

**Tennessee Department of Transportation  
Division of Materials and Tests**

**Ready Mix Concrete Plant Certification Procedures (SOP 4-3)**

Purpose: The purpose of this document is to outline the process of certification of ready mix concrete plants providing concrete for State projects. **These inspections standardize certification throughout the regions, improve concrete quality, assure consistency of product, support quality control, and assure adherence to TDOT Standard Specifications.**

This Standard Operating Procedure applies to ready mix plants in Tennessee and out-of-state that provide concrete for TDOT projects.

Discussion: Ready mix concrete suppliers must undergo a complete inspection of processes, plant equipment, trucks, laboratory equipment, materials, and technician qualifications. **A satisfactory plant inspection is required to become an approved producer and these inspections must be repeated annually at a minimum to remain on the Producer/Supplier List.**

Procedure: To become a producer/supplier for the State of Tennessee, the Producer must contact [Regional Materials and Tests](#). Once approved, Regional Materials and Tests personnel will randomly visit the Producer at a minimum of once per year. All inspections will be carried under the following guidelines:

Plant Inspection: The Regional Inspector will visit the plant to check the overall condition of the plant and mixers. **The inspection shall include an overall review of weighing devices, admixture dispensers, stockpile maintenance, bins, and evidence of laboratory inspection. Process control plans and aggregate quality testing reports shall be made available for evaluation.** The results of the plant inspection **will be** documented on form [DT-1479](#), Ready Mix Concrete Plant Inspection Report.

Laboratory Equipment Inspection: **The Regional Inspector will review all laboratory equipment to ensure that it meets the requirements for a Type A laboratory, as stated is TDOT Standard Specification 106.06. Each review will include an inspection of weighing devices; stoves; sampling, reducing, and shaking equipment; thermometers; and other apparatus necessary to perform standard tests and practices. The inventory of equipment will be documented on form [DT-0309](#), Equipment Inspection for Concrete Plant Laboratories and Jobsites. [SOP 1-4 \(Laboratory Qualification Requirements\)](#) documents the minimum qualifications for field laboratories and concrete testing equipment.**

Concrete Truck Inspection: The Regional Inspector will inspect all available trucks for data plates, revolution counters, mixer-blade wear, water gauges, axle configuration, tare weight, and allowable gross weights. The inspection is documented on the [Concrete Truck Checklist](#).

Technician Qualifications: The plant shall have personnel certified according to [TDOT Standard Specifications 501.03, 604.03, and SOP 1-3 \(Field Technician Certification Requirements\)](#). All certified technicians are to be listed on the [Certified Technician Form](#) and shall be made available to the TDOT Inspector.

Materials: All materials shall meet the requirements outlined in [SOP 4-4 \(Submittal and Approval of Concrete Mixture Designs\)](#). All constituent materials and admixtures shall be listed on the [Materials List](#).

Process Control Plan: The Producer must develop a [Batch Plant Process Control Plan](#) annually and submit for approval to Regional Materials and Tests that outlines the steps or procedures that will ensure that the concrete meets the minimum TDOT Specification requirements. The approved Process Control Plan shall be submitted at the pre-pour conference of each project.

Process Control Inspection: On a regular basis, the batch plant process control procedures will be inspected by representatives from Headquarters Materials and Tests and Regional Materials and Tests, as stated on the [Process Control Inspection Checklist](#).

Documentation: [Concrete Plant Records Minimum Requirements](#) must be kept and made available for inspection. These documents may be reviewed during the process control inspections.

Certification: Upon completion and documentation of initial inspection, Regional Materials and Tests will approve the ready mix producer to be placed on the Producer/Supplier List. If the producer does not pass a random inspection from Regional Materials and Tests, the producer maybe removed from the Producer/Supplier List until the issue has been resolved.

Mix Designs: Each plant shall have an approved concrete mix design as outlined in [SOP 4-4 \(Submittal and Approval of Concrete Mixture Designs\)](#).

Delivery Ticket: Form [DT-1756](#), Concrete Delivery Ticket must accompany each load to the placement site. The ticket must have all the required information according to TDOT Standard Specifications 501.03 and 604.03.