

## NRMCA Plant Certification

### Items the Company should have ready prior to requesting an Inspection

Inspectors likely establish their charges based on time spent during the inspection. Having the following information ready and available for the inspector will save a considerable amount of time. The relevant check list item is listed in parenthesis. There might be additional information also requested by the inspector prior to the inspection. More details and the intent of inspection for these check list items is discussed in the NRMCA Plant Inspectors Guide.

1. To qualify as a cold-weather production plant an estimate of the average daily production (yd<sup>3</sup>) during freezing weather will be needed. (Sec 1.3.2)
2. The heating capacity of hot water heater or boiler must be determined if not shown on an information plate on the heating unit. The capacity of any hot water storage used in the heating process shall be available to the Inspector. (Sec 1.3.2)
3. When admixtures are not stored in heated enclosures in regions that experience freezing temperatures, a letter from the admixture supplier on adequacy of storage so as the functionality of the admixtures for each type stored is not adversely impacted. (Note 2).
4. Copy of most recent scale calibration certificate for weigh batchers used for cementitious materials, aggregate and other concrete ingredients that use weighing scales. (Sec 2.1.2, Note 3). The work sheets for verification of scale accuracy should be available to the Inspector for verification that normally accepted calibration procedures were followed. For previously certified plants records should be provided indicating scale accuracy verification has been conducted at 6 month intervals during the prior certification period. (Section 6)
5. If the field standard weights used for weigh batcher accuracy verification are the property of the ready mix concrete facility, a copy of the test weight certification, less than 2 years old, will also be needed. (Sec 2.1.2, Note 6).
6. Evidence of the availability of at least 500 pounds of test weights to check operational accuracy of scales or letter from scale company indicating availability of this service (2.1.3, Note 9).
7. Copy of manufacturer's "NTEP Certificates of Conformance" for load cells if the plant utilizes load cells in the weighing process. (Sec 2.1.5). This requirement applies to each load-cell within the weighing system. Load cells with National Type Evaluation Program approval (as all should be) will be listed on the National Conference of Weights and Measures web-site if not available in the producer's records. See Sec 2.1.5 of the guide for details.
8. Most recent records of verification of accuracy of each admixture dispenser used. (Sec 2.5.4). This may be marked with stickers on the admixture dispensers. For previously certified plants records should be provided indicating accuracy verification has been conducted at 6 month intervals during the period of the prior certification. (Section 6)
9. Information from the plant and control system manufacturer on the level of automation at the plant for batching system (Sec 2.6).
10. Most recent records of verification of accuracy of water weigh batcher (Sec 2.1.2) or batching water meter accuracy (Sec 2.5.3). For previously certified plants records should be provided indicating accuracy verification has been conducted at 6 month intervals during the period of the prior certification. (Section 6)
11. Copy of MSDS sheets for each chemical admixture stored at the batch plant.  
*This information provides both safety information in handling the admixture and freezing temperature data.*
12. Copies of 2 sets of 10 consecutive batch quantity printouts will be needed for the analysis of batching accuracy of each material. (Sec 2.5).  
*These data are confidential and not for distribution beyond this office.*
13. Record of moisture probe (if used) verification for the last six (6) months available for review. Record of aggregate moisture data for aggregates not controlled by a moisture probe during at least the last one month.

(Sec 2.5.5.1). For previously certified plants records should be provided indicating accuracy verification has been conducted at 6 month intervals during the prior certification period. (Section 6)

14. Copy of delivery ticket. (Blank or issued) (Sec. 4).

Information needed regarding delivery fleet inspection varies with which option the company has selected: Option A (In-house inspection) or Option B (Inspection by plant inspector).

15. Option A requires the following information assembled and available for plant inspector.
- a. Statement of qualifications of each person involved in delivery vehicle inspection process. (Sec. 5 and Sec 10.4)
  - b. The "Fleet Inspection Reporting Form" shall be available for review by plant inspector.
  - c. Information to ensure all delivery units have inspection cards or are on order from NRMCA.
  - d. Make available for interviews during the plant inspection all personnel performing delivery unit inspections.
16. Option B requires the following information assembled and available for plant inspector. (Sec. 5.)
- a. Copy of mixing blade schematic drawing for each different drum size and manufacturer. (Sec 5.1.1)  
*These are normally available on 8 ½ by 11 inch sheets from the mixer manufacturer. An essential part of the transit mixer inspection is the configuration of new blades for each mixer.*
  - b. List of truck numbers with name of mixer manufacturer for each transit mix truck included as a part of the plant certification process.
  - c. Each truck mixer should be pre-inspected by plant personnel for a legible drum data plate, a Truck Mixer Manufacturer Bureau rating plate, functioning drum revolution counter, and either a functioning sight glass on the side-water tank or a functioning meter on the truck's supplemental water supply line.
  - d. During the truck mixer inspection process it will be necessary for plant personnel to be present to operate the truck, mixer, and mixer water systems. It may be necessary to have the drum inspection hatches temporarily removed on selected units.
17. For truck mixers that do not bear a TMMB rating plate, documentation of the gross drum volume relative to the rated mixing capacity and evidence of mixing uniformity evaluation performed at least once on one unit of the typical design. (Note 28)

There may be some technical questions concerning the batching computer. The telephone number and name of a technical contact person with the manufacturer of your batching computer system should be provided.