		
<b>Heat Source</b>	<b>Specific Instructions</b>	<b>Drying increments (minutes)</b>
<b>Controlled:</b> Forced draft (preferred), ventilated, or convection oven	110 ±5°C (230 ±9°F)	1 hour

**Calculation**

**Constant Mass:**

Calculate constant mass using the following formula:

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$$\frac{M_p - M_n}{M_p} \times 100 = \% \text{ Change}$$

Where:

$M_p$  = previous mass measurement

$M_n$  = new mass measurement

Example:

Mass of container: 1232.1 g

Mass of the container and sample after first drying cycle: 2637.2 g

Mass,  $M_p$ , of possibly dry sample: 2637.2 g - 1232.1 g = 1405.1 g

Mass of container and dry sample after second drying cycle: 2634.1 g

Mass,  $M_n$ , of dry sample: 2634.1 g - 1232.1 g = 1402.0 g

$$\frac{1405.1 \text{ g} - 1402.0 \text{ g}}{1405.1 \text{ g}} \times 100 = 0.22\%$$

*0.22 percent is not less than 0.10 percent, so continue drying*

Mass of container and dry sample after third drying cycle: 2633.0 g

Mass,  $M_n$ , of dry sample: 2633.0 g - 1232.1 g = 1400.9 g

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$$\frac{1402.0 \text{ g} - 1400.9 \text{ g}}{1402.0 \text{ g}} \times 100 = 0.08\%$$

*0.08 percent is less than 0.10 percent, so constant mass has been reached.*

### Moisture Content Aggregate and Soils:

Calculate the moisture content, as a percent, using the following formula:

$$w = \frac{M_W - M_D}{M_D} \times 100$$

Where:  $w$  = moisture content, percent

$M_W$  = wet mass

$M_D$  = dry mass

Example:

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Mass of container: 1232.1 g

Mass of container and wet sample: 2764.7 g

Mass,  $M_W$ , of wet sample: 2764.7 g - 1232.1 g = 1532.6 g

Mass of container and dry sample (**COOLED**): 2633.5 g

Mass,  $M_D$ , of dry sample: 2633.5 g - 1232.1 g = 1401.4 g

$$w = \frac{1532.6 \text{ g} - 1401.4 \text{ g}}{1401.4 \text{ g}} \times 100 = \frac{131.2 \text{ g}}{1401.4 \text{ g}} \times 100 = 9.36\% \text{ report } 9.4\%$$

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**Report**

- Results on forms approved by the agency
- Sample ID
- $M_w$ , wet mass
- $M_D$ , dry mass
- $w$ , moisture content to nearest 0.1 percent

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**Tips!**

- Let the sample cool before determining final dry mass.
- Divide by  $M_D$ , not  $M_w$ .

## REVIEW QUESTIONS

1. What extra care should be taken when using a microwave to dry aggregates?
2. What is the maximum temperature that a sample should be allowed to attain for each of the various types of ovens?
3. How is “constant mass” defined according to this FOP:

For Aggregate?

For Soil?



**PERFORMANCE EXAM CHECKLIST**

**TOTAL EVAPORABLE MOISTURE CONTENT OF AGGREGATE BY DRYING  
FOP FOR AASHTO T 255**

**LABORATORY DETERMINATION OF MOISTURE CONTENT OF SOILS  
FOP FOR AASHTO T 265**

Participant Name \_\_\_\_\_ Exam Date \_\_\_\_\_

Record the symbols "P" for passing or "F" for failing on each step of the checklist.

Procedure Element	Trial 1	Trial 2
1. Representative sample of appropriate mass obtained?	_____	_____
2. Mass of container determined to 0.1 g?	_____	_____
3. Sample placed in container and mass determined to 0.1 g?	_____	_____
4. Test sample mass conforms to the required mass?	_____	_____
5. Wet sample mass determined to 0.1 g?	_____	_____
6. Loss of moisture avoided prior to mass determination?	_____	_____
7. Sample dried by a suitable heat source?	_____	_____
8. If aggregate heated by means other than a controlled oven, is sample stirred to avoid localized overheating?	_____	_____
9. For aggregate: Is aggregate heated for the additional, specified time (forced draft, ventilated, convection – 30 minutes; microwave – 2 minutes; other 10 minutes) and then mass determined and compared to previous mass showing less than 0.10 percent loss?	_____	_____
10. For soil: Is soil heated for at least 1hour additional drying time and then mass determined and compared to previous mass - showing less than 0.10 percent loss?	_____	_____
11. Sample cooled, dry mass determined and recorded to the nearest 0.1 percent?	_____	_____
12. Moisture content calculated correctly and recorded to the nearest 0.1 percent?	_____	_____

Comments: First attempt: Pass \_\_\_\_\_ Fail \_\_\_\_\_ Second attempt: Pass \_\_\_\_\_ Fail \_\_\_\_\_

\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_

Examiner Signature \_\_\_\_\_ WAQTC #: \_\_\_\_\_

EMBANKMENT AND BASE  
IN-PLACE DENSITY

WAQTC

FOP AASHTO T 255/T 265 (16)

**MOISTURE-DENSITY RELATIONS OF SOILS:**

**USING A 2.5 kg (5.5 lb) RAMMER AND A 305 mm (12 in.) DROP  
FOP FOR AASHTO T 99**

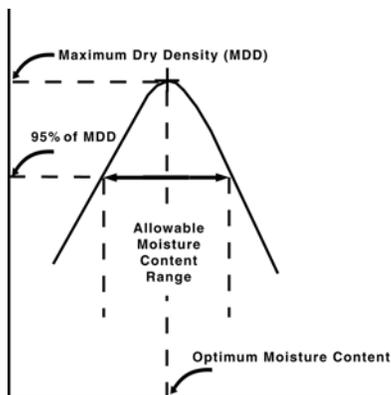
**USING A 4.54 kg (10 lb) RAMMER AND A 457 mm (18 in.) DROP  
FOP FOR AASHTO T 180**



**Steel roller**



**Adding water**



**Moisture vs. dry density**

**Significance**

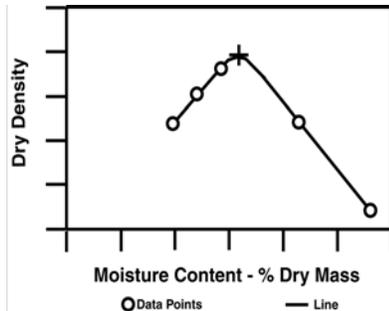
The density or degree of compaction, of soil or soil-aggregate mixtures has a significant influence on the stability and durability of roadways. Low density subgrade, subbase, base or embankment will lead to excessive deflection under load or long term settlement in an amount higher than anticipated, or both. Obtaining proper density depends on two major factors: compactive effort and moisture content.

Compactive effort relates to the type and weight of compaction equipment, along with the thickness of the “lift” being compacted and the number of times each lift is passed over by the compaction equipment. Equipment includes static and vibratory rollers, smooth and sheepfoot steel rollers, and pneumatic tire rollers of varied weights yielding many different compactive efforts.

Density also depends upon moisture content. The moisture content corresponding to maximum dry density of the soil or soil-aggregate mixture under a given compactive effort is known as optimum water content. As the water content increases or decreases from this optimum value, the dry density decreases.

Agency specifications commonly require that a certain percentage of maximum dry density be obtained while the moisture content of the soil or soil-aggregate mixture is held within certain limits. For example, a specification might call for 95 percent of maximum dry density with a moisture content of the optimum value  $\pm 2$  percent. For these reasons, it is critical to understand the various test methods and equipment used in determining the moisture-density relations of soil.

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**Optimum water content**

09

### Scope

This procedure covers the determination of the moisture-density relations of soils and soil-aggregate mixtures in accordance with two similar test methods:

- AASHTO T 99-15: Methods A, B, C, and D
- AASHTO T 180-15: Methods A, B, C, and D

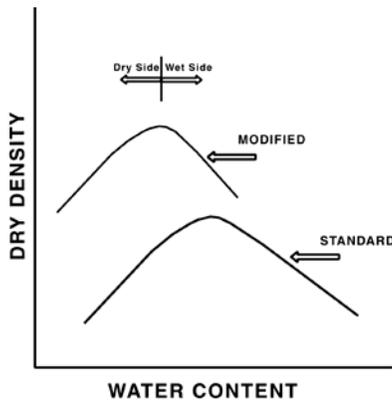
10

This test method applies to soil mixtures having 40 percent or less retained on the 4.75 mm (No. 4) sieve for methods A or B, or, 30 percent or less on the 19 mm (¾ in.) with methods C or D. The retained material is defined as oversize (coarse) material. If no minimum percentage is specified, 5 percent will be used. Samples containing oversize (coarse) material that meet the percent retained criteria should be corrected by using the Annex. Samples of soil or soil-aggregate mixture are prepared at several moisture contents and compacted into molds of specified size, using manual or mechanical rammers that deliver a specified quantity of compactive energy. The moist masses of the compacted samples are divided by the volume of the mold to determine moist density values. Moisture contents of the compacted samples are determined and used to obtain the dry density values of the same samples. Maximum dry density and optimum moisture content for the soil or soil-aggregate mixture is determined by plotting the relationship between dry density and moisture content.

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Molds and Rammer



Sample extruder

**Apparatus**

- 12 • Mold – Cylindrical made of metal with the dimensions shown in Table 1 or Table 2. If permitted by the agency, the mold may be of the “split” type, consisting of two half-round sections, which can be securely locked in place to form a cylinder. Determine the mold volume according to the “Calibration of Measure” section of AASHTO T 19 for Unit Mass of Aggregate.
- 13 • Mold assembly – Mold, base plate, and a detachable collar.
- 14 • Rammer –Manually or mechanically-operated rammers as detailed in Table 1 or Table 2. A manually-operated rammer shall be equipped with a guide sleeve to control the path and height of drop. The guide sleeve shall have at least four vent holes no smaller than 9.5 mm (3/8 in.) in diameter, spaced approximately 90 degrees apart and approximately 19 mm (3/4 in.) from each end. A mechanically-operated rammer will uniformly distribute blows over the sample and will be calibrated with several soil types, and shall be adjusted, if necessary, to give the same moisture-density results as with the manually-operated rammer. For additional information concerning calibration, see the FOP for AASHTO T 99/T 180.
- Sample extruder – A jack, lever frame, or other device for extruding compacted specimens from the mold quickly and with little disturbance.
- Balance(s) or scale(s) of the capacity and sensitivity required for the procedure used by the agency.

A balance or scale with a capacity of 11.5 kg (25 lb) and a sensitivity of 1 g for obtaining the sample, meeting the requirements of AASHTO M 231, Class G 5.

A balance or scale with a capacity of 2 kg and a sensitivity of 0.1 g is used for moisture content determinations done under both

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4.75 mm (No. 4) sieve - Straight edge

procedures, meeting the requirements of AASHTO M 231, Class G 5.

- Drying apparatus – A thermostatically controlled drying oven, capable of maintaining a temperature of  $110 \pm 5^{\circ}\text{C}$  ( $230 \pm 9^{\circ}\text{F}$ ) for drying moisture content samples in accordance with the FOP for AASHTO T 255/T 265.
- Straightedge – A steel straightedge at least 250 mm (10 in.) long, with one beveled edge and at least one surface plane within 0.1 percent of its length, used for final trimming.
- Sieve(s) – 4.75 mm (No. 4) and/or 19.0 mm (3/4 in.), conforming to AASHTO M 92.
- Mixing tools – Miscellaneous tools such as a mixing pan, spoon, trowel, spatula, etc., or a suitable mechanical device, for mixing the sample with water.
- Containers with close-fitting lids to prevent gain or loss of moisture in the sample.

**Table 1**

**Comparison of Apparatus, Sample, and Procedure - Metric**

	<b>T 99</b>	<b>T 180</b>
Mold Volume, m <sup>3</sup>	Methods A, C: 0.000943 ±000001	Methods A, C: 0.000943 ±000001
	Methods B, D: 0.002124 ±000025	Methods B, D: 0.002124 ±000025
Mold Diameter, mm	Methods A, C: 101.60 ±0.40	Methods A, C: 101.60 ±0.40
	Methods B, D: 152.40 ±0.70	Methods B, D: 152.40 ±0.70
Mold Height, mm	116.40 ±0.50	116.43 ±0.50
Detachable Collar Height, mm	50.80 ±0.64	50.80 ±0.64
Rammer Diameter, mm	50.80 ±0.64	50.80 ±0.64
Rammer Mass, kg	2.495 ±0.009	4.536 ±0.009
Rammer Drop, mm	305	457
Layers	3	5
Blows per Layer	Methods A, C: 25	Methods A, C: 25
	Methods B, D: 56	Methods B, D: 56
Material Size, mm	Methods A, B: 4.75 minus	Methods A, B: 4.75 minus
	Methods C, D: 19.0 minus	Methods C, D: 19.0 minus
Test Sample Size, kg	Method A: 3	Method B: 7
	Method C: 5 <sub>(1)</sub>	Method D: 11 <sub>(1)</sub>
Energy, kN-m/m <sup>3</sup>	592	2,693

(1) This may not be a large enough sample depending on your nominal maximum size for moisture content samples.

**Table 2**  
**Comparison of Apparatus, Sample, and Procedure - English**

	<b>T 99</b>	<b>T 180</b>
Mold Volume, ft <sup>3</sup>	Methods A, C: 0.0333 ±0.0005	Methods A, C: 0.0333 ±0.0005
	Methods B, D: 0.0750 ±0.0009	Methods B, D: 0.0750 ±0.0009
Mold Diameter, in.	Methods A, C: 4.000 ±0.016	Methods A, C: 4.000 ±0.016
	Methods B, D: 6.000 ±0.026	Methods B, D: 6.000 ±0.026
Mold Height, in.	4.584 ±0.018	4.584 ±0.018
Detachable Collar Height, in.	2.000 ±0.025	2.000 ±0.025
Rammer Diameter, in.	2.000 ±0.025	2.000 ±0.025
Rammer Mass, lb	5.5 ±0.02	10 ±0.02
Rammer Drop, in.	12	18
Layers	3	5
Blows per Layer	Methods A, C: 25	Methods A, C: 25
	Methods B, D: 56	0.Methods B, D: 56
Material Size, in.	Methods A, B: No. 4 minus	Methods A, B: No. 4 minus
	Methods C, D: 3/4 minus	Methods C, D: 3/4 minus
Test Sample Size, lb	Method A: 7	Method B: 16
	Method C: 12 <sub>(1)</sub>	Method D: 25 <sub>(1)</sub>
Energy, lb-ft/ft <sup>3</sup>	12,375	56,250

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(1) This may not be a large enough sample depending on your nominal maximum size for moisture content samples.

**Sample**

If the sample is damp, dry it until it becomes friable under a trowel. Drying may be in air or by use of a drying apparatus maintained at a temperature not exceeding 60°C (140°F). Thoroughly break up aggregations in a manner that avoids reducing the natural size of individual particles.

Obtain a representative test sample of the mass required by the agency by passing the material through the sieve required by the agency. See Table 1 or Table 2 for test sample mass and material size requirements.

*Note 1:* Both T 99 and T 180 have four methods (A, B, C, D) that require different masses and employ different sieves.

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Mold \ Sieve	4.75 mm (No. 4)	19 mm (3/4")
4"	A	C
6"	B	D

**Methods**



**Compacting**



**Typical mold**

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**Note 2:** If the sample is plastic (clay types), it should stand for a minimum of 12 hours after the addition of water to allow the moisture to be absorbed. In this case, several samples at different moisture contents should be prepared, put in sealed containers and tested the next day. In instances where the material is prone to degradation, i.e., granular material, a compaction sample with differing moisture content should be prepared for each point.

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**Procedure**

During compaction, the mold shall rest firmly on a dense, uniform, rigid, and stable foundation or base. This base shall remain stationary during the compaction process.

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1. Determine the mass of the clean, dry mold. Include the base plate, but exclude the extension collar. Record the mass to the nearest 1 g (0.005 lb).
2. Thoroughly mix the selected representative sample with sufficient water to dampen it to approximately 4 to 8 percentage points below optimum moisture content. See Note 2. For many materials this condition can be identified by forming a cast by hand.
3. Form a specimen by compacting the prepared soil in the mold (with collar attached) in approximately equal layers. For each layer:
  - a. Spread the loose material uniformly in the mold.
  - b. Lightly tamp the loose material with the manual rammer or other similar device, this establishes a firm surface.

**Note 3:** It is recommended to cover the remaining material with a non-absorbent sheet or damp cloth to minimize loss of moisture.

- c. Compact each layer with uniformly distributed blows from the rammer. See Table 1 for mold size, number of layers, number of blows, and rammer specification for the various test methods. Use the method specified by the agency.
- d. Trim down material that has not been compacted and remains adjacent to the walls



Trimming



Mass of mold and wet soil



Extruding the material



Moisture sample

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of the mold and extends above the compacted surface.

4. Remove the extension collar. Avoid shearing off the sample below the top of the mold. The material compacted in the mold should not be over 6 mm (1/4 in) above the top of the mold once the collar has been removed.
  5. Trim the compacted soil even with the top of the mold with the beveled edge of the straightedge.
  6. Determine the mass of the mold and wet soil to the nearest 1 g (0.005 lb) or better.
  7. Determine the wet mass of the sample by subtracting the mass in Step 1 from the mass in Step 6.
  8. Calculate the wet density as indicated below under "Calculations."
  9. Extrude the material from the mold. For soils and soil-aggregate mixtures, slice vertically through the center and take a representative moisture content sample from one of the cut faces, ensuring that all layers are represented. For granular materials, a vertical face will not exist. Take a representative sample. This sample must meet the sample size requirements of the test method used to determine moisture content.
- Note 4:* When developing a curve for free-draining soils such as uniform sands and gravels, where seepage occurs at the bottom of the mold and base plate, taking a representative moisture content from the mixing bowl may be preferred in order to determine the amount of moisture available for compaction.
10. Determine the moisture content of the sample in accordance with the FOP for AASHTO T 255 / T 265.
  11. Thoroughly break up the remaining portion of the molded specimen until it will again pass through the sieve, as judged by eye, and add to the remaining portion of the sample being tested. See Note 2.
  12. Add sufficient water to increase the moisture content of the remaining soil by approximately

1 to 2 percentage points and repeat the above procedure.

Continue determinations until there is either a decrease or no change in the wet density. There will be a minimum of three points on the dry side of the curve and two points on the wet side.

**Note 5:** In cases of free-draining granular material, the development of points on the wet side of optimum may not be practical.

### Calculations

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1. Calculate the wet density, in  $\text{kg/m}^3$  ( $\text{lb/ft}^3$ ), by dividing the wet mass by the measured volume of the mold (AASHTO T 19).

Example – Methods A or C mold:

Wet mass = 1.916 kg (4.22 lb)

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Measured volume of the mold =  $0.000946 \text{ m}^3$  ( $0.0334 \text{ ft}^3$ )

$$\text{Wet Density} = \frac{1.916 \text{ kg}}{0.000946 \text{ m}^3} = 2025 \text{ kg/m}^3$$

$$\text{Wet Density} = \frac{4.22 \text{ lb}}{0.0334 \text{ ft}^3} = 126.3 \text{ lb/ft}^3$$

2. Calculate the dry density as follows:

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$$\rho_d = \left( \frac{\rho_w}{w + 100} \right) \times 100 \quad \text{or} \quad \rho_d = \frac{\rho_w}{\left( \frac{w}{100} \right) + 1}$$

Where:

$\rho_d$  = Dry density,  $\text{kg/m}^3$  ( $\text{lb/ft}^3$ )

$\rho_w$  = Wet density,  $\text{kg/m}^3$  ( $\text{lb/ft}^3$ )

w = Moisture content, as a percentage

Example:

$$\rho_w = 2030 \text{ kg/m}^3 \text{ (126.6 lb/ft}^3\text{)}$$

$$w = 14.7\%$$

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$$\rho_d = \left( \frac{2030 \text{ kg/m}^3}{14.7 + 100} \right) \times 100 = 1770 \text{ kg/m}^3 \quad \rho_d = \left( \frac{126.6 \text{ lb/ft}^3}{14.7 + 100} \right) \times 100 = 110.4 \text{ lb/ft}^3$$

or

$$\rho_d = \left( \frac{2030 \text{ kg/m}^3}{\frac{14.7}{100} + 1} \right) = 1770 \text{ kg/m}^3 \quad \rho_d = \left( \frac{126.6 \text{ lb/ft}^3}{\frac{14.7}{100} + 1} \right) = 110.4 \text{ lb/ft}^3$$

### Moisture-Density Curve Development

When dry density is plotted on the vertical axis versus moisture content on the horizontal axis and the points are connected with a smooth line, a moisture-density curve is developed. The coordinates of the peak of the curve are the maximum dry density, or just “maximum density,” and the “optimum moisture content” of the soil.

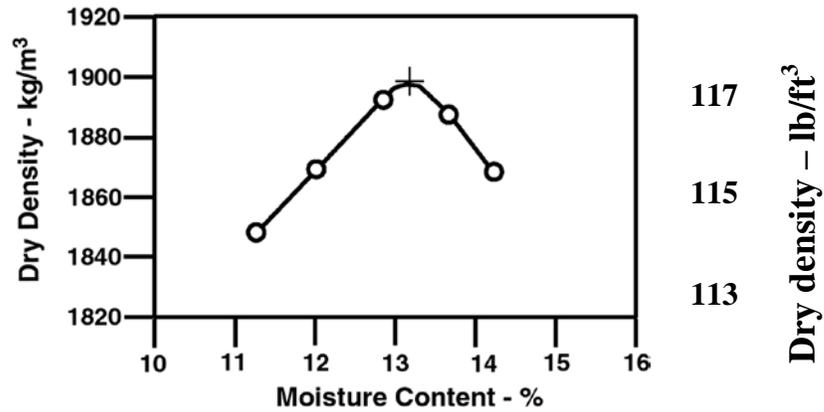
35

Example:

Given the following dry density and corresponding moisture content values, develop a moisture-density relations curve and determine maximum dry density and optimum moisture content.

Dry Density,		Moisture Content, %
kg/m <sup>3</sup>	lb/ft <sup>3</sup>	
1846	114.3	11.3
1868	115.7	12.1
1887	116.9	12.8
1884	116.7	13.6
1871	115.9	14.2

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In this case, the curve has its peak at:

Maximum dry density =  $1890 \text{ kg/m}^3$  ( $117.0 \text{ lb/ft}^3$ )

Optimum moisture content = 13.2%

Note that both values are approximate, since they are based on sketching the curve to fit the points.

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### Report

- Results on forms approved by the agency
- Sample ID
- Maximum dry density to the closest  $1 \text{ kg/m}^3$  ( $0.1 \text{ lb/ft}^3$ )
- Optimum moisture content to the closest 0.1 percent

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### Tips!

- Ideally, obtain dry 3 points and 2 wet points. This produces a reliable moisture-density curve.
- Moisture-density curves are based on dry densities.
- If oversize material exists, corrections must be made.

**ANNEX**

**CORRECTION OF MAXIMUM DRY DENSITY AND OPTIMUM MOISTURE FOR OVERSIZED PARTICLES**

This section corrects the maximum dry density and moisture content of the material retained on the 4.75 mm (No. 4) sieve, Methods A and B; or the material retained on the 19 mm (¾ in.) sieve, Methods C and D. The maximum dry density, corrected for oversized particles and total moisture content, are compared with the field-dry density and field moisture content.

2

This correction can be applied to the sample on which the maximum dry density is performed. A correction may not be practical for soils with only a small percentage of oversize material. The agency shall specify a minimum percentage below which the method is not needed. If not specified, this method applies when more than 5 percent by weight of oversize particles is present.

3

Bulk specific gravity ( $G_{sb}$ ) of the oversized particles is required to determine the corrected maximum dry density. Use the bulk specific gravity as determined using the FOP for AASHTO T 85 in the calculations. For construction activities an agency established value or specific gravity of 2.600 may be used.

4

This correction can also be applied to the sample obtained from the field while performing in-place density.

5

1. Use the sample from this procedure or a sample obtained according to the FOP for AASHTO T 310.
2. Sieve the sample on the 4.75 mm (No. 4) sieve for Methods A and B or the 19 mm (¾ in.) sieve, Methods C and D.
3. Determine the dry mass of the oversized and fine fractions ( $M_{DC}$  and  $M_{DF}$ ) by one of the following:
  - a. Dry the fractions, fine and oversized, in air or by use of a drying apparatus that is maintained at a temperature not exceeding 60°C (140°F).
  - b. Calculate the dry masses using the moisture samples.

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To determine the dry mass of the fractions using moisture samples.

1. Determine the moist mass of both fractions, fine ( $M_{Mf}$ ) and oversized ( $M_{Mc}$ ):
2. Obtain moisture samples from the fine and oversized material.
3. Determine the moisture content of the fine particles ( $MC_f$ ) and oversized particles ( $MC_c$ ) of the material by FOP for AASHTO T 255/T 265 or agency approved method.

4. Calculate the dry mass of the oversize and fine particles.

$$M_D = \frac{M_m}{1 + MC}$$

Where:

$M_D$  = mass of dry material (fine or oversize particles).

$M_m$  = mass of moist material (fine or oversize particles).

8

MC = moisture content of respective fine or oversized, expressed as a decimal.

5. Calculate the percentage of the fine ( $P_f$ ) and oversized ( $P_c$ ) particles by dry weight of the total sample as follows: See Note 2.

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$$P_f = \frac{100M_{DF}}{M_{DF} + M_{DC}} \quad \frac{100 \times 15.4 \text{ lb}}{15.4 \text{ lbs} + 5.7 \text{ lb}} = 73\% \quad \frac{100 \times 7.034 \text{ kg}}{7.03 \text{ kg} + 2.602 \text{ kg}} = 73\%$$

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And

$$P_c = \frac{100M_{DC}}{M_{DF} + M_{DC}} \quad \frac{100 \times 5.7 \text{ lb}}{15.4 \text{ lbs} + 5.7 \text{ lb}} = 27\% \quad \frac{100 \times 2.602 \text{ kg}}{7.03 \text{ kg} + 2.602 \text{ kg}} = 27\%$$

Or for  $P_c$ :

$$P_c = 100 - P_f$$

Where:

$P_f$  = percent of fine particles, of sieve used, by weight

$P_c$  = percent of oversize particles, of sieve used, by weight

$M_{DF}$  = mass of fine particles

$M_{DC}$  = mass of oversize particles

### Optimum Moisture Correction Equation

1. Calculate the corrected moisture content as follows:

$$MC_T = \frac{(MC_F \times P_f) + (MC_C \times P_c)}{100} \quad 11$$

$$MC_T = \frac{(10.6\% \times 73.0\%) + (2.1\% \times 27.0\%)}{100} = 8.3\% \quad 12$$

$MC_T$  = corrected moisture content of combined fines and oversized particles, expressed as a % moisture

$MC_F$  = moisture content of fine particles, as a % moisture

$MC_C$  = moisture content of oversized particles, as a % moisture

**Note 1:** Moisture content of oversize material can be assumed to be two (2) percent for most construction applications.

**Note 2:** In some field applications agencies will allow the percentages of oversize and fine materials to be determined with the materials in the wet state.

### Density Correction Equation

2. Calculate the corrected dry density of the total sample (combined fine and oversized particles) as follows: 13

$$D_d = \frac{100\%}{\frac{P_f}{D_f} + \frac{P_c}{k}} \quad 14$$

Where:

$D_d$  = corrected total dry density (combined fine and oversized particles)  
 $\text{kg/m}^3$  ( $\text{lb/ft}^3$ )

$D_f$  = dry density of the fine particles  $\text{kg/m}^3$  ( $\text{lb/ft}^3$ ), determined in the lab

$P_c$  = percent of oversize particles, of sieve used, by weight.

$P_f$  = percent of fine particles, of sieve used, by weight.

$k$  = Metric: 1,000 \* Bulk Specific Gravity ( $G_{sb}$ ) (oven dry basis)  
of coarse particles ( $\text{kg/m}^3$ ).

$k$  = English: 62.4 \* Bulk Specific Gravity ( $G_{sb}$ ) (oven dry basis)  
of coarse particles ( $\text{lb/ft}^3$ )

*Note 3:* If the specific gravity is known, then this value will be used in the calculation. For most construction activities the specific gravity for aggregate may be assumed to be 2.600.

### Calculation

Sample Calculations:

- Metric:

Maximum laboratory dry density ( $D_f$ ): 2329 kg/m<sup>3</sup>

Percent coarse particles ( $P_c$ ): 27%

Percent fine particles ( $P_f$ ): 73%

Mass per volume coarse particles ( $k$ ): (2.697) (1000) = 2697 kg/m<sup>3</sup>

$$D_d = \frac{100\%}{\frac{P_f}{D_f} + \frac{P_c}{k}}$$

$$D_d = \frac{100\%}{\frac{73\%}{2329 \text{ kg/m}^3} + \frac{27\%}{2697 \text{ kg/m}^3}}$$

$$D_d = \frac{100\%}{0.03134 \text{ kg/m}^3 + 0.01001 \text{ kg/m}^3}$$

$$D_d = 2418.1 \text{ kg/m}^3 \text{ report } 2418 \text{ kg/m}^3$$

- English:

Maximum laboratory dry density ( $D_f$ ): 140.4 lb/ft<sup>3</sup>

Percent coarse particles ( $P_c$ ): 27%

Percent fine particles ( $P_f$ ): 73%

Mass per volume coarse particles ( $k$ ): (2.697) (62.4) = 168.3 lb/ft<sup>3</sup>

$$D_d = \frac{100\%}{\frac{P_f}{D_f} + \frac{P_c}{k}}$$

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$$D_d = \frac{100\%}{\frac{73\%}{140.4 \text{ lb/ft}^3} + \frac{27\%}{168.3 \text{ lb/ft}^3}}$$

$$D_d = \frac{100\%}{0.5199 \text{ lb/ft}^3 + 0.1604 \text{ lb/ft}^3}$$

$$D_d = \frac{100\%}{0.6803 \text{ lb/ft}^3}$$

$$D_d = 146.99 \text{ lb/ft}^3 \quad \text{report } 147.0 \text{ lb/ft}^3$$

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### Report

- Results on forms approved by the agency
- Sample ID
- Corrected maximum dry density to the closest  $1 \text{ kg/m}^3$  ( $0.1 \text{ lb/ft}^3$ )
- Corrected optimum moisture to the 0.1 percent

EMBANKMENT AND BASE  
IN-PLACE DENSITY

WAQTC

FOP AASHTO T 99 / T 180 (15)

## REVIEW QUESTIONS

1. Describe how the plotted data is used to determine optimum moisture content and maximum dry density.
2. How many blows of the rammer are required per lift for the various procedures and methods?
3. Describe how the sample for moisture content is obtained.
4. What sample mass is required for Method A of the T 99 test?

For Method C of the T 180 test?

5. Describe the purpose of the annex.
6. The adjustment is based on the mass of material retained on what size sieve?

7. A soil-aggregate mixture has a maximum dry density of 138.6 lb/ft<sup>3</sup> English units and optimum moisture of 6.4 percent. The coarse particles make up 22 percent of the material, having a  $G_{sb}$  of 2.631 and 1.7 percent moisture.

What is the corrected maximum density?

What is the corrected moisture?

### PERFORMANCE EXAM CHECKLIST

#### MOISTURE-DENSITY RELATION OF SOILS FOP FOR AASHTO T 99

Participant Name \_\_\_\_\_ Exam Date \_\_\_\_\_

Record the symbols “P” for passing or “F” for failing on each step of the checklist.

Procedure Element	Trial 1	Trial 2
1. If damp, sample dried in air or drying apparatus, not exceeding 60°C (140°F)?	_____	_____
2. Sample broken up and an adequate amount sieved over the appropriate sieve (4.75 mm / No. 4 or 19.0 mm / 3/4 in.) to determine oversize (coarse particle) percentage?	_____	_____
3. Sample passing the sieve has appropriate mass?	_____	_____
4. If soil is plastic (clay types):		
a. Multiple samples mixed with water varying moisture content by 1 to 2 percent, bracketing the optimum moisture content?	_____	_____
b. Samples placed in covered containers and allowed to stand for at least 12 hours?	_____	_____
5. Sample determined to be 4 to 8 percent below expected optimum moisture content?	_____	_____
6. Mold placed on rigid and stable foundation?	_____	_____
7. Layer of soil (approximately one third compacted depth) placed in mold with collar attached, loose material lightly tamped?	_____	_____
8. Soil compacted with appropriate number of blows (25 or 56)?	_____	_____
9. Material adhering to the inside of the mold trimmed?	_____	_____
10. Layer of soil (approximately two thirds compacted depth) placed in mold with collar attached, loose material lightly tamped?	_____	_____
11. Soil compacted with appropriate number of blows (25 or 56)?	_____	_____
12. Material adhering to the inside of the mold trimmed?	_____	_____
13. Mold filled with soil such that compacted soil will be above the mold, loose material lightly tamped?	_____	_____
14. Soil compacted with appropriate number of blows (25 or 56)?	_____	_____
15. Collar removed without shearing off sample?	_____	_____

OVER

Procedure Element	Trial 1	Trial 2
16. Approximately 6 mm (1/4 in.) of compacted material above the top of the mold (without the collar)?	_____	_____
17. Soil trimmed to top of mold with the beveled side of the straightedge?	_____	_____
18. Mass of mold and contents determined to appropriate precision?	_____	_____
19. Wet density calculated from the wet mass?	_____	_____
20. Soil removed from mold using a sample extruder if needed?	_____	_____
21. Soil sliced vertically through center (non-granular material)?	_____	_____
22. Moisture sample removed ensuring all layers are represented?	_____	_____
23. Moist mass determined immediately to 0.1 g?	_____	_____
24. Moisture sample mass of correct size?	_____	_____
25. Sample dried and water content determined according to the FOP for T 255/T 265?	_____	_____
26. Remainder of material from mold broken up until it will pass through the sieve, as judged by eye, and added to remainder of original test sample?	_____	_____
27. Water added to increase moisture content of the remaining sample in 1 to 2 percent increments?	_____	_____
28. Steps 2 through 26 repeated for each increment of water added?	_____	_____
29. If material is degradable: Multiple samples mixed with water varying moisture content by 1 to 2 percent, bracketing the optimum moisture content?	_____	_____
30. Process continued until wet density either decreases or stabilizes?	_____	_____
31. Moisture content and dry density calculated for each sample?	_____	_____
32. Dry density plotted on vertical axis, moisture content plotted on horizontal axis, and points connected with a smooth curve?	_____	_____
33. Moisture content at peak of curve recorded as optimum water content and recorded to nearest 0.1 percent?	_____	_____
34. Dry density at optimum moisture content reported as maximum density to nearest 1 kg/m <sup>3</sup> (0.1 lb/ft <sup>3</sup> )?	_____	_____
35. Corrected for coarse particles if applicable?	_____	_____

Comments: First attempt: Pass \_\_\_\_\_ Fail \_\_\_\_\_ Second attempt: Pass \_\_\_\_\_ Fail \_\_\_\_\_

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\_\_\_\_\_  
\_\_\_\_\_

Examiner Signature \_\_\_\_\_ WAQTC #: \_\_\_\_\_

**PERFORMANCE EXAM CHECKLIST**

**MOISTURE-DENSITY RELATION OF SOILS  
FOP FOR AASHTO T 180**

Participant Name \_\_\_\_\_ Exam Date \_\_\_\_\_

Record the symbols “P” for passing or “F” for failing on each step of the checklist.

<b>Procedure Element</b>	<b>Trial 1</b>	<b>Trial 2</b>
1. If damp, sample dried in air or drying apparatus, not exceeding 60°C (140°F)?	_____	_____
2. Sample broken up and an adequate amount sieved over the appropriate sieve (4.75 mm / No. 4 or 19.0 mm / 3/4 in.) to determine oversize (coarse particle) percentage?	_____	_____
3. Sample passing the sieve has appropriate mass?	_____	_____
4. If soil is plastic (clay types):		
a. Multiple samples mixed with water varying moisture content by 1 to 2 percent, bracketing the optimum moisture content?	_____	_____
b. Samples placed in covered containers and allowed to stand for at least 12 hours?	_____	_____
5. Sample determined to be 4 to 8 percent below expected optimum moisture content?	_____	_____
6. Mold placed on rigid and stable foundation?	_____	_____
7. Layer of soil (approximately one fifth compacted depth) placed in mold with collar attached, loose material lightly tamped?	_____	_____
8. Soil compacted with appropriate number of blows (25 or 56)?	_____	_____
9. Material adhering to the inside of the mold trimmed?	_____	_____
10. Layer of soil (approximately two fifths compacted depth) placed in mold with collar attached, loose material lightly tamped?	_____	_____
11. Soil compacted with appropriate number of blows (25 or 56)?	_____	_____
12. Material adhering to the inside of the mold trimmed?	_____	_____
13. Layer of soil (approximately three fifths compacted depth) placed in mold with collar attached, loose material lightly tamped?	_____	_____
14. Soil compacted with appropriate number of blows (25 or 56)?	_____	_____
15. Material adhering to the inside of the mold trimmed?	_____	_____

**OVER**

<b>Procedure Element</b>	<b>Trial 1</b>	<b>Trial 2</b>
16. Layer of soil (approximately four fifths compacted depth) placed in mold with collar attached, loose material lightly tamped?	_____	_____
17. Soil compacted with appropriate number of blows (25 or 56)?	_____	_____
18. Material adhering to the inside of the mold trimmed?	_____	_____
19. Mold filled with soil such that compacted soil will be above the mold, loose material lightly tamped?	_____	_____
20. Soil compacted with appropriate number of blows (25 or 56)?	_____	_____
21. Collar removed without shearing off sample?	_____	_____
22. Approximately 6 mm (1/4 in.) of compacted material above the top of the mold (without the collar)?	_____	_____
23. Soil trimmed to top of mold with the beveled side of the straightedge?	_____	_____
24. Mass of mold and contents determined to appropriate precision?	_____	_____
25. Wet density calculated from the wet mass?	_____	_____
26. Soil removed from mold using a sample extruder if needed?	_____	_____
27. Soil sliced vertically through center (non-granular material)?	_____	_____
28. Moisture sample removed ensuring all layers are represented?	_____	_____
29. Moist mass determined immediately to 0.1 g?	_____	_____
30. Moisture sample mass of correct size?	_____	_____
31. Sample dried and water content determined according to the FOP for T 255/T 265?	_____	_____
32. Remainder of material from mold broken up until it will pass through the sieve, as judged by eye, and added to remainder of original test sample?	_____	_____
33. Water added to increase moisture content of the remaining sample in 1 to 2 percent increments?	_____	_____
34. Steps 2 through 20 repeated for each increment of water added?	_____	_____
35. If soil is plastic (clay types):		
a. Samples mixed with water varying moisture content by 1 to 2 percent, bracketing the optimum moisture content?	_____	_____
b. Samples placed in covered containers and allowed to stand for at least 12 hours?	_____	_____
36. If material is degradable:		
Multiple samples mixed with water varying moisture content by 1 to 2 percent, bracketing the optimum moisture content?	_____	_____

**OVER**

**Procedure Element**

**Trial 1    Trial 2**

- |   |       |       |
|---|-------|-------|
| 37. Process continued until wet density either decreases or stabilizes?   | _____ | _____ |
| 38. Moisture content and dry density calculated for each sample?  | _____ | _____ |
| 39. Dry density plotted on vertical axis, moisture content plotted on horizontal axis, and points connected with a smooth curve?  | _____ | _____ |
| 40. Moisture content at peak of curve recorded as optimum water content and recorded to nearest 0.1 percent?                      | _____ | _____ |
| 41. Dry density at optimum moisture content reported as maximum density to nearest 1 kg/m <sup>3</sup> (0.1 lb/ft <sup>3</sup> )? | _____ | _____ |
| 42. Corrected for coarse particles if applicable?   | _____ | _____ |

Comments:      First attempt:    Pass\_\_\_\_\_Fail\_\_\_\_\_      Second attempt:    Pass\_\_\_\_\_Fail\_\_\_\_\_

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Examiner Signature \_\_\_\_\_ WAQTC #: \_\_\_\_\_

EMBANKMENT AND BASE  
IN-PLACE DENSITY

WAQTC

FOP AASHTO T 99/T 180 (15)

**DEVELOPING A FAMILY OF CURVES  
FOP FOR AASHTO R 75**

01

**Significance**

02

Soils sampled from one source will have many different moisture-density curves, but if a group of these curves is plotted together, similarities or relationships are usually seen. A family of curves is a group of soil moisture-density relationships that reveal similarities characteristic of the soil type and source. Higher-density soils have curves with steeper slopes and maximum dry densities at lower optimum moisture contents, while the lower-density soils have flatter curves with higher optimum moisture contents.

03

**Scope**

04

This procedure provides a method to develop a family of curves using multiple moisture density relationships developed using the same method, A, B, C, or D from the FOP for AASHTO T 99/T 180 in accordance with AASHTO R 75-16.

All curves used in a family must be developed using a single Method: A, B, C, or D of a procedure for AASHTO T 99 or T 180. See the FOP for AASHTO T 99/T 180.

05

**Terminology**

*family of curves* — a group of soil moisture-density relationships (curves) determined using AASHTO T 99 or T 180, which reveal certain similarities and trends characteristic of the soil type and source.

*spine* — smooth line extending through the point of maximum density/optimum moisture content of a family of moisture-density curves.

Mold \ Sieve	4.75 mm (No. 4)	19 mm (3/4")
4"	A	C
6"	B	D

**Methods of T 99 / T 180**

**Procedure**

- 06 1. Sort the curves by Method (A, B, C, or D of the FOP for T 99/T 180). At least three curves are required per family.
- 2. Select the highest and lowest maximum dry densities from those selected to assist in determining the desired scale of the subsequent graph.
- 07 3. Plot the maximum density and optimum moisture points of the selected curves on the graph.
- 08 4. Draw a smooth, “best fit,” curved line through the points creating the spine of the family of curves.
- 09 5. Remove maximum density and optimum moisture points that were not used to establish the spine.
- 10 6. Add the moisture/density curves associated with the points that were used to establish the spine. It is not necessary to include the portion of the curves over optimum moisture.
- 11 7. Add the moisture/density curves associated with the points that were used to establish the spine. It is not necessary to include the portion of the curves over optimum moisture.
- 12 *Note 1*—Intermediate template curves using slopes similar to those of the original moisture-density curves may be included when maximum density points are more than 2.0 lb/ft<sup>3</sup> apart. Template curves are indicated by a dashed line.
- 13 8. Plot the 80 percent of optimum moisture range when desired:
- 14 9. Using the optimum moisture of an existing curve, calculate 80 percent of optimum moisture and plot this value on the curve. Repeat for each curve in the family.
- 15 10. Draw a smooth, “best fit,” curved line connecting the 80 percent of optimum moisture points plotted on the curves that parallel the spine.

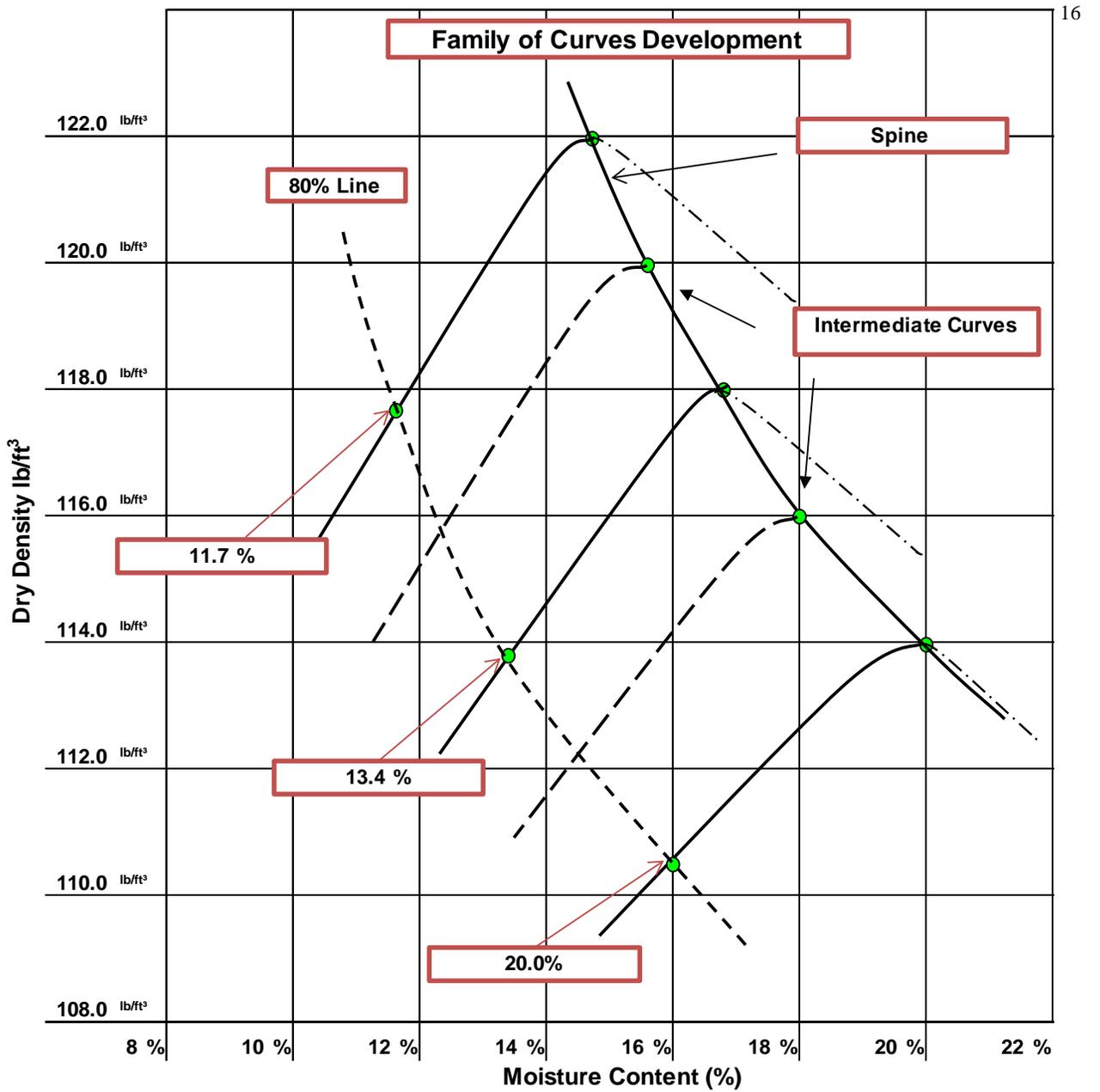
**Calculations**

Calculate 80 percent of optimum moisture of each curve:

Example:

Optimum moisture of the highest density curve = 14.6%

$$80\% \text{ of optimum moisture} = \frac{80\% \times 14.6\%}{100} = 11.7\%$$



**Tips!**

17

- Make sure that the selected moisture/density relationship curves were developed using the same method from the FOP for AASHTO T 99 / T 180 – A, B, C, or D

## REVIEW QUESTIONS

1. To what other procedure(s) is this procedure related?
2. What does the 'spine' of the curve mean?
3. Describe the limitations of developing a family of curves.







**ONE-POINT METHOD FOR DETERMINING MAXIMUM DRY DENSITY AND  
OPTIMUM MOISTURE  
FOP FOR AASHTO T 272**

01

**Significance**

02

Soils sampled from one source will have many different moisture-density curves, but if a group of these curves is plotted together, similarities or relationships are usually seen. A family of curves is a group of soil moisture-density relationships that reveal similarities characteristic of the soil type and source. Higher-density soils have curves with steeper slopes and maximum dry densities at lower optimum moisture contents, while the lower-density soils have flatter curves with higher optimum moisture contents.

03

In the field, density and moisture content are determined, and a single point is plotted on an individual moisture curve or family of curves graphs.

**Scope**

04

This procedure provides for a rapid determination of the maximum dry density and optimum moisture content of a soil sample using a one-point determination in accordance with AASHTO T 272-16. This procedure is related to the FOP for AASHTO T 99/T 180 and R 75.

05

One-point determinations are made by compacting the soil in a mold of a given size with a specified rammer dropped from a specified height and then compared to an individual moisture/density curve (FOP for AASHTO T 99 or T 180) or a family of curves (FOP for AASHTO R 75). Four alternate methods – A, B, C, and D – are used and correspond to the methods described in the FOP for AASHTO T 99/T 180. The method used in AASHTO T 272 must match the method used for the reference curve or to establish the family of curves. For example, when moisture-density relationships as determined by T 99 - Method C are used to form the family of curves or an individual moisture density curve, then T 99 - Method C must be used to for the one-point determination.

### Apparatus

See the FOP for AASHTO T 99/T 180. Use the method matching the individual curve or Family of Curves. Refer to Table 1 of the FOP for AASHTO T 99/T 180 for corresponding mold size, number of layers, number of blows, and rammer specification for the various test methods.

### Sample

Sample size is determined according to the FOP for AASHTO T 310. In cases where the existing individual curve or family cannot be used, a completely new curve must be developed and the sample size determined by the FOP for AASHTO T 99/T 180.

06 If the sample is damp, dry it until it becomes friable under a trowel. Drying may be in air or by use of a drying apparatus maintained at a temperature not exceeding 60°C (140°F). Thoroughly break up aggregations in a manner that avoids reducing the natural size of individual particles.

### Procedure

- 07
1. Determine the mass of the clean, dry mold. Include the base plate, but exclude the extension collar. Record the mass to the nearest 1 g (0.005 lb).
  - 08 2. Thoroughly mix the sample with sufficient water to adjust moisture content to 80 to 100 percent of the anticipated optimum moisture.
  3. Form a specimen by compacting the prepared soil in the mold (with collar attached) in approximately equal layers. For each layer:
    - a. Spread the loose material uniformly in the mold.

**Note 1:** It is recommended to cover the remaining material with a non-absorbent sheet or damp cloth to minimize loss of moisture.

- b. Lightly tamp the loose material with the manual rammer or other similar device, this establishes a firm surface.
- c. Compact each layer with uniformly distributed blows from the rammer.



**Dense, uniform, rigid foundation**



**Trim soil**



**Mass of mold and wet sample**

09

10

11

12

13

14

15

d. Trim down material that has not been compacted and remains adjacent to the walls of the mold and extends above the compacted surface.

4. Remove the extension collar. Avoid shearing off the sample below the top of the mold. The material compacted in the mold should not be over 6 mm (1/4 in.) above the top of the mold once the collar has been removed.

5. Trim the compacted soil even with the top of the mold with the beveled side of the straightedge.

6. Determine the mass of the mold and wet soil to the nearest 1 g (0.005 lb) or better.

7. Determine the wet mass of the sample by subtracting the mass in Step 1 from the mass in Step 6.

8. Calculate the wet density as indicated below under "Calculations."

9. Extrude the material from the mold. For soils and soil-aggregate mixtures, slice vertically through the center and take a representative moisture content sample from one of the cut faces, ensuring that all layers are represented. For granular materials, a vertical face will not exist. Take a representative sample. This sample must meet the sample size requirements of the test method used to determine moisture content.

10. Determine the moisture content of the sample in accordance with the FOP for AASHTO T 255 / T 265.

**Calculations**

1. Calculate the wet density, in kg/m<sup>3</sup> (lb/ft<sup>3</sup>), by dividing the wet mass by the measured volume of the mold (T 19).

Example – Methods A or C mold:

16

Wet mass = 2.0055 kg (4.42 lb)

Measured volume of the mold = 0.0009469 m<sup>3</sup> (0.03344 ft<sup>3</sup>)

$$Wet\ Density = \frac{2.0055\ kg}{0.0009469\ m^3} = 2118\ kg/m^3$$

$$Wet\ Density = \frac{4.42\ lb}{0.03344\ ft^3} = 132.2\ lb/ft^3$$

2. Calculate the dry density as follows.

17

$$\rho_d = \left( \frac{\rho_w}{w + 100} \right) \times 100 \quad or \quad \rho_d = \frac{\rho_w}{\left( \frac{w}{100} \right) + 1}$$

Where:

$\rho_d$  = Dry density, kg/m<sup>3</sup> (lb/ft<sup>3</sup>)

$\rho_w$  = Wet density, kg/m<sup>3</sup> (lb/ft<sup>3</sup>)

w = Moisture content, as a percentage

Example:

$$\rho_w = 2118\ kg/m^3\ (132.2\ lb/ft^3)$$

$$w = 13.5\%$$

$$\rho_d = \left( \frac{2118\ kg/m^3}{13.5 + 100} \right) \times 100 = 1866\ kg/m^3 \quad \rho_d = \left( \frac{132.2\ lb/ft^3}{13.5 + 100} \right) \times 100 = 116.5\ lb/ft^3$$

18

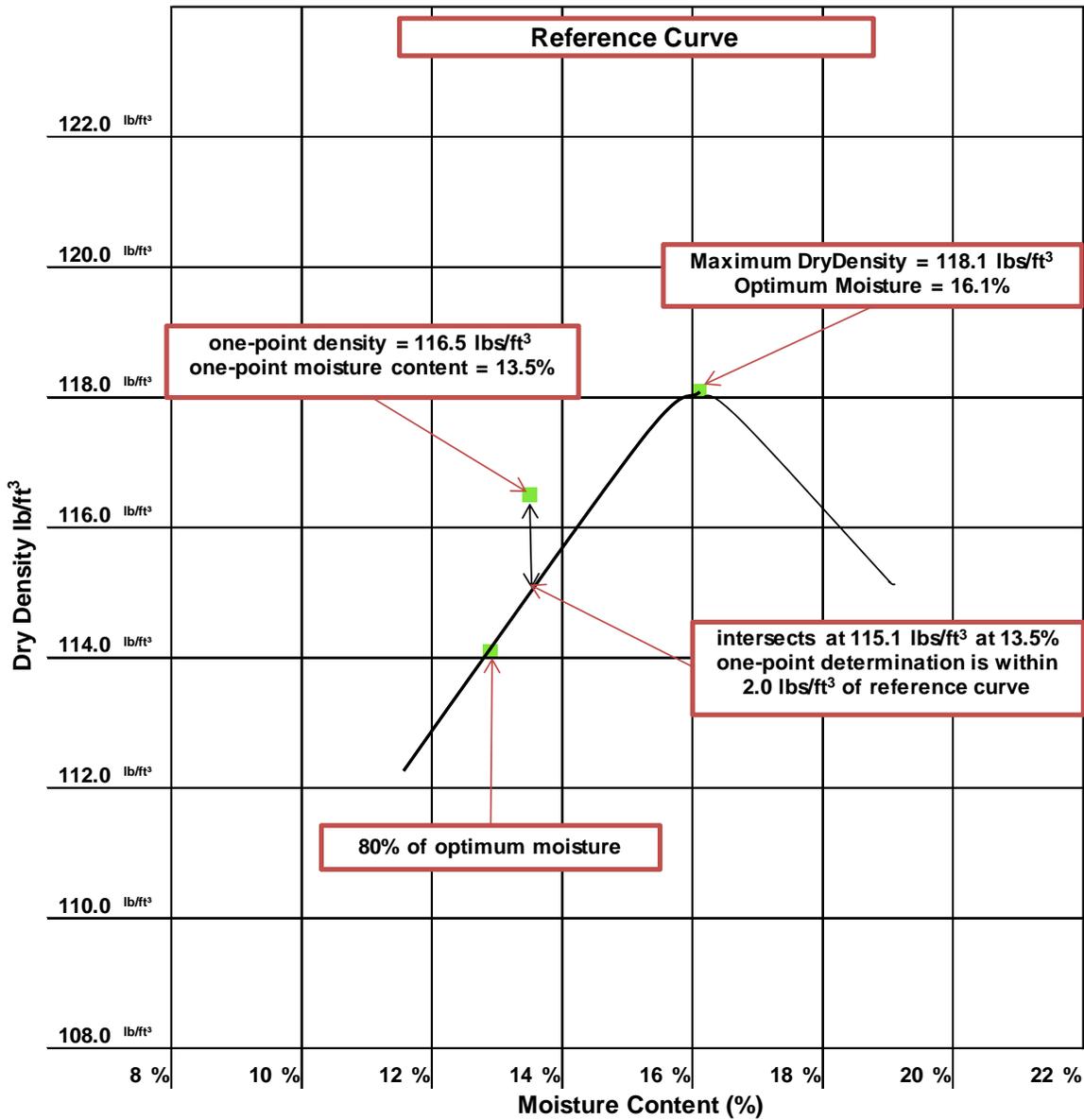
or

$$\rho_d = \left( \frac{2118\ kg/m^3}{\frac{13.5}{100} + 1} \right) = 1866\ kg/m^3 \quad \rho_d = \left( \frac{132.2\ lb/ft^3}{\frac{13.5}{100} + 1} \right) = 116.5\ lb/ft^3$$

**Maximum Dry Density and Optimum  
Moisture Content Determination Using an  
Individual Moisture / Density Curve**

1. The moisture content must be within 80 to 100 percent of optimum moisture of the reference curve. Compact another specimen, using the same material, at an adjusted moisture content if the one-point does not fall in the 80 to 100 percent of optimum moisture range.
- 19 2. Plot the one-point, dry density on the vertical axis and moisture content on the horizontal axis, on the reference curve graph.
- 20 3. If the one-point falls on the reference curve or within  $\pm 2.0 \text{ lb/ft}^3$ , then the maximum dry density and optimum moisture content determined by the curve can be used.
4. Perform a full moisture-density relationship if the one-point does not fall on or within  $\pm 2.0 \text{ lb/ft}^3$  of the reference curve at 80 to 100 percent optimum moisture.

Example



Example:

21

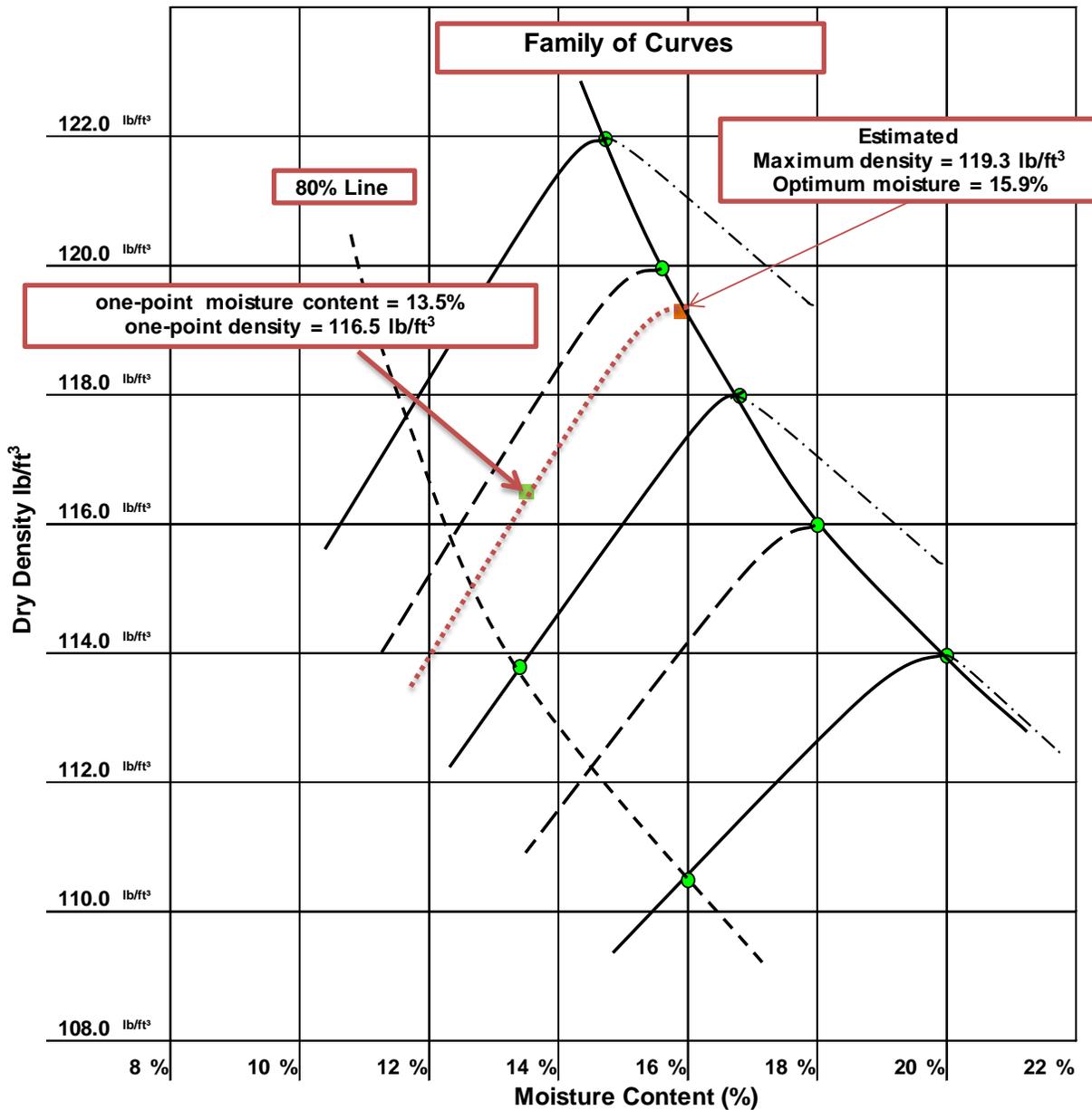
The results of a one-point determination were 116.5 lb/ft<sup>3</sup> at 13.5 percent moisture. The point was plotted on the reference curve graph. The one-point determination is within 2.0 lb/ft<sup>3</sup> of the point on the curve that corresponds with the moisture content.

### Maximum Dry Density and Optimum Moisture Content Determination Using a Family of Curves

- 22 1. If the moisture-density one-point falls on one of  
the curves in the family of curves, the maximum  
dry density and optimum moisture content  
defined by that curve is used.
- 23 2. If the moisture-density one-point falls within the  
family of curves but not on an existing curve,  
draw a new curve through the plotted single  
point parallel and in character with the nearest  
existing curve in the family of curves. Use the  
maximum dry density and optimum moisture  
content as defined by the new curve shall be  
used.
- 24 3. The one-point must fall either between or on the  
highest or lowest curves. If it does not, then a  
full curve must be developed.
4. If the one-point plotted within or on the family  
of curves does not fall in the 80 to 100 percent  
of optimum moisture content, compact another  
specimen, using the same material, at an  
adjusted moisture content that will place the  
one-point within this range.
5. If the new curve through a one-point is not well  
defined or is in any way questionable, perform a  
full moisture-density relationship to correctly  
define the new curve and verify the applicability  
of the family of curves.

**Note 2:** New curves drawn through plotted single point  
determinations shall not become a permanent part of the  
family of curves until verified by a full moisture-density  
procedure following the FOP for AASHTO T 99/T 180.

**EXAMPLE**



The results of a one-point determination were 116.5 lb/ft<sup>3</sup> at 13.5 percent moisture. The point was plotted on the reference curve graph. The point was plotted on the appropriate family between two previously developed curves near and intermediate curve.

The “dotted” curve through the moisture-density one-point was sketched between the existing curves. A maximum dry density of 119.3 lb/ft<sup>3</sup> and a corresponding optimum moisture content of 15.9 percent were estimated.

26

### Report

- Results on forms approved by the agency
- Sample ID
- Maximum dry density to the closest  $1 \text{ kg/m}^3$  ( $0.1 \text{ lb/ft}^3$ )
- Optimum moisture content to the closest 0.1 percent
- Reference curve or Family of Curves used

27

### Tips!

- Make sure that the moisture content of the one-point sample is between 80 and 100 percent of optimum moisture.
- Remember that a full moisture-density procedure shall be made if the curve drawn through the one-point is not well defined or is questionable.

EMBANKMENT AND BASE  
IN-PLACE DENSITY

WAQTC

FOP AASHTO T 272 (16)

## REVIEW QUESTIONS

1. To what other procedure(s) is this procedure related?
2. How are the two procedures used together?
3. Describe the limitations of using the one-point determination with a family of curves.



**PERFORMANCE EXAM CHECKLIST**

**ONE-POINT METHOD  
FOP FOR AASHTO T 272 (T 99)**

Participant Name \_\_\_\_\_ Exam Date \_\_\_\_\_

Record the symbols “P” for passing or “F” for failing on each step of the checklist.

Procedure Element	Trial 1	Trial 2
1. One-point determination of dry density and corresponding moisture content made in accordance with the FOP for AASHTO T 99?	_____	_____
a. Correct size (4.75 mm / No. 4 or 19.0 mm / 3/4 in.) material used?	_____	_____
2. If necessary, sample dried until friable in air or drying apparatus, not exceeding 60°C (140°F)?	_____	_____
3. Sample broken up and an adequate amount sieved over the appropriate sieve (4.75 mm / No. 4 or 19.0 mm / 3/4 in.) to determine oversize (coarse particle) percentage?	_____	_____
4. Sample passing the sieve has appropriate mass?	_____	_____
5. Layer of soil (approximately one third compacted depth) placed in mold with collar attached, loose material lightly tamped?	_____	_____
6. Soil compacted with appropriate number of blows (25 or 56)?	_____	_____
7. Material adhering to the inside of the mold trimmed?	_____	_____
8. Layer of soil (approximately two thirds compacted depth) placed in mold with collar attached, loose material lightly tamped?	_____	_____
9. Soil compacted with appropriate number of blows (25 or 56)?	_____	_____
10. Material adhering to the inside of the mold trimmed?	_____	_____
11. Mold filled with soil such that compacted soil will be above the mold, loose material lightly tamped?	_____	_____
12. Soil compacted with appropriate number of blows (25 or 56)?	_____	_____
13. Collar removed without shearing off sample?	_____	_____
14. Approximately 6 mm (1/4 in.) of compacted material above the top of the mold (without the collar)?	_____	_____
15. Soil trimmed to top of mold with the beveled side of the straightedge?	_____	_____
16. Mass of mold and contents determined to appropriate precision?	_____	_____
17. Wet density calculated from the wet mass?	_____	_____
18. Soil removed from mold using a sample extruder if needed?	_____	_____
19. Soil sliced vertically through center (non-granular material)?	_____	_____
20. Moisture sample removed ensuring all layers are represented?	_____	_____

**OVER**

Procedure Element	Trial 1	Trial 2
21. Moist mass determined immediately to 0.1 g?	_____	_____
22. Moisture sample mass of correct size?	_____	_____
23. Sample dried and water content determined according to the FOP for T 255/T 265?	_____	_____
24. One-point plotted on family of curves supplied?	_____	_____
25. One-point falls within 80 to 100 percent of optimum moisture content in order to be valid?	_____	_____
26. If one-point does not fall within 80 to 100 percent of optimum moisture content, another one-point determination with an adjusted water content is made?	_____	_____
27. Maximum dry density and corresponding optimum moisture content correctly estimated?	_____	_____

Comments: First attempt: Pass\_\_\_\_\_Fail\_\_\_\_\_ Second attempt: Pass\_\_\_\_\_Fail\_\_\_\_\_

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Examiner Signature \_\_\_\_\_ WAQTC #: \_\_\_\_\_

### PERFORMANCE EXAM CHECKLIST

#### ONE-POINT METHOD FOP FOR AASHTO T 272 (T 180)

Participant Name \_\_\_\_\_ Exam Date \_\_\_\_\_

Record the symbols “P” for passing or “F” for failing on each step of the checklist.

Procedure Element	Trial 1	Trial 2
1. One-point determination of dry density and corresponding moisture content made in accordance with the FOP for AASHTO T 180?	_____	_____
a. Correct size (4.75 mm / No. 4 or 19.0 mm / 3/4 in.) material used?	_____	_____
2. If necessary, sample dried until friable in air or drying apparatus, not exceeding 60°C (140°F)?	_____	_____
3. Sample broken up and an adequate amount sieved over the appropriate sieve (4.75 mm / No. 4 or 19.0 mm / 3/4 in.) to determine oversize (coarse particle) percentage?	_____	_____
4. Sample passing the sieve has appropriate mass?	_____	_____
5. Mold placed on rigid and stable foundation?	_____	_____
6. Layer of soil (approximately one fifth compacted depth) placed in mold with collar attached, loose material lightly tamped?	_____	_____
7. Soil compacted with appropriate number of blows (25 or 56)?	_____	_____
8. Material adhering to the inside of the mold trimmed?	_____	_____
9. Layer of soil (approximately two fifths compacted depth) placed in mold with collar attached, loose material lightly tamped?	_____	_____
10. Soil compacted with appropriate number of blows (25 or 56)?	_____	_____
12. Material adhering to the inside of the mold trimmed?	_____	_____
13. Layer of soil (approximately three fifths compacted depth) placed in mold with collar attached, loose material lightly tamped?	_____	_____
14. Soil compacted with appropriate number of blows (25 or 56)?	_____	_____
15. Material adhering to the inside of the mold trimmed?	_____	_____
16. Layer of soil (approximately four fifths compacted depth) placed in mold with collar attached, loose material lightly tamped?	_____	_____
17. Soil compacted with appropriate number of blows (25 or 56)?	_____	_____
18. Material adhering to the inside of the mold trimmed?	_____	_____

OVER

Procedure Element	Trial 1	Trial 2
19. Mold filled with soil such that compacted soil will be above the mold, loose material lightly tamped?	_____	_____
20. Soil compacted with appropriate number of blows (25 or 56)?	_____	_____
21. Collar removed without shearing off sample?	_____	_____
22. Approximately 6 mm (1/4 in.) of compacted material above the top of the mold (without the collar)?	_____	_____
23. Soil trimmed to top of mold with the beveled side of the straightedge?	_____	_____
26. Mass of mold and contents determined to appropriate precision?	_____	_____
27. Wet density calculated from the wet mass?	_____	_____
28. Soil removed from mold using a sample extruder if needed?	_____	_____
29. Soil sliced vertically through center (non-granular material)?	_____	_____
30. Moisture sample removed ensuring all layers are represented?	_____	_____
31. Moist mass determined immediately to 0.1 g?	_____	_____
32. Moisture sample mass of correct size?	_____	_____
33. Sample dried and water content determined according to the FOP for T 255/T 265?	_____	_____
34. One-point plotted on family of curves supplied?	_____	_____
35. One-point falls within 80 to 100 percent of optimum moisture content in order to be valid?	_____	_____
36. If one-point does not fall within 80 to 100 percent of optimum moisture content, another one-point determination with an adjusted water content is made?	_____	_____
37. Maximum dry density and corresponding optimum moisture content correctly estimated?	_____	_____

Comments: First attempt: Pass\_\_\_\_\_Fail\_\_\_\_\_ Second attempt: Pass\_\_\_\_\_Fail\_\_\_\_\_

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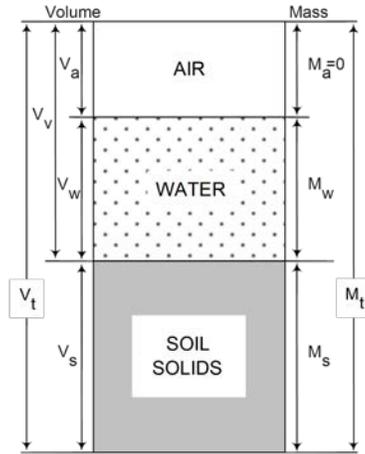
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Examiner Signature \_\_\_\_\_ WAQTC #: \_\_\_\_\_

**SPECIFIC GRAVITY AND ABSORPTION OF COARSE AGGREGATE  
FOP FOR AASHTO T 85**



**Phase diagram**

01  
02  
03

**Significance**

Bulk specific gravity is a characteristic used for calculating the volume occupied by the aggregate or various mixtures containing aggregate, including Portland Cement Concrete, bituminous mixes, and other materials that are proportioned or analyzed on an absolute volume basis. Specific gravity is the ratio of the mass of a material to the mass of an equal volume of water. Several categories of specific gravity are used relative to aggregate.

Bulk specific gravity (oven dry),  $G_{sb}$ , is used for computations when the aggregate is dry. Bulk specific gravity (saturated surface dry or SSD),  $G_{sb\ SSD}$ , is used if the aggregate is wet. Apparent specific gravity,  $G_{sa}$ , is based solely on the solid material making up the constituent particles and does not include the pore space within the particles that is accessible to water.

Absorption values are used to calculate the change in the mass of an aggregate due to water absorbed in the pore spaces within the constituent particles, compared to the dry condition, when it is deemed that the aggregate has been in contact with water long enough to satisfy most of the absorption potential. The laboratory standard for absorption is that obtained after submerging dry aggregate for between 15 to 19 hours in water. Aggregates mined from below the water table may have a higher absorption, when used, if not allowed to dry. Conversely, some aggregates, when used, may contain an amount of absorbed moisture less than the 15 hours soaked condition. For an aggregate that has been in contact with water and that has free moisture on the particle surfaces, the percentage of free moisture can be determined by deducting the absorption from the total moisture content.

The pores in lightweight aggregates may or may not become filled with water after immersion for 15 hours. In fact, many such aggregates can remain immersed in water for several days without satisfying most of the aggregates' absorption

potential. Therefore, this method is not intended for use with lightweight aggregate.

**Scope**

This procedure covers the determination of specific gravity and absorption of coarse aggregate in accordance with AASHTO T 85-14. Specific gravity may be expressed as bulk specific gravity ( $G_{sb}$ ), bulk specific gravity - saturated surface dry ( $G_{sb SSD}$ ), or apparent specific gravity ( $G_{sa}$ ).  $G_{sb}$  and absorption are based on aggregate after soaking in water. This procedure is not intended for use with lightweight aggregates.

**Terminology**

Absorption – the increase in the mass of aggregate due to water being absorbed into the pores of the material, but not including water adhering to the outside surface of the particles, expressed as a percentage of the dry mass. The aggregate is considered “dry” when it has been maintained at a temperature of  $110 \pm 5^\circ\text{C}$  ( $230 \pm 9^\circ\text{F}$ ) for sufficient time to remove all uncombined water.

Saturated Surface Dry (SSD) – the condition of an aggregate particle when the permeable voids are filled with water, but no water is present on exposed surfaces.

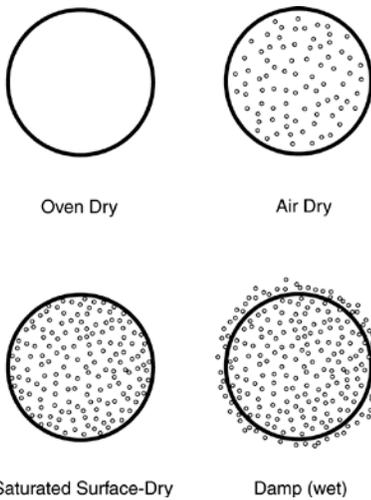
Specific Gravity – the ratio of the mass, in air, of a volume of a material to the mass of the same volume of gas-free distilled water at a stated temperature.

Apparent Specific Gravity ( $G_{sa}$ ) – the ratio of the mass, in air, of a volume of the impermeable portion of aggregate to the mass of an equal volume of gas-free distilled water at a stated temperature.

Bulk Specific Gravity ( $G_{sb}$ ) – the ratio of the mass, in air, of a volume of aggregate (including the permeable and impermeable voids in the particles, but not including the voids between particles) to the mass of an equal volume of gas-free distilled water at a stated temperature.

Bulk Specific Gravity (SSD) ( $G_{sb SSD}$ ) – the ratio of the mass, in air, of a volume of aggregate,

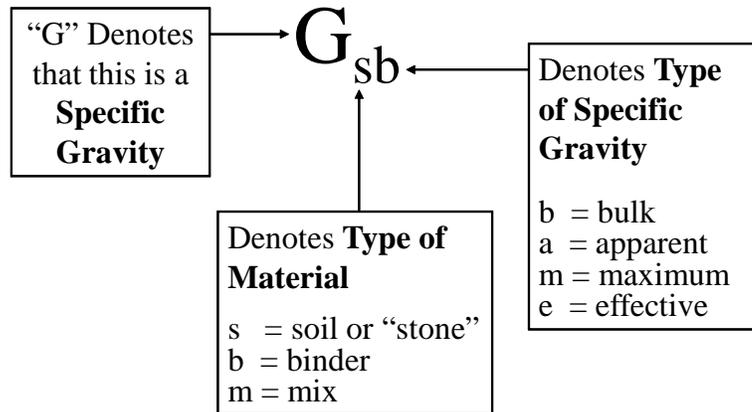
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**Moisture conditions**

including the mass of water within the voids filled to the extent achieved by submerging in water for 15 to 19 hours (but not including the voids between particles), to the mass of an equal volume of gas-free distilled water at a stated temperature.

## Definition: (Specific Gravity Symbols)



8



Sample Container

### Apparatus

- Balance or scale: with a capacity of 5 kg, sensitive to 1 g, and meeting the requirements of AASHTO M 231.
- Sample container: a wire basket of 3.35 mm (No. 6) or smaller mesh, with a capacity of 4 to 7 L (1 to 2 gal) to contain aggregate with a nominal maximum size of 37.5 mm (1 1/2 in.) or smaller; or a larger basket for larger aggregates, or both.
- Water tank: watertight and large enough to completely immerse aggregate and basket, equipped with an overflow valve to keep water level constant.
- Suspension apparatus: wire used to suspend apparatus shall be of the smallest practical diameter.
- Sieves: 4.75 mm (No. 4) or other sizes as needed, conforming to AASHTO M 92.
- Large absorbent towel

### Sample Preparation

- 11
1. Obtain the sample in accordance with the FOP for AASHTO T 2 (see Note 1).
  2. Mix the sample thoroughly and reduce to the approximate sample size required by Table 1 in accordance with the FOP for AASHTO R 76.
  3. Reject all material passing the appropriate sieve by dry sieving.
  4. Thoroughly wash sample to remove dust or other coatings from the surface.
  - 12 5. Dry the test sample to constant mass at a temperature of  $110 \pm 5^{\circ}\text{C}$  ( $230 \pm 9^{\circ}\text{F}$ ) and cool in air at room temperature for 1 to 3 hours.

*Note 1:* Where the absorption and specific gravity values are to be used in proportioning concrete mixtures in which the aggregates will be in their naturally moist condition, the requirement for initial drying to constant mass may be eliminated, and, if the surfaces of the particles in the sample have been kept continuously wet until test, the 15-to-19 hour soaking may also be eliminated.

6. Re-screen the sample over the appropriate sieve. Reject all material passing that sieve.
7. The sample shall meet or exceed the minimum mass given in Table 1.

*Note 2:* If this procedure is used only to determine the  $G_{sb}$  of oversized material for the FOP for AASHTO T 99 or T 180, the material can be rejected over the appropriate sieve. For T 99 / T 180 Methods A and B, use the 4.75 mm (No.4) sieve; for T 99 / T 180 Methods C and D, use the 19 mm (3/4 in).

**Table 1**

Nominal Maximum Size*, mm (in.)	Minimum Mass of Test Sample, g (lb)
12.5 (1/2) or less	2000 (4.4)
19.0 (3/4)	3000 (6.6)
25.0 (1)	4000 (8.8)
37.5 (1 1/2)	5000 (11)
50 (2)	8000 (18)
63 (2 1/2)	12,000 (26)
75 (3)	18,000 (40)

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\* One sieve larger than the first sieve to retain more than 10 percent of the material using an agency specified set of sieves based on cumulative percent retained. Where large gaps in specification sieves exist, intermediate sieve(s) may be inserted to determine nominal maximum size.

**Procedure**

1. Immerse the aggregate in water at room temperature for a period of 15 to 19 hours.

14

*Note 3:* When testing coarse aggregate of large nominal maximum size requiring large test samples, it may be more convenient to perform the test on two or more subsamples, and then combine values obtained.

2. Place the empty basket into the water bath and attach to the balance. Inspect the immersion tank to ensure the water level is at the overflow outlet height. Tare the balance with the empty basket attached in the water bath.
3. Remove the test sample from the water and roll it in a large absorbent cloth until all visible films of water are removed. Wipe the larger particles individually. If the test sample dries past the SSD condition, immerse in water for 30 min, and then resume the process of surface-drying.

15

*Note 4:* A moving stream of air may be used to assist in the drying operation, but take care to avoid evaporation of water from aggregate pores.



SSD Sample



Submerged container

4. Determine the SSD mass of the sample, and record this and all subsequent masses to the nearest 0.1 g or 0.1 percent of the sample mass, whichever is greater. Designate this mass as “B.”
5. Immediately place the SSD test sample in the sample container and weigh it in water maintained at  $23.0 \pm 1.7^{\circ}\text{C}$  ( $73.4 \pm 3^{\circ}\text{F}$ ). Shake the container to release entrapped air before recording the weight. Re-inspect the immersion tank to ensure the water level is at the overflow outlet height. Designate this submerged weight as “C.”

*Note 5:* The container should be immersed to a depth sufficient to cover both it and the test sample during mass determination. The wire suspending the container should be of the smallest practical size to minimize any possible effects of a variable immersed length.

16

6. Remove the sample from the basket. Ensure that all material has been removed and place in a container of known mass.

17

7. Dry the test sample to constant mass in accordance with the FOP for AASHTO T 255/T 265 (Aggregate section) and cool in air at room temperature for 1 to 3 hours. Designate this mass as “A.”

### Calculations

Perform calculations and determine values using the appropriate formula below.

Bulk specific gravity ( $G_{sb}$ )

$$G_{sb} = \frac{A}{B - C}$$

Bulk specific gravity, SSD ( $G_{sb}$  SSD)

18

$$G_{sbSSD} = \frac{B}{B - C}$$

Apparent specific gravity ( $G_{sa}$ )

19

$$G_{sa} = \frac{A}{A - C}$$

20

Absorption

$$\text{Absorption} = \frac{B - A}{A} \times 100 \quad 21$$

Where:

- A = oven dry mass, g
- B = SSD mass, g
- C = weight in water, g

**Sample Calculations**

Sample	A	B	C	B - C	A - C	B - A
1	2030.9	2044.9	1304.3	740.6	726.6	14.0
2	1820.0	1832.5	1168.1	664.4	651.9	12.5
3	2035.2	2049.4	1303.9	745.5	731.3	14.2

Sample	G <sub>sb</sub>	G <sub>sb</sub> SSD	G <sub>sa</sub>	Absorption
1	2.742	2.761	2.795	0.7
2	2.739	2.758	2.792	0.7
3	2.730	2.749	2.783	0.7

These calculations demonstrate the relationship between G<sub>sb</sub>, G<sub>sb</sub> SSD, and G<sub>sa</sub>. G<sub>sb</sub> is always lowest, since the volume includes voids permeable to water. G<sub>sb</sub> SSD is always intermediate. G<sub>sa</sub> is always highest, since the volume does not include voids permeable to water. When running this test, check to make sure the values calculated make sense in relation to one another.

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**Report**

- Results on forms approved by the agency
- Sample ID
- Specific gravities to 3 decimal places
- Absorption to 0.1 percent

**Tips!**

23

- Shake the container and sample when weighing in water to release entrapped air.
- Compare G<sub>sb</sub>, G<sub>sb</sub> SSD, and G<sub>sa</sub> to see if they make sense.

## REVIEW QUESTIONS

1. What size sample is required for aggregate with a nominal maximum size of 25 mm (1 in.)?
2. When is soaking required? For how long must material be soaked?
3. When, in the process, are dry and SSD masses determined?



**PERFORMANCE EXAM CHECKLIST**

**SPECIFIC GRAVITY AND ABSORPTION OF COARSE AGGREGATE  
FOP FOR AASHTO T 85**

Participant Name \_\_\_\_\_ Exam Date \_\_\_\_\_

Record the symbols “P” for passing or “F” for failing on each step of the checklist.

<b>Procedure Element</b>	<b>Trial 1</b>	<b>Trial 2</b>
1. Sample obtained by FOP for AASHTO T 2 and reduced by FOP for AASHTO R 76 or from FOP for AASHTO T 99 / T 180?	_____	_____
2. Screened on the appropriate size sieve?	_____	_____
3. Sample mass appropriate?	_____	_____
4. Particle surfaces clean?	_____	_____
5. Dried to constant mass 110 ±5°C (230 ±9°F) and cooled to room temperature?	_____	_____
6. Covered with water for 15 to 19 hours?	_____	_____
7. Basket placed into immersion tank and attached to balance?	_____	_____
8. Immersion tank inspected for proper water height?	_____	_____
9. Balance tared with basket in tank and temperature checked 23.0 ±1.7°C (73.4 ±3°F)?	_____	_____
10. Sample removed from water and rolled in cloth to remove visible films of water?	_____	_____
11. Larger particles wiped individually?	_____	_____
12. Evaporation avoided?	_____	_____
13. Sample mass determined to 0.1 g?	_____	_____
14. Sample immediately placed in basket, in immersion tank?	_____	_____
15. Entrapped air removed before weighing by shaking basket while immersed?	_____	_____
16. Immersion tank inspected for proper water height?	_____	_____
17. Immersed sample weight determined to 0.1 g?	_____	_____
18. All the sample removed from basket?	_____	_____
19. Sample dried to constant mass and cooled to room temperature?	_____	_____

**OVER**

**Procedure Element**

**Trial 1 Trial 2**

20. Sample mass determined to 0.1 g?

\_\_\_\_\_

21. Proper formulas used in calculations?

\_\_\_\_\_

Comments: First attempt: Pass\_\_\_\_\_Fail\_\_\_\_\_ Second attempt: Pass\_\_\_\_\_Fail\_\_\_\_\_

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Examiner Signature \_\_\_\_\_ WAQTC #: \_\_\_\_\_

## USE OF AKDOT & PF ATM 212, ITD IT 74, WSDOT T 606, OR WFLHD HUMPHRES CURVES

### Background

Coarse-grained granular soils are free-draining and have little or no cohesion. These soils are, therefore, not particularly well suited for the moisture-density relations procedures of AASHTO T 99 or AASHTO T 180. Transportation agencies have developed specialized test methods that are hybrids of those moisture-density procedures and methods that employ compaction under load with vibration. Those methods include:

- AKDOT & PF's ATM 212
- ITD's IT 74
- WSDOT's T 606
- WFLHD's Humphres

### Description of Procedure

In these tests, material is compacted in a mold and in a manner similar to those used in a Proctor test, after which the material is further compacted through a combination of applied loads and vibration. A laboratory maximum dry density is determined, as is the percent of material passing a certain sieve such as the 4.75 mm (No. 4). A number of determinations are made for different percentages passing the specified sieve. A graph is developed in which dry density is plotted versus the percentage of material passing that sieve. These tests are conducted in the agency's central lab, and the curve developed is a central lab function. Figure 1 is an example of such a curve.

Construction specifications will call out a percent of maximum dry density required for the granular materials used on the job. These specified values will be based on ATM 212, IT 74, T 606, or Humphres, depending on the agency.

In the field, the dry density of the granular material will be determined in accordance with the FOP for AASHTO 310. The percent of material passing the specified sieve will be determined for a sample

obtained at the site of the density test. The dry density and percent passing values will then be compared with the curve developed in the lab for that particular granular material to determine conformance with the project specifications.

**Maximum Density Chart**

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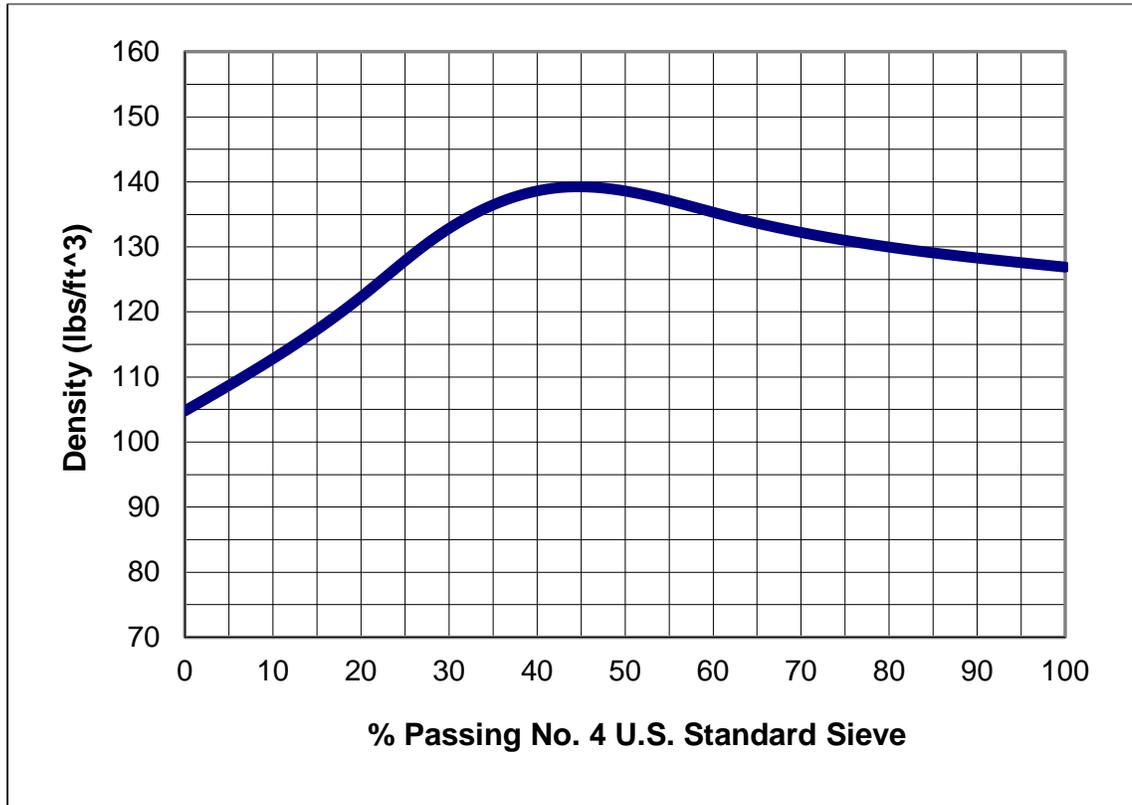
<b>Density Curves</b>			
<b>Pass #4</b>	<b>Maximum</b>	<b>Pass #4</b>	<b>Maximum</b>
0.0	104.8	31.0	133.7
1.0	105.6	32.0	134.5
2.0	106.4	33.0	135.2
3.0	107.1	34.0	135.8
4.0	107.9	35.0	136.4
5.0	108.7	36.0	137.0
6.0	109.5	37.0	137.5
7.0	110.3	38.0	137.9
8.0	111.1	39.0	138.3
9.0	112.0	40.0	138.6
10.0	112.8	41.0	138.9
11.0	113.7	42.0	139.0
12.0	114.5	43.0	139.2
13.0	115.4	44.0	139.2
14.0	116.4	45.0	139.2
15.0	117.3	46.0	139.2
16.0	118.2	47.0	139.1
17.0	119.2	48.0	139.0
18.0	120.2	49.0	138.8
19.0	121.3	50.0	138.6
20.0	122.3	51.0	138.3
21.0	123.4	52.0	138.1
22.0	124.5	53.0	137.8
23.0	125.6	54.0	137.5
24.0	126.8	55.0	137.1
25.0	127.9	56.0	136.8
26.0	129.0	57.0	136.4
27.0	130.0	58.0	136.0
28.0	131.0	59.0	135.7
29.0	132.0	60.0	135.3
30.0	132.8	61.0	135.0

<b>Density Curves</b>			
<b>Pass #4</b>	<b>Maximum</b>	<b>Pass #4</b>	<b>Maximum</b>
62.0	134.6	82.0	129.6
63.0	134.3	83.0	129.4
64.0	134.0	84.0	129.3
65.0	133.6	85.0	129.1
66.0	133.3	86.0	128.9
67.0	133.1	87.0	128.8
68.0	132.8	88.0	128.6
69.0	132.5	89.0	128.4
70.0	132.2	90.0	128.3
71.0	132.0	91.0	128.1
72.0	131.7	92.0	128.0
73.0	131.5	93.0	127.9
74.0	131.2	94.0	127.7
75.0	131.0	95.0	127.6
76.0	130.8	96.0	127.4
77.0	130.6	97.0	127.3
78.0	130.4	98.0	127.2
79.0	130.2	99.0	127.0
80.0	130.0	100.0	126.9
81.0	129.8		

<b>Control Points for Density Curves</b>		
<b>Pass #4</b>	<b>Maximum</b>	<b>Loose</b>
0.0	104.8	87.6
20.5	122.8	99.6
27.4	130.4	103.8
42.5	139.1	105.4
61.1	134.9	96.7
100.0	126.9	81.9

**Maximum Density Curve**

08



**Example:**

A compaction test was taken and a sample was removed from the test site per the FOP for AASHTO T 310. The sample was graded over a 4.75 mm (No. 4) sieve. The following results were reported.

Dry density from

FOP for AASHTO T 310 = 136.0 lb/ft<sup>3</sup>

Percent passing 4.75 mm (No. 4) sieve = 49%

Maximum density = 138.8 lb/ft<sup>3</sup>

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$$\text{Percent compaction} = \frac{136.0 \text{ lb/ft}^3}{138.8 \text{ lb/ft}^3} \times 100 = 98\%$$

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**IN-PLACE DENSITY AND MOISTURE CONTENT OF SOIL AND SOIL-AGGREGATE BY NUCLEAR METHODS (SHALLOW DEPTH)**

**FOP FOR AASHTO T 310**



**Checking deflection**



**Caution!**



**Gauge, transport case and instruction manual**

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**Significance**

The final in-place density of roadway embankment and base is critical to the quality and longevity of a highway project. Low-density material will lead to excessive deflection under load or permanent deformation, or both.

This procedure provides a rapid, nondestructive technique for determining the in-place wet density and moisture content of soil, aggregate, and soil-aggregate mixes. The non-destructive nature of the test allows repetitive measurements to be made at a single test location between roller passes. The procedure is normally suitable from test depths of 50 mm (2 in.) to 300 mm (12 in.).

**Scope**

This procedure covers the determination of density, moisture content, and relative compaction of soil, aggregate, and soil-aggregate mixes in accordance with AASHTO T 310-13. This field operating procedure is derived from AASHTO T 310. The nuclear moisture-density gauge is used in the direct transmission mode.

**Apparatus**

- Nuclear density gauge with the factory matched standard reference block.
- Drive pin, guide / scraper plate, and hammer for testing in direct transmission mode.
- Transport case for properly shipping and housing the gauge and tools.
- Instruction manual for the specific make and model of gauge.
- Radioactive materials information and calibration packet containing:
  - Daily Standard Count Log
  - Factory and Laboratory Calibration Data Sheet



Nuclear gauge

09

- Leak Test Certificate
- Shippers Declaration for Dangerous Goods
- Procedure Memo for Storing, Transporting and Handling Nuclear Testing Equipment
- Other radioactive materials documentation as required by local regulatory requirements

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- Sealable containers and utensils for moisture content determinations.

**Radiation Safety**

- This method does not purport to address all of the safety problems associated with its use. The gauge utilizes radioactive materials that may be hazardous to the health of the user unless proper precautions are taken. Users of this gauge must become familiar with the applicable safety procedures and governmental regulations. All operators will be trained in radiation safety prior to operating nuclear density gauges. Some agencies require the use of personal monitoring devices such as a thermoluminescent dosimeter or film badge. Effective instructions together with routine safety procedures such as source leak tests, recording and evaluation of personal monitoring device data, etc., are a recommended part of the operation and storage of this gauge.

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**Calibration**

Calibrate the nuclear gauge as required by the agency. This calibration may be performed by the agency using manufacturer’s recommended procedures or by other facilities approved by the agency. Verify or re-establish calibration curves, tables, or equivalent coefficients every 12 months.

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**Standardization**

1. Turn the gauge on and allow it to stabilize (approximately 10 to 20 minutes) prior to standardization. Leave the power on during the day’s testing.

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2. Standardize the nuclear gauge at the construction site at the start of each day's work and as often as deemed necessary by the operator or agency. Daily variations in standard count shall not exceed the daily variations established by the manufacturer of the gauge.

If the daily variations are exceeded after repeating the standardization procedure, the gauge should be repaired and/or recalibrated.

3. Record the standard count for both density and moisture in the Daily Standard Count Log. The exact procedure for standard count is listed in the manufacturer's Operator's Manual.

*Note 1:* New standard counts may be necessary more than once a day. See agency requirements.

### Overview

15 There are two methods for determining in-place determination of soil / soil aggregate:

- Method A: Single Direction
- Method B: Two Directions

### Procedure

- 16
1. Select a test location(s) randomly and in accordance with agency requirements. Test sites should be relatively smooth and flat and meet the following conditions:
    - a) At least 10 m (30 ft.) away from other sources of radioactivity
    - b) At least 3 m (10 ft.) away from large objects
    - c) The test site should be at least 150 mm (6 in.) away from any vertical projection, unless the gauge is corrected for trench wall effect.
  2. Remove all loose and disturbed material, and remove additional material as necessary to expose the top of the material to be tested.



Prepared area



Filling surface voids



Guide plate and drive pin

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3. Prepare a flat area sufficient in size to accommodate the gauge. Plane the area to a smooth condition so as to obtain maximum contact between gauge and the material being tested. For Method B, the flat area must be sufficient to permit rotating the gauge 90 or 180 degrees about the source rod.

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4. Fill in surface voids beneath the gauge with fines of the material being tested passing the 4.75 mm (No. 4) sieve or finer. Smooth the surface with the guide plate or other suitable tool. The depth of the filler should not exceed approximately 3 mm (1/8 in.).

19

5. Make a hole perpendicular to the prepared surface using the guide plate and drive pin. The hole shall be at least 50 mm (2 in.) deeper than the desired probe depth, and shall be aligned so that insertion of the probe will not cause the gauge to tilt from the plane of the prepared area. Remove the drive pin by pulling straight up and twisting the extraction tool.

20

6. Place the gauge on the prepared surface so the source rod can enter the hole without disturbing loose material.

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7. Insert the probe in the hole and lower the source rod to the desired test depth using the handle and trigger mechanism.

8. Seat the gauge firmly by partially rotating it back and forth about the source rod. Ensure the gauge is seated flush against the surface by pressing down on the gauge corners, and making sure that the gauge does not rock.

9. Pull gently on the gauge to bring the side of the source rod nearest to the scaler / detector firmly against the side of the hole.

23

10. Perform one of the following as required by agency:

- a. **Method A Single Direction:** Take a test consisting of the average of two one-minute readings, and record both density and moisture data. The two wet density readings should be within  $32 \text{ kg/m}^3$  ( $2.0 \text{ lb/ft}^3$ ) of each other. The average of the two wet



**Taking a reading**

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**Representative sample site**

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densities and moisture contents will be used to compute dry density.

- b. **Method B Two Direction:** Take a one-minute reading and record both density and moisture data. Rotate the gauge 90 or 180 degrees, pivoting it around the source rod. Reseat the gauge by pulling gently on the gauge to bring the side of the source rod nearest to the scaler / detector firmly against the side of the hole and take a one-minute reading. (In trench locations, rotate the gauge 180 degrees for the second test.) Some agencies require multiple one-minute readings in both directions. Analyze the density and moisture data. A valid test consists of wet density readings in both gauge positions that are within  $50 \text{ kg/m}^3$  ( $3.0 \text{ lb/ft}^3$ ). If the tests do not agree within this limit, move to a new location. The average of the wet density and moisture contents will be used to compute dry density.

11. If required by the agency, obtain a representative sample of the material, 4 kg (9 lb) minimum, from directly beneath the gauge full depth of material tested. This sample will be used to verify moisture content and / or identify the correct density standard. Immediately seal the material to prevent loss of moisture.

The material tested by direct transmission can be approximated by a cylinder of soil approximately 300 mm (12 in.) in diameter directly beneath the centerline of the radioactive source and detector. The height of the cylinder will be approximately the depth of the measurement. When organic material or large aggregate is removed during this operation, disregard the test information and move to a new test site.

26 12. To verify the moisture content from the nuclear  
gauge, determine the moisture content with a  
representative portion of the material using the  
FOP for AASHTO T 255/ T 265 or other  
agency approved methods. If the moisture  
content from the nuclear gauge is within  
27  $\pm 1$  percent the nuclear gauge readings can be  
accepted. Retain the remainder of the sample at  
its original moisture content for a one-point  
compaction test under the FOP for AASHTO  
T 272, or for gradation, if required.

*Note 2:* Example: A gauge reading of 16.8 percent moisture  
and oven dry or 17.7 percent are within the 1 percent  
requirements. Moisture correlation curves will be  
developed according to agency guidelines. These curves  
should be reviewed and possibly redeveloped every  
90 days because of moisture source decay.

28 13. Determine the dry density by one of the  
following methods:

a. From nuclear gauge readings, compute by  
subtracting the mass (weight) of the water  
( $\text{kg/m}^3$  or  $\text{lb/ft}^3$ ) from the wet density ( $\text{kg/m}^3$   
or  $\text{lb/ft}^3$ ); or compute using the percent  
moisture by dividing wet density from the  
nuclear gauge by  $1 +$  moisture content  
expressed as a decimal.

29 b. When verification is required and the  
nuclear gauge readings cannot be accepted,  
the moisture content is determined by the  
FOP for AASHTO T 255/T 265 or other  
agency approved methods. Compute dry  
density by dividing wet density from the  
nuclear gauge by  $1 +$  moisture content  
expressed as a decimal.

### Percent Compaction

30 • Percent compaction is determined by comparing  
the in-place dry density as determined by this  
procedure to the appropriate agency density  
standard. For soil or soil-aggregate mixes, these  
are moisture-density curves developed using the  
FOP for AASHTO T 99 / T 180. When using  
maximum dry densities developed by the FOP  
for AASHTO T 99 / T 180 or FOP for

AASHTO T 272, it may be necessary to use the Annex in the FOP for AASHTO T 99/T 180 to determine corrected maximum dry density and optimum moisture content.

For coarse granular materials, the density standard may be density-gradation curves developed using a vibratory method such as AKDOT&PF's ATM 212, ITD's T 74, WSDOT's TM 606, or WFLHD's Humphres.

See appropriate agency policies for use of density standards.

### Calculation

Wet Density readings from gauge: 1963 kg/m<sup>3</sup> (121.6 lb/ft<sup>3</sup>) 31

1993 kg/m<sup>3</sup> (123.4 lb/ft<sup>3</sup>)

Avg.: 1978 kg/m<sup>3</sup> (122.5 lb/ft<sup>3</sup>)

**Moisture readings from gauge: 14.2% and 15.4% = Avg. 14.8%**

Moisture content from the FOP's for AASHTO T 255 / T 265: 15.9%

*Moisture content is greater than 1 percent different so the gauge moisture cannot be used.*

**Calculate the dry density as follows:**

$$\rho_d = \left( \frac{\rho_w}{w + 100} \right) \times 100 \quad \text{or} \quad \rho_d = \left( \frac{\rho_w}{\frac{w}{100} + 1} \right) \quad 32$$

where

$\rho_d$  = Dry density, kg/m<sup>3</sup> (lb/ft<sup>3</sup>)

$\rho_w$  = Wet density, kg/m<sup>3</sup> (lb/ft<sup>3</sup>)

w = Moisture content from the FOPs for AASHTO T 255 / T 265, as a percentage

$$\rho_d = \left( \frac{1978 \text{ kg/m}^3 \text{ or } 122.5 \text{ lb/ft}^3}{15.9 + 100} \right) \times 100 \quad \rho_d = \left( \frac{1978 \text{ kg/m}^3 \text{ or } 122.5 \text{ lb/ft}^3}{\frac{15.9}{100} + 1} \right)$$

Corrected for moisture Dry Density: 1707 kg/m<sup>3</sup> (105.7 lb/ft<sup>3</sup>) 33

Calculate percent compaction as follows: 34

$$\% \text{ Compaction} = \frac{\rho_d}{\text{Agency density standard}} \times 100$$

**Example:**

$$\% \text{ Compaction} = \frac{105.7 \text{ lb/ft}^3}{111.3 \text{ lb/ft}^3} \times 100 = 95\% \quad 35$$

Where:

$\rho_d$  = Dry density, kg/m<sup>3</sup> (lb/ft<sup>3</sup>)

Agency density standard = Corrected maximum dry density  
from the FOP from T 99/T 180 Annex

**Report**

36

- Results on forms approved by the agency
- Sample ID
- Location of test, elevation of surface, and thickness of layer tested
- Visual description of material tested
- Make, model and serial number of the nuclear moisture-density gauge

37

- Wet density to 0.1 lb/ft<sup>3</sup>
- Moisture content as a percent, by mass, of dry soil mass to 0.1 percent
- Dry density to 0.1 lb/ft<sup>3</sup>
- Density standard to 0.1 lb/ft<sup>3</sup>
- Percent compaction
- Name and signature of operator

**Tips!**

- Check to make sure that: 38
  - base of gauge is clean prior to testing.
  - shutter block and assembly are free of debris and operating correctly.
  - source rod tip does not have a buildup of material on end.
  - gauge is reading the proper position of the source rod when it is indexed, and that it has been seated correctly. 39
  - the hole into which the source is lowered is at least 50 mm (2 in.) deeper than the indexed position of the source rod.
  - surface is flat and the gauge does not rock.
  - surface has been properly prepared using filler material.
- Make sure battery is charged before starting work







**PERFORMANCE EXAM CHECKLIST**

**IN-PLACE DENSITY AND MOISTURE CONTENT OF SOIL AND SOIL-AGGREGATE BY NUCLEAR METHODS (SHALLOW DEPTH)  
FOP FOR AASHTO T 310**

Participant Name \_\_\_\_\_ Exam Date \_\_\_\_\_

Record the symbols “P” for passing or “F” for failing on each step of the checklist.

<b>Procedure Element</b>	<b>Trial 1</b>	<b>Trial 2</b>
1. Gauge turned on 10 to 20 minutes before use?	_____	_____
2. Calibration verified?	_____	_____
3. Standard count taken and recorded in accordance with manufacturer’s instructions?	_____	_____
4. Test location selected appropriately 10 m (30 ft.) from other radioactive sources, 3 m (10 ft.) from large objects, 150 mm (6 in.) away from vertical projections?	_____	_____
5. Loose, disturbed material removed?	_____	_____
6. Flat, smooth area prepared?	_____	_____
7. Surface voids filled with native fines (-No. 4) to 3 mm (1/8 in.) maximum thickness?	_____	_____
8. Hole driven 50 mm (2 in.) deeper than probe depth?	_____	_____
9. Gauge placed, probe placed, and source rod lowered without disturbing loose material?	_____	_____
10. Method A:		
a. Gauge firmly seated, and gently pulled back so that the source rod is against the side of the hole toward the scaler / detectors?	_____	_____
b. Two, one-minute reading taken; wet density within 32 kg/m <sup>3</sup> (2.0 lb/ft <sup>3</sup> )?	_____	_____
c. Density and moisture data averaged?	_____	_____
11. Method B:		
a. Gauge firmly seated, and gently pulled back so that the source rod is against the side of the hole toward the scaler / detectors?	_____	_____
b. A minimum of a one-minute reading taken; density and moisture data recorded?	_____	_____
c. Gauge turned 90° or 180° (180° in trench)?	_____	_____

**OVER**



**THEORETICAL MAXIMUM SPECIFIC GRAVITY ( $G_{mm}$ ) AND DENSITY OF HOT MIX ASPHALT (HMA) PAVING MIXTURES  
FOP FOR AASHTO T 209**

**Significance**

01

Maximum specific gravity ( $G_{mm}$ ) is the ratio of the mass of a given volume of cooled hot mix asphalt (HMA) at 25°C (77°F) to the mass of an equal volume of water at the same temperature. The procedure is often called the Rice test after its developer, James Rice.  $G_{mm}$  is used in conjunction with bulk specific gravity to determine in-place density or percent air voids or both in compacted HMA. Percentage of air voids,  $V_a$ , is significant because durability characteristics of HMA are influenced by the amount of voids in the compacted material.

02

**Scope**

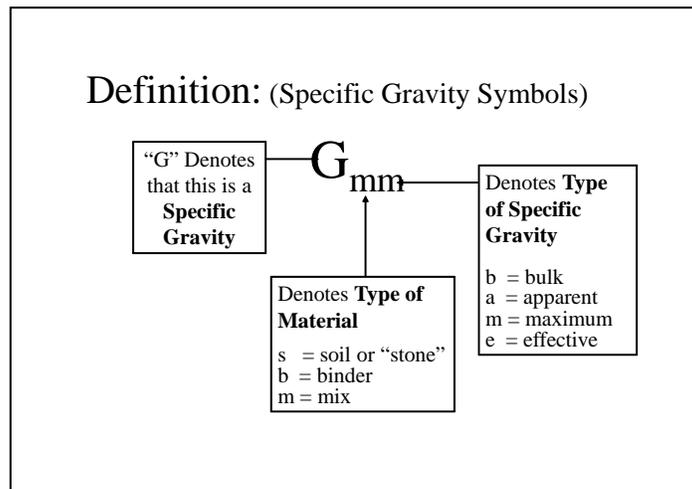
03

This procedure covers the determination of the maximum specific gravity ( $G_{mm}$ ) of uncompact hot mix asphalt (HMA) paving mixtures in accordance with AASHTO T 209-12. Two methods using different containers – bowl and pycnometer / volumetric flask – are covered.

Specimens prepared in the laboratory shall be cured according to the agency standard.

**Definition: (Specific Gravity Symbols)**

04



05

**Apparatus**

- Balance or scale: 10,000 g capacity, readable to 0.1 g
- Container: A glass, metal, or plastic bowl, pycnometer or volumetric flask between 2000 and 10,000 mL as required by the minimum sample size requirements in Table 1 and capable of withstanding a partial vacuum
- Pycnometer / volumetric flask cover: A glass plate or a metal or plastic cover with a vented opening
- Vacuum lid: A transparent lid with a suitable vacuum connection. The vacuum opening to be covered with a fine wire mesh
- Vacuum pump or water aspirator: Capable of evacuating air from the container to a residual pressure of 4.0 kPa (30 mm Hg)
- Residual pressure manometer or vacuum gauge: Traceable to NIST and capable of measuring residual pressure down to 4.0 kPa (30 mm Hg) or less
- Manometer or vacuum gauge: Capable of measuring the vacuum being applied at the source of the vacuum
- Water bath: A constant-temperature water bath (optional)
- Thermometers: Standardized liquid-in-glass, or electronic digital total immersion type, accurate to 0.5°C (1°F)
- Bleeder valve to adjust vacuum
- Timer



**Metal container/  
Volumetric Flask**

06

07



**Vacuum pump**

08

**Standardization of Pycnometer or Volumetric Flask**

Use a pycnometer / volumetric flask that is standardized to accurately determine the mass of water, at  $25 \pm 0.5^\circ\text{C}$  ( $77 \pm 1^\circ\text{F}$ ), in the pycnometer / volumetric flask. The pycnometer / volumetric flask shall be standardized periodically in conformance with procedures established by the agency.

09

**Test Sample Preparation**

1. Obtain samples in accordance with the FOP for AASHTO T 168 and reduce according to AASHTO R 47.
2. Test sample size shall conform to the requirements of Table 1. Samples larger than the capacity of the container may be tested in two or more increments. Results will be combined and averaged. If the increments have a specific gravity difference greater than 0.014 the test must be re-run.



**Separating particles**

10

**Table 1  
Test Sample Size for  $G_{mm}$**

Nominal Maximum Aggregate Size* mm (in.)	Minimum Mass g
37.5 or greater (1 1/2)	4000
19 to 25 (3/4 to 1)	2500
12.5 or smaller (1/2)	1500

\*Nominal maximum size: One sieve larger than the first sieve to retain more than 10 percent of the material using an agency specified set of sieves based on cumulative percent retained.



**Placing sample in flask**

12

**Procedure – General**

11

Two procedures – bowl and pycnometer / volumetric flask – are covered. The first 11 steps are the same for both.

1. Separate the particles of the sample, taking care not to fracture the mineral particles, so that the particles of the fine aggregate portion are not larger than 6.3 mm (1/4 in.). If the mixture is not sufficiently soft to be separated manually, place it in a large flat pan and warm in an oven only until it is pliable enough for separation.
2. Cool the sample to room temperature.
3. Determine and record the mass of the dry container to the nearest 0.1 g.
4. Place the sample in the container.
5. Determine and record the mass of the container and sample to the nearest 0.1 g.



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15



Manually agitating container



Mechanically agitating container



Manometer

16

17

18

19

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6. Determine and record the mass of the sample by subtracting the mass determined in Step 3 from the mass determined in Step 5. Designate this mass as “A.”

7. Add sufficient water at approximately 25°C (77°F) to cover the sample by about 25 mm (1 in).

*Note 1:* The release of entrapped air may be facilitated by the addition of a wetting agent. Check with the agency to see if this is permitted and, if it is, for a recommended agent.

8. Place the lid on the container and attach the vacuum line. To ensure a proper seal between the container and the lid, wet the O-ring or use a petroleum gel.

9. Remove entrapped air by subjecting the contents to a partial vacuum of 3.7 ±0.3 kPa (27.5 ±2.5 mm Hg) residual pressure for 15 ±2 minutes.

10. Agitate the container and contents, either continuously by mechanical device or manually by vigorous shaking, at 2 minute intervals. This agitation facilitates the removal of air.

11. Release the vacuum, increasing the pressure to atmospheric pressure in 10 to 15 seconds, turn off the vacuum pump, and remove the lid. When performing the pycnometer / volumetric flask method, complete steps 12B through 16B within 10 ±1 minutes.

**Procedure – Bowl**

12A. Fill the water bath to overflow level with water at 25 ±1°C (77 ±1.8°F) and allow the water to stabilize.

13A. Zero or tare the balance with the immersion apparatus attached, ensuring that the device is not touching the sides or the bottom of the water bath.

14A. Suspend and immerse the bowl and contents in water at 25 ±1°C (77 ±2°F) for 10 ±1 minutes. The holder shall be immersed sufficiently to cover both it and the bowl.

15A. Determine and record the submerged weight of the bowl and contents to the nearest 0.1 g.



**Determining temperature**



**Determining mass**

22  
23  
24  
25  
26  
27  
28

- 16A. Refill the water bath to overflow level.
- 17A. Empty and re-submerge the bowl following step 12A to determine the submerged weight of the bowl to the nearest 0.1 g.
- 18A. Determine and record the submerged weight of the sample the nearest 0.1 g by subtracting the submerged weight of the bowl from the submerged weight determined in Step 15A. Designate this submerged weight as “C.”

**Procedure – Pycnometer or Volumetric Flask**

- 12B. Immediately fill the pycnometer / volumetric flask with water.
- 13B. Stabilize the temperature of the pycnometer / volumetric flask and contents so that final temperature is within  $25 \pm 1^\circ\text{C}$  ( $77 \pm 2^\circ\text{F}$ ).
- 14B. Finish filling the pycnometer / volumetric flask with water that is  $25 \pm 1^\circ\text{C}$  ( $77 \pm 2^\circ\text{F}$ ), place the metal or plastic cover or a glass plate on the pycnometer / volumetric flask, and eliminate all air.

*Note 2:* When using the metal pycnometer and cover, place the cover on the pycnometer and push down slowly, forcing excess water out of the hole in the center of the cover. Use care when filling the pycnometer to avoid reintroducing air into the water.

- 15B. Towel dry the outside of the pycnometer / volumetric flask and cover.
- 16B. Determine and record the mass of the pycnometer / volumetric flask, cover, de-aired water, and sample to the nearest 0.1 g. within  $10 \pm 1$  minutes of completion of Step 11. Designate this mass as “E.”

**Procedure – Mixtures Containing Uncoated Porous Aggregate**

If the pores of the aggregates are not thoroughly sealed by a bituminous film, they may become saturated with water during the vacuuming procedure, resulting in an error in maximum density. To determine if this has occurred, complete the general procedure and then:

29

1. Carefully drain water from sample through a towel held over the top of the container to prevent loss of material.
2. Spread sample in a flat shallow pan and place before an electric fan to remove surface moisture.
3. Determine the mass of the sample when the surface moisture appears to be gone.
4. Continue drying and determine the mass of the sample at 15-minute intervals until less than a 0.5 g loss is found between determinations.
5. Record the mass as the saturated surface dry mass to the nearest 0.1 g. Designate this mass as "A<sub>SSD</sub>."
6. Calculate, as indicated below, G<sub>mm</sub> using "A" and "A<sub>SSD</sub>," and compare the two values.

**Calculation**

Calculate the G<sub>mm</sub> to three decimal places as follows.

**Bowl Procedure**

30

$$G_{mm} = \frac{A}{A - C} \quad \text{or} \quad G_{mm} = \frac{A}{A_{SSD} - C}$$

(for mixes containing uncoated aggregate materials)

where:

A = mass of dry sample in air, g

A<sub>SSD</sub> = Mass of saturated surface dry sample in air, g

C = submerged weight of sample in water, g

**Example**

A = 1432.7 g

A<sub>SSD</sub> = 1434.2 g

C = 848.6 g

$$G_{mm} = \frac{1432.7 \text{ g}}{1432.7 \text{ g} - 848.6 \text{ g}} = 2.453 \quad \text{or} \quad G_{mm} = \frac{1432.7 \text{ g}}{1434.2 \text{ g} - 848.6 \text{ g}} = 2.447$$

**Pycnometer / Volumetric Flask Procedure**

31

$$G_{mm} = \frac{A}{A + D - E} \quad \text{or} \quad G_{mm} = \frac{A}{A_{SSD} + D - E}$$

(for mixtures containing uncoated materials)

where:

A = Mass of dry sample in air, g

A<sub>SSD</sub> = Mass of saturated surface dry sample in air, g

D = Mass of pycnometer / volumetric flask filled with water at 25°C (77°F), g, determined during the Standardization of Pycnometer / Volumetric Flask procedure

E = Mass of pycnometer / volumetric flask filled with water and test sample at test temperature, g

**Example (in which two increments of a large sample are averaged):**

Increment 1

A = 2200.3 g

D = 7502.5 g

E = 8812.0 g

Temperature = 26.2°C

Increment 2

A = 1960.2 g

D = 7525.5 g

E = 8690.8 g

Temperature = 25.0°C

32

$$G_{mm_1} = \frac{2200.3 \text{ g}}{2200.3 \text{ g} + 7502.5 \text{ g} - 8812.0 \text{ g}} = 2.470$$

$$G_{mm_2} = \frac{1960.2 \text{ g}}{1960.2 \text{ g} + 7525.5 \text{ g} - 8690.8 \text{ g}} = 2.466$$

Allowable variation is: 0.014

2.470 - 2.466 = 0.004, which is &lt; 0.014, so they can be averaged.

Average

$$2.470 + 2.466 = 4.936 \quad 4.936 \div 2 = 2.468$$

**Theoretical Maximum Density**

33

To calculate the theoretical maximum density at 25°C (77°F) use one of the following formulas. The density of water at 25°C (77°F) is 997.1 in Metric units or 62.245 in English units.

$$\text{Theoretical maximum density kg/m}^3 = G_{mm} \times 997.1 \text{ kg/ m}^3$$

$$2.468 \times 997.1 \text{ kg/ m}^3 = 2461 \text{ kg/ m}^3$$

Or:

$$\text{Theoretical maximum density lb/ft}^3 = G_{mm} \times 62.245 \text{ lb/ft}^3$$

$$2.468 \times 62.245 \text{ lb/ft}^3 = 153.6 \text{ lb/ft}^3$$

34

**Report**

- Results on forms approved by the agency
- Sample ID
- $G_{mm}$  to three decimal places
- Theoretical maximum density to 1 kg/m<sup>3</sup> (0.1 lb/ft<sup>3</sup>)

**Tips!**

35

- Use a standardized pycnometer or volumetric flask with known mass when filled, if using pycnometer or volumetric procedure.
- Check for absorption in uncoated aggregate.

**REVIEW QUESTIONS**

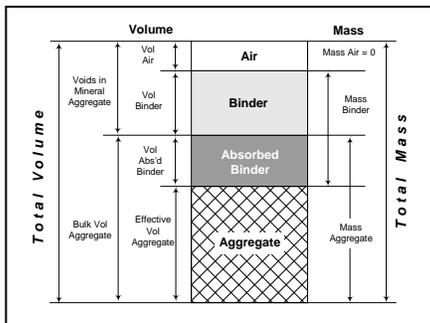
1. A mix with the nominal maximum aggregate size of 25 mm (1 in.) should use what size sample?
  
2. At what temperature should the sample be for testing?
  
3. Removing entrapped air from the contents of the flask by a partial vacuum is done for how long?
  
4. How and why is the flask agitated?



**BULK SPECIFIC GRAVITY ( $G_{mb}$ ) OF COMPACTED HOT MIX ASPHALT (HMA) MIXTURES USING SATURATED SURFACE-DRY SPECIMENS  
FOP FOR AASHTO T 166**



HMA core



HMA phase diagram

01

**Significance**

02

Compacted hot mix asphalt (HMA) includes voids that may contain gas, such as air, or liquid, such as water. The voids may be permeable; that is, they connect to the surface and can fill with water. They may also be impermeable and, thus, filled only with air.

Because voids exist and contain air or water, the overall, or bulk, density of the compacted mix is less than the density of a theoretical mix of aggregate and binder having no voids. Thus, bulk density and associated bulk specific gravity are indications of void and air content – both of which impact various properties of bituminous roadways.

03

Bulk specific gravity is the ratio of the mass of a given volume of dry, compacted mix at 25°C (77°F) in air to the mass of an equal volume of water at the same temperature. The weight of the sample in water is subtracted from the mass of a saturated surface-dry (SSD) sample in air in order to determine the mass of the water displaced by the specimen. The measurement of void volume, which includes permeable internal and surface pores occupied by water, is useful for mix quality control because it takes into consideration the volume of voids permeable to water within the specimen.

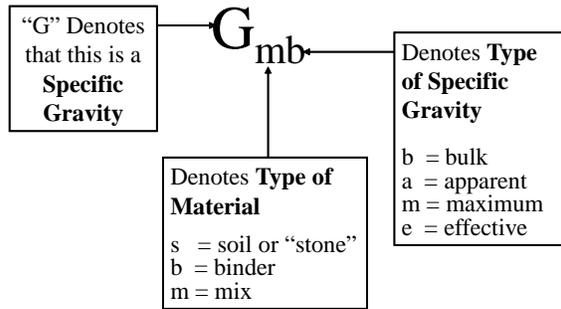
04

**Scope**

05

This procedure covers the determination of bulk specific gravity ( $G_{mb}$ ) of compacted HMA using three methods – A, B, and C – in accordance with AASHTO T 166-16. This FOP is for use on specimens not having open or interconnecting voids or not absorbing more than 2.00 percent water by volume, or both. When specimens have open or interconnecting voids and/or absorbing more than 2.00 percent water by volume AASHTO T 275 or AASHTO T 331 should be performed.

Definition: (Specific Gravity Symbols)



06

**Overview**

- Method A: Suspension
- Method B: Volumeter
- Method C: Rapid test for A or B

07

**Test Specimens**

Test specimens may be either laboratory-molded or from HMA pavement. For specimens it is recommended that the diameter be equal to four times the maximum size of the aggregate and the thickness be at least one and one half times the maximum size of the aggregate.

08

Test specimens from HMA pavement will be sampled according to AASHTO 67.

**Terminology**

*Constant Mass:* The state at which a mass does not change more than a given percent, after additional drying for a defined time interval, at a required temperature.

09



**Suspension apparatus**

10

11

### **Apparatus - Method A (Suspension)**

- Balance or scale: 5 kg capacity, readable to 0.1 g, and fitted with a suitable suspension apparatus and holder to permit weighing the specimen while suspended in water, conforming to AASHTO M 231.
- Suspension apparatus: Wire of the smallest practical size and constructed to permit the container to be fully immersed.
- Water bath: For immersing the specimen in water while suspended under the balance or scale, and equipped with an overflow outlet for maintaining a constant water level.
- Towel: Damp cloth towel used for surface drying specimens.
- Oven: Capable of maintaining a temperature of  $110 \pm 5^{\circ}\text{C}$  ( $230 \pm 9^{\circ}\text{F}$ ) for drying the specimens to a constant mass.
- Pan: Pan or other suitable container of known mass, large enough to hold a sample for drying in oven.
- Thermometer: Having a range of 19 to  $27^{\circ}\text{C}$  ( $66$  to  $80^{\circ}\text{F}$ ), graduated in  $0.1^{\circ}\text{C}$  ( $0.2^{\circ}\text{F}$ ) subdivisions.

12

**Procedure - Method A (Suspension)**

Recently molded laboratory samples that have not been exposed to moisture do not need drying.

1. Dry the specimen to constant mass, if required.
  - a. Initially dry overnight at  $52 \pm 3^{\circ}\text{C}$  ( $125 \pm 5^{\circ}\text{F}$ ).
  - b. Determine and record the mass of the specimen ( $M_p$ ).
  - c. Return the specimen to the oven for at least 2 hours.
  - d. Determine and record the mass of the specimen ( $M_n$ ).
  - e. Determine percent change by subtracting the new mass determination ( $M_n$ ) from the previous mass determination ( $M_p$ ) divide by the previous mass determination ( $M_p$ ) multiply by 100.
  - f. Continue drying until there is less than 0.05 percent change in specimen mass after 2-hour drying intervals (constant mass).
  - g. Constant mass has been achieved, sample is defined as dry.

*Note 1:* To expedite the procedure, steps 1 and 2 may be performed last. To further expedite the process, see Method C.

2. Cool the specimen in air to  $25 \pm 5^{\circ}\text{C}$  ( $77 \pm 9^{\circ}\text{F}$ ), and determine and record the dry mass to the nearest 0.1 g. Designate this mass as "A."
3. Fill the water bath to overflow level with water at  $25 \pm 1^{\circ}\text{C}$  ( $77 \pm 1.8^{\circ}\text{F}$ ) and allow the water to stabilize.
4. Zero or tare the balance with the immersion apparatus attached, ensuring that the device is not touching the sides or the bottom of the water bath.
5. Immerse the specimen shaking to remove the air bubbles. Place the specimen on its side in the suspension apparatus. Leave it immersed for  $4 \pm 1$  minutes.



13

6. Determine and record the submerged weight to the nearest 0.1 g. Designate this submerged weight as "C."

14

7. Remove the sample from the water and quickly surface dry with a damp cloth towel within 5 seconds.

8. Zero or tare the balance.

9. Immediately determine and record the mass of the SSD specimen to nearest 0.1 g. Designate this mass as "B." Any water that seeps from the specimen during the mass determination is considered part of the saturated specimen. Do not to exceed 15 seconds performing Steps 7 through 9.

### Calculations - Method A (Suspension)

#### Constant Mass:

16

Calculate constant mass using the following formula:

$$\%Change = \frac{M_p - M_n}{M_p} \times 100$$

Where:

$M_p$  = previous mass measurement, g

$M_n$  = new mass measurement, g

**Bulk specific gravity ( $G_{mb}$ ) and percent water absorbed:**

17

$$G_{mb} = \frac{A}{B - C}$$

$$\text{Percent Water Absorbed (by volume)} = \frac{B - A}{B - C} \times 100$$

where:

- $G_{mb}$  = Bulk specific gravity  
 A = Mass of dry specimen in air, g  
 B = Mass of SSD specimen in air, g  
 C = Weight of specimen in water, g

**Example:**

$$G_{mb} = \frac{4833.6 \text{ g}}{4842.4 \text{ g} - 2881.3 \text{ g}} = 2.465$$

18

$$\% \text{ Water Absorbed (by volume)} = \frac{4842.4 \text{ g} - 4833.6 \text{ g}}{4842.4 \text{ g} - 2881.3 \text{ g}} \times 100 = 0.45\%$$

19

**Apparatus - Method B (Volumeter)**

- Balance or scale: 5 kg capacity, readable to 0.1 g and conforming to AASHTO M 231.
- Water bath: Thermostatically controlled to  $25 \pm 0.5^\circ\text{C}$  ( $77 \pm 0.9^\circ\text{F}$ ).
- Thermometer: Range of  $19$  to  $27^\circ\text{C}$  ( $66$  to  $80^\circ\text{F}$ ), and graduated in  $0.1^\circ\text{C}$  ( $0.2^\circ\text{F}$ ) subdivisions.
- Volumeter: Calibrated to 1200 mL or appropriate capacity for test sample and having a

tapered lid with a capillary bore.

- Oven: Capable of maintaining a temperature of  $110 \pm 5^{\circ}\text{C}$  ( $230 \pm 9^{\circ}\text{F}$ ) for drying the specimens to a constant mass.
- Pan: Pan or other suitable container of known mass, large enough to hold a sample for drying in oven.
- Towel: Damp cloth towel used for surface drying specimens.

### 21 Procedure - Method B (Volumeter)

Recently molded laboratory samples that have not been exposed to moisture do not need drying.

1. Dry the specimen to constant mass, if required.
  - a. Initially dry overnight at  $52 \pm 3^{\circ}\text{C}$  ( $125 \pm 5^{\circ}\text{F}$ ).
  - b. Determine and record the mass of the specimen ( $M_p$ ).
  - c. Return the specimen to the oven for at least 2 hours.
  - d. Determine and record the mass of the specimen ( $M_n$ ).
  - e. Determine percent change by subtracting the new mass determination ( $M_n$ ) from the previous mass determination ( $M_p$ ) divide by the previous mass determination ( $M_p$ ) multiply by 100.
  - f. Continue drying until there is less than 0.05 percent change in specimen mass after 2-hour drying intervals (constant mass).
  - g. Constant mass has been achieved, sample is defined as dry.

*Note 1:* To expedite the procedure, steps 1 and 2 may be performed last. To further expedite the process, see Method C.

- 22 2. Cool the specimen in air to  $25 \pm 5^{\circ}\text{C}$  ( $77 \pm 9^{\circ}\text{F}$ ), and determine and record the dry mass to the nearest 0.1 g. Designate this mass as "A."
- 23 3. Immerse the specimen in the temperature controlled water bath for at least 10 minutes.
4. Fill the volumeter with distilled water at  $25 \pm 1^{\circ}\text{C}$



Drying surface



Determining mass of SSD specimen

24

(77 ±1.8°F), making sure some water escapes through the capillary bore of the tapered lid. Wipe the volumeter dry. Determine the mass of the volumeter to the nearest 0.1 g. Designate this mass as “D.”

25

5. At the end of the ten minute period, remove the specimen from the water bath and quickly surface dry with a damp towel within 5 seconds.

26

6. Immediately determine and record the mass of the SSD specimen to the nearest 0.1 g. Designate this mass as “B.” Any water that seeps from the specimen during the mass determination is considered part of the saturated specimen.

7. Place the specimen in the volumeter and let stand 60 seconds.

27

8. Bring the temperature of the water to 25 ±1°C (77 ±1.8°F) and cover the volumeter, making sure some water escapes through the capillary bore of the tapered lid.

9. Wipe the volumeter dry.

28

10. Determine and record the mass of the volumeter and specimen to the nearest 0.1 g. Designate this mass as “E.”

*Note 2:* Method B is not acceptable for use with specimens that have more than 6 percent air voids.

**Calculations - Method B (Volumeter)**

29

**Constant Mass:**

Calculate constant mass using the following formula:

$$\%Change = \frac{M_p - M_n}{M_p} \times 100$$

Where:

$M_p$  = previous mass measurement

$M_n$  = new mass measurement

**Bulk specific gravity ( $G_{mb}$ ) and percent water absorbed:**

30

$$G_{mb} = \frac{A}{B + D - E}$$

$$\text{Percent Water Absorbed (by volume)} = \frac{B - A}{B + D - E} \times 100$$

Where:

 $G_{mb}$  = Bulk specific gravity

A = Mass of dry specimen in air, g

B = Mass of SSD specimen in air, g

D = Mass of volumeter filled with water at  $25 \pm 1^\circ\text{C}$  ( $77 \pm 1.8^\circ\text{F}$ ), g

E = Mass of volumeter filled with specimen and water, g

**Example:**

31

$$G_{mb} = \frac{4833.6 \text{ g}}{4842.4 \text{ g} + 2924.4 \text{ g} - 5806.0 \text{ g}} = 2.465$$

$$\% \text{ Water Absorbed (by volume)} = \frac{4842.4 \text{ g} - 4833.6 \text{ g}}{4842.4 \text{ g} + 2924.4 \text{ g} - 5806.0 \text{ g}} \times 100 = 0.45\%$$

32

**Apparatus - Method C (Rapid Test for Method A or B)**

See Methods A or B.

*Note 3:* This procedure can be used for specimens that are not required to be saved and contain substantial amounts of moisture. Cores can be tested the same day as obtained by this method.

33

**Procedure - Method C (Rapid Test for Method A or B)**

1. Start on Step 3 of Method A or B, and complete that procedure, then determine dry mass, "A," as follows.
2. Determine and record mass of a large, flat-

bottom container.

- 34
3. Place the specimen in the container.
  4. Place in an oven at a minimum of 105°C (221°F). Do not exceed the Job Mix Formula mixing temperature.
  5. Dry until the specimen can be easily separated into fine aggregate particles that are not larger than 6.3 mm (¼ in.).
- 35
6. Determine and record the mass of the specimen ( $M_p$ ).
  7. Return the specimen to the oven for at least 2 hours.
  8. Determine and record the mass of the specimen ( $M_n$ ).
  9. Determine percent change by subtracting the new mass determination ( $M_n$ ) from the previous mass determination ( $M_p$ ) divide by the previous mass determination ( $M_p$ ) multiply by 100.
  10. Continue drying until there is less than 0.05 percent change in specimen mass after 2-hour drying intervals (constant mass).
  11. Constant mass has been achieved, sample is defined as dry.
  12. Cool in air to 25 ±5°C (77 ±9°F).
  13. Determine and record the mass of the container and dry specimen to the nearest 0.1 g.
- 36
14. Determine and record the mass of the dry specimen to the nearest 0.1 g by subtracting the mass of the container from the mass determined in Step 13. Designate this mass as "A."

37

### **Calculations - Method C (Rapid Test for Method A or B)**

Complete the calculations as outlined in Methods A or B, as appropriate.

38

**Report**

- Results on forms approved by the agency
- Sample ID
- $G_{mb}$  to 0.001
- Absorption to 0.01 percent
- The method performed

39

**Tips!**

- Use method approved by agency.
- Check for open or interconnecting voids and/or absorption over 2.00 percent.
- Check temperature of water in water bath.



**REVIEW QUESTIONS**

1. For how long must samples be submerged prior to determining immersed weight for Method A?
2. In determining the SSD mass of a specimen, how must the sample be dried?
3. At what temperature and for how long should core samples be dried?
4. How do methods A and B differ?



**IN-PLACE DENSITY OF ASPHALT MIXTURES BY NUCLEAR METHOD  
FOP AASHTO T 355**

**Significance**

01 The final in-place density of roadway pavement is  
02 critical to the quality and longevity of a highway  
project. Low-density material will lead to excessive  
deflection under load or permanent deformation, or  
both.

This procedure provides a rapid, nondestructive  
technique for determining the in-place density of  
compacted asphalt mixtures. It can be used to  
establish the proper rolling effort and pattern to  
achieve the required density. The results of this  
procedure may also be used as an indicator for in-  
place properties that could impact overall performance  
of asphalt mixtures.

The non-destructive nature of the test allows  
repetitive measurements to be made at a single test  
location between roller passes.

**Scope**

03 This test method describes a procedure for  
04 determining the density of asphalt mixtures by  
means of a nuclear gauge using the backscatter  
method in accordance with AASHTO T 355-16.  
Correlation with densities determined under the  
FOP for AASHTO T 166 is required by some  
agencies.

**Apparatus**

- 05 • Nuclear density gauge with the factory matched  
standard reference block.
- Transport case for properly shipping and  
housing the gauge and tools.
- 06 • Instruction manual for the specific make and  
model of gauge.
- Radioactive materials information and  
calibration packet containing:
  - 07 – Daily standard count log
  - Factory and laboratory calibration data sheet



**Caution!**



**Gauge, transport case and  
instruction manual**



**Nuclear gauge**



**Filler on pavement**

08

- Leak test certificate
- Shippers' declaration for dangerous goods
- Procedure memo for storing, transporting and handling nuclear testing equipment
- Other radioactive materials documentation as required by local regulatory requirements

**Material**

- Filler material: Fine-graded sand from the source used to produce the asphalt pavement or other agency approved materials.

09

**Radiation Safety**

This method does not purport to address all of the safety problems associated with its use. The gauge utilizes radioactive materials that may be hazardous to the health of the user unless proper precautions are taken. Users of this gauge must become familiar with the applicable safety procedures and governmental regulations. All operators will be trained in radiation safety prior to operating nuclear density gauges. Some agencies require the use of personal monitoring devices such as a thermoluminescent dosimeter or film badge. Effective instructions, together with routine safety procedures such as source leak tests, recording and evaluation of personal monitoring device data, etc., are a recommended part of the operation and storage of this gauge.

10

11



**Stabilizing the Gauge**

12

### Calibration

Calibrate the nuclear gauge as required by the agency. This calibration may be performed by the agency using the manufacturer's recommended procedures or by other facilities approved by the agency. Verify or re-establish calibration curves, tables, or equivalent coefficients every 12 months.

13

### Standardization

1. Turn the gauge on and allow it to stabilize (approximately 10 to 20 minutes) prior to standardization. Leave the power on during the day's testing.
2. Standardize the nuclear gauge at the construction site at the start of each day's work and as often as deemed necessary by the operator or agency. Daily variations in standard count shall not exceed the daily variations established by the manufacturer of the gauge. If the daily variations are exceeded after repeating the standardization procedure, the gauge should be repaired, recalibrated, or both.
3. Record the standard count for both density and moisture in the daily standard count log. The exact procedure for standard count is listed in the manufacturer's Operator's Manual.

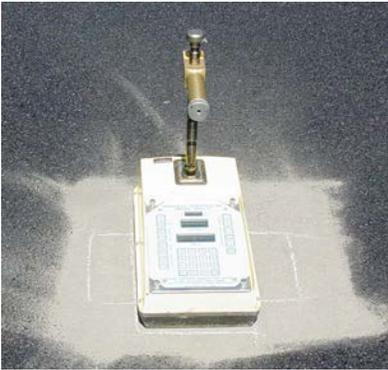
14

*Note 1:* New standard counts may be necessary more than once a day. See agency requirements.

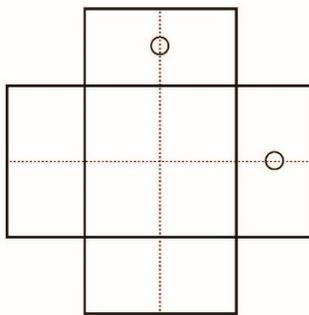
15

### Test Site Location

1. Select a test location(s) randomly and in accordance with agency requirements. Test sites should be relatively smooth and flat and meet the following conditions:
  - a. At least 10 m (30 ft) away from other sources of radioactivity.
  - b. At least 3 m (10 ft) away from large objects.
  - c. If the gauge will be closer than 600 mm (24 in.) to any vertical mass, or less than 300 mm (12 in.) from a vertical pavement edge, use the gauge manufacturer's correction procedure.



**Nuclear gauge**



**Footprint of the gauge test site**

16

**Procedure**

17

1. Maintain maximum contact between the base of the gauge and the surface of the material under test. Use filler material to fill surface voids. Spread a small amount of filler material over the test site surface and distribute it evenly. Strike off the surface with a straightedge (such as a lathe or flat-bar steel) to remove excess material.

18

2. Place the gauge on the test site, perpendicular to the roller passes. Using a crayon (not spray paint), mark the outline or footprint of the gauge. Extend the probe to the backscatter position.

19

3. Take a one-minute test and record the wet density reading.

20

4. Rotate the gauge 90 degrees centered over the original footprint. Mark the outline or footprint of the gauge.

21

5. Take another one-minute test and record the wet density reading.

6. If the difference between the two one-minute tests is greater than  $40 \text{ kg/m}^3$  ( $2.5 \text{ lb/ft}^3$ ), retest in both directions. If the difference of the retests is still greater than  $40 \text{ kg/m}^3$  ( $2.5 \text{ lb/ft}^3$ ) test at 180 and 270 degrees.

7. The density reported for each test site shall be the average of the two individual one-minute density readings.

**Calculation of Results**

22

Percent compaction is determined by comparing the in-place wet density as determined by this method to the appropriate agency density standard. See appropriate agency policy for use of density standards.

23

$$\text{Percent compaction} = \frac{\text{Corrected Reading}}{\text{Maximum Density}} \times 100$$

**Example:**

Reading #1: 141.5 lb/ft<sup>3</sup>

Reading #2: 140.1 lb/ft<sup>3</sup> Are the two readings within the tolerance? (YES)

Reading average: 140.8 lb/ft<sup>3</sup>

Core correction : +2.1 lb/ft<sup>3</sup>

**Corrected reading:** 142.9 lb/ft<sup>3</sup>

24

From the FOP for AASHTO T 209:

$$G_{mm} = 2.466$$

$$\text{Maximum Laboratory Dry Density} = 2.466 \times 62.245 \text{ lb/ft}^3 = 153.5 \text{ lb/ft}^3$$

$$\text{Percent compaction} = \frac{142.9 \text{ lb/ft}^3}{153.5 \text{ lb/ft}^3} \times 100 = 93.1\%$$

25

**Report**

- Results on forms approved by the agency
- Test ID
- Location of test and thickness of layer tested
- Mixture type
- Make, model and serial number of the nuclear moisture-density gauge
- Calculated wet density of each measurement and any adjustment data
- Density standard
- Compaction 0.1 percent
- Name and signature of operator

**Tips!**

26

- Check to make sure that base of gauge is clean prior to testing.
- Shutter block and assembly are free of debris and operating correctly.
- Gauge is reading the proper position of the source rod when it is indexed, and that it has been seated correctly.
- Surface is flat and the gauge 27 does not rock.
- Surface has been properly prepared using filler material.
- Do not leave the gauge on a hot surface for a long time.

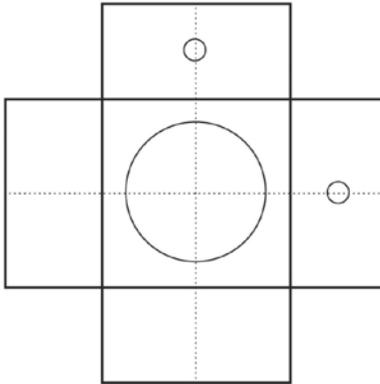
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**APPENDIX – CORRELATION WITH CORES**

(Nonmandatory Information)

**Note 2:** When density correlation with the FOP for AASHTO T 166 is required, correlation of the nuclear gauge with pavement cores shall be made on the first day's paving (within 24 hours) or from a test strip constructed prior to the start of paving. Cores must be taken before traffic is allowed on the pavement.

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**Footprint of the gauge test site**  
**Core location in the center of the footprint**

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1. Determine the number of cores required for correlation from the agency's specifications. Cores shall be located on the first day's paving or on the test strip. Locate the test sites in accordance with the agency's specifications. Follow the "Procedure" section above to establish test sites and obtain densities using the nuclear gauge.
2. Obtain a pavement core from each of the test sites according to AASHTO R 67. The core should be taken from the center of the nuclear gauge footprint. If direct transmission was used, locate the core at least 25 mm (1 in.) away from the edge of the drive pin hole.
3. Determine the density of the cores by the FOP for AASHTO T 166, Bulk Specific Gravity ( $G_{mb}$ ) of Compacted Asphalt Mixtures Using Saturated Surface Dry Specimens.
4. Calculate a correlation factor for the nuclear gauge reading as follows:
  - a. Calculate the difference between the core density and the average nuclear gauge density at each test site to the nearest  $1 \text{ kg/m}^3$  ( $0.1 \text{ lb/ft}^3$ ). Calculate the average difference and standard deviation of the differences for the entire data set to the nearest  $1 \text{ kg/m}^3$  ( $0.1 \text{ lb/ft}^3$ ).
  - b. If the standard deviation of the differences is equal to or less than  $40 \text{ kg/m}^3$  ( $2.5 \text{ lb/ft}^3$ ), the correlation factor applied to the average nuclear gauge density shall be the average difference calculated above in 4.a.
  - c. If the standard deviation of the differences is greater than  $40 \text{ kg/m}^3$  ( $2.5 \text{ lb/ft}^3$ ), the test site with the greatest variation from the

31

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average difference shall be eliminated from the data set and the data set properties and correlation factor recalculated following 4.a and 4.b.

- d. If the standard deviation of the modified data set still exceeds the maximum specified in 4.b, additional test sites will be eliminated from the data set and the data set properties and correlation factor recalculated following 4.a and 4.b. If the data set consists of less than five test sites, additional test sites shall be established.

**Note A1:** The exact method used in calculating the nuclear gauge correlation factor shall be defined by agency policy.

**Note A2:** The above correlation procedure must be repeated if there is a new job mix formula. Adjustments to the job mix formula beyond tolerances established in the contract documents will constitute a new job mix formula. A correlation factor established using this procedure is only valid for the particular gauge and at the probe depth used in the correlation procedure. If another gauge is brought onto the project, it shall be correlated using the same procedure. Multiple gauges may be correlated from the same series of cores if done at the same time.

**Note A3:** For the purpose of this procedure, a job mix formula is defined as the percent and grade of paving asphalt used with a specified gradation of aggregate from a designated aggregate source. A new job mix formula may be required whenever compaction of the wearing surface exceeds the agency's specified maximum density or minimum air voids.

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**Core Correlation Example:**

	Core results from T 166:	Average Gauge reading:	Difference:	X	X <sup>2</sup>
1	144.9 lb/ft <sup>3</sup>	142.1 lb/ft <sup>3</sup>	2.8 lb/ft <sup>3</sup>	-0.7	0.49
2	142.8 lb/ft <sup>3</sup>	140.9 lb/ft <sup>3</sup>	1.9 lb/ft <sup>3</sup>	0.2	0.04
3	143.1 lb/ft <sup>3</sup>	140.7 lb/ft <sup>3</sup>	2.4 lb/ft <sup>3</sup>	-0.3	0.09
4	140.7 lb/ft <sup>3</sup>	138.9 lb/ft <sup>3</sup>	1.8 lb/ft <sup>3</sup>	0.3	0.09
5	145.1 lb/ft <sup>3</sup>	143.6 lb/ft <sup>3</sup>	1.5 lb/ft <sup>3</sup>	0.6	0.36
6	144.2 lb/ft <sup>3</sup>	142.4 lb/ft <sup>3</sup>	1.8 lb/ft <sup>3</sup>	0.3	0.09
7	143.8 lb/ft <sup>3</sup>	141.3 lb/ft <sup>3</sup>	2.5 lb/ft <sup>3</sup>	-0.4	0.16
8	142.8 lb/ft <sup>3</sup>	139.8 lb/ft <sup>3</sup>	3.0 lb/ft <sup>3</sup>	0.9	0.81
9	144.8 lb/ft <sup>3</sup>	143.3 lb/ft <sup>3</sup>	1.5 lb/ft <sup>3</sup>	-0.6	0.36
10	143.0 lb/ft <sup>3</sup>	141.0 lb/ft <sup>3</sup>	2.0 lb/ft <sup>3</sup>	-0.1	0.01

Average Difference: +2.1 lb/ft<sup>3</sup>

$$\sqrt{\frac{\sum x^2}{n-1}}$$

Where:

$\sum$  = Sum

x = Difference from the average Difference

n-1 = number of data sets minus 1

Example: 10 – 1 = 9

$$\sqrt{\frac{2.5}{9}} = 0.53$$

The Sum of X<sup>2</sup> = 2.5 and the number of data sets = 9 for a computed standard deviation of 0.53. This is within the allowable 2.5 therefore no cores are eliminated, use the average difference from all ten cores.



## **REVIEW QUESTIONS**

1. Describe the calibration and standardization process.
2. What precautions must be taken in selecting a test location?
3. How do you determine percent compaction?
4. Describe the procedure for correlating results with pavement cores.



**PERFORMANCE EXAM CHECKLIST**

**IN-PLACE DENSITY OF ASPHALT MIXTURES BY NUCLEAR METHOD  
FOP FOR AASHTO T 355**

Participant Name \_\_\_\_\_ Exam Date \_\_\_\_\_

Record the symbols "P" for passing or "F" for failing on each step of the checklist.

Procedure Element	Trial 1	Trial 2
1. Gauge turned on approximately 10 to 20 minutes before use?	_____	_____
2. Gauge calibrated and standard count recorded?	_____	_____
3. Test location selected appropriately [600 mm (24 in.) from vertical projections or 10 m (30 ft.) from any other radioactive sources]?	_____	_____
4. Procedure:		
a. Filler spread evenly over test site?	_____	_____
b. Excess filler material removed by striking off the surface?	_____	_____
c. Gauge placed on pavement surface and footprint of gauge marked?	_____	_____
d. Probe extended to backscatter position?	_____	_____
e. One-minute count taken; gauge rotated 90°, reseated, and another one-minute count taken?	_____	_____
f. Densities averaged?	_____	_____
g. If difference of the wet densities is greater than 40 kg/m <sup>3</sup> (2.5 lb/ft <sup>3</sup> ), retest conducted in both directions?	_____	_____
5. Core correlation applied if required?	_____	_____
6. Percent compaction calculated correctly?	_____	_____

Comments:      First attempt: Pass \_\_\_\_\_ Fail \_\_\_\_\_      Second attempt: Pass \_\_\_\_\_ Fail \_\_\_\_\_

\_\_\_\_\_

\_\_\_\_\_

\_\_\_\_\_

\_\_\_\_\_

Examiner Signature \_\_\_\_\_ WAQTC #: \_\_\_\_\_



**APPENDIX A**  
**FIELD OPERATING PROCEDURES - SHORT FORM**

<u>Chapter</u>	<u>Section</u>
13	AASHTO T 255 Total Evaporable Moisture Content of Aggregate by Drying; and AASHTO T 265 Laboratory Determination of Moisture Content of Soils
14	AASHTO T 99 Moisture-Density Relations of Soils Using a 2.5-kg (5.5-lb) Rammer and 305-mm (12-in.) Drop; AASHTO T 180 Moisture-Density Relations of Soils Using a 4.54-kg (10-lb) Rammer and 457-mm (18-in.) Drop
15	AASHTO R 75 Family of Curves
16	AASHTO 272 One-Point Method for Determining Maximum Dry Density and Optimum Moisture
17	AASHTO T 85 Specific Gravity and Absorption of Coarse Aggregate
18	Instruction on Use of AKDOT & PF ATM 212, ITD IT 74, WSDOT T 606, or WFLHD Humphres Curves
19	AASHTO T 310 In-Place Density and Moisture Content of Soil and Soil-Aggregate by the Nuclear Method
20	AASHTO T 209 Theoretical Maximum Specific Gravity ( $G_{mm}$ ) and Density of Hot Mix Asphalt (HMA) Paving Mixtures
21	AASHTO T 166 Bulk Specific Gravity ( $G_{mb}$ ) of Compacted Hot Mix Asphalt Mixtures HMA) Using Saturated Surface Dry Specimens
22	AASHTO T 355 In-Place Density of Asphalt Mixtures Using by Nuclear Method



**TOTAL EVAPORABLE MOISTURE CONTENT OF AGGREGATE BY DRYING  
FOP FOR AASHTO T 255  
LABORATORY DETERMINATION OF MOISTURE CONTENT OF SOILS  
FOP FOR AASHTO T 265**

**Scope**

This procedure covers the determination of moisture content of aggregate and soil in accordance with AASHTO T 255-00 and AASHTO T 265-15. It may also be used for other construction materials.

**Overview**

Moisture content is determined by comparing the wet mass of a sample and the mass of the sample after drying to constant mass. The term constant mass is used to define when a sample is dry.

*Constant mass* – the state at which a mass does not change more than a given percent, after additional drying for a defined time interval, at a required temperature.

**Apparatus**

- Balance or scale: capacity sufficient for the principle sample mass, accurate to 0.1 percent of sample mass or readable to 0.1 g, and meeting the requirements of AASHTO M 231
- Containers, clean, dry and capable of being sealed
- Suitable drying containers
- Microwave safe container with ventilated lid
- Heat source, controlled:
  - Forced draft oven
  - Ventilated oven
  - Convection oven
- Heat source, uncontrolled:
  - Infrared heater/heat lamp, hot plate, fry pan, or any other device/method that will dry the sample without altering the material being dried

- Microwave oven (900 watts minimum)
- Utensils such as spoons
- Hot pads or gloves

### Sample Preparation

In accordance with the FOP for AASHTO T 2 obtain a representative sample in its existing condition.

For aggregates the representative sample size is based on Table 1 or other information that may be specified by the agency.

**TABLE 1**  
**Sample Sizes for Moisture Content of Aggregate**

Nominal Maximum Size* mm (in.)	Minimum Sample Mass g (lb)
4.75 (No. 4)	500 (1.1)
9.5 (3/8)	1500 (3.3)
12.5 (1/2)	2000 (4)
19.0 (3/4)	3000 (7)
25.0 (1)	4000 (9)
37.5 (1 1/2)	6000 (13)
50 (2)	8000 (18)
63 (2 1/2)	10,000 (22)
75 (3)	13,000 (29)
90 (3 1/2)	16,000 (35)
100 (4)	25,000 (55)
150 (6)	50,000 (110)

\* One sieve larger than the first sieve to retain more than 10 percent of the material using an agency specified set of sieves based on cumulative percent retained. Where large gaps in specification sieves exist, intermediate sieve(s) may be inserted to determine nominal maximum.

For soils the representative sample size is based on Table 2 or other information that may be specified by the agency.

**TABLE 2**  
**Sample Sizes for Moisture Content of Soil**

<b>Maximum Particle Size mm (in)</b>	<b>Minimum Sample Mass g</b>
0.425 (No. 40)	10
4.75 (No. 4)	100
12.5 (1/2)	300
25.0 (1)	500
50 (2)	1000

Immediately seal or cover samples to prevent any change in moisture content or follow the steps in “Procedure.”

### **Procedure**

Determine and record the sample mass as follows:

- For aggregate, determine and record all masses to the nearest 0.1 percent of the sample mass or to the nearest 0.1 g.
- For soil, determine and record all masses to the nearest 0.1 g.

When determining the mass of hot samples or containers or both, place and tare a buffer between the sample container and the balance. This will eliminate damage to or interference with the operation of the balance or scale.

1. Determine and record the mass of the container (and lid for microwave drying).
2. Place the wet sample in the container.
  - a. For oven(s), hot plates, infrared heaters, etc.: Spread the sample in the container.
  - b. For microwave oven: Heap sample in the container; cover with ventilated lid.
3. Determine and record the total mass of the container and wet sample.
4. Determine and record the wet mass of the sample by subtracting the container mass determined in Step 1 from the mass of the container and sample determined in Step 3.

5. Place the sample in one of the following drying apparatus:
  - a. For aggregate –
    - i. Controlled heat source (oven): at  $110 \pm 5^{\circ}\text{C}$  ( $230 \pm 9^{\circ}\text{F}$ ).
    - ii. Uncontrolled heat source (Hot plate, infrared heater, etc.): Stir frequently to avoid localized overheating.
  - b. For soil – controlled heat source (oven): at  $110 \pm 5^{\circ}\text{C}$  ( $230 \pm 9^{\circ}\text{F}$ ).

**Note 1:** Soils containing gypsum or significant amounts of organic material require special drying. For reliable moisture contents dry these soils at  $60^{\circ}\text{C}$  ( $140^{\circ}\text{F}$ ). For more information see AASHTO T 265, Note 2.

6. Dry until sample appears moisture free.
7. Determine mass of sample and container.
8. Determine and record the mass of the sample by subtracting the container mass determined in Step 1 from the mass of the container and sample determined in Step 7.
9. Return sample and container to the heat source for additional drying.
  - a. For aggregate –
    - i. Controlled heat source (oven): 30 minutes
    - ii. Uncontrolled heat source (Hot plate, infrared heater, etc.): 10 minutes
    - iii. Uncontrolled heat source (Microwave oven): 2 minutes

**Caution:** Some minerals in the sample may cause the aggregate to overheat, altering the aggregate gradation.

- b. For soil – controlled heat source (oven): 1 hour
10. Determine mass of sample and container.
11. Determine and record the mass of the sample by subtracting the container mass determined in Step 1 from the mass of the container and sample determined in Step 10.

12. Determine percent change by subtracting the new mass determination ( $M_n$ ) from the previous mass determination ( $M_p$ ) divide by the previous mass determination ( $M_p$ ) multiply by 100.
13. Continue drying, performing steps 9 through 12, until there is less than a 0.10 percent change after additional drying time.
14. Constant mass has been achieved, sample is defined as dry.
15. Allow the sample to cool. Immediately determine and record the total mass of the container and dry sample.
16. Determine and record the dry mass of the sample by subtracting the mass of the container determined in Step 1 from the mass of the container and sample determined in Step 15.
17. Determine and record percent moisture by subtracting the final dry mass determination ( $M_D$ ) from the initial wet mass determination ( $M_W$ ) divide by the final dry mass determination ( $M_D$ ) multiply by 100.

**Table 3**  
**Methods of Drying**

<b>Aggregate</b>		
<b>Heat Source</b>	<b>Specific Instructions</b>	<b>Drying intervals to achieve constant mass (minutes)</b>
<b>Controlled:</b> Forced draft (preferred), ventilated, or convection oven	$110 \pm 5^\circ\text{C}$ ( $230 \pm 9^\circ\text{F}$ )	30
<b>Uncontrolled:</b>		
Hot plate, infrared heater, etc.	Stir frequently	10
Microwave	Heap sample and cover with ventilated lid	2
<b>Soil</b>		
<b>Heat Source</b>	<b>Specific Instructions</b>	<b>Drying increments (minutes)</b>
<b>Controlled:</b> Forced draft (preferred), ventilated, or convection oven	$110 \pm 5^\circ\text{C}$ ( $230 \pm 9^\circ\text{F}$ )	1 hour

## Calculation

### Constant Mass:

Calculate constant mass using the following formula:

$$\frac{M_p - M_n}{M_p} \times 100 = \% \text{ Change}$$

Where:  $M_p$  = previous mass measurement  
 $M_n$  = new mass measurement

Example:

Mass of container: 1232.1 g

Mass of container and sample after first drying cycle: 2637.2 g

Mass,  $M_p$ , of possibly dry sample: 2637.2 g - 1232.1 g = 1405.1 g

Mass of container and dry sample after second drying cycle: 2634.1 g

Mass,  $M_n$ , of dry sample: 2634.1 g - 1232.1 g = 1402.0 g

$$\frac{1405.1 \text{ g} - 1402.0 \text{ g}}{1405.1 \text{ g}} \times 100 = 0.22\%$$

*0.22 percent is not less than 0.10 percent, so continue drying*

Mass of container and dry sample after third drying cycle: 2633.0 g

Mass,  $M_n$ , of dry sample: 2633.0 g - 1232.1 g = 1400.9 g

$$\frac{1402.0 \text{ g} - 1400.9 \text{ g}}{1402.0 \text{ g}} \times 100 = 0.08\%$$

*0.08 percent is less than 0.10 percent, so constant mass has been reached.*

### Moisture Content:

Calculate the moisture content, as a percent, using the following formula:

$$w = \frac{M_W - M_D}{M_D} \times 100$$

Where:

w = moisture content, percent

$M_W$  = wet mass

$M_D$  = dry mass

Example:

Mass of container: 1232.1 g

Mass of container and wet sample: 2764.7 g

Mass,  $M_W$ , of wet sample: 2764.7 g - 1232.1 g = 1532.6 g

Mass of container and dry sample (COOLED): 2633.5 g

Mass,  $M_D$ , of dry sample: 2633.5 g - 1232.1 g = 1401.4 g

$$w = \frac{1532.6 \text{ g} - 1401.4 \text{ g}}{1401.4 \text{ g}} \times 100 = \frac{131.2 \text{ g}}{1401.4 \text{ g}} \times 100 = 9.36\% \text{ report } 9.4\%$$

### Report

- Results on forms approved by the agency
- Sample ID
- $M_W$ , wet mass
- $M_D$ , dry mass
- w, moisture content to nearest 0.1 percent

EMBANKMENT AND BASE  
IN-PLACE DENSITY

WAQTC

FOP AASHTO T 255 / T 265 (16)

**MOISTURE-DENSITY RELATIONS OF SOILS:  
USING A 2.5 kg (5.5 lb) RAMMER AND A 305 mm (12 in.) DROP  
FOP FOR AASHTO T 99  
USING A 4.54 kg (10 lb) RAMMER AND A 457 mm (18 in.) DROP  
FOP FOR AASHTO T 180**

**Scope**

This procedure covers the determination of the moisture-density relations of soils and soil-aggregate mixtures in accordance with two similar test methods:

- AASHTO T 99-15: Methods A, B, C, and D
- AASHTO T 180-15: Methods A, B, C, and D

This test method applies to soil mixtures having 40 percent or less retained on the 4.75 mm (No. 4) sieve for methods A or B, or, 30 percent or less retained on the 19 mm (¾ in.) with methods C or D. The retained material is defined as oversize (coarse) material. If no minimum percentage is specified, 5 percent will be used. Samples that contain oversize (coarse) material that meet percent retained criteria should be corrected by using Annex. Samples of soil or soil-aggregate mixture are prepared at several moisture contents and compacted into molds of specified size, using manual or mechanical rammers that deliver a specified quantity of compactive energy. The moist masses of the compacted samples are multiplied by the appropriate factor to determine moist density values. Moisture contents of the compacted samples are determined and used to obtain the dry density values of the same samples. Maximum dry density and optimum moisture content for the soil or soil-aggregate mixture is determined by plotting the relationship between dry density and moisture content.

**Apparatus**

- Mold – Cylindrical made of metal with the dimensions shown in Table 1 or Table 2, If permitted by the agency, the mold may be of the “split” type, consisting of two half-round sections, which can be securely locked in place to form a cylinder. Determine the mold volume according to the “Calibration of Measure” section of AASHTO T 19 for Unit Mass of Aggregate.
- Mold assembly – Mold, base plate, and a detachable collar.
- Rammer –Manually or mechanically-operated rammers as detailed in Table 1 or Table 2. A manually-operated rammer shall be equipped with a guide sleeve to control the path and height of drop. The guide sleeve shall have at least four vent holes no smaller than 9.5 mm (3/8 in.) in diameter, spaced approximately 90 degrees apart and approximately 19 mm (¾ in.) from each end. A mechanically-operated rammer will uniformly distribute blows over the sample and will be calibrated with several soil types, and be adjusted, if necessary, to give the same moisture-density results as with the manually operated rammer. For additional information concerning calibration, see the FOP for AASHTO T 99 and T 180.

- Sample extruder – A jack, lever frame, or other device for extruding compacted specimens from the mold quickly and with little disturbance.
- Balance(s) or scale(s) of the capacity and sensitivity required for the procedure used by the agency.

A balance or scale with a capacity of 11.5 kg (25 lb) and a sensitivity of 1 g for obtaining the sample, meeting the requirements of AASHTO M 231, Class G 5.

A balance or scale with a capacity of 2 kg and a sensitivity of 0.1 g is used for moisture content determinations done under both procedures, meeting the requirements of AASHTO M 231, Class G 2.

- Drying apparatus – A thermostatically controlled drying oven, capable of maintaining a temperature of  $110 \pm 5^{\circ}\text{C}$  ( $230 \pm 9^{\circ}\text{F}$ ) for drying moisture content samples in accordance with the FOP for AASHTO T 255/T 265.
- Straightedge – A steel straightedge at least 250 mm (10 in.) long, with one beveled edge and at least one surface plane within 0.1 percent of its length, used for final trimming.
- Sieve(s) – 4.75 mm (No. 4) and/or 19.0 mm (3/4 in.), conforming to AASHTO M 92.
- Mixing tools – Miscellaneous tools such as a mixing pan, spoon, trowel, spatula, etc., or a suitable mechanical device, for mixing the sample with water.
- Containers with close-fitting lids to prevent gain or loss of moisture in the sample.

**Table 1**  
**Comparison of Apparatus, Sample, and Procedure – Metric**

	<b>T 99</b>	<b>T 180</b>
Mold Volume, m <sup>3</sup>	Methods A, C: 0.000943 ± 0.000001	Methods A, C: 0.000943 ±0.000001
	Methods B, D: 0.002124 ±0.000025	Methods B, D: 0.002124 ±0.000025
Mold Diameter, mm	Methods A, C: 101.60 ±0.40	Methods A, C: 101.60 ±0.4
	Methods B, D: 152.40 ±0.70	Methods B, D: 152.40 ±0.70
Mold Height, mm	116.40 ±0.50	116.40 ±0.50
Detachable Collar Height, mm	50.80 ±0.64	50.80 ±0.64
Rammer Diameter, mm	50.80 ±0.25	50.80 ±0.25
Rammer Mass, kg	2.495 ±0.009	4.536 ±0.009
Rammer Drop, mm	305	457
Layers	3	5
Blows per Layer	Methods A, C: 25	Methods A, C: 25
	Methods B, D: 56	Methods B, D: 56
Material Size, mm	Methods A, B: 4.75 minus	Methods A, B: 4.75 minus
	Methods C, D: 19.0 minus	Methods C, D: 19.0 minus
Test Sample Size, kg	Method A: 3	Method B: 7
	Method C: 5 (1)	Method D: 11(1)
Energy, kN-m/m <sup>3</sup>	592	2,693

(1) This may not be a large enough sample depending on your nominal maximum size for moisture content samples.

**Table 2**  
**Comparison of Apparatus, Sample, and Procedure – English**

	<b>T 99</b>	<b>T 180</b>
Mold Volume, ft <sup>3</sup>	Methods A, C: 0.0333 ±0.0005	Methods A, C: 0.0333 ±0.0005
	Methods B, D: 0.0750 ±0.0009	Methods B, D: 0.0750 ±0.0009
Mold Diameter, in.	Methods A, C: 4.000 ±0.016	Methods A, C: 4.000 ±0.016
	Methods B, D: 6.000 ±0.026	Methods B, D: 6.000 ±0.026
Mold Height, in.	4.584 ±0.018	4.584 ±0.018
Detachable Collar Height, in.	2.000 ±0.025	2.000 ±0.025
Rammer Diameter, in.	2.000 ±0.025	2.000 ±0.025
Rammer Mass, lb	5.5 ±0.02	10 ±0.02
Rammer Drop, in.	12	18
Layers	3	5
Blows per Layer	Methods A, C: 25	Methods A, C: 25
	Methods B, D: 56	Methods B, D: 56
Material Size, in.	Methods A, B: No. 4 minus	Methods A, B: No.4 minus
	Methods C, D: 3/4 minus	Methods C, D: 3/4 minus
Test Sample Size, lb	Method A: 7	Method B: 16
	Method C: 12 <sub>(1)</sub>	Method D: 25 <sub>(1)</sub>
Energy, lb-ft/ft <sup>3</sup>	12,375	56,250

(1) This may not be a large enough sample depending on your nominal maximum size for moisture content samples.

## Sample

If the sample is damp, dry it until it becomes friable under a trowel. Drying may be in air or by use of a drying apparatus maintained at a temperature not exceeding 60°C (140°F). Thoroughly break up aggregations in a manner that avoids reducing the natural size of individual particles.

Obtain a representative test sample of the mass required by the agency by passing the material through the sieve required by the agency. See Table 1 or Table 2 for test sample mass and material size requirements.

**Note 1:** Both T 99 and T 180 have four methods (A, B, C, D) that require different masses and employ different sieves.

**Note 2:** If the sample is plastic (clay types), it should stand for a minimum of 12 hours after the addition of water to allow the moisture to be absorbed. In this case, several samples at different moisture contents should be prepared, put in sealed containers and tested the next day. In instances where the material is prone to degradation, i.e., granular material, a compaction sample with differing moisture contents should be prepared for each point.

## Procedure

During compaction, the mold shall rest firmly on a dense, uniform, rigid, and stable foundation or base. This base shall remain stationary during the compaction process.

1. Determine the mass of the clean, dry mold. Include the base plate, but exclude the extension collar. Record the mass to the nearest 1 g (0.005 lb).
2. Thoroughly mix the selected representative sample with sufficient water to dampen it to approximately 4 to 8 percentage points below optimum moisture content. See Note 2. For many materials this condition can be identified by forming a cast by hand.
3. Form a specimen by compacting the prepared soil in the mold (with collar attached) in approximately equal layers. For each layer:
  - a. Spread the loose material uniformly in the mold.

**Note 3:** It is recommended to cover the remaining material with a non-absorbent sheet or damp cloth to minimize loss of moisture.

- b. Lightly tamp the loose material with the manual rammer or other similar device, this establishes a firm surface.
    - c. Compact each layer with uniformly distributed blows from the rammer. See Table 1 for mold size, number of layers, number of blows, and rammer specification for the various test methods. Use the method specified by the agency.
    - d. Trim down material that has not been compacted and remains adjacent to the walls of the mold and extends above the compacted surface.

4. Remove the extension collar. Avoid shearing off the sample below the top of the mold. The material compacted in the mold should not be over 6 mm (¼ in.) above the top of the mold once the collar has been removed.
  5. Trim the compacted soil even with the top of the mold with the beveled side of the straightedge.
  6. Determine the mass of the mold and wet soil to the nearest 1 g (0.005 lb) or better.
  7. Determine the wet mass of the sample by subtracting the mass in Step 1 from the mass in Step 6.
  8. Calculate the wet density as indicated below under “Calculations.”
  9. Extrude the material from the mold. For soils and soil-aggregate mixtures, slice vertically through the center and take a representative moisture content sample from one of the cut faces, ensuring that all layers are represented. For granular materials, a vertical face will not exist. Take a representative sample. This sample must meet the sample size requirements of the test method used to determine moisture content.
- Note 4:* When developing a curve for free-draining soils such as uniform sands and gravels, where seepage occurs at the bottom of the mold and base plate, taking a representative moisture content from the mixing bowl may be preferred in order to determine the amount of moisture available for compaction.
10. Determine the moisture content of the sample in accordance with the FOP for AASHTO T 255 / T 265.
  11. Thoroughly break up the remaining portion of the molded specimen until it will again pass through the sieve, as judged by eye, and add to the remaining portion of the sample being tested. See Note 2.
  12. Add sufficient water to increase the moisture content of the remaining soil by approximately 1 to 2 percentage points and repeat steps 3 through 11.
  13. Continue determinations until there is either a decrease or no change in the wet density. There will be a minimum of three points on the dry side of the curve and two points on the wet side.
- Note 5:* In cases of free-draining granular material, the development of points on the wet side of optimum may not be practical.

**Calculations**

1. Calculate the wet density, in kg/m<sup>3</sup> (lb/ft<sup>3</sup>), by dividing the wet mass by the measured volume of the mold (T 19).

Example – Methods A or C mold:

Wet mass = 1.916 kg (4.22 lb)

Measured volume of the mold = 0.000946 m<sup>3</sup> (0.0334 ft<sup>3</sup>)

$$Wet\ Density = \frac{1.916\ kg}{0.000946\ m^3} = 2025\ kg/m^3$$

$$Wet\ Density = \frac{4.22\ lb}{0.0334\ ft^3} = 126.3\ lb/ft^3$$

2. Calculate the dry density as follows.

$$\rho_d = \left( \frac{\rho_w}{w + 100} \right) \times 100 \quad or \quad \rho_d = \frac{\rho_w}{\left( \frac{w}{100} \right) + 1}$$

Where:

$\rho_d$  = Dry density, kg/m<sup>3</sup> (lb/ft<sup>3</sup>)

$\rho_w$  = Wet density, kg/m<sup>3</sup> (lb/ft<sup>3</sup>)

w = Moisture content, as a percentage

**Example:**

$$\rho_w = 2030\ kg/m^3\ (126.6\ lb/ft^3)$$

$$w = 14.7\%$$

$$\rho_d = \left( \frac{2030\ kg/m^3}{14.7 + 100} \right) \times 100 = 1770\ kg/m^3 \quad \rho_d = \left( \frac{126.6\ lb/ft^3}{14.7 + 100} \right) \times 100 = 110.4\ lb/ft^3$$

or

$$\rho_d = \left( \frac{2030\ kg/m^3}{\frac{14.7}{100} + 1} \right) = 1770\ kg/m^3 \quad \rho_d = \left( \frac{126.6\ lb/ft^3}{\frac{14.7}{100} + 1} \right) = 110.4\ lb/ft^3$$

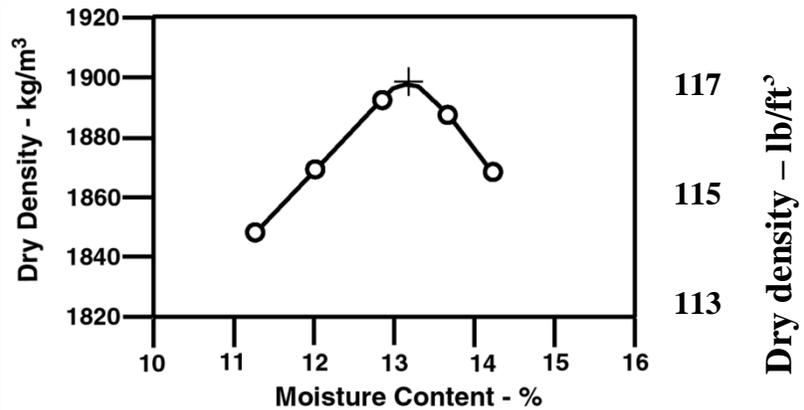
### Moisture-Density Curve Development

When dry density is plotted on the vertical axis versus moisture content on the horizontal axis and the points are connected with a smooth line, a moisture-density curve is developed. The coordinates of the peak of the curve are the maximum dry density, or just “maximum density,” and the “optimum moisture content” of the soil.

**Example:**

Given the following dry density and corresponding moisture content values develop a moisture-density relations curve and determine maximum dry density and optimum moisture content.

Dry Density		Moisture Content, %
kg/m <sup>3</sup>	lb/ft <sup>3</sup>	
1846	114.3	11.3
1868	115.7	12.1
1887	116.9	12.8
1884	116.7	13.6
1871	115.9	14.2



In this case, the curve has its peak at:

Maximum dry density = 1890 kg/m<sup>3</sup> (117.0 lb/ft<sup>3</sup>)  
 Optimum moisture content = 13.2%

Note that both values are approximate, since they are based on sketching the curve to fit the points.

## Report

- Results on forms approved by the agency
- Sample ID
- Maximum dry density to the closest  $1 \text{ kg/m}^3$  ( $0.1 \text{ lb/ft}^3$ )
- Optimum moisture content to the closest 0.1 percent

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## ANNEX

### CORRECTION OF MAXIMUM DRY DENSITY AND OPTIMUM MOISTURE FOR OVERSIZED PARTICLES

This section corrects the maximum dry density and moisture content of the material retained on the 4.75 mm (No. 4) sieve, Methods A and B; or the material retained on the 19 mm (¾ in.) sieve, Methods C and D. The maximum dry density, corrected for oversized particles and total moisture content, are compared with the field-dry density and field moisture content.

This correction can be applied to the sample on which the maximum dry density is performed. A correction may not be practical for soils with only a small percentage of oversize material. The agency shall specify a minimum percentage below which the method is not needed. If not specified, this method applies when more than 5 percent by weight of oversize particles is present.

Bulk specific gravity ( $G_{sb}$ ) of the oversized particles is required to determine the corrected maximum dry density. Use the bulk specific gravity as determined using the FOP for AASHTO T 85 in the calculations. For construction activities an agency established value or specific gravity of 2.600 may be used.

This correction can also be applied to the sample obtained from the field while performing in-place density.

1. Use the sample from this procedure or a sample obtained according to the FOP for AASHTO T 310.
2. Sieve the sample on the 4.75 mm (No. 4) sieve for Methods A and B or the 19 mm (¾ in.) sieve, Methods C and D.
3. Determine the dry mass of the oversized and fine fractions ( $M_{DC}$  and  $M_{DF}$ ) by one of the following:
  - a. Dry the fractions, fine and oversized, in air or by use of a drying apparatus that is maintained at a temperature not exceeding 60°C (140°F).
  - b. Calculate the dry masses using the moisture samples.

To determine the dry mass of the fractions using moisture samples.

1. Determine the moist mass of both fractions, fine ( $M_{Mf}$ ) and oversized ( $M_{Mc}$ ):
2. Obtain moisture samples from the fine and oversized material.

3. Determine the moisture content of the fine particles ( $MC_f$ ) and oversized particles ( $MC_c$ ) of the material by FOP for AASHTO T 255/T 265 or agency approved method.
4. Calculate the dry mass of the oversize and fine particles.

$$M_D = \frac{M_m}{1 + MC}$$

Where:

$M_D$  = mass of dry material (fine or oversize particles)  
 $M_m$  = mass of moist material (fine or oversize particles)  
 MC = moisture content of respective fine or oversized, expressed as a decimal

5. Calculate the percentage of the fine ( $P_f$ ) and oversized ( $P_c$ ) particles by dry weight of the total sample as follows: See Note 2.

$$P_f = \frac{100M_{DF}}{M_{DF} + M_{DC}} \quad \frac{100 \times 15.4 \text{ lb}}{15.4 \text{ lbs} + 5.7 \text{ lb}} = 73\% \quad \frac{100 \times 7.034 \text{ kg}}{7.03 \text{ kg} + 2.602 \text{ kg}} = 73\%$$

And

$$P_c = \frac{100M_{DC}}{M_{DF} + M_{DC}} \quad \frac{100 \times 5.7 \text{ lb}}{15.4 \text{ lbs} + 5.7 \text{ lb}} = 27\% \quad \frac{100 \times 2.602 \text{ kg}}{7.03 \text{ kg} + 2.602 \text{ kg}} = 27\%$$

Or for  $P_c$ :

$$P_c = 100 - P_f$$

Where:

$P_f$  = percent of fine particles, of sieve used, by weight  
 $P_c$  = percent of oversize particles, of sieve used, by weight  
 $M_{DF}$  = mass of fine particles  
 $M_{DC}$  = mass of oversize particles

### Optimum Moisture Correction Equation

1. Calculate the corrected moisture content as follows:

$$MC_T = \frac{(MC_F \times P_f) + (MC_c \times P_c)}{100} = \frac{(13.2\% \times 73.0\%) + (2.1\% \times 27.0\%)}{100} = 10.2\%$$

$MC_T$  = corrected moisture content of combined fines and oversized particles, expressed as a % moisture

$MC_F$  = moisture content of fine particles, as a % moisture

$MC_C$  = moisture content of oversized particles, as a % moisture

**Note 1:** Moisture content of oversize material can be assumed to be two (2) percent for most construction applications.

**Note 2:** In some field applications agencies will allow the percentages of oversize and fine materials to be determined with the materials in the wet state.

### Density Correction Equation

2. Calculate the corrected dry density of the total sample (combined fine and oversized particles) as follows:

$$D_d = \frac{100\%}{\frac{P_f}{D_f} + \frac{P_c}{k}}$$

Where:

$D_d$  = corrected total dry density (combined fine and oversized particles)  
kg/m<sup>3</sup> (lb/ft<sup>3</sup>)

$D_f$  = dry density of the fine particles kg/m<sup>3</sup> (lb/ft<sup>3</sup>), determined in the lab

$P_c$  = percent of oversize particles, of sieve used, by weight.

$P_f$  = percent of fine particles, of sieve used, by weight.

$k$  = Metric: 1,000 \* Bulk Specific Gravity ( $G_{sb}$ ) (oven dry basis)  
of coarse particles (kg/m<sup>3</sup>).

$k$  = English: 62.4 \* Bulk Specific Gravity ( $G_{sb}$ ) (oven dry basis)  
of coarse particles (lb/ft<sup>3</sup>)

**Note 3:** If the specific gravity is known, then this value will be used in the calculation. For most construction activities the specific gravity for aggregate may be assumed to be 2.600.

### Calculation

Sample Calculations:

- Metric:

Maximum laboratory dry density ( $D_f$ ):	1890 kg/m <sup>3</sup>
Percent coarse particles ( $P_c$ ):	27%
Percent fine particles ( $P_f$ ):	73%
Mass per volume coarse particles (k):	(2.697) (1000) = 2697 kg/m <sup>3</sup>

$$D_a = \frac{100\%}{\frac{P_f}{D_f} + \frac{P_c}{k}}$$

$$D_a = \frac{100\%}{\frac{73\%}{1890 \text{ kg/m}^3} + \frac{27\%}{2697 \text{ kg/m}^3}}$$

$$D_a = \frac{100\%}{0.03862 \text{ kg/m}^3 + 0.01001 \text{ kg/m}^3}$$

$$D_a = 2056.3 \text{ kg/m}^3 \text{ report } 2056 \text{ kg/m}^3$$

English:

Maximum laboratory dry density ( $D_f$ ): 117.0 lb/ft<sup>3</sup>

Percent coarse particles ( $P_c$ ): 27%

Percent fine particles ( $P_f$ ): 73%

Mass per volume of coarse particles ( $k$ ): (2.697) (62.4) = 168.3 lb/ft<sup>3</sup>

$$D_a = \frac{100\%}{\frac{P_f}{D_f} + \frac{P_c}{k}}$$

$$D_a = \frac{100\%}{\frac{73\%}{117.0 \text{ lb/ft}^3} + \frac{27\%}{168.3 \text{ lb/ft}^3}}$$

$$D_a = \frac{100\%}{0.6239 \text{ lb/ft}^3 + 0.1604 \text{ lb/ft}^3}$$

$$D_a = \frac{100\%}{0.7843 \text{ lb/ft}^3}$$

$$D_a = 127.50 \text{ lb/ft}^3 \text{ report } 127.5 \text{ lb/ft}^3$$

## Report

- Results on forms approved by the agency
- Sample ID
- Corrected maximum dry density to the closest 1 kg/m<sup>3</sup> (0.1 lb/ft<sup>3</sup>)
- Corrected optimum moisture to the 0.1 percent

EMBANKMENT AND BASE  
IN-PLACE DENSITY

WAQTC

FOP AASHTO T 99 / T 180 (15)

## DEVELOPING A FAMILY OF CURVES FOP FOR AASHTO R 75

### Scope

This procedure provides a method to develop a family of curves in accordance with AASHTO R 75-16 using multiple moisture density relationships developed using the same method, A, B, C, or D, from the FOP for AASHTO T 99/T 180.

All curves used in a family must be developed using a single Method: A, B, C, or D of a procedure for AASHTO T 99 or T 180. See the FOP for AASHTO T 99/T 180.

### Terminology

*family of curves* — a group of soil moisture-density relationships (curves) determined using AASHTO T 99 or T 180, which reveal certain similarities and trends characteristic of the soil type and source.

*spine* — smooth line extending through the point of maximum density/optimum moisture content of a family of moisture-density curves.

### Procedure

1. Sort the curves by Method (A, B, C, or D of the FOP for T 99/T 180). At least three curves are required per family.
2. Select the highest and lowest maximum dry densities from those selected to assist in determining the desired scale of the subsequent graph.
3. Plot the maximum density and optimum moisture points of the selected curves on the graph.
4. Draw a smooth, “best fit,” curved line through the points creating the spine of the family of curves.
5. Remove maximum density and optimum moisture points that were not used to establish the spine.
6. Add the moisture/density curves associated with the points that were used to establish the spine. It is not necessary to include the portion of the curves over optimum moisture.

*Note 1*—Intermediate template curves using slopes similar to those of the original moisture-density curves may be included when maximum density points are more than 2.0 lb/ft<sup>3</sup> apart. Template curves are indicated by a dashed line.

7. Plot the 80 percent of optimum moisture range when desired:
8. Using the optimum moisture of an existing curve, calculate 80 percent of optimum moisture and plot this value on the curve. Repeat for each curve in the family.
9. Draw a smooth, "best fit," curved line connecting the 80 percent of optimum moisture points plotted on the curves that parallel the spine.

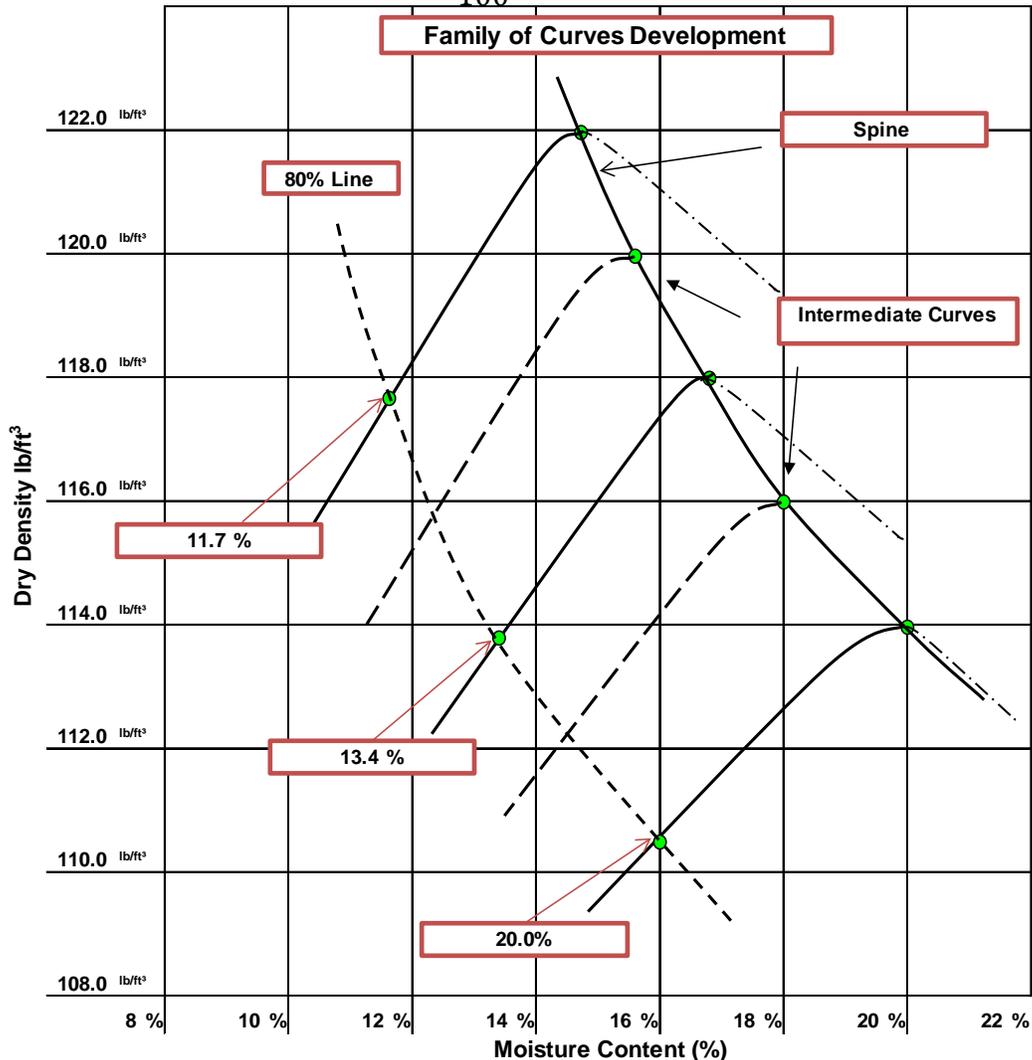
**Calculations**

Calculate 80 percent of optimum moisture of each curve:

Example:

Optimum moisture of the highest density curve = 14.6%

$$80\% \text{ point} = \frac{80}{100} \times 14.6\% = 11.7\%$$



## **ONE-POINT METHOD FOR DETERMINING MAXIMUM DRY DENSITY AND OPTIMUM MOISTURE FOP FOR AASHTO T 272**

### **Scope**

This procedure provides for a rapid determination of the maximum dry density and optimum moisture content of a soil sample, using a one-point determination in accordance with AASHTO T 272-16. This procedure is related to the FOPs for AASHTO T 99/T 180 and R 75.

One-point determinations are made by compacting the soil in a mold of a given size with a specified rammer dropped from a specified height and then compared to an individual moisture/density curve (FOP for AASHTO T 99 or T 180) or a family of curves (FOP for AASHTO R 75). Four alternate methods – A, B, C, and D – are used and correspond to the methods described in the FOP for AASHTO T 99/T 180. The method used in AASHTO T 272 must match the method used for the reference curve or to establish the family of curves. For example, when moisture-density relationships as determined by T 99 - Method C are used to form the family of curves or an individual moisture density curve, then T 99 - Method C must be used to for the one-point determination.

### **Apparatus**

See the FOP for AASHTO T 99/T 180. Use the method matching the individual curve or Family of Curves. Refer to Table 1 of the FOP for AASHTO T 99 / T 180 for corresponding mold size, number of layers, number of blows, and rammer specification for the various test methods.

### **Sample**

Sample size determined according to the FOP for AASHTO T 310. In cases where the existing individual curve or family cannot be used a completely new curve will need to be developed and the sample size will be determined by the FOP for AASHTO T 99/T 180.

If the sample is damp, dry it until it becomes friable under a trowel. Drying may be in air or by use of a drying apparatus maintained at a temperature not exceeding 60°C (140°F). Thoroughly break up aggregations in a manner that avoids reducing the natural size of individual particles.

### **Procedure**

1. Determine the mass of the clean, dry mold. Include the base plate, but exclude the extension collar. Record the mass to the nearest 1 g (0.005 lb).
2. Thoroughly mix the sample with sufficient water to adjust moisture content to 80 to 100 percent of the anticipated optimum moisture.

3. Form a specimen by compacting the prepared soil in the mold (with collar attached) in approximately equal layers. For each layer:
  - a. Spread the loose material uniformly in the mold.
- Note 1:* It is recommended to cover the remaining material with a non-absorbent sheet or damp cloth to minimize loss of moisture.
- b. Lightly tamp the loose material with the manual rammer or other similar device, this establishes a firm surface.
  - c. Compact each layer with uniformly distributed blows from the rammer.
  - d. Trim down material that has not been compacted and remains adjacent to the walls of the mold and extends above the compacted surface.
4. Remove the extension collar. Avoid shearing off the sample below the top of the mold. The material compacted in the mold should not be over 6 mm (¼ in.) above the top of the mold once the collar has been removed.
5. Trim the compacted soil even with the top of the mold with the beveled side of the straightedge.
6. Determine the mass of the mold and wet soil to the nearest 1 g (0.005 lb) or better.
7. Determine the wet mass of the sample by subtracting the mass in Step 1 from the mass in Step 6.
8. Calculate the wet density as indicated below under “Calculations.”
9. Extrude the material from the mold. For soils and soil-aggregate mixtures, slice vertically through the center and take a representative moisture content sample from one of the cut faces, ensuring that all layers are represented. For granular materials, a vertical face will not exist. Take a representative sample. This sample must meet the sample size requirements of the test method used to determine moisture content.
10. Determine the moisture content of the sample in accordance with the FOP for AASHTO T 255 / T 265.

### Calculations

1. Calculate the wet density, in  $\text{kg/m}^3$  ( $\text{lb/ft}^3$ ), by dividing the wet mass by the measured volume of the mold (T 19).

Example – Methods A or C mold:

Wet mass = 2.0055 kg (4.42 lb)

Measured volume of the mold =  $0.0009469 \text{ m}^3$  ( $0.03344 \text{ ft}^3$ )

$$\text{Wet Density} = \frac{2.0055 \text{ kg}}{0.0009469 \text{ m}^3} = 2118 \text{ kg/m}^3$$

$$\text{Wet Density} = \frac{4.42 \text{ lb}}{0.03344 \text{ ft}^3} = 132.2 \text{ lb/ft}^3$$

2. Calculate the dry density as follows.

$$\rho_d = \left( \frac{\rho_w}{w + 100} \right) \times 100 \quad \text{or} \quad \rho_d = \frac{\rho_w}{\left( \frac{w}{100} \right) + 1}$$

Where:

$\rho_d$  = Dry density,  $\text{kg/m}^3$  ( $\text{lb/ft}^3$ )  
 $\rho_w$  = Wet density,  $\text{kg/m}^3$  ( $\text{lb/ft}^3$ )  
 $w$  = Moisture content, as a percentage

Example:

$\rho_w = 2118 \text{ kg/m}^3$  ( $132.2 \text{ lb/ft}^3$ )  
 $w = 13.5\%$

$$\rho_d = \left( \frac{2118 \text{ kg/m}^3}{13.5 + 100} \right) \times 100 = 1866 \text{ kg/m}^3 \quad \rho_d = \left( \frac{132.2 \text{ lb/ft}^3}{13.5 + 100} \right) \times 100 = 116.5 \text{ lb/ft}^3$$

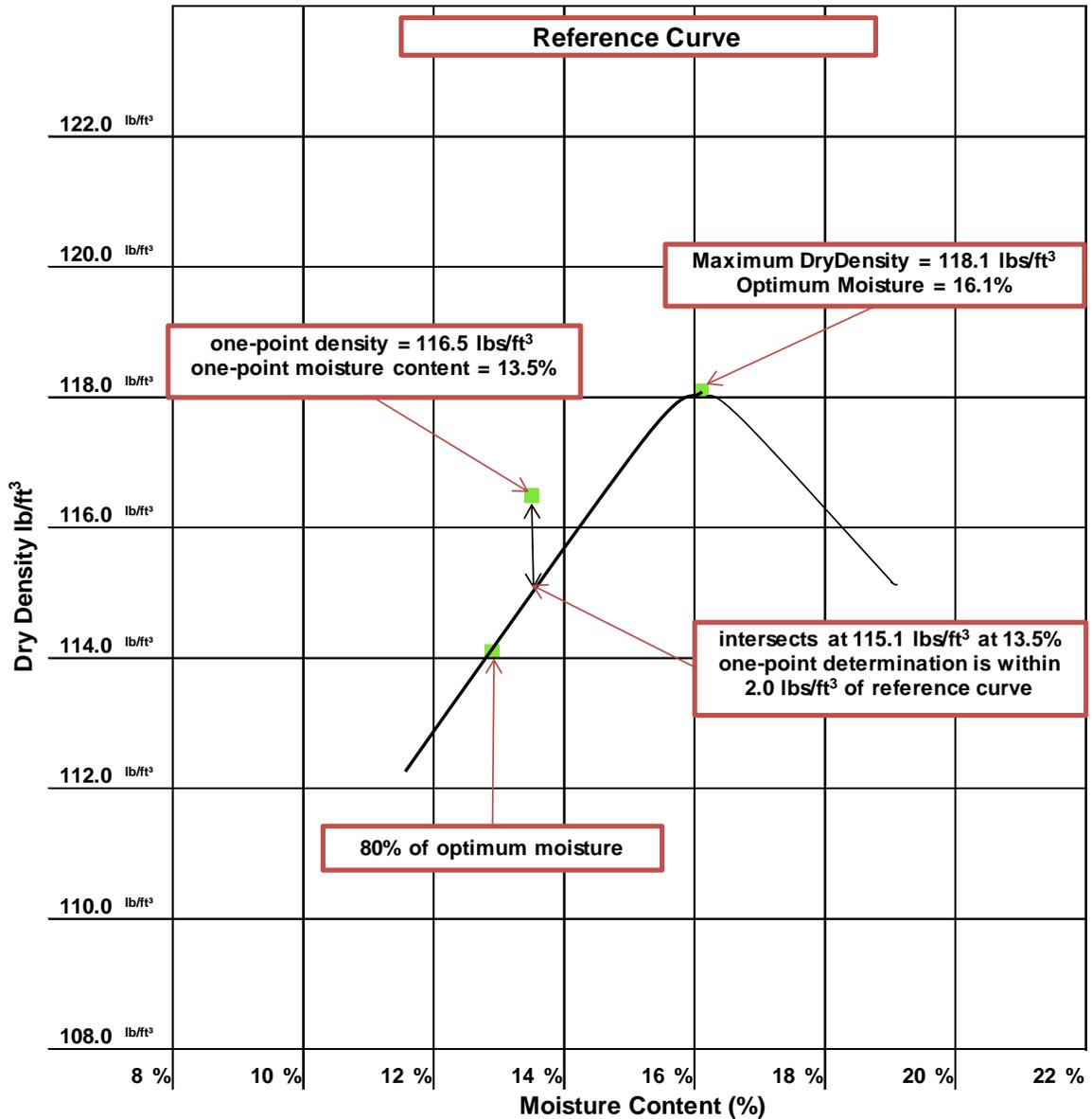
or

$$\rho_d = \left( \frac{2118 \text{ kg/m}^3}{\frac{13.5}{100} + 1} \right) = 1866 \text{ kg/m}^3 \quad \rho_d = \left( \frac{132.2 \text{ lb/ft}^3}{\frac{13.5}{100} + 1} \right) = 116.5 \text{ lb/ft}^3$$

### **Maximum Dry Density and Optimum Moisture Content Determination Using an Individual Moisture / Density Curve**

1. The moisture content must be within 80 to 100 percent of optimum moisture of the reference curve. Compact another specimen, using the same material, at an adjusted moisture content if the one-point does not fall in the 80 to 100 percent of optimum moisture range.
2. If the moisture content of the one-point determination is not within 80 to 100 percent of the optimum moisture content, compact another specimen, using the same material, at adjusted moisture content.
3. Plot the one-point, dry density on the vertical axis and moisture content on the horizontal axis, on the reference curve graph.
4. If the one-point falls on the reference curve or within  $\pm 2.0$  lbs/ft<sup>3</sup>, then the maximum dry density and optimum moisture content determined by the curve can be used.
5. Perform a full moisture-density relationship if the one-point does not fall on or within  $\pm 2.0$  lbs/ft<sup>3</sup> of the reference curve at 80 to 100 percent optimum moisture.

Example



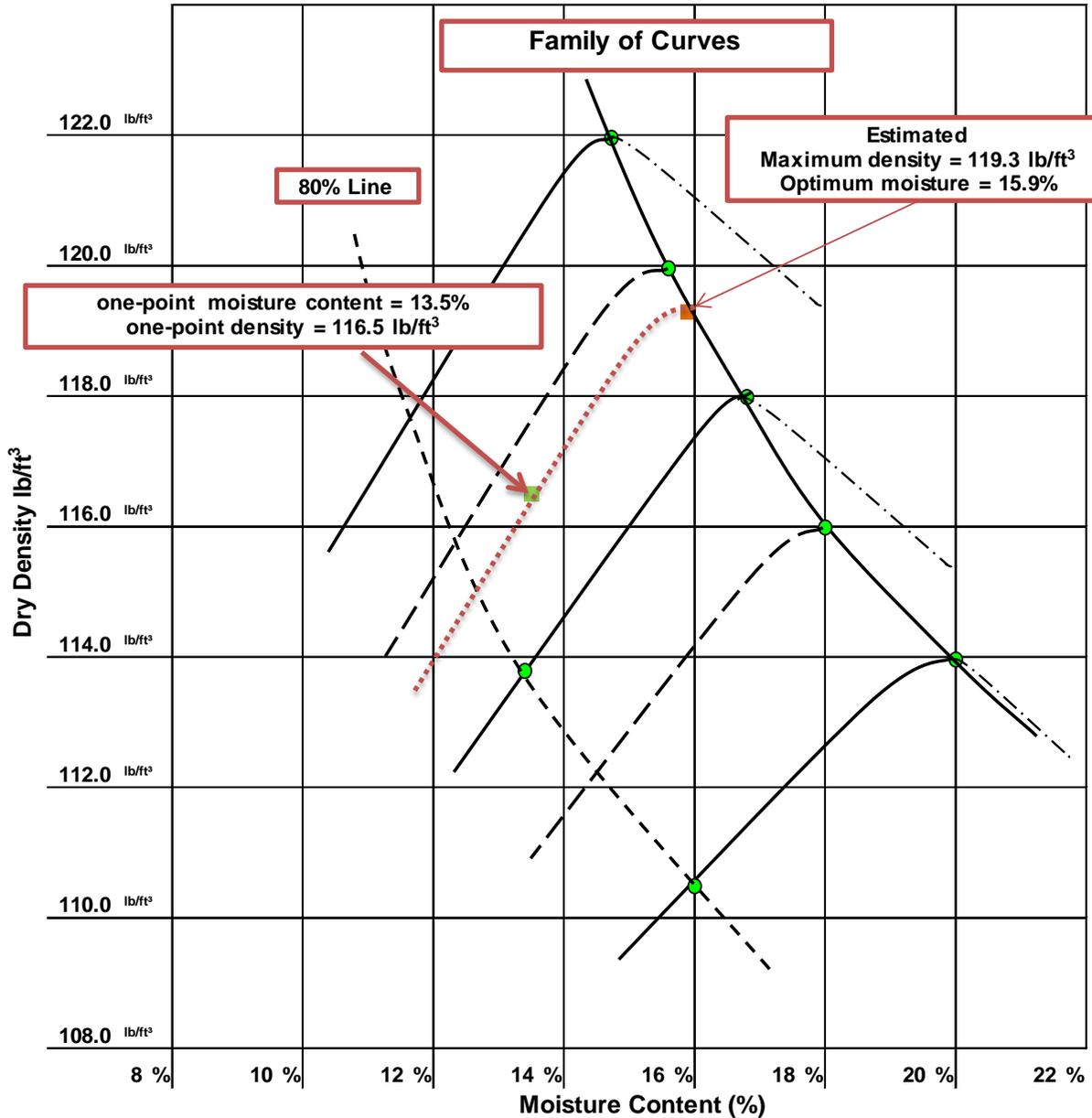
The results of a one-point determination were 116.5 lb/ft<sup>3</sup> at 13.5 percent moisture. The point was plotted on the reference curve graph. The one-point determination is within 2.0 lb/ft<sup>3</sup> of the point on the curve that corresponds with the moisture content.

### **Maximum Dry Density and Optimum Moisture Content Determination Using a Family of Curves**

1. If the moisture-density one-point falls on one of the curves in the family of curves, the maximum dry density and optimum moisture content defined by that curve is used.
2. If the moisture-density one-point falls within the family of curves but not on an existing curve, draw a new curve through the plotted single point, parallel and in character with the nearest existing curve in the family of curves. Use the maximum dry density and optimum moisture content as defined by the new curve.
3. The one-point must fall either between or on the highest or lowest curves in the family. If it does not, then a full curve must be developed.
4. If the one-point plotted within or on the family of curves does not fall in the 80 to 100 percent of optimum moisture content, compact another specimen, using the same material, at an adjusted moisture content that will place the one point within this range.
5. If the new curve through a one-point is not well defined or is in any way questionable, perform a full moisture-density relationship to correctly define the new curve and verify the applicability of the family of curves.

*Note 2:* New curves drawn through plotted single point determinations shall not become a permanent part of the family of curves until verified by a full moisture-density procedure following the FOP for AASHTO T 99/T 180.

EXAMPLE



The results of a one-point determination were 116.5 lb/ft<sup>3</sup> at 13.5 percent moisture. The point was plotted on the reference curve graph. The point was plotted on the appropriate family between two previously developed curves near and intermediate curve.

The “dotted” curve through the moisture-density one-point was sketched between the existing curves. A maximum dry density of 119.3 lb/ft<sup>3</sup> and a corresponding optimum moisture content of 15.9 percent were estimated.

## Report

- Results on forms approved by the agency
- Sample ID
- Maximum dry density to the closest  $1 \text{ kg/m}^3$  ( $0.1 \text{ lb/ft}^3$ )
- Optimum moisture content to the closest 0.1 percent
- Reference curve or Family of Curves used

## **SPECIFIC GRAVITY AND ABSORPTION OF COARSE AGGREGATE FOP FOR AASHTO T 85**

### **Scope**

This procedure covers the determination of specific gravity and absorption of coarse aggregate in accordance with AASHTO T 85-14. Specific gravity may be expressed as bulk specific gravity ( $G_{sb}$ ), bulk specific gravity, saturated surface dry ( $G_{sb}$  SSD), or apparent specific gravity ( $G_{sa}$ ).  $G_{sb}$  and absorption are based on aggregate after soaking in water. This procedure is not intended to be used with lightweight aggregates.

### **Terminology**

Absorption – the increase in the mass of aggregate due to water being absorbed into the pores of the material, but not including water adhering to the outside surface of the particles, expressed as a percentage of the dry mass. The aggregate is considered “dry” when it has been maintained at a temperature of  $110 \pm 5^\circ\text{C}$  ( $230 \pm 9^\circ\text{F}$ ) for sufficient time to remove all uncombined water.

Saturated Surface Dry (SSD) – condition of an aggregate particle when the permeable voids are filled with water, but no water is present on exposed surfaces.

Specific Gravity – the ratio of the mass, in air, of a volume of a material to the mass of the same volume of gas-free distilled water at a stated temperature.

Apparent Specific Gravity ( $G_{sa}$ )– the ratio of the mass, in air, of a volume of the impermeable portion of aggregate to the mass of an equal volume of gas-free distilled water at a stated temperature.

Bulk Specific Gravity ( $G_{sb}$ )– the ratio of the mass, in air, of a volume of aggregate (including the permeable and impermeable voids in the particles, but not including the voids between particles) to the mass of an equal volume of gas-free distilled water at a stated temperature.

Bulk Specific Gravity (SSD) ( $G_{sb}$  SSD) – the ratio of the mass, in air, of a volume of aggregate, including the mass of water within the voids filled to the extent achieved by submerging in water for 15 to 19 hours (but not including the voids between particles), to the mass of an equal volume of gas-free distilled water at a stated temperature.

### **Apparatus**

- Balance or scale: with a capacity of 5 kg, sensitive to 1 g. Meeting the requirements of AASHTO M 231.
- Sample container: a wire basket of 3.35 mm (No. 6) or smaller mesh, with a capacity of 4 to 7 L (1 to 2 gal) to contain aggregate with a nominal maximum size of 37.5 mm (1 1/2 in.) or smaller; or a larger basket for larger aggregates, or both.

- Water tank: watertight and large enough to completely immerse aggregate and basket, equipped with an overflow valve to keep water level constant.
- Suspension apparatus: wire used to suspend apparatus shall be of the smallest practical diameter.
- Sieves 4.75 mm (No. 4) or other sizes as needed, conforming to AASHTO M 92.
- Large absorbent towel

### Sample Preparation

1. Obtain the sample in accordance with the FOP for AASHTO T 2 (see Note 1).
2. Mix the sample thoroughly and reduce it to the approximate sample size required by Table 1 in accordance with the FOP for AASHTO R 76.
3. Reject all material passing the appropriate sieve by dry sieving.
4. Thoroughly wash sample to remove dust or other coatings from the surface.
5. Dry the test sample to constant mass at a temperature of  $110 \pm 5^{\circ}\text{C}$  ( $230 \pm 9^{\circ}\text{F}$ ) and cool in air at room temperature for 1 to 3 hours.

*Note 1:* Where the absorption and specific gravity values are to be used in proportioning concrete mixtures in which the aggregates will be in their naturally moist condition, the requirement for initial drying to constant mass may be eliminated, and, if the surfaces of the particles in the sample have been kept continuously wet until test, the 15-to-19 hour soaking may also be eliminated.

6. Re-screen the sample over the appropriate sieve. Reject all material passing that sieve.
7. The sample shall meet or exceed the minimum mass given in Table 1.

*Note 2:* If this procedure is used only to determine the  $G_{sb}$  of oversized material for the FOP for AASHTO T 99 / T 180, the material can be rejected over the appropriate sieve. For T 99 / T 180 Methods A and B, use the 4.75 mm (No. 4) sieve; T 99 / T 180 Methods C and D use the 19 mm (3/4 in).

**Table 1**

<b>Nominal Maximum Size* mm (in.)</b>	<b>Minimum Mass of Test Sample, g (lb)</b>
12.5 (1/2) or less	2000 (4.4)
19.0 (3/4)	3000 (6.6)
25.0 (1)	4000 (8.8)
37.5 (1 1/2)	5000 (11)
50 (2)	8000 (18)
63 (2 1/2)	12,000 (26)
75 (3)	18,000 (40)

\* One sieve larger than the first sieve to retain more than 10 percent of the material using an agency specified set of sieves based on cumulative percent retained. Where large gaps in specification sieves exist, intermediate sieve(s) may be inserted to determine nominal maximum size.

**Procedure**

1. Immerse the aggregate in water at room temperature for a period of 15 to 19 hours.

*Note 3:* When testing coarse aggregate of large nominal maximum size requiring large test samples, it may be more convenient to perform the test on two or more subsamples, and then combine the values obtained.

2. Place the empty basket into the water bath and attach to the balance. Inspect the immersion tank to ensure the water level is at the overflow outlet height. Tare the balance with the empty basket attached in the water bath.

3. Remove the test sample from the water and roll it in a large absorbent cloth until all visible films of water are removed. Wipe the larger particles individually. If the test sample dries past the SSD condition, immerse in water for 30 min, and then resume the process of surface-drying.

*Note 4:* A moving stream of air may be used to assist in the drying operation, but take care to avoid evaporation of water from aggregate pores.

4. Determine the SSD mass of the sample, and record this and all subsequent masses to the nearest 0.1 g or 0.1 percent of the sample mass, whichever is greater. Designate this mass as “B.”

5. Immediately place the SSD test sample in the sample container and weigh it in water maintained at  $23.0 \pm 1.7^\circ\text{C}$  ( $73.4 \pm 3^\circ\text{F}$ ). Shake the container to release entrapped air before recording the weight. Re-inspect the immersion tank to insure the water level is at the overflow outlet height. Designate this submerged weight as “C.”

*Note 5:* The container should be immersed to a depth sufficient to cover it and the test sample during mass determination. Wire suspending the container should be of the smallest practical size to minimize any possible effects of a variable immersed length.

6. Remove the sample from the basket. Ensure all material has been removed. Place in a container of known mass.

7. Dry the test sample to constant mass in accordance with the FOP for AASHTO T 255 / T 265 (Aggregate section) and cool in air at room temperature for 1 to 3 hours. Designate this mass as “A.”

### Calculations

Perform calculations and determine values using the appropriate formula below.

Bulk specific gravity ( $G_{sb}$ )

$$G_{sb} = \frac{A}{B - C}$$

Bulk specific gravity, SSD ( $G_{sb}$  SSD)

$$G_{sb}SSD = \frac{B}{B - C}$$

Apparent specific gravity ( $G_{sa}$ )

$$G_{sa} = \frac{A}{A - C}$$

Absorption

$$\text{Absorption} = \frac{B - A}{A} \times 100$$

Where:

- A = oven dry mass, g
- B = SSD mass, g
- C = weight in water, g

### Sample Calculations

Sample	A	B	C	B - C	A - C	B - A
1	2030.9	2044.9	1304.3	740.6	726.6	14.0
2	1820.0	1832.5	1168.1	664.4	651.9	12.5
3	2035.2	2049.4	1303.9	745.5	731.3	14.2

Sample	$G_{sb}$	$G_{sb}$ SSD	$G_{sa}$	Absorption
1	2.742	2.761	2.795	0.7
2	2.739	2.758	2.792	0.7
3	2.730	2.749	2.783	0.7

These calculations demonstrate the relationship between  $G_{sb}$ ,  $G_{sb}$  SSD, and  $G_{sa}$ .  $G_{sb}$  is always lowest, since the volume includes voids permeable to water.  $G_{sb}$  SSD is always intermediate.  $G_{sa}$  is always highest, since the volume does not include voids permeable to water. When running this test, check to make sure the values calculated make sense in relation to one another.

## Report

- Results on forms approved by the agency
- Sample ID
- Specific gravity values to 3 decimal places
- Absorption to 0.1 percent

EMBANKMENT AND BASE  
IN-PLACE DENSITY

WAQTC

FOP AASHTO T 85 (16)

## **USE OF AKDOT & PF ATM 212, ITD IT 74, WSDOT T 606, OR WFLHD HUMPHRES CURVES**

### **Background**

Coarse-grained granular soils are free-draining and have little or no cohesion. These soils are, therefore, not particularly well suited for the moisture-density relations procedures of AASHTO T 99 or AASHTO T 180. Transportation agencies have developed specialized test methods that are hybrids of those moisture-density procedures and methods that employ compaction under load with vibration. Those methods include:

- AKDOT & PF's ATM 212
- ITD's IT 74
- WSDOT's T 606
- WFLHD's Humphres

### **Description of Procedure**

In these tests, material is compacted in a mold and in a manner similar to those used in a Proctor test, after which the material is further compacted through a combination of applied loads and vibration. A laboratory maximum dry density is determined, as is the percent of material passing a certain sieve such as the 4.75 mm (No. 4). A number of determinations are made for different percentages passing the specified sieve. A graph is developed in which dry density is plotted versus the percentage of material passing that sieve. These tests are conducted in the agency's central lab, and the curve developed is a central lab function. Figure 1 is an example of such a curve.

Construction specifications will call out a percent of maximum dry density required for the granular materials used on the job. These specified values will be based on ATM 212, IT 74, T 606, or Humphres, depending on the agency.

In the field, the dry density of the granular material will be determined in accordance with the FOP for AASHTO 310. The percent of material passing the specified sieve will be determined for a sample obtained at the site of the density test. The dry density and percent passing values will then be compared with the curve developed in the lab for that particular granular material to determine conformance with the project specifications.

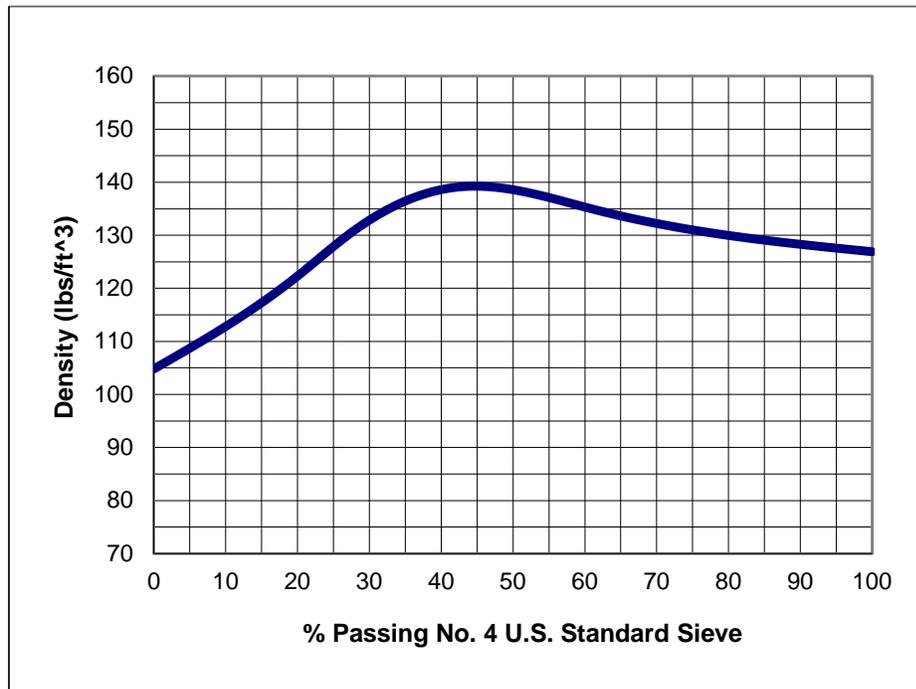
**Maximum Density Chart**

<b>Density Curves</b>			
<b>Pass #4</b>	<b>Maximum</b>	<b>Pass #4</b>	<b>Maximum</b>
0.0	104.8	31.0	133.7
1.0	105.6	32.0	134.5
2.0	106.4	33.0	135.2
3.0	107.1	34.0	135.8
4.0	107.9	35.0	136.4
5.0	108.7	36.0	137.0
6.0	109.5	37.0	137.5
7.0	110.3	38.0	137.9
8.0	111.1	39.0	138.3
9.0	112.0	40.0	138.6
10.0	112.8	41.0	138.9
11.0	113.7	42.0	139.0
12.0	114.5	43.0	139.2
13.0	115.4	44.0	139.2
14.0	116.4	45.0	139.2
15.0	117.3	46.0	139.2
16.0	118.2	47.0	139.1
17.0	119.2	48.0	139.0
18.0	120.2	49.0	138.8
19.0	121.3	50.0	138.6
20.0	122.3	51.0	138.3
21.0	123.4	52.0	138.1
22.0	124.5	53.0	137.8
23.0	125.6	54.0	137.5
24.0	126.8	55.0	137.1
25.0	127.9	56.0	136.8
26.0	129.0	57.0	136.4
27.0	130.0	58.0	136.0
28.0	131.0	59.0	135.7
29.0	132.0	60.0	135.3
30.0	132.8	61.0	135.0

<b>Density Curves</b>			
<b>Pass #4</b>	<b>Maximum</b>	<b>Pass #4</b>	<b>Maximum</b>
62.0	134.6	82.0	129.6
63.0	134.3	83.0	129.4
64.0	134.0	84.0	129.3
65.0	133.6	85.0	129.1
66.0	133.3	86.0	128.9
67.0	133.1	87.0	128.8
68.0	132.8	88.0	128.6
69.0	132.5	89.0	128.4
70.0	132.2	90.0	128.3
71.0	132.0	91.0	128.1
72.0	131.7	92.0	128.0
73.0	131.5	93.0	127.9
74.0	131.2	94.0	127.7
75.0	131.0	95.0	127.6
76.0	130.8	96.0	127.4
77.0	130.6	97.0	127.3
78.0	130.4	98.0	127.2
79.0	130.2	99.0	127.0
80.0	130.0	100.0	126.9
81.0	129.8		

<b>Control Points for Density Curves</b>		
<b>Pass #4</b>	<b>Maximum</b>	<b>Loose</b>
0.0	104.8	87.6
20.5	122.8	99.6
27.4	130.4	103.8
42.5	139.1	105.4
61.1	134.9	96.7
100.0	126.9	81.9

**Maximum Density Curve**



**Example:**

A compaction test was taken and a sample was removed from the test site per the FOP for AASHTO T 310. The sample was graded over a 4.75 mm (No. 4) sieve. The following results were reported.

Dry density from the  
FOP for AASHTO T 310 = 136.0 lb/ft<sup>3</sup>

Percent passing 4.75 mm (No. 4) sieve = 49%

Maximum density = 138.8 lb/ft<sup>3</sup>

$$\text{Percent compaction} = \frac{136.0 \text{ lb/ft}^3}{138.8 \text{ lb/ft}^3} \times 100 = 98\%$$

EMBANKMENT AND BASE  
IN-PLACE DENSITY

WAQTC

FOP CURVES (16)

## **IN-PLACE DENSITY AND MOISTURE CONTENT OF SOIL AND SOIL-AGGREGATE BY NUCLEAR METHODS (SHALLOW DEPTH) FOP FOR AASHTO T 310**

### **Scope**

This procedure covers the determination of density, moisture content, and relative compaction of soil, aggregate, and soil-aggregate mixes in accordance with AASHTO T 310-13. This field operating procedure is derived from AASHTO T 310. The nuclear moisture-density gauge is used in the direct transmission mode.

### **Apparatus**

- Nuclear density gauge with the factory matched standard reference block.
- Drive pin, guide/scrapper plate, and hammer for testing in direct transmission mode.
- Transport case for properly shipping and housing the gauge and tools.
- Instruction manual for the specific make and model of gauge.
- Radioactive materials information and calibration packet containing:
  - Daily Standard Count Log.
  - Factory and Laboratory Calibration Data Sheet.
  - Leak Test Certificate.
  - Shippers Declaration for Dangerous Goods.
  - Procedure Memo for Storing, Transporting and Handling Nuclear Testing Equipment.
  - Other radioactive materials documentation as required by local regulatory requirements.
- Sealable containers and utensils for moisture content determinations.

### **Radiation Safety**

This method does not purport to address all of the safety problems associated with its use. This test method involves potentially hazardous materials. The gauge utilizes radioactive materials that may be hazardous to the health of the user unless proper precautions are taken. Users of this gauge must become familiar with the applicable safety procedures and governmental regulations. All operators will be trained in radiation safety prior to operating

nuclear density gauges. Some agencies require the use of personal monitoring devices such as a thermoluminescent dosimeter or film badge. Effective instructions together with routine safety procedures such as source leak tests, recording and evaluation of personal monitoring device data, etc., are a recommended part of the operation and storage of this gauge.

## Calibration

Calibrate the nuclear gauge as required by the agency. This calibration may be performed by the agency using manufacturer's recommended procedures or by other facilities approved by the agency. Verify or re-establish calibration curves, tables, or equivalent coefficients every 12 months.

## Standardization

1. Turn the gauge on and allow it to stabilize (approximately 10 to 20 minutes) prior to standardization. Leave the power on during the day's testing.
2. Standardize the nuclear gauge at the construction site at the start of each day's work and as often as deemed necessary by the operator or agency. Daily variations in standard count shall not exceed the daily variations established by the manufacturer of the gauge. If the daily variations are exceeded after repeating the standardization procedure, the gauge should be repaired and/or recalibrated.
3. Record the standard count for both density and moisture in the Daily Standard Count Log. The exact procedure for standard count is listed in the manufacturer's Operator's Manual.

*Note 1:* New standard counts may be necessary more than once a day. See agency requirements.

## Overview

There are two methods for determining in-place density of soil / soil aggregate mixtures. See agency requirements for method selection.

- Method A Single Direction
- Method B Two Direction

## Procedure

1. Select a test location(s) randomly and in accordance with agency requirements. Test sites should be relatively smooth and flat and meet the following conditions:
  - a. At least 10 m (30 ft) away from other sources of radioactivity
  - b. At least 3 m (10 ft) away from large objects

- c. The test site should be at least 150 mm (6 in.) away from any vertical projection, unless the gauge is corrected for trench wall effect.
2. Remove all loose and disturbed material, and remove additional material as necessary to expose the top of the material to be tested.
3. Prepare a flat area sufficient in size to accommodate the gauge. Plane the area to a smooth condition so as to obtain maximum contact between the gauge and the material being tested. For Method B, the flat area must be sufficient to permit rotating the gauge 90 or 180 degrees about the source rod.
4. Fill in surface voids beneath the gauge with fines of the material being tested passing the 4.75 mm (No. 4) sieve or finer. Smooth the surface with the guide plate or other suitable tool. The depth of the filler should not exceed approximately 3 mm (1/8 in.).
5. Make a hole perpendicular to the prepared surface using the guide plate and drive pin. The hole shall be at least 50 mm (2 in.) deeper than the desired probe depth, and shall be aligned such that insertion of the probe will not cause the gauge to tilt from the plane of the prepared area. Remove the drive pin by pulling straight up and twisting the extraction tool.
6. Place the gauge on the prepared surface so the source rod can enter the hole without disturbing loose material.
7. Insert the probe in the hole and lower the source rod to the desired test depth using the handle and trigger mechanism.
8. Seat the gauge firmly by partially rotating it back and forth about the source rod. Ensure the gauge is seated flush against the surface by pressing down on the gauge corners, and making sure that the gauge does not rock.
9. Pull gently on the gauge to bring the side of the source rod nearest to the scaler / detector firmly against the side of the hole.
10. Perform one of the following methods, per agency requirements:
  - a. Method A Single Direction: Take a test consisting of the average of two, one minute readings, and record both density and moisture data. The two wet density readings should be within  $32 \text{ kg/m}^3$  ( $2.0 \text{ lb/ft}^3$ ) of each other. The average of the two wet densities and moisture contents will be used to compute dry density.
  - b. Method B Two Direction: Take a one-minute reading and record both density and moisture data. Rotate the gauge 90 or 180 degrees, pivoting it around the source rod. Reseat the gauge by pulling gently on the gauge to bring the side of the source rod nearest to the scaler/detector firmly against the side of the

hole and take a one-minute reading. (In trench locations, rotate the gauge 180 degrees for the second test.) Some agencies require multiple one-minute readings in both directions. Analyze the density and moisture data. A valid test consists of wet density readings in both gauge positions that are within  $50 \text{ kg/m}^3$  ( $3.0 \text{ lb/ft}^3$ ). If the tests do not agree within this limit, move to a new location. The average of the wet density and moisture contents will be used to compute dry density.

11. If required by the agency, obtain a representative sample of the material, 4 kg (9 lb) minimum, from directly beneath the gauge full depth of material tested. This sample will be used to verify moisture content and / or identify the correct density standard. Immediately seal the material to prevent loss of moisture.

The material tested by direct transmission can be approximated by a cylinder of soil approximately 300 mm (12 in.) in diameter directly beneath the centerline of the radioactive source and detector. The height of the cylinder will be approximately the depth of measurement. When organic material or large aggregate is removed during this operation, disregard the test information and move to a new test site.

12. To verify the moisture content from the nuclear gauge, determine the moisture content with a representative portion of the material using the FOP for AASHTO T 255/T 265 or other agency approved methods. If the moisture content from the nuclear gauge is within  $\pm 1$  percent, the nuclear gauge readings can be accepted. Retain the remainder of the sample at its original moisture content for a one-point compaction test under the FOP for AASHTO T 272, or for gradation, if required.

*Note 2:* Example: A gauge reading of 16.8 percent moisture and an oven dry of 17.7 percent are within the  $\pm 1$  percent requirements. Moisture correlation curves will be developed according to agency guidelines. These curves should be reviewed and possibly redeveloped every 90 days.

13. Determine the dry density by one of the following.
  - a. From nuclear gauge readings, compute by subtracting the mass (weight) of the water ( $\text{kg/m}^3$  or  $\text{lb/ft}^3$ ) from the wet density ( $\text{kg/m}^3$  or  $\text{lb/ft}^3$ ) or compute using the percent moisture by dividing wet density from the nuclear gauge by  $1 + \text{moisture content expressed as a decimal}$ .
  - b. When verification is required and the nuclear gauge readings cannot be accepted, the moisture content is determined by the FOP for AASHTO T 255/T 265 or other agency approved methods. Compute dry density by dividing wet density from the nuclear gauge by  $1 + \text{moisture content expressed as a decimal}$ .

## Percent Compaction

- Percent compaction is determined by comparing the in-place dry density as determined by this procedure to the appropriate agency density standard. For soil or soil-aggregate mixes, these are moisture-density curves developed using the FOP for AASHTO

T 99/T 180. When using maximum dry densities from the FOP for AASHTO T 99/T 180 or FOP for AASHTO T 272, it may be necessary to use the Annex in the FOP for T 99/T 180 to determine corrected maximum dry density and optimum moisture content.

For coarse granular materials, the density standard may be density-gradation curves developed using a vibratory method such as AKDOT&PF's ATM 212, ITD's T 74, WSDOT's TM 606, or WFLHD's Humphres.

See appropriate agency policies for use of density standards.

### Calculation

Wet density readings from gauge: 1963 kg/m<sup>3</sup> (121.6 lb/ft<sup>3</sup>)  
1993 kg/m<sup>3</sup> (123.4 lb/ft<sup>3</sup>)

Avg: 1978 kg/m<sup>3</sup> (122.5 lb/ft<sup>3</sup>)

**Moisture readings from gauge: 14.2% and 15.4% = Avg 14.8%**

Moisture content from the FOP's for AASHTO T 255/ T 265: 15.9%

*Moisture content is greater than 1 percent different so the gauge moisture cannot be used.*

**Calculate the dry density as follows:**

$$\rho_d = \left( \frac{\rho_w}{w + 100} \right) \times 100 \quad \text{or} \quad \rho_d = \left( \frac{\rho_w}{\frac{w}{100} + 1} \right)$$

Where:

$\rho_d$  = Dry density, kg/m<sup>3</sup> (lb/ft<sup>3</sup>)

$\rho_w$  = Wet density, kg/m<sup>3</sup> (lb/ft<sup>3</sup>)

w = Moisture content from the FOP's for AASHTO T 255 / T 265, as a percentage

$$\rho_d = \left( \frac{1978 \text{ kg/m}^3 \text{ or } 122.5 \text{ lb/ft}^3}{15.9 + 100} \right) \times 100 \quad \rho_d = \left( \frac{1978 \text{ kg/m}^3 \text{ or } 122.5 \text{ lb/ft}^3}{\frac{15.9}{100} + 1} \right)$$

Corrected for moisture Dry Density: 1707 kg/m<sup>3</sup> (105.7 lb/ft<sup>3</sup>)

Calculate percent compaction as follows:

$$\% \text{ Compaction} = \frac{\rho_d}{\text{Agency density standard}} \times 100$$

**Example:**

$$\% \text{ Compaction} = \frac{105.7 \text{ lb/ft}^3}{111.3 \text{ lb/ft}^3} \times 100 = 95\%$$

Where:

$\rho_d$  = Dry density, kg/m<sup>3</sup> (lb/ft<sup>3</sup>)  
Agency density standard = Corrected maximum dry density  
from the FOP from T 99/T 180 Annex

**Report**

- Results on forms approved by the agency
- Sample ID
- Location of test, elevation of surface, and thickness of layer tested.
- Visual description of material tested.
- Make, model and serial number of the nuclear moisture-density gauge.
- Wet density to 0.1 lb/ft<sup>3</sup>.
- Moisture content as a percent, by mass, of dry soil mass to 0.1 percent.
- Dry density to 0.1 lb/ft<sup>3</sup>.
- Density standard to 0.1 lb/ft<sup>3</sup>.
- Percent compaction.
- Name and signature of operator.

## **THEORETICAL MAXIMUM SPECIFIC GRAVITY ( $G_{mm}$ ) AND DENSITY OF HOT MIX ASPHALT (HMA) PAVING MIXTURES FOP FOR AASHTO T 209**

### **Scope**

This procedure covers the determination of the maximum specific gravity ( $G_{mm}$ ) of uncompacted hot mix asphalt (HMA) paving mixtures in accordance with AASHTO T 209-12. Two methods using different containers – bowl and pycnometer / volumetric flask– are covered.

Specimens prepared in the laboratory shall be cured according to agency standards.

### **Apparatus**

- Balance or scale: 10,000 g capacity, readable to 0.1 g
- Container: A glass, metal, or plastic bowl, pycnometer or volumetric flask between 2000 and 10,000 mL as required by the minimum sample size requirements in Table 1 sample and capable of withstanding a partial vacuum
- Pycnometer / volumetric flask cover: A glass plate or a metal or plastic cover with a vented opening
- Vacuum lid: A transparent lid with a suitable vacuum connection, with a vacuum opening to be covered with a fine wire mesh
- Vacuum pump or water aspirator: Capable of evacuating air from the container to a residual pressure of 4.0 kPa (30 mm Hg)
- Residual pressure manometer or vacuum gauge: Traceable to NIST and capable of measuring residual pressure down to 4.0 kPa (30 mm Hg) or less
- Manometer or vacuum gauge: Capable of measuring the vacuum being applied at the source of the vacuum
- Water bath: A constant-temperature water bath (optional)
- Thermometers: Standardized liquid-in-glass, or electronic digital total immersion type, accurate to 0.5°C (1°F)
- Bleeder valve to adjust vacuum
- Timer

## Standardization of Pycnometer or Volumetric Flask

Use a pycnometer / volumetric flask that is standardized to accurately determine the mass of water, at  $25 \pm 0.5^\circ\text{C}$  ( $77 \pm 1^\circ\text{F}$ ), in the pycnometer / volumetric flask. The pycnometer / volumetric flask shall be standardized periodically in conformance with procedures established by the agency.

## Test Sample Preparation

1. Obtain samples in accordance with the FOP for AASHTO T 168 and reduce according to the FOP for AASHTO R 47.
2. Test sample size shall conform to the requirements of Table 1. Samples larger than the capacity of the container may be tested in two or more increments. Results will be combined and averaged. If the increments have a specific gravity difference greater than 0.014 the test must be re-run.

**Table 1**  
**Test Sample Size for  $G_{mm}$**

<b>Nominal Maximum* Aggregate Size mm (in.)</b>	<b>Minimum Mass g</b>
37.5 or greater (1 ½)	4000
19 to 25 (¾ to 1)	2500
12.5 or smaller (½)	1500

\*Nominal maximum size: One sieve larger than the first sieve to retain more than 10 percent of the material using an agency specified set of sieves based on cumulative percent retained.

## Procedure – General

Two procedures – bowl and pycnometer / volumetric flask – are covered. The first 11 steps are the same for both.

1. Separate the particles of the sample, taking care not to fracture the mineral particles, so that the particles of the fine aggregate portion are not larger than 6.3 mm (1/4 in.). If the mixture is not sufficiently soft to be separated manually, place it in a large flat pan and warm in an oven only until it is pliable enough for separation.
2. Cool the sample to room temperature.
3. Determine and record the mass of the dry container to the nearest 0.1 g.
4. Place the sample in the container.
5. Determine and record the mass of the dry container and sample to the nearest 0.1 g.
6. Determine and record the mass of the sample by subtracting the mass determined in Step 3 from the mass determined in Step 5. Designate this mass as “A.”

7. Add sufficient water at approximately 25° C (77° F) to cover the sample by about 25 mm (1 in.).  
*Note 1:* The release of entrapped air may be facilitated by the addition of a wetting agent. Check with the agency to see if this is permitted and, if it is, for a recommended agent.
8. Place the lid on the container and attach the vacuum line. To ensure a proper seal between the container and the lid, wet the O-ring or use a petroleum gel.
9. Remove entrapped air by subjecting the contents to a partial vacuum of  $3.7 \pm 0.3$  kPa ( $27.5 \pm 2.5$  mm Hg) residual pressure for  $15 \pm 2$  minutes.
10. Agitate the container and contents, either continuously by mechanical device or manually by vigorous shaking, at 2 minute intervals. This agitation facilitates the removal of air.
11. Release the vacuum, increasing the pressure to atmospheric pressure in 10 to 15 seconds, turn off the vacuum pump, and remove the lid. When performing the pycnometer / volumetric flask method, complete steps 12B through 16B within  $10 \pm 1$  minutes.

### Procedure – Bowl

- 12A. Fill the water bath to overflow level with water at  $25 \pm 1^\circ\text{C}$  ( $77 \pm 2^\circ\text{F}$ ) and allow the water to stabilize.
- 13A. Zero or tare the balance with the immersion apparatus attached, ensuring that the device is not touching the sides or the bottom of the water bath.
- 14A. Suspend and immerse the bowl and contents in water at  $25 \pm 1^\circ\text{C}$  ( $77 \pm 2^\circ\text{F}$ ) for  $10 \pm 1$  minutes. The holder shall be immersed sufficiently to cover both it and the bowl.
- 15A. Determine and record the submerged weight of the bowl and contents to the nearest 0.1 g.
- 16A. Refill the water bath to overflow level.
- 17A. Empty and re-submerge the bowl following Step 12A to determine the submerged weight of the bowl to the nearest 0.1 g.
- 18A. Determine and record the submerged weight of the sample to the nearest 0.1 g by subtracting the submerged weight of the bowl from the submerged weight determined in Step 15A. Designate this submerged weight as “C.”

**Procedure – Pycnometer or Volumetric Flask**

- 12B. Immediately fill the pycnometer / volumetric flask with water without reintroducing air.
- 13B. Stabilize the temperature of the pycnometer / volumetric flask and contents so that the final temperature is within  $25 \pm 1^{\circ}\text{C}$  ( $77 \pm 2^{\circ}\text{F}$ ).
- 14B. Finish filling the pycnometer / volumetric flask with water that is  $25 \pm 1^{\circ}\text{C}$  ( $77 \pm 2^{\circ}\text{F}$ ), place the cover or a glass plate on the pycnometer / volumetric flask, and eliminate all air.
- Note 2:* When using a metal pycnometer and cover, place the cover on the pycnometer and push down slowly, forcing excess water out of the hole in the center of the cover. Use care when filling the pycnometer to avoid reintroducing air into the water.
- 15B. Towel dry the outside of the pycnometer / volumetric flask and cover.
- 16B. Determine and record the mass of the pycnometer / volumetric flask, cover, de-aired water, and sample to the nearest 0.1 g. within  $10 \pm 1$  minutes of completion of Step 11. Designate this mass as “E.”

**Procedure – Mixtures Containing Uncoated Porous Aggregate**

If the pores of the aggregates are not thoroughly sealed by a bituminous film, they may become saturated with water during the vacuuming procedure, resulting in an error in maximum density. To determine if this has occurred, complete the general procedure and then:

1. Carefully drain water from sample through a towel held over the top of the container to prevent loss of material.
2. Spread sample in a flat shallow pan and place before an electric fan to remove surface moisture.
3. Determine the mass of the sample when the surface moisture appears to be gone.
4. Continue drying and determine the mass of the sample at 15-minute intervals until less than a 0.5 g loss is found between determinations.
5. Record the mass as the saturated surface dry mass to the nearest 0.1 g. Designate this mass as “ASSD.”
6. Calculate, as indicated below,  $G_{mm}$ , using “A” and “ASSD,” and compare the two values.

**Calculation**

Calculate the  $G_{mm}$  to three decimal places as follows:

**Bowl Procedure**

$$G_{mm} = \frac{A}{A - C}$$

or

$$G_{mm} = \frac{A}{A_{SSD} - C}$$

(for mixes containing uncoated aggregate materials)

where:

A = mass of dry sample in air, g

$A_{SSD}$  = Mass of saturated surface dry sample in air, g

C = submerged weight of sample in water, g

**Example:**

A = 1432.7 g

$A_{SSD}$  = 1434.2 g

C = 848.6 g

$$G_{mm} = \frac{1432.7 \text{ g}}{1432.7 \text{ g} - 848.6 \text{ g}} = 2.453 \quad \text{or} \quad G_{mm} = \frac{1432.7 \text{ g}}{1434.2 \text{ g} - 848.6 \text{ g}} = 2.447$$

**Pycnometer / Volumetric Flask Procedure**

$$G_{mm} = \frac{A}{A + D - E}$$

or

$$G_{mm} = \frac{A}{A_{SSD} + D - E}$$

(for mixtures containing uncoated materials)

where:

A = Mass of dry sample in air, g

$A_{SSD}$  = Mass of saturated surface-dry sample in air, g

D = Mass of pycnometer / volumetric flask filled with water at 25°C (77°F), g, determined during the Standardization of Pycnometer / Volumetric Flask procedure

E = Mass of pycnometer / volumetric flask filled with water and the test sample at test temperature, g

**Example (in which two increments of a large sample are averaged):**

Increment 1

Increment 2

A = 2200.3 g

A = 1960.2 g

D = 7502.5 g

D = 7525.5 g

E = 8812.3 g

E = 8690.8 g

Temperature = 26.2°C    Temperature = 25.0°C

$$G_{mm_1} = \frac{2200.3 \text{ g}}{2200.3 \text{ g} + 7502.5 \text{ g} - 8812.3 \text{ g}} \times 0.99968 = 2.470$$

$$G_{mm_2} = \frac{1960.2 \text{ g}}{1960.2 \text{ g} + 7525.5 \text{ g} - 8690.8 \text{ g}} \times 1.00000 = 2.466$$

Allowable variation is: 0.014

2.470 - 2.466 = 0.004, which is < 0.014, so they can be averaged.

Average

$$2.470 + 2.466 = 4.936 \quad 4.936 \div 2 = 2.468$$

### Theoretical Maximum Density

To calculate the theoretical maximum density at 25°C (77°F) use one of the following formulas. The density of water at 25°C (77°F) is 997.1 in Metric units or 62.245 in English units.

$$\text{Theoretical maximum density kg/m}^3 = G_{\text{mm}} \times 997.1 \text{ kg/m}^3$$

$$2.468 \times 997.1 \text{ kg/m}^3 = 2461 \text{ kg/m}^3$$

or

$$\text{Theoretical maximum density lb/ft}^3 = G_{\text{mm}} \times 62.245 \text{ lb/ft}^3$$

$$2.468 \times 62.245 \text{ lb/ft}^3 = 153.6 \text{ lb/ft}^3$$

### Report

- Results on forms approved by the agency
- Sample ID
- $G_{\text{mm}}$  to three decimal places
- Theoretical maximum density to 1  $\text{kg/m}^3$  (0.1  $\text{lb/ft}^3$ )



## **BULK SPECIFIC GRAVITY ( $G_{mb}$ ) OF COMPACTED HOT MIX ASPHALT (HMA) USING SATURATED SURFACE-DRY SPECIMENS FOP FOR AASHTO T 166**

### **Scope**

This procedure covers the determination of bulk specific gravity ( $G_{mb}$ ) of compacted hot mix asphalt (HMA) using three methods – A, B, and C – in accordance with AASHTO T 166-16. This FOP is for use on specimens not having open or interconnecting voids or absorbing more than 2.00 percent water by volume, or both. When specimens have open or interconnecting voids or absorbing more than 2.00 percent water by volume, or both, AASHTO T 275 or AASHTO T 331 should be performed.

### **Overview**

- Method A: Suspension
- Method B: Volumeter
- Method C: Rapid test for A or B

### **Test Specimens**

Test specimens may be either laboratory-molded or from HMA pavement. For specimens it is recommended that the diameter be equal to four times the maximum size of the aggregate and the thickness be at least one and one half times the maximum size.

Test specimens from HMA pavement will be sampled according to AASHTO R 67.

### **Terminology**

*Constant Mass:* The state at which a mass does not change more than a given percent, after additional drying for a defined time interval, at a required temperature.

### **Apparatus - Method A (Suspension)**

Balance or scale: 5 kg capacity, readable to 0.1 g, and fitted with a suitable suspension apparatus and holder to permit weighing the specimen while suspended in water, conforming to AASHTO M 231.

- Suspension apparatus: Wire of the smallest practical size and constructed to permit the container to be fully immersed.
- Water bath: For immersing the specimen in water while suspended under the balance or scale, and equipped with an overflow outlet for maintaining a constant water level.

- Towel: Damp cloth towel used for surface drying specimens.
- Oven: Capable of maintaining a temperature of  $110 \pm 5^{\circ}\text{C}$  ( $230 \pm 9^{\circ}\text{F}$ ) for drying the specimens to a constant mass.
- Pan: Pan or other suitable container of known mass, large enough to hold a sample for drying in oven.
- Thermometer: Having a range of  $19$  to  $27^{\circ}\text{C}$  ( $66$  to  $80^{\circ}\text{F}$ ), graduated in  $0.1^{\circ}\text{C}$  ( $0.2^{\circ}\text{F}$ ) subdivisions.

### Procedure - Method A (Suspension)

Recently molded laboratory samples that have not been exposed to moisture do not need drying.

1. Dry the specimen to constant mass, if required.
  - a. Initially dry overnight at  $52 \pm 3^{\circ}\text{C}$  ( $125 \pm 5^{\circ}\text{F}$ ).
  - b. Determine and record the mass of the specimen ( $M_p$ ).
  - c. Return the specimen to the oven for at least 2 hours.
  - d. Determine and record the mass of the specimen ( $M_n$ ).
  - e. Determine percent change by subtracting the new mass determination ( $M_n$ ) from the previous mass determination ( $M_p$ ) divide by the previous mass determination ( $M_p$ ) multiply by 100.
  - f. Continue drying until there is less than 0.05 percent change in specimen mass after 2-hour drying intervals (constant mass).
  - g. Constant mass has been achieved, sample is defined as dry.
2. Cool the specimen in air to  $25 \pm 5^{\circ}\text{C}$  ( $77 \pm 9^{\circ}\text{F}$ ), and determine and record the dry mass to the nearest 0.1 g. Designate this mass as "A."
3. Fill the water bath to overflow level with water at  $25 \pm 1^{\circ}\text{C}$  ( $77 \pm 1.8^{\circ}\text{F}$ ) and allow the water to stabilize.
4. Zero or tare the balance with the immersion apparatus attached, ensuring that the device is not touching the sides or the bottom of the water bath.

*Note 1:* To expedite the procedure, steps 1 and 2 may be performed last. To further expedite the process, see Method C.

5. Immerse the specimen shaking to remove the air bubbles. Place the specimen on its side in the suspension apparatus. Leave it immersed for  $4 \pm 1$  minutes.
6. Determine and record the submerged weight to the nearest 0.1 g. Designate this submerged weight as "C."
7. Remove the sample from the water and quickly surface dry with a damp cloth towel within 5 seconds.
8. Zero or tare the balance.
9. Immediately determine and record the mass of the SSD specimen to nearest 0.1 g. Designate this mass as "B." Any water that seeps from the specimen during the mass determination is considered part of the saturated specimen. Do not to exceed 15 seconds performing Steps 7 through 9.

### Calculations - Method A (Suspension)

#### Constant Mass:

Calculate constant mass using the following formula:

$$\%Change = \frac{M_p - M_n}{M_p} \times 100$$

Where:

$M_p$  = previous mass measurement, g

$M_n$  = new mass measurement, g

#### Bulk specific gravity ( $G_{mb}$ ) and percent water absorbed:

$$G_{mb} = \frac{A}{B - C}$$

$$\text{Percent Water Absorbed (by volume)} = \frac{B - A}{B - C} \times 100$$

where:

A = Mass of dry specimen in air, g

B = Mass of SSD specimen in air, g

C = Weight of specimen in water at  $25 \pm 1^\circ\text{C}$  ( $77 \pm 1.8^\circ\text{F}$ ), g

**Example:**

$$G_{mb} = \frac{4833.6 \text{ g}}{4842.4 \text{ g} - 2881.3 \text{ g}} = 2.465$$

$$\% \text{ Water Absorbed (by volume)} = \frac{4842.4 \text{ g} - 4833.6 \text{ g}}{4842.4 \text{ g} - 2881.3 \text{ g}} \times 100 = 0.45\%$$

**Apparatus - Method B (Volumeter)**

- Balance or scale: 5 kg capacity, readable to 0.1 g and conforming to AASHTO M 231.
- Water bath: Thermostatically controlled to  $25 \pm 0.5^\circ\text{C}$  ( $77 \pm 0.9^\circ\text{F}$ ).
- Thermometer: Range of  $19$  to  $27^\circ\text{C}$  ( $66$  to  $80^\circ\text{F}$ ), and graduated in  $0.1^\circ\text{C}$  ( $0.2^\circ\text{F}$ ) subdivisions.
- Volumeter: Calibrated to 1200 mL or appropriate capacity for test sample and having a tapered lid with a capillary bore.
- Oven: Capable of maintaining a temperature of  $110 \pm 5^\circ\text{C}$  ( $230 \pm 9^\circ\text{F}$ ) for drying the specimens to a constant mass.
- Pan: Pan or other suitable container of known mass, large enough to hold a sample for drying in oven.
- Towel: Damp cloth towel used for surface drying specimens.

**Procedure - Method B (Volumeter)**

Recently molded laboratory samples that have not been exposed to moisture do not need drying.

1. Dry the specimen to constant mass, if required.
  - a. Initially dry overnight at  $52 \pm 3^\circ\text{C}$  ( $125 \pm 5^\circ\text{F}$ ).
  - b. Determine and record the mass of the specimen ( $M_p$ ).
  - c. Return the specimen to the oven for at least 2 hours.
  - d. Determine and record the mass of the specimen ( $M_n$ ).

- e. Determine percent change by subtracting the new mass determination ( $M_n$ ) from the previous mass determination ( $M_p$ ) divide by the previous mass determination ( $M_p$ ) multiply by 100.
  - f. Continue drying until there is less than 0.05 percent change in specimen mass after 2-hour drying intervals (constant mass).
  - g. Constant mass has been achieved, sample is defined as dry.
- Note 1:* To expedite the procedure, steps 1 and 2 may be performed last. To further expedite the process, see Method C.
2. Cool the specimen in air to  $25 \pm 5^\circ\text{C}$  ( $77 \pm 9^\circ\text{F}$ ), and determine and record the dry mass to the nearest 0.1 g. Designate this mass as "A."
  3. Immerse the specimen in the temperature-controlled water bath for at least 10 minutes.
  4. Fill the volumeter with distilled water at  $25 \pm 1^\circ\text{C}$  ( $77 \pm 1.8^\circ\text{F}$ ) making sure some water escapes through the capillary bore of the tapered lid. Wipe the volumeter dry. Determine the mass of the volumeter to the nearest 0.1 g. Designate this mass as "D."
  5. At the end of the ten minute period, remove the specimen from the water bath and quickly surface dry with a damp cloth towel within 5 seconds.
  6. Immediately determine and record the mass of the SSD specimen to the nearest 0.1 g.
  7. Designate this mass as "B." Any water that seeps from the specimen during the mass determination is considered part of the saturated specimen.
  8. Place the specimen in the volumeter and let stand 60 seconds.
  9. Bring the temperature of the water to  $25 \pm 1^\circ\text{C}$  ( $77 \pm 1.8^\circ\text{F}$ ) and cover the volumeter, making sure some water escapes through the capillary bore of the tapered lid.
  10. Wipe the volumeter dry.
  11. Determine and record the mass of the volumeter and specimen to the nearest 0.1 g. Designate this mass as "E."

*Note 2:* Method B is not acceptable for use with specimens that have more than 6 percent air voids.

**Calculations - Method B (Volumeter)****Constant Mass:**

Calculate constant mass using the following formula:

$$\%Change = \frac{M_p - M_n}{M_p} \times 100$$

Where:

$M_p$  = previous mass measurement, g

$M_n$  = new mass measurement, g

**Bulk specific gravity ( $G_{mb}$ ) and percent water absorbed:**

$$G_{mb} = \frac{A}{B + D - E}$$

$$\text{Percent Water Absorbed (by volume)} = \frac{B - A}{B + D - E} \times 100$$

where:

A = Mass of dry specimen in air, g

B = Mass of SSD specimen in air, g

D = Mass of volumeter filled with water at  $25 \pm 1^\circ\text{C}$  ( $77 \pm 1.8^\circ\text{F}$ ), g

E = Mass of volumeter filled with specimen and water, g

**Example:**

$$G_{mb} = \frac{4833.6 \text{ g}}{4842.4 \text{ g} + 2924.4 \text{ g} - 5806.0 \text{ g}} = 2.465$$

$$\% \text{ Water Absorbed (by volume)} = \frac{4842.4 \text{ g} - 4833.6 \text{ g}}{4842.4 \text{ g} + 2924.4 \text{ g} - 5806.0 \text{ g}} \times 100 = 0.45\%$$

**Method C (Rapid Test for Method A or B)**

See Methods A or B.

*Note 3:* This procedure can be used for specimens that are not required to be saved and contain substantial amounts of moisture. Cores can be tested the same day as obtained by this method.

**Procedure - Method C (Rapid Test for Method A or B)**

1. Start on Step 3 of Method A or B, and complete that procedure, then determine dry mass, "A," as follows.
2. Determine and record mass of a large, flat-bottom container.
3. Place the specimen in the container.
4. Place in an oven at a minimum of 105°C (221°F). Do not exceed the Job Mix Formula mixing temperature.
5. Dry until the specimen can be easily separated into fine aggregate particles that are not larger than 6.3 mm (¼ in.).
6. Determine and record the mass of the specimen ( $M_p$ ).
7. Return the specimen to the oven for at least 2 hours.
8. Determine and record the mass of the specimen ( $M_n$ ).
9. Determine percent change by subtracting the new mass determination ( $M_n$ ) from the previous mass determination ( $M_p$ ) divide by the previous mass determination ( $M_p$ ) multiply by 100.
10. Continue drying until there is less than 0.05 percent change in specimen mass after 2-hour drying intervals (constant mass).
11. Constant mass has been achieved, sample is defined as dry.
12. Cool in air to 25 ±5°C (77 ±9°F).
13. Determine and record the mass of the container and specimen to the nearest 0.1 g.
14. Determine and record the mass of the dry specimen to the nearest 0.1 g by subtracting the mass of the container from the mass determined in Step 13. Designate this mass as "A."

**Calculations - Method C (Rapid Test for Method A or B)**

Complete the calculations as outlined in Methods A or B, as appropriate.

**Report**

- Results on forms approved by the agency
- Sample ID
- $G_{mb}$  to 0.001
- Absorption to 0.01 percent
- Method performed

## **IN-PLACE DENSITY OF ASPHALT MIXTURES BY NUCLEAR METHOD FOP FOR AASHTO T 355**

### **Scope**

This test method describes a procedure for determining the density of asphalt mixtures by means of a nuclear gauge using the backscatter method in accordance with AASHTO T 355-16. Correlation with densities determined under the FOP for AASHTO T 166 is required by some agencies.

### **Apparatus**

- Nuclear density gauge with the factory-matched standard reference block.
- Transport case for properly shipping and housing the gauge and tools.
- Instruction manual for the specific make and model of gauge.
- Radioactive materials information and calibration packet containing:
  - Daily standard count log
  - Factory and laboratory calibration data sheet
  - Leak test certificate
  - Shippers' declaration for dangerous goods
  - Procedure memo for storing, transporting and handling nuclear testing equipment
  - Other radioactive materials documentation as required by local regulatory requirements

### **Material**

- Filler material: Fine-graded sand from the source used to produce the asphalt pavement or other agency approved materials.

### **Radiation Safety**

This method does not purport to address all of the safety problems associated with its use. This test method involves potentially hazardous materials. The gauge utilizes radioactive materials that may be hazardous to the health of the user unless proper precautions are taken. Users of this gauge must become familiar with the applicable safety procedures and governmental regulations. All operators will be trained in radiation safety prior to operating nuclear density gauges. Some agencies require the use of personal monitoring devices such

as a thermoluminescent dosimeter or film badge. Effective instructions, together with routine safety procedures such as source leak tests, recording and evaluation of personal monitoring device data, etc., are a recommended part of the operation and storage of this gauge.

### **Calibration**

Calibrate the nuclear gauge as required by the agency. This calibration may be performed by the agency using the manufacturer's recommended procedures or by other facilities approved by the agency. Verify or re-establish calibration curves, tables, or equivalent coefficients every 12 months.

### **Standardization**

1. Turn the gauge on and allow it to stabilize (approximately 10 to 20 minutes) prior to standardization. Leave the power on during the day's testing.
2. Standardize the nuclear gauge at the construction site at the start of each day's work and as often as deemed necessary by the operator or agency. Daily variations in standard count shall not exceed the daily variations established by the manufacturer of the gauge. If the daily variations are exceeded after repeating the standardization procedure, the gauge should be repaired, recalibrated, or both.
3. Record the standard count for both density and moisture in the daily standard count log. The exact procedure for standard count is listed in the manufacturer's Operator's Manual.

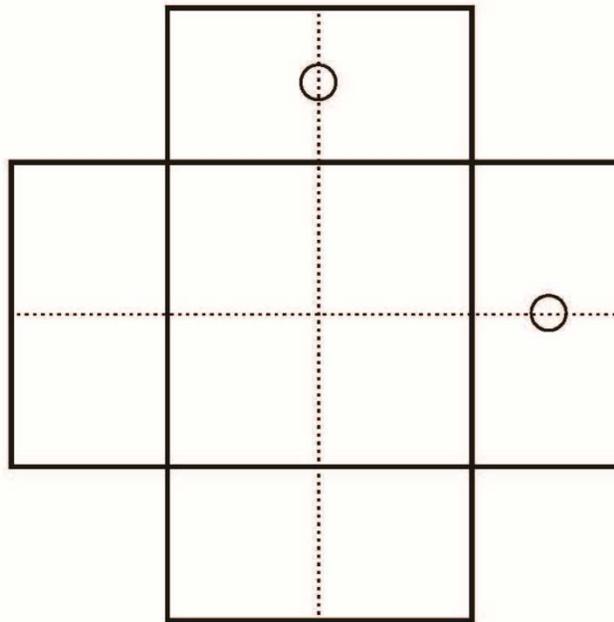
*Note 1:* New standard counts may be necessary more than once a day. See agency requirements.

### **Test Site Location**

1. Select a test location(s) randomly and in accordance with agency requirements. Test sites should be relatively smooth and flat and meet the following conditions:
  - a. At least 10 m (30 ft.) away from other sources of radioactivity.
  - b. At least 3 m (10 ft.) away from large objects.
  - c. If the gauge will be closer than 600 mm (24 in.) to any vertical mass, or less than 300 mm (12 in.) from a vertical pavement edge, use the gauge manufacturer's correction procedure.

**Procedure**

1. Maintain maximum contact between the base of the gauge and the surface of the material under test. Use filler material to fill surface voids. Spread a small amount of filler material over the test site surface and distribute it evenly. Strike off the surface with a straightedge (such as a lathe or flat-bar steel) to remove excess material.
2. Place the gauge on the test site, perpendicular to the roller passes. Using a crayon (not spray paint), mark the outline or footprint of the gauge. Extend the probe to the backscatter position.
3. Take a one-minute test and record the wet density reading.
4. Rotate the gauge 90 degrees centered over the original footprint. Mark the outline or footprint of the gauge.
5. Take another one-minute test and record the wet density reading.
6. If the difference between the two one-minute tests is greater than  $40 \text{ kg/m}^3$  ( $2.5 \text{ lb/ft}^3$ ), retest in both directions. If the difference of the retests is still greater than  $40 \text{ kg/m}^3$  ( $2.5 \text{ lb/ft}^3$ ) test at 180 and 270 degrees.
7. The density reported for each test site shall be the average of the two individual one-minute wet density readings.

**Footprint of the gauge test site**

## Calculation of Results

Percent compaction is determined by comparing the in-place wet density as determined by this method to the appropriate agency density standard. See appropriate agency policy for use of density standards.

### Example:

Reading #1: 141.5 lb/ft<sup>3</sup>

Reading #2: 140.1 lb/ft<sup>3</sup> Are the two readings within the tolerance? (YES)

Reading average: 140.8 lb/ft<sup>3</sup>

Core correction : +2.1 lb/ft<sup>3</sup>

Corrected reading: 142.9 lb/ft<sup>3</sup>

From the FOP for AASHTO T 209:

$$G_{mm} = 2.466$$

$$\text{Maximum Laboratory Dry Density} = 2.466 \times 62.245 \text{ lb/ft}^3 = 153.5 \text{ lb/ft}^3$$

$$\text{Percent compaction} = \frac{142.9 \text{ lb/ft}^3}{153.5 \text{ lb/ft}^3} \times 100 = 93.1\%$$

## Report

- Results on forms approved by the agency
- Test ID
- Location of test and thickness of layer tested
- Mixture type
- Make, model and serial number of the nuclear moisture-density gauge
- Calculated wet density of each measurement and any adjustment data
- Density standard
- Compaction 0.1 percent
- Name and signature of operator

## APPENDIX – CORRELATION WITH CORES

(Nonmandatory Information)

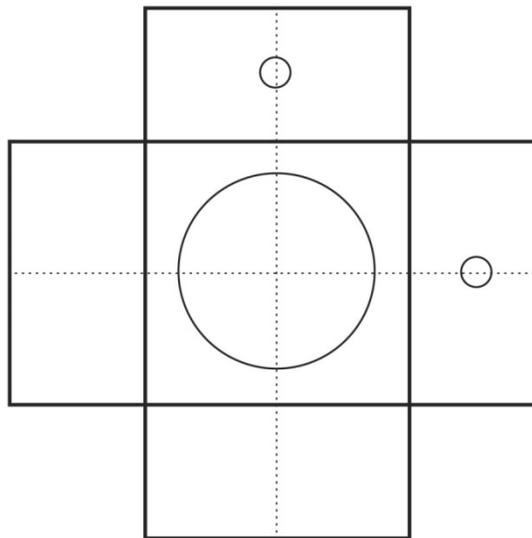
The Bulk Specific Gravity ( $G_{mb}$ ) of the core is a physical measurement of the in-place HMA and can be compared with the nuclear density gauge readings. Comparing the core value to the corresponding gauge values, a correlation can be established.

The correlation can then be used to adjust the gauge readings to the in-place density of the cores. The core correlation is gauge specific and must be determined without traffic allowed on the pavement between nuclear density gauge readings and obtaining the core. When using multiple nuclear density gauges each gauge should be correlated to the core locations prior to removal of the core.

When density correlation with the FOP for AASHTO T 166 is required, correlation of the nuclear gauge with pavement cores shall be made on the first day's paving (within 24 hours) or from a test strip constructed prior to the start of paving. Cores must be taken before traffic is allowed on the pavement.

### Correlation with Cores

1. Determine the number of cores required for correlation from the agency's specifications. Cores shall be located on the first day's paving or on the test strip. Locate the test sites in accordance with the agency's specifications. Follow the "Procedure" section above to establish test sites and obtain densities using the nuclear gauge.
2. Obtain a pavement core from each of the test sites according to AASHTO R 67. The core should be taken from the center of the nuclear gauge footprint.



**Footprint of the gauge test site. Core location in the center of the footprint.**

3. Determine the density of the cores by the FOP for AASHTO T 166, Bulk Specific Gravity of Compacted Asphalt Mixtures Using Saturated Surface Dry Specimens.
4. Calculate a correlation factor for the nuclear gauge reading as follows:
  - a. Calculate the difference between the core density and the average nuclear gauge density at each test site to the nearest  $1 \text{ kg/m}^3$  ( $0.1 \text{ lb/ft}^3$ ). Calculate the average difference and standard deviation of the differences for the entire data set to the nearest  $1 \text{ kg/m}^3$  ( $0.1 \text{ lb/ft}^3$ ).
  - b. If the standard deviation of the differences is equal to or less than  $40 \text{ kg/m}^3$  ( $2.5 \text{ lb/ft}^3$ ), the correlation factor applied to the average nuclear gauge density shall be the average difference calculated above in 4.a.
  - c. If the standard deviation of the differences is greater than  $40 \text{ kg/m}^3$  ( $2.5 \text{ lb/ft}^3$ ), the test site with the greatest variation from the average difference shall be eliminated from the data set and the data set properties and correlation factor recalculated following 4.a and 4.b.
  - d. If the standard deviation of the modified data set still exceeds the maximum specified in 4.b, additional test sites will be eliminated from the data set and the data set properties and correlation factor recalculated following 4.a and 4.b. If the data set consists of less than five test sites, additional test sites shall be established.

**Note A1:** The exact method used in calculating the nuclear gauge correlation factor shall be defined by agency policy.

**Note A2:** The above correlation procedure must be repeated if there is a new job mix formula. Adjustments to the job mix formula beyond tolerances established in the contract documents will constitute a new job mix formula. A correlation factor established using this procedure is only valid for the particular gauge and at the probe depth used in the correlation procedure. If another gauge is brought onto the project, it shall be correlated using the same procedure. Multiple gauges may be correlated from the same series of cores if done at the same time.

**Note A3:** For the purpose of this procedure, a job mix formula is defined as the percent and grade of paving asphalt used with a specified gradation of aggregate from a designated aggregate source. A new job mix formula may be required whenever compaction of the wearing surface exceeds the agency's specified maximum density or minimum air voids.

**Core Correlation Example:**

	Core results from T 166:	Average Gauge reading:	Difference:	X	X <sup>2</sup>
1	144.9 lb/ft <sup>3</sup>	142.1 lb/ft <sup>3</sup>	2.8 lb/ft <sup>3</sup>	-0.7	0.49
2	142.8 lb/ft <sup>3</sup>	140.9 lb/ft <sup>3</sup>	1.9 lb/ft <sup>3</sup>	0.2	0.04
3	143.1 lb/ft <sup>3</sup>	140.7 lb/ft <sup>3</sup>	2.4 lb/ft <sup>3</sup>	-0.3	0.09
4	140.7 lb/ft <sup>3</sup>	138.9 lb/ft <sup>3</sup>	1.8 lb/ft <sup>3</sup>	0.3	0.09
5	145.1 lb/ft <sup>3</sup>	143.6 lb/ft <sup>3</sup>	1.5 lb/ft <sup>3</sup>	0.6	0.36
6	144.2 lb/ft <sup>3</sup>	142.4 lb/ft <sup>3</sup>	1.8 lb/ft <sup>3</sup>	0.3	0.09
7	143.8 lb/ft <sup>3</sup>	141.3 lb/ft <sup>3</sup>	2.5 lb/ft <sup>3</sup>	-0.4	0.16
8	142.8 lb/ft <sup>3</sup>	139.8 lb/ft <sup>3</sup>	3.0 lb/ft <sup>3</sup>	0.9	0.81
9	144.8 lb/ft <sup>3</sup>	143.3 lb/ft <sup>3</sup>	1.5 lb/ft <sup>3</sup>	-0.6	0.36
10	143.0 lb/ft <sup>3</sup>	141.0 lb/ft <sup>3</sup>	2.0 lb/ft <sup>3</sup>	-0.1	0.01
	Average Difference:		+2.1 lb/ft <sup>3</sup>		

$$\sqrt{\frac{\sum x^2}{n-1}}$$

Where:

$\sum$  = Sum

x = Difference from the average Difference

n-1 = number of data sets minus 1

Example:  $10 - 1 = 9$

$$\sqrt{\frac{2.5}{9}} = 0.53$$

X1.1.1. The Sum of X<sup>2</sup> = 2.5 and the number of data sets = 9 for a computed standard deviation of 0.53. This is within the allowable 2.5 therefore no cores are eliminated, use the average difference from all ten cores.

