



# Best Practices for Minimizing Segregation

## 1. Aggregate Stockpiles

- A. Build in layers.
- B. Avoid any procedure that allows aggregate to be pushed or dumped over the side of a stockpile.
- C. Separate to prevent intermingling.
- D. Aggregate Handling:
  - (1) Loader operator works full face of stockpile.
  - (2) Install dividers on cold feed bins to prevent material from flowing into an adjacent bin.
  - (3) Do not pile aggregate so high that it flows over the dividers.

## 2. Loading Surge Silo: (If plant has batcher or gob hopper at top of silo.)

- A. Adjust conveying devices to deposit material in center of batcher or gob hopper.
- B. Keep gates on batcher or gob hopper closed unless dropping load of mix.
- C. Close gates on batcher or gob hopper before it is empty to prevent material from dribbling into silo.

## 3. Loading Trucks:

- A. Keep gates on bottom of silo closed so material does not dribble into trucks.
- B. Take care to center trucks (Left to Right) when loading.
- C. Consider loading trucks in multiple drops with first drop at rear, second drop at front, and then alternate dumps.
- D. If the mix is prone to segregate you should avoid loading trucks by slowly driving forward while dropping mix.

## 4. Dumping Trucks:

- A. To provide a surge of material to the paver, when using end dump trucks, the box should be raised until the mix moves to the rear before opening the tailgate.
- B. If any mix is spilled on the roadway in front of the paver while dumping the truck, this mix should be removed from the roadway before the paver starts forward.

## 5. Laydown Operations:

- A. Only dump wings of the hopper at the end of the day and then waste this material. Do not knock cold material off the wings and into the hopper.
- B. To provide consistent flow of material to the screed, the operator should avoid gradual deceleration or gradual acceleration.  
The paver should be stopped and started quickly at normal operating speed.
- C. Keep hopper more than half full at all times.
- D. Auger height should be adjusted so bottom of auger is at least two (2) inches above the finished surface of the mat.
- E. Adjust feed sensors to keep material near the center of the auger at all times.
- F. Correctly adjust the lead and trail crown of the screed so that the surface of the HMA behind the paver is uniform in appearance and texture.
- G. Install reverse fins at the center of auger to tuck the proper amount of material under the gear box.
- H. Adjust flow gates at rear of the hopper so that:
  - (1) The slat conveyors run continuously.
  - (2) The amount of material furnished to the augers allows them to run nearly 100% of the time.
- I. The risk of causing thermal segregation is increased when paving in cooler temperatures.

## 6. Windrow Elevators:

- A. When using pick up machines, they should be adjusted such that all the HMA is removed from the surface.