

## **Asfaltsegud. Materjalide spetsifikatsioonid. Osa 21: Tehase tootmisohje**

Bituminous mixtures - Material specifications - Part 21:  
Factory Production Control

## EESTI STANDARDI EESSÕNA

## NATIONAL FOREWORD

Käesolev Eesti standard EVS-EN 13108-21:2007 sisaldab Euroopa standardi EN 13108-21:2006+AC:2008 ingliskeelset teksti.

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English Version

**Bituminous mixtures - Material specifications - Part 21: Factory  
Production Control**

Mélanges bitumineux - Specifications des matériaux -  
Partie 21: Contrôle de la production en usine

Asphaltmischgut - Mischgutanforderungen - Teil 21:  
Werkseigene Produktionskontrolle

This European Standard was approved by CEN on 12 October 2005.

CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration. Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the Central Secretariat or to any CEN member.

This European Standard exists in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the Central Secretariat has the same status as the official versions.

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## Foreword

This European Standard (EN 13108-21:2006) has been prepared by Technical Committee CEN/TC 227 "Road materials", the secretariat of which is held by DIN.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by July 2006, and conflicting national standards shall be withdrawn at the latest by January 2008.

This European Standard is one of a series of standards as listed below:

EN 13108-1, *Bituminous mixtures — Material specifications — Part 1: Asphalt Concrete.*

EN 13108-2, *Bituminous mixtures — Material specifications — Part 2: Asphalt Concrete for very thin layers.*

EN 13108-3, *Bituminous mixtures — Material specifications — Part 3: Soft Asphalt.*

EN 13108-4, *Bituminous mixtures — Material specifications — Part 4: Hot Rolled Asphalt.*

EN 13108-5, *Bituminous mixtures — Material specifications — Part 5: Stone Mastic Asphalt.*

EN 13108-6, *Bituminous mixtures — Material specifications — Part 6: Mastic Asphalt.*

EN 13108-7, *Bituminous mixtures — Material specifications — Part 7: Porous Asphalt.*

EN 13108-8, *Bituminous mixtures — Material specifications — Part 8: Reclaimed asphalt.*

EN 13108-20, *Bituminous mixtures — Material specifications — Part 20: Type Testing.*

EN 13108-21, *Bituminous mixtures — Material specifications — Part 21: Factory Production Control.*

No existing European Standard is superseded.

According to the CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Slovakia, Slovenia, Spain, Sweden, Switzerland and United Kingdom.

## Introduction

This European Standard has been written as part of the system for the evaluation of conformity of bituminous mixtures. It is designed to be used in conjunction with the product standards EN 13108-1 to -7 and is called up by these standards as part of Evaluation of Conformity.

The Factory Production Control procedure is designed to be applied to European Standards for bituminous mixtures whether or not regulatory marking is to be applied.

Evaluation of conformity comprises Initial Type Testing (ITT) and Factory Production Control (FPC). This European Standard has been written to provide the basis for quality and conformity control and as part of the system for the evaluation of conformity of bituminous mixtures. When the appropriate 'conformity' clauses are applied it forms part of the system for attestation of conformity as required by the Construction Products Directive. It provides the minimum level of FPC for CE Marking.

For commercial and/or contractual reasons manufacturers can choose to carry out more testing and inspection.

The system in this European Standard builds mainly upon traditional sampling and testing of constituent materials and finished product. Processes as well as process control systems are continuously being developed which means that new systems for Factory Production Control will be introduced and implemented. If a producer is able to demonstrate that his process control system is able to secure the fulfilment of the requirements on the finished products in a satisfactory way then alternative minimum frequencies of inspection and testing may be acceptable.

The basis of this European Standard is that of the control of constituents, composition and mixing by regular sampling and inspection. It does not involve the routine monitoring of the performance properties of the bituminous mixtures. Periodic revalidation of these properties is dealt with separately in EN 13108-20.

Frequencies and tolerances for the evaluation of conformity are given in Annex A.

The tasks for evaluating the FPC as part of attestation of conformity are defined in Annex B.

## 1 Scope

This European Standard specifies both quality and Factory Production Control requirements for use during the manufacture of bituminous mixtures intended for use on roads, airfields and other trafficked areas.

Additional testing carried out within contracts is beyond the scope of this European Standard.

The Factory Production Control is to be applied to European Standards for bituminous mixtures if regulatory marking of conformity is to be applied. It is also a necessary part of evaluation of conformity in situations where regulatory marking does not apply.

This European Standard is applicable to the control of bituminous mixtures where the constituents and target composition are known, and have been shown by means of Type Testing to comply with all appropriate specified compositional, performance related or performance based requirements in EN 13108-1 to -7.

## 2 Normative references

The following referenced documents are indispensable for the application of this European Standard. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

EN 12591, *Bitumen and bituminous binders — Specifications for paving grade bitumens*

EN 12697-27, *Bituminous mixtures — Test methods for hot mix asphalt — Part 27: Sampling*

EN 12697-28, *Bituminous mixtures — Test methods for hot mix asphalt — Part 28: Preparation of samples for determining binder content, water content and grading*

EN 13043, *Aggregates for bituminous mixtures and surface treatments for roads, airfields and other trafficked areas*

EN ISO 9001, *Quality management systems — Requirements (ISO 9001:2000)*

## 3 Terms and definitions

For the purposes of this European Standard, the following terms and definitions apply.

### 3.1

#### **Factory Production Control (FPC)**

permanent internal control of production exercised by the manufacturer where all the elements, requirements and provisions adopted by the manufacturer shall be documented in a systematic manner in the form of written policies and procedures. This production control system documentation is designed to ensure a common understanding of quality assurance and enable the achievement of the required product characteristics and the effective operation of the production control system to be checked

### 3.2

#### **technical specifications**

Harmonised European Standards and European Technical Approvals for asphalt mixtures