

DIN EN 13108-21:2006-07 (E)

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

Contents		Page
Foreword		4
Introduction		5
1	Scope	6
2	Normative references	6
3	Terms and definitions	6
4	Requirements	7
4.1	Factory Production Control	7
4.2	Quality plan	7
4.3	Organisation	8
4.3.1	Responsibility and authority	8
4.3.2	Management representative	8
4.3.3	Internal audits	8
4.3.4	Management review	8
4.3.5	Sub-contract services	8
4.4	Document control	8
5	Control procedures	9
5.1	Constituent materials	9
5.2	Purchaser supplied product	9
5.3	Process control	9
5.4	Handling, storage and delivery	10
5.5	Plant calibration and maintenance	10
6	Inspection and testing	10
6.1	General	10
6.2	Incoming constituent materials	11
6.3	Finished bituminous mixture	15
7	Non-conformity	15
7.1	General	15
7.2	Non-conformity of constituent material	16
7.3	Non-conformity of bituminous mixture (arising from in-process inspection)	16
7.4	Non-conformity of bituminous mixture (arising from analysis of finished product under Annex A)	16
8	Inspection, measuring and test equipment	16
9	Records	16
10	Training	17
Annex A (normative)	Tolerances and test frequencies for finished asphalt	18
A.1	General	18
A.2	Testing, tolerances and conformity assessment	18
A.3	Operating Compliance Level (OCL)	19
A.4	Test frequency	20

A.5	Mean deviation from target	20
Annex B (normative)	Initial inspection and assessment of factory and Factory Production Control and continuous surveillance of Factory Production Control for bituminous mixtures	22
B.1	Introduction	22
B.2	Scope	22
B.3	Initial Inspection of Factory Production Control	22
B.4	Continuous surveillance	22
Annex C (informative)	Guidance on evaluation of conformity	24
C.1	Evaluation of conformity	24
C.2	Type Testing	24
C.3	Factory Production Control	24
C.4	Analysis	24
Annex D (informative)	Additional testing of mix characteristics	26
D.1	General	26
D.2	Sampling, test specimens and testing	26
D.3	Range of testing	26
D.4	Reporting	27
Annex E (informative)	Special requirements for airfields	28
Bibliography	29