

State of Illinois
Department of Transportation
Bureau of Materials
Springfield

POLICY MEMORANDUM

Revised: [April 14, 2022](#)

31-13.2

This Policy Memorandum supersedes number 31-13.1 dated [June 1, 2018](#)

TO: REGIONAL ENGINEERS AND BUREAU CHIEFS IN THE OFFICE OF
HIGHWAYS PROJECT IMPLEMENTATION

SUBJECT: RECLAIMED ASPHALT PAVEMENT (RAP) FOR AGGREGATE
APPLICATIONS

1.0 SCOPE

The RAP aggregate producer is responsible for processing raw feed grindings, asphalt pavement or pavement preservation courses into aggregate that will comply with applicable gradation specifications. Consistent application of quality control (QC) at the crushing/screening plant or jobsite is required to achieve consistent RAP aggregate product for construction use.

All RAP products for Department/Local Agency aggregate use, whether at the jobsite, mix plant or central recycling facility, shall be tested according to this policy.

2.0 PURPOSE

The purpose of this policy is to establish a QC procedure to manage RAP material designated for use in aggregate applications.

3.0 SAMPLING/TESTING PERSONNEL

3.1 All sampling and testing shall be conducted by either an Aggregate Technician or a Mixture Aggregate Technician as designated in the current Bureau of Materials Policy Memorandum, "Aggregate Gradation Control System ([AGCS](#))."

3.2 The overall program shall be administered by a QC Manager, as designated in Section 3.14 in the Policy Memorandum, "Aggregate Gradation Control System ([AGCS](#))" or the HMA QC Manager designated in Section 1030.05 (d)(1) of the Standard Specifications.

3.3 Jobsite stockpiles are for use on the same contract the material originally came from. If the material is used on a different contract, the contractor for that project will have to restart this testing program with the production testing procedure defined in Section 4.1, herein.

4.0 SAMPLING/TESTING PROCEDURE

4.1 Production Testing

4.1.1 All RAP aggregate shall be 100% passing the top sieve of the gradation specified. The material shall be sampled and tested for gradation at a minimum of 1 test every 1,000 tons (907 metric tons) for the first 5,000 tons (4,536 metric tons) during production. After the first 5,000 tons (4,536 metric tons), the material shall be sampled and tested at a minimum of 1 test every 5,000 tons (4,536 metric tons).

4.1.2 Sampling shall be according to one of the approved methods listed Illinois [Modified AASHTO R 90](#), in the IDOT Manual of Test Procedures for Materials. The required gradation testing sieve shall be the top sieve of the gradation specified.

4.1.3 As part of the gradation testing, a visual of the material to check for uniformity shall also be performed. Material that is one-sized, over-sized, or gap-graded shall be rejected.

4.2 Failing Gradation Samples

4.2.1 Material that does not have 100% passing the top sieve of the specified gradation shall be immediately resampled. The producer shall immediately cease adding new material to their approved pile.

4.2.2 If the resample passes, the material may be placed on the approved stockpile.

4.2.3 If the resample fails, the District will be contacted and production shall stop until corrective action has been initiated by the source, through either [additional](#) crushing or rescreening the material. [Upon the restart of production, the material shall be stockpiled separately and an immediate production sample taken.](#) Once the sample passes, the production testing frequency may continue and the material can be moved to the approved stockpile.

4.3 Loadout Testing

4.3.1 Loadout samples shall be taken as soon as the pile is shipped/loaded out and then a minimum of 1 test every 5,000 tons (4,536 metric tons) thereafter. If a loadout sample fails, an immediate resample shall be taken and loadout of the approved stockpile shall cease until passing results of the resample are known.

4.3.2 If the resample passes, loadout of the approved stockpile may continue.

4.3.3 If the resample fails, the approved stockpile is rejected and the source will need to re-crush or rescreen the material. Production testing frequency shall be followed during this reprocessing.

4.3.4 Jobsite stockpiles shall be visually inspected for over-sized agglomerations (RAP particles that have melded back together), excessive segregation, and any construction debris. If any of these are present, the material shall be rescreened and retested prior to use. If none of the above are present, the jobsite stockpile shall be exempt from loadout sampling.

5.0 IDOT MONITORING

- 5.1 The Aggregate Inspector or Mixture Aggregate Technician shall witness the sampling of one of the RAP aggregate samples a minimum of 1 every 20,000 tons (18,144 metric tons). The Aggregate Inspector or Resident Engineer (RE) will obtain a final split of the product for IDOT testing. The District will run the gradation over the same sieve size the producer is using. The samples shall be compared [according to](#) Illinois Manual of Test Procedures, Appendix A.5 “Procedure for Sample Comparison.”
- 5.2 Any District result not comparing within the limits noted above or fails the limits noted under production testing, shall be cause for a District investigation. Corrective action may be required by the Department if determined to be a producer problem. Continued lack of comparison or continued failure of the District monitor sample shall be considered non-compliance and may be cause for removal of the source from this program per section 6.0 herein.

6.0 ACCEPTANCE/REJECTION

- 6.1 RAP aggregate sources shall submit a certification letter stating that this material meets the requirements of this policy and the AGCS policy prior to shipment for use in any Department/Local Agency project.
- 6.2 RAP aggregate products having unacceptable oversize or gradation shall be isolated and removed for the approved stockpile to the satisfaction of the District Materials Engineer, RE or his/her representative.
- 6.3 Shipment or placement of RAP aggregate having unacceptable properties as defined in Section 4.0 herein shall result in the removal from the [Approved/Qualified Producer List of Aggregate Sources](#).

7.0 CLOSING NOTICE

Archive versions of this policy memorandum may be examined by contacting the Bureau of Materials.

The current Bureau Chief of Materials has approved this policy memorandum. Signed documents are on file with the Bureau.