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

Mélanges bitumineux - Spécifications des  
matériaux - Partie 21: Maîtrise de la  
production

Asphaltmischgut - Mischgutanforderungen -  
Teil 21: Werkseigene Produktionskontrolle

This corrigendum becomes effective on 29 October 2008 for incorporation in the three official language versions of the EN.

Ce corrigendum prendra effet le 29 octobre 2008 pour incorporation dans les trois versions linguistiques officielles de la EN.

Die Berichtigung tritt am 29. Oktober 2008 zur Einarbeitung in die drei offiziellen Sprachfassungen der EN in Kraft.



EUROPEAN COMMITTEE FOR STANDARDIZATION  
COMITÉ EUROPÉEN DE NORMALISATION  
EUROPÄISCHES KOMITEE FÜR NORMUNG

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Ref. No.: EN 13108-21:2006/AC:2008 D/E/F

## **1 Modification to Clause 5**

### **5.3, Table 1**

*Add a line in "line 2 Binder" between "Tank temperature" and "penetration and softening point" until and included column 3 and 4.*

### **5.4**

*In the first paragraph there is a reference to a note, but there is no note. Delete "(see note)".*

## **2 Modification to Clause 6**

### **6.2 and 6.3**

*all the tables*

*Add "and" or a comma and "and" between the frequencies mentioned in the last columns of the tables. Otherwise producers can choose between these frequencies. Add full stops at the end of text in the last columns of the tables.*

E.g.

a) ... and b) ... .

a) ..., b) ... and c) ... .

Change column 4 of Table 2 as follows:

**Table 2 — Minimum plant calibration requirements**

Column	1	2	3	4
Line	Item of plant	Inspection/test	Purpose	Minimum frequency
1	Weighing equipment	Visual inspection as described in procedures	To ascertain that weighing equipment is functioning correctly	Daily.
		Testing of weighing accuracy — (recalibration)	To ensure accuracy within quality plan requirements	a) On installation <sup>a</sup> , b) every year and c) in case of doubt.
2	Admixture dispensers	Organoleptic inspection	To ascertain that dispenser is functioning correctly	First batch of the day containing admixture.
		Test for accuracy as described in procedures.	To ensure accuracy within quality plan requirements	a) On installation <sup>a</sup> , b) every year and c) in case of doubt.
3	Flow meters	Comparison of the actual amount with the metered amount by reconciliation	To ensure accuracy within quality plan requirements	a) On installation <sup>a</sup> , b) annually and c) in case of doubt.
4	Batching system (on batch plants)	Comparison of actual mass of constituents in the batch with the intended mass using the method prescribed in the quality plan	To ascertain the batching accuracy in accordance with the quality plan	a) On installation <sup>a</sup> , b) annually and c)in case of doubt.
5	Proportioning system (on continuous plants)	Comparison of actual mass in a measured period of time with the intended mass using the method prescribed in the quality plan	To ascertain the accuracy in accordance with the quality plan	a) On installation <sup>a</sup> , b) annually and c) in case of doubt.
6	Temperature, monitoring equipment	Visual as described in procedures	To ascertain the equipment is functioning correctly	Daily.
		Test of accuracy as described in procedures.	To ensure correct temperatures are recorded	a) On installation <sup>a</sup> , b) every year and c) in case of doubt.
NOTE 'In case of doubt' refers to the reasonable judgement of an experienced plant operator.				
<sup>a</sup> Or after comprehensive repair.				

Change column 3 of Table 3 as follows:

**Table 3 — Minimum inspection and test frequencies for aggregates <sup>a</sup>**

Column	1	2	3
Line	Inspection/Test	Purpose	Frequency
1	<b>Tests for intrinsic properties of aggregate (strength etc.)</b>	To check suitability for intended use	Source approval before initial use. Updated in accordance with EN 13043.
2	<b>Inspection of delivery ticket <sup>b</sup></b>	To check consignment is as ordered and from correct source	Each delivery.
3	<b>Organoleptic check of stockpile <sup>b</sup></b>	For comparison with normal appearance with respect to source, grading, shape and impurities	Daily.
4	<b>By sieve analysis</b>	To assess compliance with standard or other agreed grading	a) First delivery from new source, b) in case of doubt following organoleptic check and c) 1 per 2 000 t.
5	<b>Shape, crushed particle index, etc</b>	To assess compliance with standard or other agreed specification	a) First delivery from new source, b) in case of doubt and c) as indicated in quality plan.
6	<b>Moisture content</b>	Process control	As indicated in the quality plan.
<sup>a</sup> This table may include the results of tests and inspections by the supplier as part of his Factory Production Control (see 6.2).			
<sup>b</sup> These requirements will not apply in the case of direct supplies from an aggregate production unit to an asphalt plant on the same site.			

Change column 3 of Table 4 as follows:

**Table 4 — Minimum inspection and test frequencies for filler <sup>a</sup>**

Column	1	2	3
Line	Inspection/test	Purpose	Frequency
1	<b>Tests for intrinsic properties of filler (bulk density, stiffening properties etc.)</b>	To check suitability for intended use	Supplier approval before initial use. Updated in accordance with EN 13043.
2	<b>Inspection of delivery ticket</b>	To check consignment is as ordered and from the correct source	Each delivery.
3	<b>Sieve analysis</b>	To check compliance with standard or other agreed grading	a) First delivery from new source and b) as indicated in the quality plan.
<sup>a</sup> This table may include the results of tests and inspections by the supplier as part of his Factory Production Control.			

Change column 3 of Table 5 as follows:

**Table 5 — Minimum inspection and test frequencies for binders <sup>a</sup>**

Column	1	2	3
Line	Inspection/test	Purpose	Frequency
1	<b>Intrinsic properties of binder</b>	To confirm characteristics of product and compliance with appropriate specification	Source approval before initial use. Updated in accordance with EN 12591.
2	<b>Inspection of delivery ticket</b>	To check consignment is as ordered and from the correct source	Each delivery.
3	<b>Temperature</b>	To check that binder is with permitted temperature limits	Each delivery.
4	<b>Grade properties (penetration, softening point or viscosity)</b>	To assess compliance with specification	1 per 300 t.
5	<b>Organoleptic check (by sample or tank inspection)</b>	For comparison with normal perceptible properties	Each delivery or daily in tanks.
<sup>a</sup> This table may include the results of tests and inspections by the supplier as part of his Factory Production Control.			

Change column 3 of Table 6 as follows:

**Table 6 — Minimum inspection and test frequencies for additives <sup>a</sup>**

Column	1	2	3
Line	Inspection/test	Purpose	Frequency
1	<b>Appropriate tests to determine intrinsic properties</b>	To confirm characteristics of product or check compliance with specification	a) Source approval prior to initial use and b) as stated in the quality plan.
2	<b>Inspection of delivery ticket</b>	To check that consignment is as ordered and from the correct source	Each delivery.
3	<b>Organoleptic check of consignment</b>	For comparison with normal appearance	Each delivery, if practicable; otherwise in accordance with quality plan.
<sup>a</sup> This table may include the results of tests and inspections by the supplier as part of his Factory Production Control.			

Change column 3 of Table 7 as follows:

**Table 7 — Minimum inspection and test frequencies for reclaimed asphalt <sup>a</sup>**

Column	1	2	3
Line	Inspection/test	Purpose	Frequency
1	<b>Organoleptic check</b>	To enable separation by type, screening for harmful or detrimental components	On receipt of each consignment (In case of doubt, e.g. tar content additional testing required).
2	<b>Classification of recovered aggregate (visual check for angularity, petrological type etc.)</b>	To assess suitability for use in various mixtures	1 per 1 000 t.
3	<b>Moisture content</b>	Process control	As indicated by the quality plan.

<sup>a</sup> The overall sampling and test frequencies for reclaimed asphalt are those from EN 13108-8 applicable to the feedstock. The tests in this table represent only in process inspections of consistency.

Change column 3 of Table 8 as follows:

**Table 8 — Minimum inspection/test frequencies for delivered product**

Column	1	2	3
Line	Inspection/test	Purpose	Frequency
1	<b>Organoleptic check on mixed asphalt</b>	For comparison with normal appearance with respect to grading, evenness of mixing and adequacy of coating	Every load.
2	<b>Temperature</b>	To ensure material conforms with specification or other requirements	a) As required under 5.3 and b) whenever samples are taken.
3	<b>Grading and binder content</b>	To ensure material conforms to specification	See Annex A.
4	<b>Other characteristics included in technical specifications</b>	To assess conformity	As detailed in quality plan See Annex D.
5	<b>Suitability of delivery vehicles by visual assessment</b>	To check adequacy of insulation	Prior to first use <sup>a</sup> and in case of doubt.
6	<b>Cleanliness of delivery vehicles by visual assessment</b>	To avoid contamination	Every load prior to loading <sup>a</sup> .

<sup>a</sup> See 5.4.

### 6.3, Table 8

In line 4, column 3: replace "Annex B" with "Annex D".

### **3 Modification to Annex A**

#### **Annex A, A.4**

*In A.4, add the following sentence after the 3<sup>rd</sup> text block:*

"A mobile plant that is relocated will be considered in the same way as a plant that has had a shut down for more than three months or a major repair."

### **4 Modification to Annex B**

#### **Annex B, B.4.3 – B.5**

*Add the following title "B.5 Obligations of producer" and move the last paragraph of B.4.3 as new paragraph to B.5.*

### **5 Modification to Annex C**

#### **Annex C, C.2**

*In the 1<sup>st</sup> sentence, add "mixtures" after "bituminous" to read: "The ENs for bituminous mixtures ...".*

### **6 Modification to the Bibliography**

#### **Bibliography**

*In reference [2] (EN 932-2) replace "Part 1" with "Part 2".*